



**RECOMMENDED
PRACTICE
SEAL-LOCK BOSS**

Approved	Initials	Date
Prepared by	RBI	09/26/18
Engineer	SJH	10/10/18
GM QA	GJR	09/28/18
Revision	009	10/11/18

SUBJECT: FIELD RUNNING AND HANDLING PROCEDURES

1.0 SCOPE

- 1.1 This document sets forth Hunting's recommended practice for the field running and handling procedures that should be used in conjunction with the **SEAL-LOCK BOSS** casing product line.

2.0 REFERENCES

- 2.1 The following documents were used for reference in the preparation of this document:
- 2.1.1 API RP 5C1
 - 2.1.2 API BUL. 5A2

3.0 EQUIPMENT

- 3.1 The following list of equipment should be on location when **SEAL-LOCK BOSS** casing is run:
- 3.1.1 Ample supply of fresh, unopened thread compound.

NOTE: For thread compounds, please refer to Hunting's website to verify the current Recommended Thread Compounds approved by Hunting – Per Connection List.

To access the list, visit www.hunting-intl.com, click on "Connection Technology" and look for the link: "Recommended Thread Compounds approved by Hunting".

- 3.1.2 Thread lubricant applicators #58235 moustache brush recommended or 3" or 4" paint brush with bristles cut to approximately 1" in length.

NOTE: Hunting does not recommend the bottlebrush commonly used for thread lubricant application as the amount of lubricant cannot be adequately controlled.

- 3.1.3 Hunting's field service kit.
- 3.1.4 Appropriate sales data sheet.
- 3.1.5 **VISUAL THREAD INSPECTION**, Ancillary Specification.
- 3.1.6 **STEEL IMPERFECTIONS**, Ancillary Specification.
- 3.1.7 **OPTIONAL** - Torque turn monitoring equipment.
- 3.1.8 **OPTIONAL** - Molybdenum disulfide spray.
- 3.1.9 **OPTIONAL** - WD-40.

4.0 FIELD RUNNING AND HANDLING PROCEDURES

- 4.1 Precaution
- 4.1.1 Tubulars should not be stacked higher than five tiers at the rig. (API RP 5C1).
 - 4.1.2 Layers should be separated by wooden dunnage so that no weight rests on the connections. (API RP 5C1)
 - 4.1.3 Thread protectors should always remain in place when moving or handling tubulars.
 - 4.1.4 If a mixed string is to be run, ensure proper identification to accommodate sequence of running.
 - 4.1.5 Do not use a welding torch to remove thread protectors. A thread protector removal tool is available from Hunting should weather, handling or other conditions make protector removal a difficult or time-consuming procedure.
 - 4.1.6 Avoid rough handling. Do not unload pipe by dropping.
 - 4.1.7 Do not handle more than three joints unless the pipe is packaged or bundled.



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4.1.8 Never use hooks on the ends of pipe. Handle with nylon slings only.

4.2 Preparation

- 4.2.1 Ensure that all necessary running equipment is available and in good condition.
- 4.2.2 Slip type or shoulder elevators of proper size, in good repair and with the setting plate adjusted properly, should be used.
- 4.2.3 Ensure that slips are of the correct size to accommodate the size, weight and length of the tube.
- 4.2.4 Ensure that the safety clamp is the correct size and in serviceable condition.
- 4.2.5 Check for traveling block alignment.
- 4.2.6 Ensure that all accessories are available and in good condition, including cross-overs, handling plugs, float equipment, etc. and if appropriate, that the proper service personnel are present and aware of the procedures.
- 4.2.7 Ensure that an ample supply of thread compound is available. Only fresh, previously unopened containers of compound shall be used.

NOTE: See Section 3.1.1 for recommended thread compounds.

- 4.2.8 A stabbing board or a yoke may be required to offer stability for ease of make-up.
- 4.2.9 Ensure that the power tong snub line is at 90° and level with the tong.

NOTE: Ensure that an accurate torque monitoring device (Martin-Decker torque gauge) is available, the load cell is for use in the required torque range, and the load cell has been calibrated within the past four (4) months.

