

5.1.4 Shoulder Contact Face

Shoulder contact faces of rotary shouldered connections shall be plane, and square with the thread axis, within 0.05 mm (0.002 in.). The surface finish of the contact face, before any surface treatment, shall be 5 μm (125 $\mu\text{in.}$) R_a or better, so as to assure a reliable sealing surface.

5.1.5 Standoff

Rotary shouldered connections shall be produced with standoff tolerances as specified in 7.2.

5.1.6 Lead Tolerance

The lead tolerance of rotary shouldered connections shall be as follows:

- a) ± 0.038 mm per 25.4 mm (0.0015 in. per in.) for any 25.4 mm (1.0 in.) between first and last full depth threads; and
- b) ± 0.114 mm (0.0045 in.) between first and last full depth threads, or the sum of 0.0254 mm (0.001 in.) for each 25.4 mm (1 in.) between first and last full depth threads, whichever is greater.

The method for determining lead is described in 7.4.

5.1.7 Taper Tolerance

The taper tolerance of rotary shouldered connections shall be as follows:

- a) pin thread: $+0.0025$ mm/mm to 0 mm/mm ($+0.0030$ in./ft to 0 in./ft) average taper between first and last full depth threads; and
- b) box thread: 0 mm/mm to -0.0025 mm/mm (0 in./ft to -0.0030 in./ft) average taper between first and last full depth threads.

The method for determining taper is described in 7.5.

5.1.8 Box Counterbore

The box counterbore shall have the diameter, D_C , specified in Table B.1, and taper, T , as shown in the detail of Figure 3. The depth of the counterbore shall be $7D_C$ as specified in Table B.1. The angle of the bevel at the intersection of the counterbore and the first threads is optional to the manufacturer but is typically 25° to 45°.

5.1.9 Thread Form

The **thread form** shall be as defined in Table B.2 and shown in Figures 4 and 5. The surface finish of the thread flanks and root before any surface treatment shall be 2.5 μm (63 $\mu\text{in.}$) R_a or better in order to maximize the fatigue life of the connection. This may be demonstrated using a sacrificial test piece on a process qualification basis.

The design intent for root radius, R , in Figure 4 is a tolerance of ± 0.025 mm (± 0.001 in.); this is not an auditable dimension but it is indirectly verified through the truncated thread height.

5.2 Bevels for Drill Collars and Tools that Mate Directly with Drill Collars

5.2.1 General

All connections shall have bevels on the outside surface with diameters detailed below. The bevel design is based on an angle of 45°.

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Table of Contents **Api 57code 2nd Edition**

1. Understanding the eBook **Api 57code 2nd Edition**
 - The Rise of Digital Reading **Api 57code 2nd Edition**
 - Advantages of eBooks Over Traditional Books
2. Identifying **Api 57code 2nd Edition**
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an **Api 57code 2nd Edition**
 - User-Friendly Interface
4. Exploring eBook Recommendations from **Api 57code 2nd Edition**
 - Personalized Recommendations

- Api 57code 2nd Edition User Reviews and Ratings
- Api 57code 2nd Edition and Bestseller Lists

5. Accessing Api 57code 2nd Edition Free and Paid eBooks

- Api 57code 2nd Edition Public Domain eBooks
- Api 57code 2nd Edition eBook Subscription Services
- Api 57code 2nd Edition Budget-Friendly Options

6. Navigating Api 57code 2nd Edition eBook Formats

- ePUB, PDF, MOBI, and More
- Api 57code 2nd Edition Compatibility with Devices
- Api 57code 2nd Edition Enhanced eBook Features

7. Enhancing Your Reading Experience

- Adjustable Fonts and Text Sizes of Api 57code 2nd Edition
- Highlighting and Note-Taking Api 57code 2nd Edition
- Interactive Elements Api 57code 2nd Edition

8. Staying Engaged with Api 57code 2nd Edition

- Joining Online Reading Communities
- Participating in Virtual Book Clubs
- Following Authors and Publishers Api 57code 2nd Edition

9. Balancing eBooks and Physical Books Api 57code 2nd Edition

- Benefits of a Digital Library
- Creating a Diverse Reading Collection Api 57code 2nd Edition

10. Overcoming Reading Challenges

- Dealing with Digital Eye Strain
- Minimizing Distractions
- Managing Screen Time

11. Cultivating a Reading Routine Api 57code 2nd Edition

- Setting Reading Goals Api 57code 2nd Edition
- Carving Out Dedicated Reading Time

12. Sourcing Reliable Information of Api 57code 2nd Edition

- Fact-Checking eBook Content of Api 57code 2nd Edition

- Distinguishing Credible Sources

13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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