

Making-Up Accessories - USC

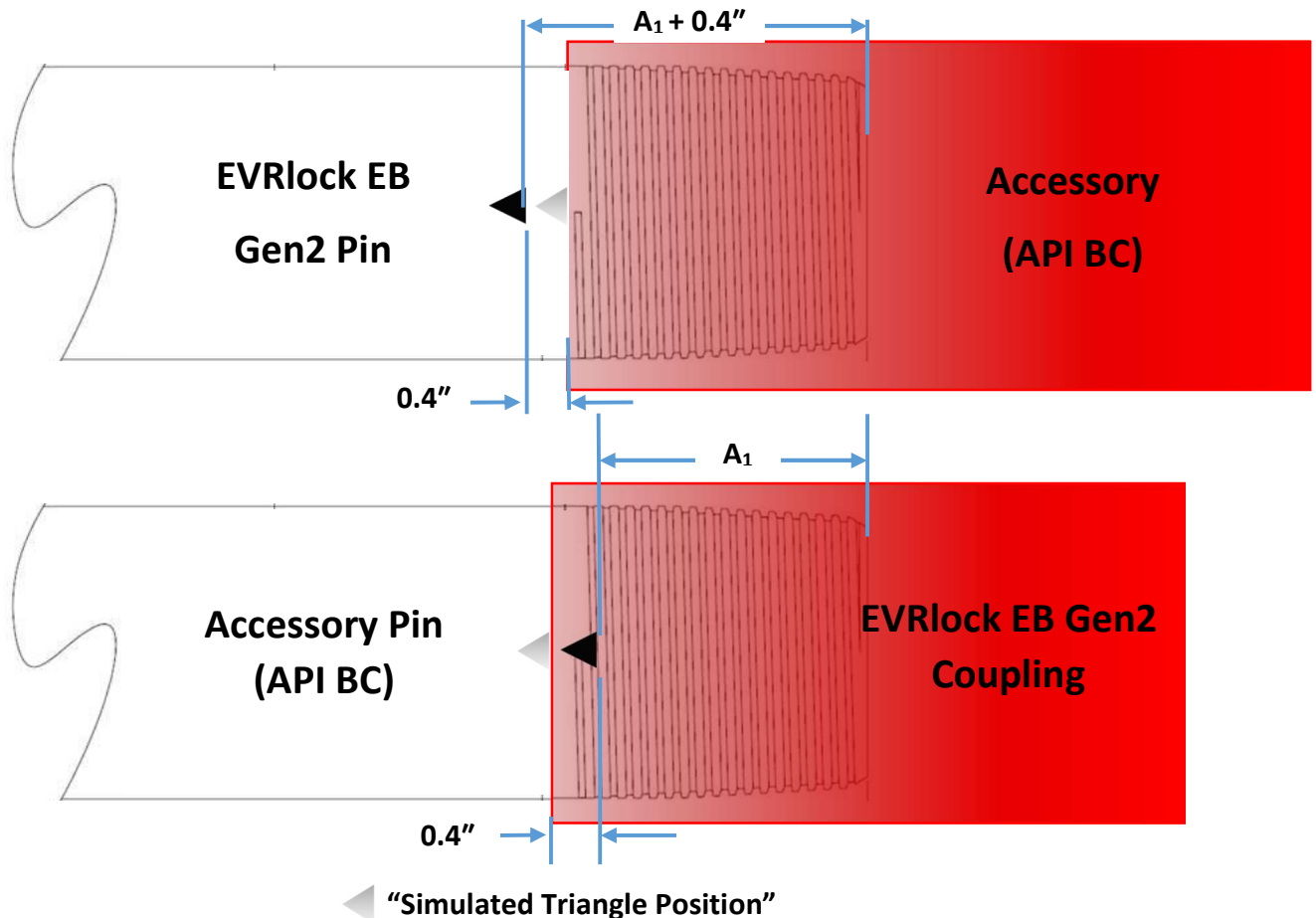
This bulletin will review a recommended practice for make-up of EVRlock EB Gen2 to accessories that are supplied with standard API BC (buttress) connections.

OCTG supplied with EVRlock EB Gen2 connections exhibit field end make-up triangles located at distance $A_1 + 0.4"$ (Note, A_1 is taken from table 5, API 5CT).

When EVRlock EB Gen2 field pins and the field side of EB Gen2 couplings are mated with string accessories such as float collars and guide shoes an offset factor should be applied to triangle position if it is being used to confirm make-up position. Even if making up to torque, the operator shall verify that the pin has been made up to the correct position.

API Buttress pins do not have a controlled pin nose land and may not be machined to have an actual runout in the black crested threads, as a result:

- Buttress pin is not designed to carry significant delta torque once shouldered and mixed Buttress/EB Gen2 accessories is derated to API properties
- It is also normal for some scuffing to be present after the thread runout when bucked out



TOLERANCE ON FINAL POWER-TIGHT POSITION of BC CONNECTIONS (API SPECIFICATION)

The face of the Coupling Advances to base of the Triangle when shouldering

Additional Notes:

- It is important to utilize the "friction factor" indicated on the "locking compound" data sheet when calculating optimal torque. These values can range from 0.8 to 2.0 depending on the type & manufacturer.
- Refer to EVRlock.com for recommended torque for specific weights and grades of EVRlock EB Gen2.
- Refer to API 5TP (or other reputable sources) for recommended torques for API BC connections.