Spec 5AC: Restricted Yield Strength Casing and Tubing

TABLE 6.7 TOLERANCES ON DIMENSIONS AND WEIGHTS See Appendix A for Metric Tables

UTSIDE DIAMETER, D: 4 in. and smaller ± 0.031 in. 4½ in. and larger ± 0.75 per cent For upset casing the following tolerances apply to the outside diameter of the pipe body immediately behind the upset for a distance of approximately 5 in. for sizes 5½ in. OD and smaller, and a distance approximately equal to the OD for sizes larger than 5½ in. Measurements shall be made with	WEIGHT: Single lengths+6.5 per cent -3.5 per cent Carload lots1.75 per cent A carload is considered to be a minimum of 40,000 lb. (18144 kg). DRIFT TEST: Each length of casing and tubing shall be tested		
calipers or snap gages. Pipe Size, OD, in. Behind Lo	throughout its entire length with a cylindrical drift mandrel conforming to the requirements listed below. The leading edge of the drift mandrel shall be rounded to permit easy entry into the pipe. The drift		
$ \begin{array}{cccccccccccccccccccccccccccccccccccc$	mandrel shall pass freely through the pipe with a reasonable exerted force equivalent to the weight o the mandrel being used for the test. Pipe shall no be rejected until it has been drift tested when it i		
For 2% in. and larger external-upset tubing the following tolerances shall apply to the outside di- ameter at distance L_a from the end of the pipe. The	free of all foreign matter and properly supported to prevent sagging.		
measurements shall be made with snap-gages or calipers. Changes in diameter between L_a and L_b	Product and Size, in. Product and Size, in. Drift Mandrel Size, in. Length Diam. min.		

shall be smooth and gradual. Pipe body tolerances do not apply for a distance of L_b from the end of the pipe. Pine Size, OD, in Tolerance, in

$\begin{array}{cccccccccccccccccccccccccccccccccccc$	
11/1 = 0.750/100	
4 /2 + /64 - 0.10 /0 D	

INSIDE DIAMETER, d, is governed by the outside diameter and weight tolerances.

UPSET DIMENSIONS:

Tolerances on upset dimensions are given in Tables 6.3, 6.5 and 6.6.

WALL THICKNESS, t.....12.5 per cent

	Drift Mandrel Size, in. Length Diam. min.			
Product and Size, in.	Length	Diam. min.		
Casing':				
8% and smaller	6	d — 1/8		
9% to 13%, incl	12	$d - \frac{5}{32}$		
Tubing ² :				
2% and smaller	42	$d - \frac{3}{32}$		
3½ and larger	42	d — 1/8		

³The minimum diameter of the drift mandrel for extreme-line casing shall be as shown in Col. 16, Table 6.3.

²Integral-joint tubing shall be tested before upsetting with a drift mandrel as shown, and shall also be drift tested at the pin end, after upsetting, with a cylindrical drift mandrel 42 in. in length and $d_{1u} - 0.015$ in. in diamotra (area Table 6. Col. 2) eter (see Table 6.6, Col. 8).

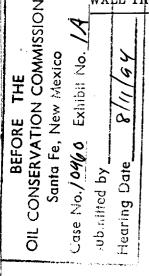


TABLE 6.8
RANGE LENGTHS
All lengths in feet

See Appendix A for Metric Tables

R	ange 1		2	3
CASING				
Total range length, incl		25 25	-34	34 or more
*Range length for 95 per cent or more of Permissible variation, max Permissible length, min		6 18	5 28	6 36
TUBING				
Total range length, incl	20-2	4 28	-32	*******
*Range length for 100 per cent of carload: Permissible variation, max Permissible length, min			2 28	
PUP JOINTS				
Lengths 2, 4, 6, 8, 10, and 12 ft.				

Tolerance — ±3 in.

*Carload tolerances shall not apply to orders of less than a carload shipped from the mill. For any carload of pipe, shipped from the mill to the final destination without transfer or re-moval from the car, the tolerance shall apply to each car. For any order consisting of more than a carload, and shipped from the mill by rail, but not to the final destination in the rail cars loaded at the mill, the carload tolerances shall apply to the total order, but not to the individual carload. carloads.

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