

# VAM HP

## MINIMUM DOPE QUANTITY FOR MAKE-UP

Nominal O.D.	Weight	Dope volume	
		(in.)	(in. <sup>3</sup> )
10 3/4	71.10	21	1.3
10 3/4	73.20	21	1.3
10 3/4	85.30	21	1.3
10 3/4	100.40	31	1.9

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:

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

### Make-up Torques

SIZE (OD)	NOMINAL WEIGHT	WALL THICKNESS	90-95-100 ksi			105-110-115 ksi		
			min.	opti.	max.	min.	opti.	max.
in. mm	ft.lb.	in. mm.	ft.lb. N.m.					
<b>10 3/4"</b> <i>273.05</i>	<b>71.10</b>	<b>0.650</b>	<b>38700</b>	<b>43000</b>	<b>47300</b>	<b>38700</b>	<b>43000</b>	<b>47300</b>
		<i>16.51</i>	<i>52400</i>	<i>58300</i>	<i>64100</i>	<i>52400</i>	<i>58300</i>	<i>64100</i>
	<b>73.20</b>	<b>0.672</b>	<b>38700</b>	<b>43000</b>	<b>47300</b>	<b>38700</b>	<b>43000</b>	<b>47300</b>
		<i>17.07</i>	<i>52400</i>	<i>58300</i>	<i>64100</i>	<i>52400</i>	<i>58300</i>	<i>64100</i>
	<b>85.30</b>	<b>0.797</b>	<b>41400</b>	<b>46000</b>	<b>50400</b>	<b>41400</b>	<b>46000</b>	<b>50400</b>
		<i>20.24</i>	<i>56100</i>	<i>62400</i>	<i>68600</i>	<i>56100</i>	<i>62400</i>	<i>68600</i>
	<b>100.40</b>	<b>0.960</b>	<b>45000</b>	<b>50000</b>	<b>55000</b>	<b>45000</b>	<b>50000</b>	<b>55000</b>
		<i>24.38</i>	<i>60900</i>	<i>67700</i>	<i>74470</i>	<i>60900</i>	<i>67700</i>	<i>74470</i>

### Make-up Torques

SIZE (OD)	NOMINAL WEIGHT	WALL THICKNESS	120-125-130 ksi		
			min.	opti.	max.
in. mm	ft.lb.	in. mm.	ft.lb. N.m.		
<b>10 3/4"</b> <i>273.05</i>	<b>71.10</b>	<b>0.650</b>	<b>38700</b>	<b>43000</b>	<b>47300</b>
		<i>16.51</i>	<i>52400</i>	<i>58300</i>	<i>64100</i>
	<b>73.20</b>	<b>0.672</b>	<b>38700</b>	<b>43000</b>	<b>47300</b>
		<i>17.07</i>	<i>52400</i>	<i>58300</i>	<i>64100</i>
	<b>85.30</b>	<b>0.797</b>	<b>41400</b>	<b>46000</b>	<b>50400</b>
		<i>20.24</i>	<i>56100</i>	<i>62400</i>	<i>68600</i>
	<b>100.40</b>	<b>0.960</b>	<b>45000</b>	<b>50000</b>	<b>55000</b>
		<i>24.38</i>	<i>60900</i>	<i>67700</i>	<i>74470</i>