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**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 22512.2-2008

Replacing GB/T 4749-2003; GB/T 9253.1-1999

**Petroleum and natural gas industries -- Rotary drilling
equipment -- Part 2: Threading and gauging of rotary
shouldered thread connections**

石油天然气工业 旋转钻井设备 第2部分：旋转台肩式螺纹连接的加工与测量
(English Translation)

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Foreword

GB/T 22512 "oil and gas industries - Rotary drilling equipment" is divided into two parts.

--- Part 1. Rotary drill string member;

--- Part 2. rotary shouldered threaded processing and measurement.

This is Part 2 GB/T 22512 of.

The partial modification of the use of ISO 10424-2:2007 "oil and gas industries - Rotary drilling equipment - Part 2. rotary shouldered thread Connection processing and Measurement "(in English).

This section according to ISO 10424-2:2007 redrafted. Taking into account China's national conditions, in the use of ISO 10424-2:2007 when this section Made some changes, the main technical differences are as follows.

--- To confuse the use of part of the thread type half-width and the thread flank angle of two different terms have been modified;

--- 9.2.3 For threaded workload rules, increasing the longitudinal save the dirty tank structure and requirements;

--- 10.3.2.2 flank angle measurement, increasing the use of other precision instruments to measure the flank angle method;

--- According to the requirements of the relevant policies, clearly stipulates that only by China National Accreditation Board for Laboratories or other ISO member countries Laboratories accredited calibration laboratory accreditation bodies before proofread gauge test approved. Appendix J to delete the content.

For ease of use, this section also made the following editorial changes.

--- With "GB/T 22512 in this part of" instead of "ISO 10424 Part";

--- With a decimal point instead of a comma as the decimal point, ",";

--- Delete ISO 10424-2:2007 (E) Foreword and Introduction;

--- FIG been repainted.

This Part replaces GB/T 9253.1-1999 "drill pipe connecting thread" and GB/T 4749-2003 "rotary shouldered threaded connection Gauge ", compared with the GB/T 9253.1-1999 and GB/T 4749-2003 The main changes are as follows.

--- Use the "rotary shouldered thread connections" instead of the term "oil drill pipe joints" and "joint oil drilling";

--- Increased requirements chamfer diameter drill collar and direct connection to the drill collar threaded connection (in this section 6.2);

--- Increasing the provision of low torque structure (section 6.3);

--- Increased product selection structure (Chapter 7 of this section);

--- Added a gauge detected recognition request to modify the gauge parameter specifications and methods of measurement (Chapter 10 section);

--- Increase the informative appendix "Other rotary shouldered connections" (in this section in Appendix F);

--- Increase the informative appendix "computing" (in this section in Appendix I);

--- Remove the thread flank gauge measuring surface and surface roughness measurement methods and plug thread diameter (GB/T 4749-2003 5.7 and Appendix B).

This section of the Appendices C and D are normative appendices, Appendix A, Appendix B, Appendix E, Appendix F, Appendix G, Appendix H and Appendix I Informative

appendices.

This part of the National Oil Drilling Equipment and Tools Standardization Technical Committee (SAC/TC96) and focal points.

This section is responsible for drafting unit. China National Petroleum Corporation Institute pipe.

Participated in the drafting of this section. Baoji Petroleum Machinery Co., Ltd., Beijing Petroleum Machinery Factory and Shanxi wind and thunder North Industries Group Co.

the company.

1 Scope

This section GB/T 22512 specifies the oil and gas industry with rotary shouldered threaded connection and gauge requirements, including thread and Thread gauge size requirements, methods of measurement, thread gauge specifications and testing methods and instrumentation. The priority for screwing the drill column member.

Supplementary Provisions special tolerances, quality, testing, and product requirements can be determined by the relevant parties to negotiate.

This section applies to the following preferred rotary shouldered threaded connection design.

Digital (NC) type;

Regular (REG) type;

Consistent eye (FH) type.

Above rotary shouldered threaded connections are traceable to the relevant international organizations gauge measurement and calibration systems.

2 Units of measurement consistency ---

In this section, the data SI units and USC units represent the two systems. SI and US customary single Bit system data sheets are given in the standard text and Appendix A. The data in Figure SI units and US customary units are made in two single Bit notation. For a particular order, we use only one of these units, without giving other data units indicated. Used in this International System of Units section and USC units conversion formulas in Appendix G.

Accordance with the specifications of these two units in any one system of units represented by the products should be considered equivalent and completely interchangeable. therefore, Comply with the requirements of this section by one of the units represented by another also meets the requirements expressed in units.

This section, SI units in parentheses after the data for the data represented by USC units.

3 Normative References

The following documents contain provisions which, through reference GB/T 22512 in this section constitute provisions of this section. For dated reference documents Member, all subsequent amendments (not including errata content) or revisions do not apply to this section, however, encouraged to reach under this section Parties to research agreement to use the latest versions of these documents. For undated reference documents, the latest versions apply to this section.

GB/T 15481-2000 General requirements for testing and calibration laboratories (idt ISO/IEC 17025:1999) ISO 10424-1 oil and gas industries - Rotary drilling equipment - Part 1. Rotary drill string member ISO 11961 Oil and Gas Industry Steel drill APISpec7 Rotary Drill Stem Elements

4.1 Terms and Definitions

The following terms and definitions apply to this part of the GB/T 22512 of.

4.1.1

Rotary shouldered connection outer diameter contact surfaces.