4.3 Cleaning and Thread Inspection

All tubular connections shall be thoroughly cleaned and dried at the rig prior to running inspection.

- 4.3.1 Immediately before running, remove protectors from both the field end and the coupling. Clean each connection and protector thoroughly.
- 4.3.2 All compounds that have been applied to the connections and protectors are to be wiped off or washed off using solvent and a non-metallic bristle brush. Wipe out or blow out the solvent from the connection or protector after washing.

NOTE: Care must be taken to ensure that the cleaning process does not cause environmental pollution.

- 4.3.3 Check and clean the inside of the tubulars to eliminate any foreign material that may fall into the box while stabbing. If compressed air is available, air blast from box to pin.

NOTE: Ensure that there are no bristles left on the threads from cleaning.

- 4.3.4 Drift the pipe and accessory equipment with a clean, properly sized mandrel. Drift shall be performed box to pin, being careful not to damage the box torque shoulder or threads when placing the mandrel in the joint.
- 4.3.5 Inspect the threaded connections using Hunting's Ancillary Specifications titled **VISUAL THREAD INSPECTION** and **STEEL IMPERFECTIONS**.



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NOTE: Repair as required by VISUAL THREAD INSPECTION and/or STEEL IMPERFECTION ANCILLARY SPECIFICATIONS.

- 4.3.6 If any joint shows obvious ovality, it should not be run.
- 4.3.7 Never leave the threads exposed for longer than two hours without corrosion protection. If the connection is cleaned more than two hours but less than twelve hours before the joint is run, a light oil should be used to prevent corrosion. If it will be more than twelve hours until a joint is to be run, reapply thread compound and clean thread protectors.

4.4 Running

- 4.4.1 Handling plugs or thread protectors must be in place whenever tubulars are moved.
- 4.4.2 Joints should be moved to the V-door via a pick-up machine. If a pick-up machine is unavailable, joints should be moved to the V-door by slings or a pick-up line attached to the box end.
- 4.4.3 Elevators or pick-up line with or without pick-up elevators may be used to lift the joint up in the derrick.

NOTE: Single joint elevators are recommended for 13 3/8" and larger OD's to facilitate stabbing.

- 4.4.4 If CRT (casing running tool) is to be used, remove the thread protector and replace it with a Hunting internal tool guide / handling plug.

NOTE: When running with a CRT (Casing Running Tool) no dump valve shall be used and a 5 to 8 second torque shall be applied.

NOTE: When running with a CRT (Casing Running Tool) Hunting recommends the use of a compensator.

NOTE: Hunting connections are not interchangeable with any other connections in the industry. The use of an internal tool guide / handling plug different than the ones designed by Hunting Energy Services for specific connections or applications may result in property damage, injury, or death. Hunting will not be held accountable nor accept any liability if the proper equipment is not utilized for its intended purpose.

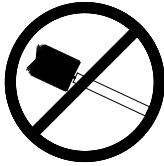
- 4.4.5 Clean and re-inspect each connection as it hangs in the derrick. Remove any thread compound, solvent or moisture remaining on the connection after removing the protector.
- 4.4.6 After the connection is clean and dry, apply a light, even coating of the thread compound to the pin and coupling connectors.



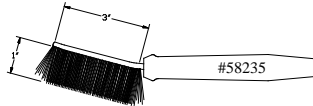
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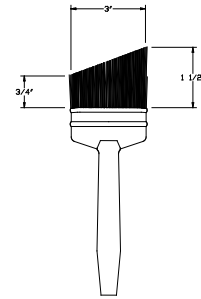
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Do Not Use
Bottle Brush



Preferred Moustache Brush #58235



Alternate Acceptable
Modified Paint Brush

NOTE: A light, even coating of thread compound is defined as all thread surfaces, root and crest, and pin face/torque shoulder covered with an even coat of thread compound. However, the thread form should remain clearly visible.

- 4.4.7 Use an alignment yoke to assist make-up.
- 4.4.8 Stab the pin connector into the box connector.
- 4.4.9 If the connection is mis-stabbed, pick up the joint, clean the pin and the box and reinspect.

