



MAKE-UP TORQUE VALUES

DOPE APPLICATION

The thread compound has to be applied 100% on the pin end to be make up.

DOPE QUANTITY

MINIMUM DOPE QUANTITY FOR MAKE-UP

Nominal O.D.	Weight	Dope volume	
		(cm ³)	(in. ³)
(in.)			
7 5/8	51.20	21	1.3
7 5/8	55.30	25	1.5
10 3/4	71.10	21	1.3
10 3/4	73.20	21	1.3
10 3/4	79.20	21	1.3
10 3/4	85.30	21	1.3
10 3/4	100.40	31	1.9
10 3/4	110.20	34	2.1

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 will be:

$$31 * 1.67 = 52g \text{ with a dope having a gravity of } 1.67 \text{ g/cm}^3$$
$$\text{and } 1.9 * 1.00 = 1.9 \text{ oz with a dope having a gravity of } 1.00 \text{ oz/in}^3$$

SIZE (OD)	NOMINAL WEIGHT	WALL THICKNESS	80 ksi			90-95-100 ksi			105-110-115 ksi			120-125-130 ksi			140 ksi		
			min.	opti.	max.	min.	opti.	max.	min.	opti.	max.	min.	opti.	max.	min.	opti.	max.
in.	lb/ft	in.	N.m.														
mm		mm.	ft. lb.														
7 5/8" 193.68	51.20	0.687							27000 30000 33000						27000 30000 33000		
									36500 40600 44700						36500 40600 44700		
10 3/4" 273.05	71.10	0.650				38700 43000 47300			38700 43000 47300			38700 43000 47300			38700 43000 47300		
						52400 58300 64100			52400 58300 64100			52400 58300 64100			52400 58300 64100		
	73.20	0.672				38700 43000 47300			38700 43000 47300			38700 43000 47300			38700 43000 47300		
						52400 58300 64100			52400 58300 64100			52400 58300 64100			52400 58300 64100		
	79.20	0.734				40600 45000 49400			40600 45000 49400			40600 45000 49400			40600 45000 49400		
						55000 61000 67000			55000 61000 67000			55000 61000 67000			55000 61000 67000		
	85.30	0.797				41400 46000 50600			41400 46000 50600			41400 46000 50600			41400 46000 50600		
						56100 62400 68600			56100 62400 68600			56100 62400 68600			56100 62400 68600		
	100.40	0.960				45000 50000 55000			45000 50000 55000			45000 50000 55000			45000 50000 55000		
						60900 67700 74470			60900 67700 74470			60900 67700 74470			60900 67700 74470		
	110.20	1.050				48600 54000 59400			48600 54000 59400			48600 54000 59400			48600 54000 59400		
						65900 73200 80500			65900 73200 80500			65900 73200 80500			65900 73200 80500		
		26.67															

If requested torque values are missing on this TSLI please contact VAM Services.