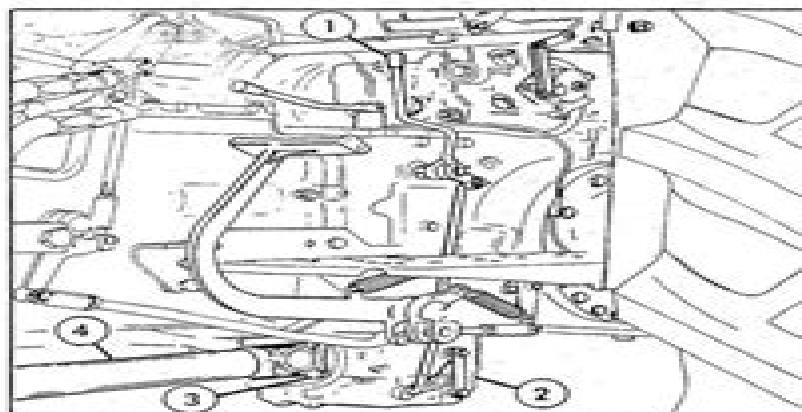


**FIG. B.X/19 REMOVE SHAFT**

1. Snap ring; 2. Cover



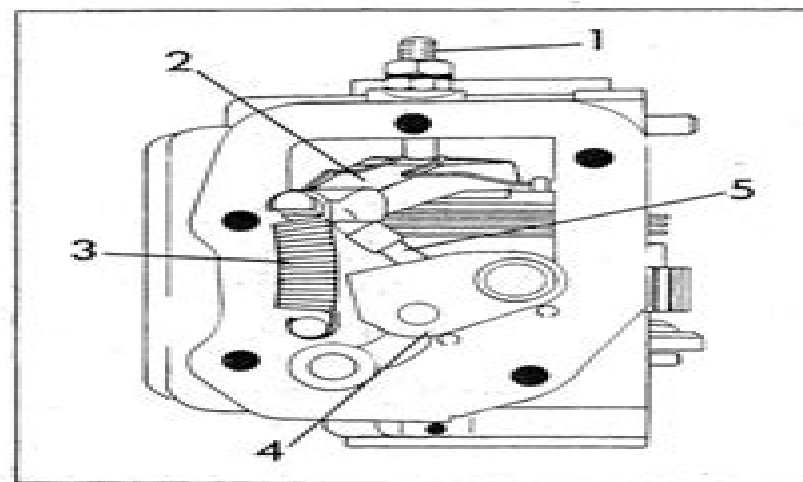
**FIG. B.X/20 REDUCTION GEARBOX INSTALLED**  
1. Control lever, shift forward to engage, rearward, disengage; 2. Reduction gearbox; 3. Cardan shaft screws; 4. Cardan shaft

Expand external snap ring and slide along shaft toward the rear of case. Make certain snap ring is out of groove and up on spline. Slide deflector up on shaft toward rear of case (Fig. B.X/22).

Using a drift, drive the drive shaft out of the casing. Remove the gear with brake disc, deflector, snap ring, brake disc and front brake plate.

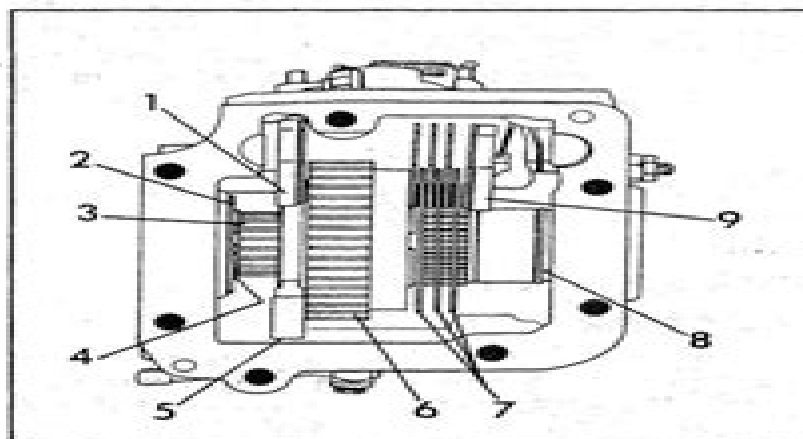
Disconnect spring and remove brake fork, and cam assembly. Remove shifting arm retainer, detent ball and spring. Drive roll pin from detent shift arm and remove shaft (Fig. B.X/21).

