

	Running Procedure for Casing with GB <i>Drilling with Casing Connections</i>	February 13, 2024
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OVERVIEW

This field running procedure applies to makeup of **GB *Drilling with Casing*** (GB DwC) Connections which include GB CD, GB CDE, GB CD RDB, GB CD RDB WS, GB CD EHTQ and GB CD Slim Hole Connections with GB Butt (Buttress), GB 4P, and GB 3P thread forms. All GBC Connections are suitable for ***Running*** (standard casing applications), ***Rotating*** (to aid string advancement), ***Drilling*** (Drilling with Casing/Drilling with Liners), and with a special mandrel, ***Driving***. This procedure also applies to the legacy GB Connections known as GB Butt and GB 3P.

Numerous factors impact the makeup torque of Buttress (GB Butt) and Modified Buttress Threads (such as GB 4P and GB 3P). Some of these factors include but are not limited to: allowable threading tolerances, joint characteristics (OD, straightness, hooked ends, and weight), vertical alignment (derrick, top drive, and elevator alignment relative to rotary table), thread compound (type, amount, and distribution), snub line (location and orientation), distance between tongs and backups, temperature/weather, equipment type, efficiencies (electrical, hydraulic, and mechanical), grips/dies (type, condition, orientation, location, contact area, and grip distribution), measurement equipment, gauge calibration, personnel, etc. The nature of these types of connections makes it impossible to provide makeup torque values that will yield proper power tight makeup on every rig under all circumstances with the wide variety of existing connection makeup equipment.

This procedure has been designed to determine the ***Running Torque*** required for proper power tight makeup of GB Connections under the circumstances and with the actual equipment, set up conditions, weather, etc. that exist at the time of running. With proper execution of this procedure, GB Connections will be properly and consistently assembled.

LIMITATIONS

GB Connections LLC ("GBC") provides the data and information in this Running Procedure for general informational purposes only in order to provide the User with basic recommended practices. This GBC Running Procedure does not constitute professional advice. This GBC Running Procedure is intended to be, and should be, supplemented with the professional judgment of qualified personnel selected by the Buyer and/or User for specific applications, including the observation of actual makeups throughout the casing run. **Every GBC Connection requires the proper amount and distribution of thread compound to all pin and coupling threads and careful field make up in strict accordance with this Running Procedure to provide expected levels of performance in service**

No structural component can perform satisfactorily if not properly prepared and assembled prior to placing it in service in a downhole environment. In the field, the USER has complete control over proper application of thread compound and field makeup. Therefore, the USER is ultimately responsible for the resulting performance downhole if the User does not follow the professional judgment of qualified personnel, the designer/manufacture procedures, and/or basic industry best-practices on the rig floor.

The GBC Terms and Conditions of Sale are incorporated herein by reference and may be accessed at: www.gbconnections.com/pdf/Terms-and-Conditions.pdf. This Running Procedure does not negate or otherwise modify GBC Terms and Conditions of Sale. All sales made by GBC are subject to its Terms and Conditions of Sale, which are incorporated herein by reference, and may be accessed at: www.gbconnections.com/pdf/Terms-and-Conditions.pdf. By using this GBC Running Procedure, Buyer and/or User warrants, represents and agrees that it has utilized its own knowledge, skill, and judgment and determined that the GBC product(s) is fit for its intended service, purpose, and use. Buyer and/or User warrants, represents and agrees that it has read and understands the GBC Terms and Conditions of Sale and agrees to be bound thereby.

