



VALLOUREC & MANNESMANN TUBES
OCTG Division – R&D Premium Connections

VAM Technical Notes

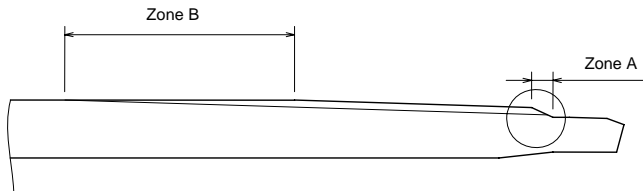
Recommended practice for burrs acceptance on VAM products



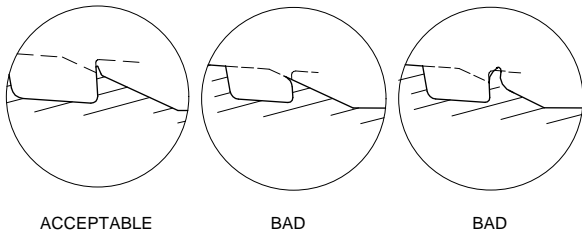
Burrs are permitted, if they don't affect the integrity of the product. A visual examination shall be conducted to determine the quality of machining.

FIRST STARTING THREAD ON PIN END (zone A)

Deburring method



Thread burrs are tolerated on the surface of the entrance bevel



In the case of severe burrs, it is necessary to reduce them, taking great care not to fold them into the thread form, where they would be more dangerous.

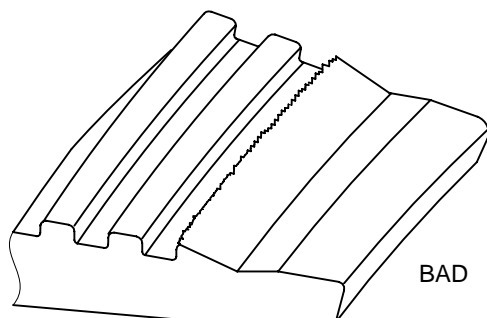
A small file or a grinding stone or a buffing wheel will be used for minor repairs.

Care should be exercised not to damage the seal area during the repair.

Check that there are no burrs in contact with the thread flanks after repair.

The featheredge created by the chamfer should be strong enough to avoid possible deformation and folding into the thread form where it may cause galling.

Severe burrs and thin edges shall be removed prior to gauging.



Clipping method

The pin chamfered starting thread can be cut in the mill to prevent burrs.

IMPERFECT THREADS ON PIN END (zone B)

Burrs on imperfect thread are tolerated within zone B, too severe burrs have to be removed using a small file or a flapper wheel or a grinding buffing wheel.

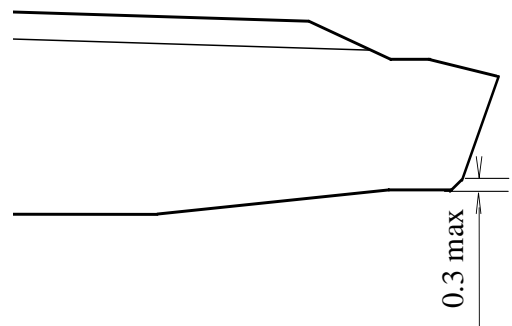
Special care must be taken to ensure that any burr is not folded back into the thread form. After this operation a careful check has to be carried out to ensure that no burrs are in contact with the thread flanks.

PERFECT THREADS

Burrs are not permissible in the perfect threads. They have to be removed using a small file, a flapper wheel or a buffing wheel.

COUNTER BORE D2 area

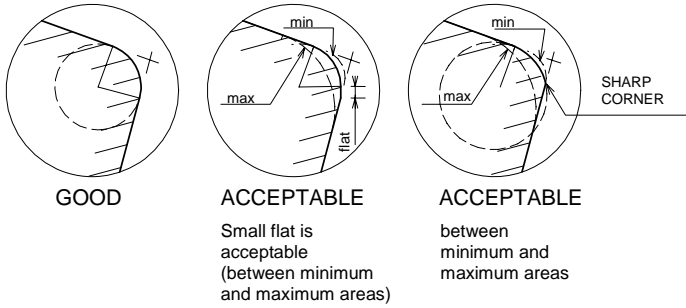
No burrs or smooth burrs tangent to shoulder, If burrs exist or cuttings are still attached to the machine surface, remove them with a file. Product in mill may be manufactured with a chamfer of 0.3 mm max. for burr removing.



TRANSITION ZONE BETWEEN SEAL & SHOULDER ON PIN END

Applicable for NEW VAM casing, VAM ACE, VAM HW ST and VAM TOP, VAM TOP HT and VAM TOP HC connections.

The radius shall be tangent to the seal side. It can be slightly secant to the shoulder side.

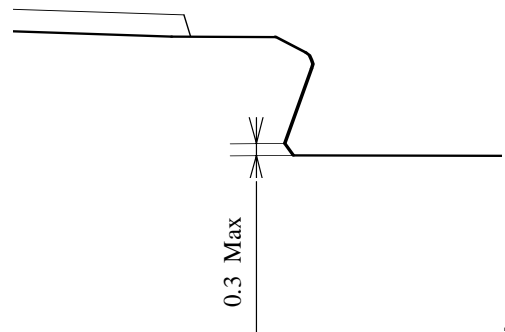


TRANSITION ZONE BETWEEN SEAL & CYLINDRICAL PORTION ON BOX END

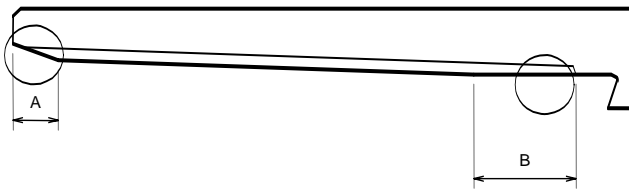
This radius should be free of any sharp angle, asperities and scratches. It should be round. No tool mark is allowed in this radius area.

COUNTER BORE D1 area

No burrs or smooth burrs tangent to shoulder, If burrs exist or cuttings are still attached to the machine surface, remove them with a file. Product in mill may be manufactured with a chamfer of 0.3 mm max. for burr removing.



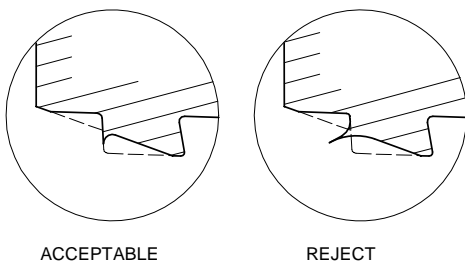
BOX THREADS



No burrs accepted on the perfect thread area, burrs are tolerated only, on the surface of A & B.

In cases of severe burrs, it is necessary to remove or at least to dress them. Special care must be taken to ensure that any burr is not folded back into the thread form where they would be more dangerous.

Detail A



Detail B