4.5 Make-up

- 4.5.1 Optional Torque-Turn Equipment.
A torque turn/time or torque/turn monitoring system may be utilized. Monitoring equipment should be capable of resolving torque to 1/100th of a turn increments as a minimum but equipment capable of resolving torque to 1/1000th of a turn encoder should be utilized when available. An enhanced computer display should be part of the torque-turn monitoring equipment and utilized to monitor make up. The monitoring equipment should be capable of dumping during the make-up by either the computer technician or when maximum parameters are reached. As the torque enters the acceptable window, the technician should be able to depress a function key to manually terminate the make-up. The system should be capable of automatic dumping as input parameters are met. The load cells used with the torque monitoring equipment should be calibrated every four months, traceable to the appropriate national standard.
- 4.5.2 Back-up tongs should be placed below the coupling. Use back-up tongs for the first 10 joints or until sufficient weight is generated in the slips to prevent the entire string from rotating.

NOTE: Power and backup tong dies shall be clean and not worn down and shall not leave marks exceeding 0.015" in depth. Excessive marks or sharp bottomed marks must be removed. Removal may be by filing only; grinding is prohibited.

- 4.5.3 Position the power tongs approximately 7" above the coupling.

NOTE: Do not allow the stabber to rock the tube during make-up.



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- 4.5.4 Begin make-up of the connection with the power tongs in high gear not to exceed 24 RPM. Just prior to torque build-up, approximately 3 – 4 turns, shift into low gear and continue the final make-up at 3 – 9 RPM. Do not rotate into the shoulder in high gear. Check to ensure that the power tong lead line is level and at a 90° angle to the power tongs. If not, raise or lower and shorten or lengthen the lead line as required.

TARGET MAKE-UP RPM

7 5/8"	-	9.0 RPM	11 7/8"	-	5.0 RPM
8 5/8"	-	8.0 RPM	13 3/8"	-	5.0 RPM
9 5/8"	-	7.0 RPM	13 5/8"	-	4.0 RPM
9 3/4"	-	7.0 RPM	14"	-	5.0 RPM
10 3/4"	-	6.5 RPM	16"	-	4.0 RPM
11 3/4"	-	6.0 RPM	18 5/8"	-	3.5 RPM
			20"	-	3.0 RPM

NOTE: If shoulder torques are high or low, adjust the thread compound application to give good make up torque curves. For high torque, apply more compound. For very high torque, apply Molybdenum disulfide to both pin and box connectors prior to the application of the thread compound.

NOTE: Hunting running specifications state that the connection must shoulder prior to reaching maximum assembly torque.

NOTE: The normal shoulder window is based on dimensional tolerances only. Other factors affecting shoulder torque are texture of phosphate coating, type of thread lubricant, make-up speeds, temperature, etc.

NOTE: The mill make-up should not move appreciably during field make-up. However, a small amount of rotation or less than 1/4 turn is acceptable.

- 4.5.5 If the optional torque/turn monitoring equipment is used a make-up torque/turn graph should be generated for every connection.

- 4.5.6 Lower the elevators over the pipe after make-up is complete, not during make-up.

- 4.5.7 In the event torque/turn or torque turn/time equipment is used at the rig site, the following procedure should be used to set acceptance criteria:

- Prior to the job, the operating company representative should review the Hunting sales data sheet for this connection. Shoulder torque acceptance limits should be in the range shown on Hunting's optimum torque/turn graph.
- Those connections falling outside the acceptable shoulder torque values should be broken out and checked for damage. If no damage is found, the connection may be made-up again. Adjust doping procedures as suggested in Section 4.5.4 **NOTE** to achieve higher or lower shouldering torque as necessary.
- A torque curve showing a small wave shall be acceptable. However, the connection with a wave in the torque curve exceeding the shouldering torque shall be broken out



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and visually inspected. If no damage is found, the connection may be made-up again.

- d) Final torque in excess of the maximum acceptable final torque or less than the minimum acceptable final torque should be broken out and visually inspected. If no damage is found, the connection may be made-up again.