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DEFINITIONS

1. Minimum Makeup (MU) Torque: Connections must have at least this amount of torque applied and clearly exhibit shoulder engagement with a delta torque spike.
2. Shoulder Torque: MU torque required to achieve shoulder engagement.
3. Running Torque: Developed at start of casing run per GBC Running Procedure and once established, used for the rest of the joints in the string, using data established with progression of the casing run. The **Running Torque** may be adjusted during the casing run as needed to stay within parameters defined here. The **Running Torque** will likely vary with each job due to the factors listed in the Overview section.
4. Delta Torque: Difference between **Shoulder Torque** and final makeup (or dump) torque.
5. Maximum Makeup (MU) Torque: **Maximum Makeup Torque provided herein is for guidance only.** Customer should rely upon the professional judgment of its qualified personnel to address casing and connection related issues that occur during and after rotating operations for specific applications. This value is not the same as the Connection Yield Torque shown. Connection Yield Torque is the lower yield torque rating for the critical cross-section of pipe body, connector body, pin nose, and the threadform load flank bearing area. Connection Yield Torque does not consider radial buckling of the pipe or connection due to excessive jaw pressure during torque application. Torque in connections can increase or decrease over that applied at makeup (connection tightening/loosening) with rotating and stimulation operations due to slip-stick, shock loads, bending, tight spots, vibration(s), temperature, and other downhole factors that may occur individually or in combination. Final assembly torque including shoulder engagement shall not exceed the **Maximum MU Torque** shown on size, weight, and grade-specific GB Performance Property Sheets at the beginning of a casing run when establishing the **Running Torque**. In the unlikely event that **Running Torque** determined by the procedure meets or exceeds the **Maximum MU Torque**, call GB Connections for assistance.
6. Yield Torque: Torque that causes yielding in the connection (usually yielding of the pin nose). **Yield Torque** rating does **NOT** consider the torque that may radially buckle the pipe body at the grip points. **Yield Torque** values for the pipe body and connection are based on nominal dimensions and minimum material yield strength.
7. Maximum Operating Torque: The **Maximum Operating Torque** shown on the GB Connections Performance Property Sheets includes a 5% safety factor on **Yield Torque**. As such, it represents the **limiting torque spike** that can be applied to the connection during rotating operations. The **Maximum Operating Torque** is **NOT** the **Maximum MU Torque** and **MAY NOT BE** a sustainable rotating torque. Operating at the **Maximum Operating Torque** for any length of time may damage connections due to likely random, unexpected torque spikes that occur during rotating operations. USER should carefully consider this value to determine if a higher Safety Factor on **Yield Torque** is more suitable for the project-specific application.

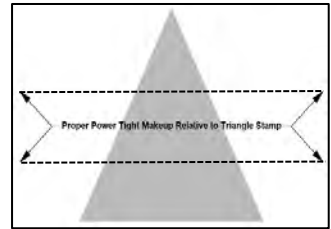
As a general rule of thumb, rotating RPMs and Torque should be “walked up” to determine the minimum needed for task accomplishment. Additional information on best practices for rotating casing can be found at <http://www.gbconnections.com/pdf/White-Paper-Rotating-Casing.pdf>.

KEY INFORMATION

Thread Compound: Best-O-Life 2000, Best-O-Life 2000 Arctic Grade (AG), API Modified, API Modified Hi-Pressure, or any industry recognized equivalent to these products. Thread compound may also be referred to as “dope”. User should avoid products that include Metal Free (MF) in the product name. Tool joint compounds are **expressly forbidden** for makeup of any GBC Connections. **Thread compound shall be applied to all pin and box threads** as described here.

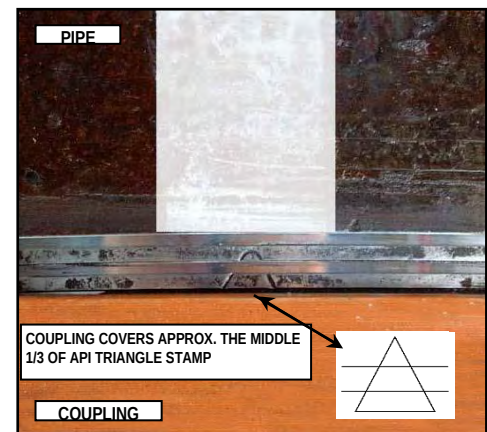
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- Torque Values: **Minimum and Maximum MU Torque** values are provided on individual GB Connections Performance Property Sheets available at the following link: <http://www.gbconnections.com>
- Continuous Makeup: Makeup of GB Connections **SHALL START AND CONTINUE WITHOUT STOPPING** until full power tight makeup is achieved.
- Makeup Speed: Use of high gear at **no more than 40 RPMs** is permissible once proper starting thread engagement has occurred. **THE FINAL TWO (2) FULL TURNS, AT A MINIMUM, SHALL BE COMPLETED IN LOW GEAR AT LESS THAN 10 RPMs.**
- Pin Nose Engagement: Pin nose engagement is indicated by a spike on an analog torque gauge or a sharp vertical spike on a torque vs. turn plot. As a secondary check, proper power tight makeup is achieved when the coupling covers approximately the **middle third of the API Triangle Stamp** on the pin (see graphic). The triangle will be stamped on the pin member and indicated by a white locator stripe.
- Acceptance Criteria: All GB Connections must exhibit shoulder engagement (achieve pin-to-pin or pin-to-shoulder engagement) with a: (1) **Delta Torque** ranging between 10% and 50% of majority of the previously recorded **Shoulder Torques** and (2) final torque not exceeding the **Running Torque** as established in this procedure. Outlier joints that require additional attention would be an exception to **Maximum MU Torque** limit as discussed under Comments, Troubleshooting.



