



ISOLATED PRODUCTS

Assembly requirements and recommendations

Thread compound

Standard recommended thread compound for VAM TOP FE is TOTAL TIFORA PG. However, several products happened to have been qualified in the frame of a customer qualification program with a specific thread compound requested by the customer : these products must always be used with that same specific thread compound unless the customer requests TOTAL TIFORA PG.

Recommended quantity of thread compound for the assembly of VAM TOP FE

Nominal OD	Thread compound volume (cm ³)
7"	25
7 5/8"	27
7 3/4"	28
8"	31
8 5/8"	37
9 5/8"	41
9 7/8"	43
10 3/4"	46
11 3/4"	59
11 7/8"	60
13 3/8"	67
13 5/8"	68
14"	70

NB. 8" and 14" dimensions only exist as Isolated Products (see TSLI 983 for more reference).

To determine the quantity to apply in terms of weight, it is needed the specific gravity of the thread compound. It is given in the table below the specific gravity of TOTAL TIFORA PG, as well as BOL PTC and standard API thread compound.

Specific gravity of some thread compounds

Thread compound	Specific Gravity (g.cm ⁻³)
TOTAL TIFORA PG	0.91
BOL PTC	1.10
Standard API 5A2 or 5A3	1.67

BOL PTC and standard API thread compound can be considered as acceptable though less preferred alternatives to TOTAL TIFORA PG. In all cases, it is recommended that the acceptability of the thread compound should be checked with the end user.

The following table gives the resulting corresponding weights for TOTAL TIFORA PG

Nominal OD	Thread compound quantity (g)
7"	23
7 5/8"	25
7 3/4"	26
8"	28
8 5/8"	34
9 5/8"	38
9 7/8"	40
10 3/4"	42
11 3/4"	54
11 7/8"	55
13 3/8"	61
13 5/8"	62
14"	64

Size (OD)	Nominal Weight	Wall Thickness	Product Name	Drawing #	75-80-85 ksi			90-95-100 ksi		
					min.	opti.	max.	min.	opti.	max.
in. mm	lb/ft	in. mm			ft.lb N.m					
7" 177.80	29.00	0.408 10.36	NA	SI-PD 100022 B	8 480 11 490	9 420 12 770	10 360 14 050	9 750 13 210	10 830 14 680	11 910 16 150
	32.00	0.453 9.19	NA	SI-PD 100022 B	10 350 14 030	11 500 15 590	12 650 17 150	12 400 16 810	13 780 18 680	15 160 20 550
8" 203.20	32.00	0.375 9.53	NA	SI-PD 100575 A	15 020 20 370	16 690 22 630	18 360 24 890	16 800 22 780	18 650 25 310	20 540 27 840
9 5/8" 244.48	53.50	0.545 13.84	NB	ST-D 7848 A	N/A			N/A		
	43.50	0.435 11.05	ND	ST-D 7853 A <i>mill side</i> <i>field side</i>	N/A			28 080 38 070	31 200 42 300	34 320 46 530
					N/A			24 160 32 760	26 850 36 400	29 540 40 040
	43.50	0.435 11.05	NF	SI-PD 100398 A	15 110 20 480	16 790 22 760	18 470 25 040	16 510 22 370	18 340 24 860	20 170 27 350
47.00	0.472 11.99	NF	SI-PD 100398 A	18 430 24 990	20 480 27 770	22 530 30 550	20 320 27 550	22 580 30 610	24 840 33 670	
10 3/4" 273.05	65.70	0.595 15.11	NA	SI-PD 100278 A	34 060 46 190	37 850 51 320	41 640 56 450	34 160 46 300	37 950 51 450	41 740 56 600
11 7/8" 301.63	67.80	0.550 13.97	NA	ST-D 7862 B	27 620 37 450	30 690 41 610	33 760 45 770	32 580 44 170	36 200 49 080	39 820 53 990
	71.80	0.582 14.78	NA	ST-D 7862 B	32 580 44 170	36 200 49 080	39 820 53 990	35 780 48 500	39 750 53 890	43 720 59 280
13 3/8" 339.73	72.00	0.514 13.06	NA	ST-D 7849 A	22 900 31 050	25 450 34 500	28 000 37 950	N/A		
	68.00	0.480 12.19	NB	ST-D 7850 B	N/A			N/A		
	72.00	0.514 13.06	NB	ST-D 7850 B	N/A			N/A		
	80.70	0.580 14.73	ND	SI-PD 100041 B	N/A			N/A		
14" 355.60	106.00	0.750 19.05	NA	SI-PD 100629 A	45 000 61 010	50 000 67 790	81 950 111 100	45 000 61 010	50 000 67 790	94 710 128 400

Size (OD)	Nominal Weight	Wall Thickness	Product Name	Drawing #	105-110-115 ksi			120-125-130 ksi		
					min.	opti.	max.	min.	opti.	max.
in. mm	lb/ft	in. mm			ft.lb. N.m					
7" 177.80	29.00	0.408 10.36	NA	SI-PD 100022 B	11 020 14 950	12 250 16 610	13 480 18 270	12 320 16 700	13 690 18 560	15 060 20 420
	32.00	0.453 9.19	NA	SI-PD 100022 B	14 060 19 060	15 620 21 180	17 180 23 300	15 720 21 310	17 470 23 680	19 220 26 050
8" 203.20	32.00	0.375	NA	SI-PD 100575 A	18 590 25 210	20 600 28 010	22 730 30 810	20 450 27 720	22 600 30 800	24 990 33 880
9 5/8" 244.48	53.50	0.545 13.84	NB	ST-D 7848 A	24 750 33 550	27 500 37 280	30 250 41 010	N/A		
	43.50	0.435 11.05	ND	ST-D 7853 A <i>mill side</i>	N/A			N/A		
	43.50	0.435 11.05	NF	SI-PD 100398 A <i>field side</i>	17 900 24 270	19 890 26 970	21 880 29 670	19 330 26 210	21 480 29 120	23 630 32 030
	47.00	0.472 11.99	NF	SI-PD 100398 A	22 210 30 110	24 680 33 460	27 150 36 810	24 150 32 730	26 830 36 370	29 510 40 010
10 3/4" 273.05	65.70	0.595 15.11	NA	SI-PD 100278 A	N/A			N/A		
11 7/8" 301.63	67.80	0.550 13.97	NA	ST-D 7862 B	N/A			N/A		
	71.80	0.582 14.78	NA	ST-D 7862 B	N/A			N/A		
13 3/8" 339.73	72.00	0.514 13.06	NA	ST-D 7849 A	24 750 33 550	27 500 37 280	30 250 41 010	N/A		
	68.00	0.480 12.19	NB	ST-D 7850 B	24 750 33 550	27 500 37 280	30 250 41 010	N/A		
	72.00	0.514 13.06	NB	ST-D 7850 B	24 750 33 550	27 500 37 280	30 250 41 010	N/A		
	80.70	0.580 14.73	ND	SI-PD 100041 B	41 940 56 860	46 600 63 180	51 260 69 500	N/A		
14" 355.60	106.00	0.750 19.05	NA	SI-PD 100629 A	45 000 61 010	50 000 67 790	100 000 135 570	45 000 61 010	50 000 67 790	100 000 135 570