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

JJF 1108-2012

Replacing JJF 1108-2003

**Calibration Specification for OCTG Thread Working Gauges
(English Translation)**

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5.1 Rotary shouldered threaded connection workload Regulation metrological characteristics (2)

5.2 round thread casing, tubing and line pipe threads workload Regulation metrological characteristics (2)

9 Recalibration interval (15)

Appendix A rotary shouldered connection thread gauge workload measurement requirements (16)

Appendix B round thread casing, tubing, line pipe thread Work Gauge measurement requirements (21)

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Introduction

This specification reference to the following criteria drafted.

GB/T 22512.2-2008 petroleum and natural gas industries - Rotary drilling equipment - Part 2. rotary shouldered Processing and measurement threaded connection (SpecificationforThreading, Gauging, andThreadinspectionofCasing, Tubing, and LinePipeThreads) the specification for the revision, instead of JJF 1108-2003 "oil drilling connector thread work rules, work round thread casing for gauge and tubing thread gauge calibration workload specification. " the main amendments.

--- Increased workload buttress casing thread gauge calibration.

--- Increased workload line pipe thread gauge calibration.

--- Rotary shouldered connections Thread Work Gauge big trail parameters, according to GB/T 22512.2-2008 standard Quasi been revised.

--- Calibration method of presentation has been revised. Calibration method based on coordinate measuring principle, gives the corresponding Formula.

--- Reference to GB/T 22512.2 and Thread Work Gauge APISPEC5B use "metering performance requirements" Moved to Appendix A, B, C in.

Oil thread gauge calibration workload specification

1 Scope

This specification applies to the calibration of rotary shouldered connection thread work regulation, as well as a round thread casing, buttress sleeve Pipe, tubing, line pipe thread gauge calibration workload.

2. References

This specification refers to the following documents.

JJF 1071-2010 National Calibration Specifications writing rules GB/T 22512.2 petroleum and natural gas industries - Rotary drilling equipment - Part 2. rotary shouldered thread even Then processing and measurement APISPEC5B casing, tubing and line pipe threads processing, measurement and test specification (Specification for Threading, Gauging, and Thread Inspection of Casing, Tubing, and Line Pipe Threads) for dated references, only the dated edition applies to this specification; undated reference documents Member, the latest edition (including any amendments) applies to this specification.

3 Terms

This specification related terms see GB/T 22512.2.

3.1 truncated thread height truncated in the direction perpendicular to the axis of the thread from the thread type from the original vertices of the triangle to the top of the thread profile.

4 Overview

Oil thread (OCTG) are OCTG (oil country tubular goods) threads for short.

According to the close relationship between the transfer from the threaded proofread gauge for determining thread Work Gauge interchange standoff value, thread Direct to check product compliance workload threads. Thread Work Gauge work includes a threaded plug gauge and thread ring gauges work. screw Working within the grain product inspection plug thread, ring gauge to check the work product external threads.

Depending on the form of thread products, using different thread work rules.

Rotary shouldered threaded connection preferred thread gauge can be divided according to their type of digital type (NC), normal form (REG), consistent eye type (FH) and the inner flat (IF). Press into right-handed and left-handed rotation.

Casing thread gauge thread is divided according to type round thread casing thread gauge (CSG) and buttress casing screw Grain gauge (BCSG).

Pipe thread gauge form of the structure is divided into non-upset tubing thread gauge (TBG) and external upset thread gauge (UPTBG).

Line pipe thread gauge marked. LP.