If necessary, remove front bearing by pressing toward the rear of the case. Remove the snap ring and press the seal out of the front of the case. Press the rear bearing into the case to



**FIG. B.X/21 L.H. REDUCTION GEARBOX**

1. Brake adjustment screw; 2. Brake fork; 3. Spring; 4. Brake cam; 5. Push rod



**FIG. B.X/22 TOP VIEW, REDUCTION GEARBOX**  
1. Front plate; 2. Deflector; 3. Sliding sleeve; 4. Snap ring; 5. Shifting pad; 6. Gear; 7. Friction disc; 8. Bevel ring

#### INSPECTION

Inspect front and rear bearings. Check front seal, cover O-ring, and replace if necessary. Check thickness of brake liner and brake disc. Brake liner should be 0.155 in. to 0.160 in. (3.930 to 4.070 mm) thick. Brake disc should be 0.98 in. to 0.104 in. (2.485 to 2.650 mm) thick. Replace if necessary. Check drive shaft, drive gear and engaging sleeve for wear.

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features sizes 4 ½ 16 enhanced internal flow low hoop stresses on coupling thanks to tighter thread tolerances 20 bevel for smooth horizontal installation enhanced structural capacity same as pipe body

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btc 215 90 263 52 15 82 8 5 8 stc 244 48 196 85 16 23 8 5 8 ltc 244 48 254 00 21 67 8 5 8 btc 244 48 269 88 20 86 9 5 8 stc 269 88 196 85 18 03 9 5 8 ltc 269 88 266 70 25 45 9 5 8 btc 269 88 269 88 23 16 10 3 4 stc 298 45 203 20 20 78 10 3 4 btc 298 45 269 88 25 74 11 3 4 stc 323 85 203 20 22 64 11 3 4

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the btc thread has higher joint and bending strengths than ltc or stc as a result this thread is often used in deeper wells

where higher hook loads are experienced thread compound must also be used to obtain a seal with btc btc is also run in horizontal wells where doglegs can cause high bending loads on larger casings

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1 to avoid cross threading stab pipe in a smooth controlled fashion ensuring the pipe is vertical when doing so continue to support and stabilise the pipe throughout the stabbing and make up operation 2 upon commencement of initial rotation use low rpm 5 rpm or below in order to ensure the pipe has not cross threaded during stabbing 3

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btc has a square thread with a flat root and crest a runout design and five buttress threads per inch each thread type is suited for a specific well condition stc is a good choice for shorter length casing applications that do not involve high axial loads or bending

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the two steps are identified as 1 the 75 percent shoulder width method 2 the mismatched outside diameter method the two methods are fully described in annex i 6 2 3 other considerations table 3 table a 3 have bevel diameters that cover a range from a suggested minimum od to a maximum od the tables also contain a reference id

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api compatibility the connection s buttress thread profile makes it fully compatible with standard api buttress connections by being api compatible in both pin and box operators can use standard api accessories and draw on a wide range of threading and repair shops providing flexibility and efficiency

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mass t c wall thickness inside diameter drift diameter calculated mass c plain end mass gain or loss due to end finishing lb  
round thread buttress thread 1 2 00 d in lb ft t in d in in lb ft short long rc scc

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inspection inspection criteria for all api connections is as outlined in api rp 5a5 ensure the complete thread area has no tears  
gouges or raised metal black crested threads within the complete thread area must not exceed 25 of the circumference of  
two 2 threads complete thread length is indicated in api rp 5b1

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api couplings and threads must comply with c 32 and c 33 or e 32 and e 33 below are two common api coupling dimensions  
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coupling dimensions eue tubing coupling other requirements in api 5ct standard 1 appearance quality

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