It is imperative that the following procedure be executed carefully at the beginning of every casing run to determine the **Running Torque** (torque to be used for the rest of the string). Torque values established on an individual casing run are never transferrable to other runs.

The **Running Torque** is determined while running the first 10 joints after joints assembled with threadlocking compounds are made up. Sometimes more than the first 10 joints will be needed to establish the **Running Torque** due to erratic results and/or other run-specific conditions. The **Running Torque** may have to be re-established or adjusted during the casing run under certain conditions¹ and observations. Use the size-specific GBC Connections Performance Property Sheets (<http://www.gbconnections.com>) for the **Minimum** and **Maximum MU Torque** values.



Connections shall be made up until shoulder engagement with **Delta Torque** between 10% and 50% of the **Shoulder Torque** (not to exceed the **Maximum MU Torque**, see procedure below) using the **Running Torque** value established in this procedure. The **Maximum MU Torque** at the beginning of the casing run for establishing the **Running Torque** shall be limited to the value shown on the applicable GBC Connections Performance Property Sheet. The **Running Torque** shall be used thereafter and throughout the run as the limiting makeup torque value. The **Maximum MU Torque** on the GBC Performance Property Sheet value is given as a practical limit for avoidance of thread galling, connection damage, and possible tube damage due to excessive jaw pressure that can occur with application of extreme makeup torque. Contact GB

¹ Examples include but are not limited to more than an occasional low or high **Delta Torque**, string of mixed mills, equipment change, large temperature change, and wobbling or noticeable vibration when joint is turning.

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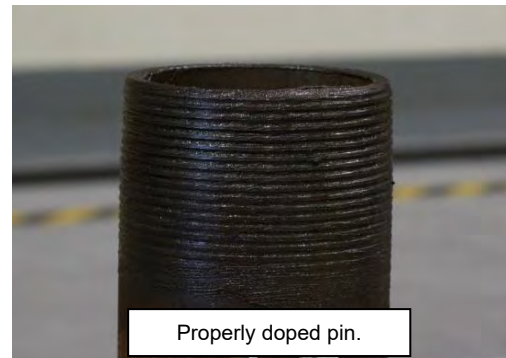
Connections if more than the **Maximum MU Torque** value is required for shoulder engagement and/or final makeup, or if torque exceeding the **Maximum Operating Torque** value is required for the intended service.

PROCEDURE FOR ESTABLISHING AND USING THE **RUNNING TORQUE**

1. Remove coupling thread protectors only after casing is set in V-Door.
2. **Always apply fresh thread compound to coupling threads and internal shoulder (where applicable).** See Comment No. 1 (below) for discussion on proper amount of thread compound.
3. Remove pin thread protectors only after joint is raised in the derrick. Visually inspect pin threads for sufficient thread compound as described in Comment No. 1; **add fresh compound to pin threads and pin nose.**
4. Fresh thread compound should **NEVER** be added on top of dope contaminated with dust, dirt, and/or debris. Threads observed to have contaminated thread compound shall be thoroughly cleaned and dried before applying fresh thread compound.
5. Stab the pin carefully into the coupling of the joint hanging in the rotary table. A stabbing guide is recommended to protect the pin nose and leading thread from physical damage that may contribute to thread galling. Make up each connection until shoulder engagement plus **Delta Torque**. Record the **Shoulder Torque** observed for the first 10 joints (excluding threadlocked accessory joints). The **Running Torque** is (a) the **Minimum MU Torque** shown on the GB Connections Performance Property Sheets **or** (b) the **Maximum Shoulder Torque** recorded from the first 10 makeups + 20%, **whichever is higher** (rounded to the next highest 500 ft-lbs.) **Delta Torque** should Primarily be between 10% and 50% of the **Shoulder Torque**. **Running Torque** shall not exceed the **Maximum MU Torque**. When making up the initial joints for establishing the **Running Torque** carefully watch the torque gauge for the **Shoulder Torque** and try to manually shut down the tongs before reaching **Maximum MU Torque** shown on the GB Connections Performance Property Sheets. Alternately, the dump valve should be set to 80% of the **Maximum MU Torque** during this initial process.
6. After the first 10 makeups (more if necessary due to conditions at the time of the run), use the **"Running Torque"** established in Step 5 for the remainder of the string. A dump valve is strongly recommended to stop makeup once the established **Running Torque** is achieved.
7. All connections made up with the established **Running Torque** should achieve shoulder engagement with the reasonable amount of **Delta Torque**. Carefully watch for the spike on the torque gauge during each make up to verify shoulder engagement. As a **secondary** verification, randomly check the makeup position relative to the API Triangle Stamp during the run. Proper power tight makeup position is achieved when the coupling covers the middle 1/3 of the API Triangle Stamp on the pin (see accompanying photo).
8. All connections should achieve shoulder engagement with at least 10% **Delta Torque** before the **Maximum MU Torque** is achieved.

