



MAKE-UP TORQUE VALUES

Tubing and Casing

SCOPE OF APPLICATION

This specification gives the standard field make-up torques to be applied on VAM MUST connections.

DOPE APPLICATION

The thread compound has to be applied 100% evenly on thread and seal, equally distributed between pin and box.

DOPE QUANTITY

MINIMUM DOPE QUANTITY FOR MAKE-UP

Nominal O.D.	Dope volume	
(in.)	(cm ³)	(in. ³)
5 1/2	17	1.0
7 5/8	24	1.5
10 3/4	42	2.6

The weight of dope to apply on a connection depends of the specific gravity of the used dope. For example, the make up dope quantity in 7 5/8" will be:

$$46 \times 1.67 = 77\text{g with a dope having a gravity of } 1.67 \text{ g/cm}^3$$
$$\text{and } 2.8 \times 1.00 = 2.8 \text{ oz with a dope having a gravity of } 1.00 \text{ oz/in}^3$$



Make-up Torques

SIZE (OD)	NOMINAL WEIGHT	WALL THICKNESS	75-80-85 ksi			90-95-100 ksi		
			min.	opti.	max.	min.	opti.	max.
in. mm.	ft.lb.	in. mm.	ft.lb. N.m.					
5 1/2"	32.00	0.612	8100	9000	9900	9150	10150	11150
		15.54	11000	12200	13400	12400	13800	15200
7 5/8"	55.30	0.750	14900	16600	18300	17280	19200	21120
		19.05	20300	22600	14900	23400	26000	28600
	59.20	0.812	16650	18450	20250	18270	20300	22330
	109.00	20.62	22500	25000	27500	24800	27500	30300
		1.033	31500	35000	38500	31500	35000	38500
		26.24	42700	47500	52300	42800	47500	52300



Make-up Torques

SIZE (OD)	NOMINAL WEIGHT	WALL THICKNESS	105-110-115 ksi			120-125-130 ksi		
			min.	opti.	max.	min.	opti.	max.
in.	ft.lb.	in. mm.	ft.lb. N.m.					
5 1/2"	32.00	0.612	10400	11600	12800	11700	13000	14300
		15.54	14100	15700	17300	15840	17600	19360
7 5/8"	55.30	0.750	19900	22100	24300	20850	23150	25450
		19.05	26900	29900	32900	28300	31400	34500
	59.20	0.812	20850	23150	25450	22800	25320	27900
	109.00	20.62	28300	31400	34500	30900	34300	37700
		1.033	31500	35000	38500	31500	35000	38500
		26.24	42700	47500	52300	42700	47500	52300



Make-up Torques

SIZE (OD)	NOMINAL AL	WALL THICK	135-140-145 ksi		
			min.	opti.	max.
in.	ft.lb.	in. mm.	ft.lb. N.m.		
7 5/8"	55.30	0.750	23150	25700	28250
		19.05	31300	34800	38300
	59.20	0.812	25050	27850	30650
	109.00	20.62	34000	37800	41600
		1.033	31500	35000	38500
		26.24	42700	47500	52300