

Field Inspection and Repairing Procedure of FlushMAX-II and FlushMAX-III

CONFIDENTIAL

1. Pipes should be placed on the inspection table to provide enough space so that that they can be rotated in a full turn for cleaning and inspection.
2. Box and pin protectors shall be removed and each end shall be cleaned thoroughly to remove storage compound and dirt.
 - a) Remove protectors. Should a pipe wrench be used, care must be exercised to ensure that jaws of the wrench do not come in contact with thread.
 - b) Blow out pipe ID (from box to pin) to completely remove dirt and rust.
 - c) Clean connections using one of the following methods:
 - A. A nonmetallic brush and cleaning solvent
 - B. Steam cleaner with water and cleaning solvent
 - C. A rotary non-metallic bristle brush with water jet and cleaning solvents
 - d) Dry the connections and wipe or blow out solvents and water from thread roots.
 - e) Clean thread protectors, replace any damaged ones.
3. Thread inspection
 - 1) Imperfection in the full crest thread length on Pin

Full crest threads shall be free from burrs, tears, cuts, shoulders, dings, galling or any other imperfection which could break the continuity of the thread.

Burrs on the starting thread of pin shall be removed by using a fine file or emery cloth.

Minor scratch, discoloration and minor corrosion pits and step are acceptable provided the surface does not protrude from the original contour of the crest or flanks. Thread found to have such slight imperfection or discoloration may be hand repaired using a fine file or emery cloth.

- 2) Imperfection on the imperfect threads on Pin are acceptable unless it protrude on the flanks. Minor protrusion on the crest is acceptable.

- 3) Minor scratch, discoloration and minor corrosion pits and step are acceptable
Defects which cannot be touched up with emery cloth on the box thread shall be rejected due to difficulty of hand repairing.
- 4) Mash on pin or box
No mash is allowed on pin or box.
- 5) Used tubing - galling or wear
 - a) Check distortion of threads with thread profile gauge (Comb gauge).
 - b) Minor galling may be hand repaired with fine file or emery cloth
4. Inspection of external and internal shoulders
 - 1) Shoulders shall be visually examined.
 - 2) External and internal shoulders shall be free from any imperfection which is protruding from original surface contour of shoulders.
No burrs allowed on entire circumference.
5. Before placing thread protectors back on the pipe ends after visual inspection, remove all dirt and foreign particles from protectors.
All damaged protectors shall be replaced. Threads shall be re-doped with a suitable thread compound.
Ensure that the entire threads is covered with compound.
6. Connection found to be unserviceable should be clearly identified .