

# Cold Working Thread Roots with CNC Lathes for Rotary Shouldered Connections

API TECHNICAL REPORT 7CR  
FIRST EDITION, JANUARY 2020



AMERICAN PETROLEUM INSTITUTE

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# Contents

	Page
1 Scope .....	1
2 Normative References .....	1
3 Terms and Definitions .....	1
4 Roll Radius and Insert Radius .....	4
4.1 Roll Radius Equals Insert Radius .....	4
4.3 Historical Roll Radius Information .....	5
5 Cold Working Tooling and Roller Designs .....	6
5.1 General .....	6
5.2 Spring Tooling Designs .....	6
5.3 Hydraulic Piston Designs .....	6
5.4 Roller Designs .....	8
6 CNC Machine Process Control .....	10
6.1 General .....	10
6.2 Coolant .....	11
6.3 Work Holding .....	11
6.4 Burrs .....	11
6.5 Machine Controls .....	12
6.6 Why to Time the Tools .....	15
7 Pin Threads to be Cold Worked and Machine Tool Paths Setup .....	15
7.1 Thread Rolling Start and Stop Locations from Part Face of the Pin .....	15
7.2 Timing the Pin Tools .....	16
7.3 Qualified Tool Location .....	16
7.4 Sample G-code Program .....	17
8 Box Threads to Be Cold Worked and Machine Tool Paths Setup .....	17
8.1 Location .....	17
8.2 Timing the Box Tools .....	18
8.3 Modified Bore Back Box Connections .....	18
8.4 Qualified Tool Location .....	18
8.5 Complete G-code Program .....	19
9 Product Thread Height Inspection .....	19
9.1 Thread Height .....	19
9.2 Inspection Process .....	20
10 Marking .....	21
Annex A (informative) Historical Information on Roll Radius .....	22
Annex B (informative) CNC Machine G32 Code Reference Samples .....	24
Annex C (informative) CW Tool Alignment .....	28
Annex D (informative) CW Flank Angle Deformation .....	29

## Contents

	Page
Annex E (informative) Roll Inspection and Wear Patterns .....	33
Bibliography.....	37

## Figures

<b>1</b>	Roll Radius Equals Insert Radii (V-038 Product Thread) .....	4
<b>2</b>	Roll Radius Larger than Insert Radii (V-038 Product Thread).....	5
<b>3</b>	Box/Pin Tooling Leaf Spring Design .....	6
<b>4</b>	Box/Pin Tooling Hydraulic Oil Design .....	7
<b>5</b>	Box/Pin Hydraulic Tooling Design.....	7
<b>6</b>	Thread Roll Designs with +5° Positive and 0° Symmetrical to Thread Axis .....	9
<b>7</b>	Overlay Comparison Chart for Form Alignment and Concentricity Inspection .....	10
<b>8</b>	Examples of Threads Rolled after Bluing for Roller Path .....	11
<b>9</b>	Burr or Stringer Created by Threading Tool.....	12
<b>10</b>	G92 Thread Cut Turning Cycle and G76 Thread Cutting Cycle (Multiple Pass) .....	13
<b>11</b>	G32 Constant Lead Thread Cutting Path .....	14
<b>12</b>	Damaged Thread by Not Using G32 Programming.....	15
<b>13</b>	Pin Thread Area to be CW Showing “x” and “z” axis for Programing and Roller.....	16
<b>14</b>	Threading Tool being Qualified Off the Part Face .....	16
<b>15</b>	Rolling Tool being Qualified Off the Part Face.....	17
<b>16</b>	Box Thread Area to be CW Showing “x” and “z” Axis for Programing and Roller.....	18
<b>17</b>	Threading Tool Being Qualified Off the Part Face .....	19
<b>18</b>	Historical Thread Roll Radius and Hydraulic Gauge Pressures .....	19
<b>19</b>	External Thread Height Gauge Measuring Deformation after CW Rolling .....	21
<b>20</b>	Internal Thread Height Gauge Measuring Deformation after CW Rolling .....	21
<b>B.1</b>	G76 and G92 Rapid Tool Movement into the Thread .....	24
<b>B.2</b>	G32 in Lead Tool Movement into the Thread .....	25
<b>B.3</b>	G32 Threading Cycle.....	25
<b>C.1</b>	Teaching the Roll Tool .....	28
<b>C.2</b>	Different Teach Tools .....	28
<b>C.3</b>	Different Teach Tool .....	28
<b>D.1</b>	50° and 55° 0.002 in. Change in Depth.....	30
<b>D.2</b>	50° and 55° 0.004 in. Change in Depth.....	31
<b>D.3</b>	50° and 55° 0.005 in. Change in Depth.....	32
<b>E.1</b>	Galling on Roller Flank .....	33
<b>E.2</b>	Radial Wear.....	34
<b>E.3</b>	Radial Galling .....	34
<b>E.4</b>	Radial Flat Wear Caused by Wheel Not Rolling.....	34
<b>E.5</b>	Radial Flat 90° .....	35
<b>E.6</b>	Radial Wear.....	35
<b>E.7</b>	Radial Pits .....	35
<b>E.8</b>	Radial Pitting .....	36
<b>E.9</b>	55 °Flank Wear.....	36

