

**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.	Dope volume	
	(in.)	(cm <sup>3</sup> )
5	14	0.9
5 1/2	16	1.0
7	25	1.5

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" will be:

$25 * 1.67 = 42g$  with a dope having a gravity of  $1.67 \text{ g/cm}^3$   
and  $1.5 * 1.00 = 1.5 \text{ oz}$  with a dope having a gravity of  $1.00 \text{ oz/in}^3$

**MAKE UP TORQUES VALUES**

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

**VAM TOP FL-D**

Make-up torques

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/ft	in. mm	ft.lb. N.m.					
5" 127.00	18.00	0.362 9.19	5100 6900	5660 7700	6220 8500	5790 7800	6430 8700	7070 9600
5 1/2" 139.70	17.00	0.304 7.72	4590 6200	5090 6900	5590 7600	5040 6800	5600 7600	6160 8400
	20.00	0.361 9.17	5640 7600	6260 8500	6880 9400	6390 8600	7090 9600	7790 10600
	23.00	0.415 10.54	6420 8700	7130 9700	7840 10700	7290 9900	8100 11000	8910 12100
7" 177.8	29.00	0.408 10.36	9450 12800	10450 14200	11450 15600	10200 13800	11300 15300	12400 16800
	32.00	0.453 11.51	11100 15000	12300 16700	13500 18400	11950 16200	13250 18000	14550 19800

**VAM TOP FL-D**

Make-up torques

SIZE (OD)	NOMI-NAL WEIGHT	WALL THICK-NESS	105-110-115 Ksi		
			min.	opti	max.
in. mm	lb/ft	in. mm	ft.lb. N.m.		
5" 127.00	18.00	0.362 9.19	6420 8700	7130 9700	7840 10700
5 1/2" 139.70	17.00	0.304 7.72	5400 7300	5990 8100	6580 8900
	20.00	0.361 9.17	6790 9200	7540 10200	8290 11200
	23.00	0.415 10.54	8150 11100	9050 12300	9950 13500
7" 177.8	29.00	0.408 10.36	10900 14800	12100 16400	13300 18000
	32.00	0.453 11.51	12800 17400	14200 19300	15600 21200