VAM TOP KS and Derivatives Products General Instructions
Assembly requirements and recommendations

The following specifications are applicable for both mill and field.

Thread compound

The table below gives the allowed thread compound to use in the mill and in the field per connection and material.

Connection	Carbon	13% Cr	Super 13% Cr	CRA
VAM TOP-KS 9 5/8” 43.5#	API Dope	API Dope		
VAM TOP-KS 9 5/8” 47#	API Dope	API Dope		
VAM TOP KS 9 5/8" 53.5#	API Dope	API Dope		
VAM TOP KS CW 9 5/8" 53.5#	Clean well Mercasol 633 SR			
VAM TOP-KS 10 ¾” 55.5#	API Dope	API Dope		
VAM TOP-KS 10 ¾” 60.7#	API Dope	API Dope	API Dope	
VAM TOP-KS 10 ¾” 65.7#	API Dope	API Dope		
VAM TOP-KS 10 ¾” 71.10#	API Dope			
VAM TOP ND 9 5/8" 53.5#			API Dope	
VAM TOP NA 13 5/8" 88.2#	OCR 325 AG			
VAM TOP-NE 9 5/8" 43.50#	API Dope			API Dope
VAM TOP-NA 9 7/8" 66.90#	API Dope			
VAM TOP-KE 13 3/8" 72.00#	API Dope	API Dope		

Other combinations are not available. In case of specific need, please contact VAM Services

Doping

Thread compound quantities for make-up are the same as for VAM TOP.

The recommended thread compound repartition is 2/3 on box end and 1/3 on pin. Thread compound shall be applied evenly in order to get a uniform coating on all parts of the connection.

The recommended thread compound quantities are indicated in the following table. The given values are to be considered as minimum ones.

Recommended quantity of thread compound for the assembly of VAM TOP KS and *derivatives products* listed §1

Nominal OD	Thread compound volume (cm^3)
9 5/8" –9 7/8"	41
10 3/4"	46
13 3/8"	67
13 5/8"	68

To determine the quantity to apply in terms of weight, it is needed the specific gravity of the thread compound. It is given in the table below the specific gravity of MERCASOL 633 SR, as well as OCR 325 AG and standard API thread compound.

Specific gravity of some thread compounds

Thread compound	Specific Gravity ($g.cm^{-3}$)
MERCASOL 633 SR New Multi Make White	1.10
OCR 325 AG	1.20
Standard API 5A2 or 5A3	1.67

Torque values

The standard torque values of VAM TOP product line are not compatible with these connections. Specific torque values are given in the table of Attachment 1. The indicated values already take into account any friction factors.

The table gives the torque range where the connections can be assembled, that is minimum, optimum and maximum torque values.

