Table 3.3.8a

Fiberglass Long Form Threads To Remove			
API EUE in	Maximum Number of Threads to Cut Off	Long Form to Short Form Thread Length Difference*	**Note:** In order to take full advantage of the performance of the fiberglass thread, it is good practice to have the metal equipment ordered in long form to match the **fiberglass long form thread.** * Per API 5B 8rd
1.90	6	.500	
2 3/8	5	.625	
2 7/8	6	.625	
3 1/2	6	.750	
4	6	.875	
4 1/2	7	.875	
5 1/2	5	.625	
7	7	.875	
8 5/8	9	1.125	
9 5/8	11	1.375	

Table 3.3.7b Fiberglass thread loss due to Make-Up

Casing and Tubing in	API Thread Specification	Thread Length in	Make-Up Loss in
1.90	EUE 10rd API 5B*	2.36	2.11
2 3/8	EUE 8rd API 5B*	2.94	2.69
2 7/8		3.25	3.00
3 1/2		3.50	3.25
4		4.00	3.75
4 1/2		3.88	3.63
5 1/2	OD 8rd API 5B**	4.75	4.50
6 5/8		4.25	4.00
7		4.88	4.63
8 5/8		4.85	4.60
9 5/8		5.13	4.88

* API Specification Standard 5B Fourteenth Edition, August 1996 - Table 14 (L4 min)
** API Specification Standard 5B Fourteenth Edition, August 1996 - Table 7 (L4 min)

3.5.3 Large Diameter Connection Make-Up (≥5½")

- Gently lower pin into box until contact is felt.
- Rotate initially with a strap wrench.
- Derrick Man should hold the joint alignment.
- Tighten connection with tongs then latch elevators.
- Proper alignment must be maintained to prevent cross-threading or joint seizure. If seizure occurs, back it out, clean it, inspect for damaged threads.
- Re-lubricate and repeat procedure.
- After hand tight, use either a STAR metal friction wrench or a qualified power tong to complete engagement.

3.5.4 Torque Requirements

Table 3.5.4a

Thread Size in	Torque (ft / lbs)			STARtec Lubricant Jts/Gal
	OPT	MIN	MAX	
1.90	125	100	175	100
2 3/8	150	125	225	100
2 7/8	185	150	250	100
3 1/2	225	175	300	68
4	275	225	375	50
4 1/2	300	250	450	50
5 1/2	400	320	560	34
6 5/8	500	400	650	34
7	525	420	735	34
8 5/8	700	475	825	26
9 5/8	630	500	880	26

Note: Monitoring both torque and thread standoff is recommended.

PRODUCT IMAGES