# Contents

Page

## Tables

<b>1</b>	Dimensions and Tolerances for Thread Rolls.....	8
<b>2</b>	50° and 55° Roll Thread Height Change after Cold Root Rolling.....	20
<b>A.1</b>	Historical Thread Roll Radius and Hydraulic Gauge Pressures.....	23
<b>B.1</b>	G32 Code for NC38 Pins.....	26

## Introduction

Users of this technical report should be aware that further or differing requirements may be needed for individual applications. This technical report is not intended to inhibit a vendor from offering, or the purchaser from accepting, alternative equipment or engineering solutions for the individual application. This may be particularly applicable where there is innovative or developing technology. Where an alternative is offered, the vendor should identify any variations from this technical report and provide details.

In API 7-2, the term “cold worked (CW)” is used and not “cold root rolling”. This is done on purpose to be able to use multiple methods (such as shot peening) to deform the thread root. Thus, shot peening is acceptable. For any other method chosen, the thread height shall be gauged and recorded before the cold root rolling is done.

Thread root rolling has been performed on rotary shoulder connections and was first introduced by L.E. Trishman <sup>[2]</sup>. The purpose of CW is to put the thread root into a compressive state by yielding the surface of the thread root, burnish away tooling scratches, and blend the root radius into the lead and stab flanks. In the early days of machining rotary shoulder connections, cutting tools were hand ground to produce the thread form. The shape of the cutting tools was left more to imagination and less to quality control methods. It wasn't until the induction of press carbide in the 1970s that threading inserts were made accurate enough to produce connections on a consistent basis. There are still procedures in effect today that require 1 RPM spindle speeds and 3 to 4 roller passes over the finished machined thread. None of the current procedures have stayed up with the technologies of CNC lathes to date regarding spindle speeds and single pass deformation of the root form. It is not known when the root roller radius was made larger than the threading insert radius, but this could be one reason why it has not been recommended to inspect standoff using ring and plug gauges after cold root rolling. Without procedures on how to align the CW roll to the threading tool paths is another cause of standoff change.

The radius on the CW roller has never been officially defined. Some suppliers use the same radius as the connection thread and others use a larger radius because of non-API requirements. This technical report will show the effects produced by a different root radius on the thread form.

# Cold Working Thread Roots with CNC Lathes for Rotary Shouldered Connections

## 1 Scope

This technical report describes procedures for cold root rolling the thread roots on API 7-2 thread sizes using CNC Lathes (CW/CNC). Cold working can be applied by two methods: 1) cold rolling under pressure with a roller shaped like the thread form or 2) shot peening. Both methods achieve acceptable results, but machine thread root rolling is more controllable.

It is not the intent of this technical report to explain the benefits of thread root rolling, but the manufacturing process and quality control requirements. This technical report will address the best practices (or recommended practices) to cold root roll API 7-2 threads and identification marking.

This technical report will not address cold root rolling using manual lathes (CW/Manual)—a similar process but with different tools used for the pin and box. However, the tools described in this technical report can also be used on manual lathes. The steps to position the CW roll into the thread and the paths the tools move can vary between CNC machines controls.

## 2 Normative References

This technical report contains no normative references. For a list of documents and articles associated with API TR 7CR, refer to the bibliography.

## 3 Terms and Definitions

For the purposes of this technical report, the following terms, definitions, and abbreviations apply.

### 3.1

#### **cold working**

#### **CW**

Plastic deformation of the connection surface at a temperature low enough to induce strain hardening.

### 3.2

#### **deburr**

Removal of burrs or stringers created by the threading tool.

### 3.3

#### **following error**

The difference between where the “z” axis is based on feedback from the spindle encoder, and where it should be, based on what the CNC control program has commanded.

### 3.4

#### **full-depth thread**

A full-formed thread in which the thread root contacts on the minor cone of an external thread or contacts on the major cone of an internal thread.

### 3.5

#### **G-code**

The common name for the most widely used numerical control (NC) programming language.