



## **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**

<b>Nominal O.D.</b>	<b>Dope volume</b>	
	<b>(in.)</b>	<b>(cm<sup>3</sup>)</b>
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:

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

**VAM MUST** field make-up torque

SIZE (OD)	NOMI- NAL WEIGHT	WALL THICK- NESS	75-80-85 Ksi			90-95-100 ksi		
			min.	opti	max.	min.	opti	max.
in. mm	lb/f	in. mm	ft.lb Nm					
<b>7"5/8</b> 193.68	<b>55.3</b>	<b>0.75</b> 19.05	<b>14900</b>	<b>16600</b>	<b>18300</b>			
	<b>59.2</b>	<b>0.81</b> 20.62	<b>16650</b>	<b>18450</b>	<b>20250</b>			
<b>10"3/4</b> 273.05	<b>109.0</b>	<b>1.03</b> 26.24	<b>31500</b>	<b>35000</b>	<b>38500</b>			

**VAM MUST** field make-up torque

SIZE (OD)	NOMI- NAL WEIGHT	WALL THICK- NESS	105-110-115 Ksi			120-125-130 Ksi		
			min.	opti	max.	min.	opti	max.
in. mm	lb/f	in. mm	ft.lb Nm					
<b>7"5/8</b> 193.68	<b>55.3</b>	<b>0.75</b> 19.05	<b>19900</b>	<b>22100</b>	<b>24300</b>			
	<b>59.2</b>	<b>0.81</b> 20.62	<b>20850</b>	<b>23150</b>	<b>25450</b>			
<b>10"3/4</b> 273.05	<b>109.0</b>	<b>1.03</b> 26.24	<b>31500</b>	<b>35000</b>	<b>38500</b>			