Connection	Size O.D.	Nominal Weight	Wall Thickness	Grade 80-85 Ksi			Grades 90-95Ksi			Grade 110 ksi			Grade 125 ksi		
				Min.	Opti.	Max.	Min.	Opti.	Max.	Min.	Opti.	Max.	Min.	Opti.	Max.
	in.	lb/ft	in.	ft.lb			ft.lb			ft.lb			ft.lb		
			mm	Nm			Nm			Nm			Nm		
VAM TOP-KS	**9 5/8**	**43.50**	**0.435**	**17600**	**19600**	**21600**	**18700**	**20800**	**22900**	**19600**	**21800**	**24000**	**20400**	**22700**	**25000**
	244.48		11.05	23900	26600	29300	25400	28200	31000	26600	29600	32600	27700	30800	33900
VAM TOP-KS	**9 5/8**	**47.00**	**0.472**	**20600**	**22900**	**25200**	**21900**	**24300**	**26700**	**23000**	**25500**	**28100**	**23900**	**26600**	**29300**
	244.48		11.99	27900	31000	34100	29600	32900	36200	31100	34600	38100	32500	36100	39700
VAM TOP-KS	**9 5/8**	**53.50**	**0.545**	**27000**	**30000**	**33000**	**28600**	**31750**	**34900**	**30000**	**33300**	**36600**	**31300**	**34800**	**38300**
*see below for special Shell Sakalin	244.48		13.84	36600	40700	44800	38700	43000	47300	40600	45100	49600	42500	47200	52000
VAM TOP-KS Cleanwell	**9 5/8**	**53.50**	**0.545**	**27000**	**30000**	**33000**	**28600**	**31750**	**34900**	**30000**	**33300**	**36600**	**31300**	**34800**	**38300**
	244.48		13.84	36600	40700	44800	38700	43000	47300	40600	45100	49600	42500	47200	52000
VAM TOP-ND	**9 5/8**	**53.50**	**0.545**	**27000**	**30000**	**33000**	**28600**	**31750**	**34900**	**30000**	**33300**	**36600**	**31300**	**34800**	**38300**
	244.48		13.84	36600	40700	44800	38700	43000	47300	40600	45100	49600	42500	47200	52000
VAM TOP-NE	**9 5/8**	**43.50**	**0.435**	**17600**	**19600**	**21600**	**18700**	**20800**	**22900**	**19600**	**21800**	**24000**	**20400**	**22700**	**25000**
	244.48		11.05	23900	26600	29300	25400	28200	31000	26600	29600	32600	27700	30800	33900
VAM TOP-NA	**9 7/8**	**66.90**	**0.668**	**39100**	**43400**	**43400**	**41400**	**46000**	**50600**	**43500**	**48300**	**53100**	**45000**	**50000**	**55000**
	250.83		16.97	52900	58800	64700	56200	62400	68600	59000	65500	72100	61000	67800	74600
VAM TOP-KS	**10 3/4**	**55.50**	**0.495**	**23900**	**26600**	**29300**	**25400**	**28200**	**31000**	**26600**	**29600**	**32600**	**27800**	**30900**	**34000**
	273.05		12.57	32500	36100	39700	34400	38200	42000	36100	40100	44100	37700	41900	46100
VAM TOP-KS	**10 3/4**	**60.70**	**0.545**	**28800**	**32000**	**35200**	**30600**	**34000**	**37400**	**32100**	**35700**	**39300**	**33500**	**37200**	**40900**
	273.05		13.84	39100	43400	47700	41500	46100	50700	43600	48400	53200	45400	50400	55400
VAM TOP-KS	**10 3/4**	**65.70**	**0.595**	**34000**	**37800**	**41600**	**36000**	**40000**	**44000**	**37800**	**42000**	**46200**	**39400**	**43800**	**48200**
	273.05		15.11	46200	51300	56400	48800	54200	59600	51200	56900	62600	53500	59400	65300
VAM TOP-KS	**10 3/4**	**71.10**	**0.65**	**39400**	**43800**	**48200**	**41800**	**46400**	**51000**	**43800**	**48700**	**53600**	**45000**	**50000**	**55000**
	273.05		16.51	53500	59400	65300	56600	62900	69200	59400	66000	72600	61000	67800	74600
VAM TOP-KE	***13 3/8***	***72.00***	***0.514***	***30600***	***34000***	***37400***	***30600***	***34000***	***37400***	***30600***	***34000***	***37400***	***30600***	***34000***	***37400***
	339.73		13.06	41500	46100	50700	41500	46100	50700	41500	46100	50700	41500	46100	50700
VAM TOP-NA	**13 5/8**	**88.20**	**0.625**	**42100**	**46800**	**51500**	**44500**	**49500**	**54500**	**45000**	**50000**	**55000**	**45000**	**50000**	**55000**
	346.08		15.88	57200	63500	69900	60400	67100	73800	61000	67800	74600	61000	67800	74600

Special Shell Sakalin - Without Cleanwell

Connection	Size O.D.	Nominal Weight	Wall Thickness	80 ksi					
				Field				Mill& licensee	
				Tubing + Liner min.	opti	Tubing max.	Liner Max.	min.	max.
	in.	lb/ft	in.	ft.lb.					
	mm		mm	N.m.					
VAM TOP KS	**9 5/8**	**53.50**	**0.545**	**27000**	**30000**	**33000**	**50000**	**47500**	**52500**
	244.48		13.84	36600	40700	44800	67800	64400	71200