



CUBEX Limited

1218 Redonda Street
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Tel (204) 694-5505
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Quality Control

Drill Pipe Thread Gage Technical Instruction

1. Introduction

1.1 To establish a standard procedure for the use of all drill pipe thread gages.

2. Scope

2.1 To establish a consistent procedure for checking driveshafts, drill pipe and saver-subs in the field.

3. Responsibility

3.1 The Mine Maintenance Department is responsible for the implementation of this Technical Instruction in the field.

4. Reference Documents

4.1 Cubex Ltd. Drill pipe thread gage technical instruction CTI 3.

5. Materials Required

5.1 Cleaning solution

5.2 Hard Arkansas stone or suitable file

5.3 Calibrated Thread Gage for appropriate size Cubex thread

6. Cleaning Precautions

6.1 Ensure that the driveshaft or drill pipe threads that are to be inspected are free of all dirt and lubricants.

6.2 Use the hard Arkansas Stone or file to remove all burrs or nicks from the threads.

7. Tolerances

7.1 New standoff for driveshafts and drill pipe is 0.230"-0.250".



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8. Technical Instruction

- 8.1 Visually examine driveshaft/drill pipe and gage for obvious damage or other signs of mishandling or wear that may affect the accuracy.
- 8.2 Clean faces and thread with lint free cloth, dampened with cleaning solution.
- 8.3 Insert thread gage in driveshaft/drill pipe finger tight.
- 8.4 If the face of the flange on the gage mates with the face of the item being inspected, the item is worn past it's service life and should be discarded.
- 8.5 Remove thread gage from driveshaft/drill pipe if unable to remove gage easily gently tap gage on end of handle and the gage should rotate easily.

9. Gage Correction

- 9.1 Any question regarding gage calibration contact Cubex Ltd Quality Control. There are no customer adjustments on the gage.
- 9.2 It is suggested that a 6 month calibration cycle is recommend for these items pending usage/wear this can be a adjusted on a user basis.

10. References

- 10.1 Cubex Ltd Master thread gage CG-018
- 10.2 Cubex Ltd. Quality Documentation *Quality Work Instruction IQC-1 Instruction for Inspection.*

If there is any questions regarding this Technical Instruction please contact Cubex Ltd. Quality Control @ 204-694-5505