4.6 Pulling

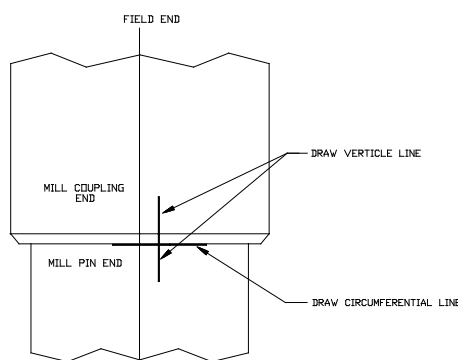
4.6.1 Preparation

- a) Slip type elevators are required.
- b) Use an alignment yoke and weight compensator when pulling casing.
- c) Use power tongs with acceptable torque read-out and back-up tongs.
- d) A wooden platform must be used for standing back tubulars. (Refer to API 5C1)
- e) Clean thread protectors should be available prior to laying down or standing back. As each connection is broken out, protectors shall be installed on each pin.

4.6.2 Breaking Out

- a) Use power tongs with torque adjustment adequate for break out without damaging pipe. When coming out of hole, the back-up tong should be placed on the coupling (below centerline) to assure that the pipe joint breaks out at the top of the coupling. Pipe wrenches or chain tongs shall not be used as back-ups.

NOTE: Prior to break-out, using an ink paint marker, draw a vertical line from the mill make-up side of the coupling onto the mill end tube body. Also draw a line circumferential on the tube body, either side of the vertical line even with the coupling face. If the mill make-up moves over 1/4 turn during break-out, use these marks to reestablish the mill make-up position.



- b) Break out the connection at a speed less than 10 rpm.
- c) After breaking loose, rotate by hand with the aid of a strap wrench. The connection will be disengaged and ready for separation in approximately 6 turns from the power tight position.

NOTE: Do not spin after the connection has “popped.” This can and will cause thread damage and/or galling.

- d) If excessive torque is noted, rotation should be stopped until cause is determined.



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- e) Great care should be exercised to disengage all of the threads before lifting the casing out of the coupling. Do not jump out of the coupling.
- 4.6.3 Standing Back
 - a) Tubulars should be set on a firm wooden platform when stood back in the derrick.
 - b) Protect threads from dirt or damage when the tubulars are out of the hole. Thread protectors should be installed on the pin members when standing back and may be required in the coupling when conditions warrant.
- 4.6.4 Re-Running
 - a) Clean connection members fully and inspect for damage.
 - b) Field repair any small protrusion on threads.
 - c) Re-run as per 4.4 and 4.5.
- 4.6.5 Laying Down
 - a) Clean protectors shall be placed on the tubulars before they are laid down.
 - b) If tubulars are stored or re-used, remove the protectors after laying down, clean and inspect connections. Coat all exposed threads with water displacing oil (WD-40) followed by Kendex or other acceptable storage compound and install clean thread protectors.

5.0 RUNNING PROCEDURE FOR ACCESSORIES MADE UP USING THREAD LOCKING COMPOUND / LUBRICANT

- 5.1 Using steam, soap and hot water, or safety solvent, remove all thread storage or running compound from both pin and box connectors.
- 5.2 Ensure that the thread and sealing surfaces are clean, dry, and free of oil, grease, or residues.
- 5.3 On thread sealing connections, apply the Hunting recommended thread compound on the first three (3) thread of the pin and last three (3) threads of the box (area of the perfect threads engagement).
- 5.4 Just prior to make up, the thread locking lubricant shall only be applied on the pin threads (not on the box), on the area that has not been covered by the approved thread compound.
- 5.5 When making up accessories like float equipment, hangers, thick wall accessories, and others, shoulder torques might be higher than normal due to relationship of the friction factors of the thread locking lubricant in comparison with the API Modified thread compounds and the wall thickness.
- 5.6 The make up torque of the accessories should be aimed to the maximum recommended torque. Therefore, if necessary, the published torque may be exceeded but in any case shall not exceed 80% of the published minimum yield torque.