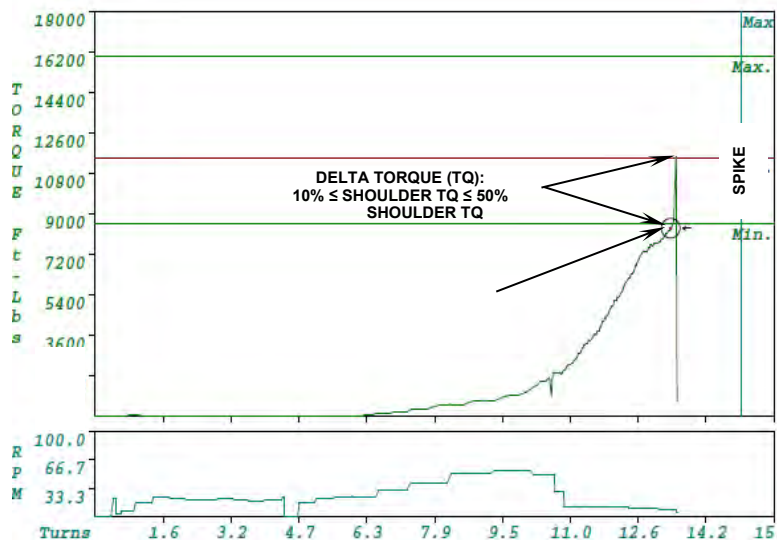
COMMENTS, TROUBLESHOOTING

1. GB Connections are thread compound friendly. Thread compounds shall be handled, mixed, and applied in strict accordance with the manufacturer's instructions. **THREAD COMPOUND SHALL BE APPLIED TO BOTH PIN AND COUPLING THREADS AND OPPOSING PIN NOSE OR SHOULDER AREA OF EVERY CONNECTION.** Thread compound "transfer" between pin and coupling will not provide proper sealing mechanism for the connection to function properly. Sufficient thread compound has been applied when all threads (pin and coupling), pin nose, and coupling ID surfaces are completely covered **WITH NO GAPS OR BARE SPOTS**. The thread form should be discernible beneath the compound, i.e. when the thread valleys appear half full. Be generous with the thread compound; but avoid over-doping to the point where **excessive** amounts are squeezed out during assembly. Use of a mustache brush is the preferred method for applying and distributing thread compounds to GB Connections.
2. If threads are cleaned on racks, new dope shall be applied in a light, even coat to both pin and coupling threads. See Comment No. 1 above for description of sufficient thread compound. Clean thread protectors shall be re-applied to freshly doped pin and coupling threads unless the casing run is imminent (no more than a few hours) to avoid contaminating exposed thread compound.
3. All connections should achieve shoulder engagement before reaching the "**Running Torque**" value determined by this procedure. Any connection that does not achieve a clear spike/shoulder engagement at the established "**Running Torque**" value shall be visually inspected for position relative to the API Triangle Stamp.
 - a) If the coupling is shy of the API Triangle Stamp Base, the connection shall be broken out, cleaned and inspected visually for thread damage, re-doped, and made-up again (or laid down if threads are damaged). Connections **SHALL NEVER** be backed up a couple of turns and remade. They shall be completely broken out, cleaned and inspected as described above.
 - b) If the coupling is at or covers the API Triangle base but does not land in approximately the middle third of the API Triangle Stamp, add additional torque to achieve shouldering and finish the makeup. It is common to see high torque (possibly exceeding the **Maximum MU Torque**) to initiate connection turning. This is acceptable as long as the torque drops off once movement starts and then spikes with shoulder engagement. If acceptable makeup doesn't occur with one additional torque application, the connection shall be broken out (as described in 3a above).
 - c) Any connection not properly assembled (i.e. not meeting the acceptance criteria) in two (2) attempts (provided threads pass a visual inspection each time) is reject and shall be laid down.



4. At the established **Running Torque**, the connections will generally shoulder with **Delta Torque** between 10% and 50%. High interference connections will tend to have a higher **Shoulder Torque** and less **Delta Torque** (at least 10% of the **Shoulder Torque** is required). Low interference connections will tend to have lower **Shoulder Torque** and more **Delta Torque**. In general, GB Connections makeup consistently but will vary due to any of the factors enumerated in the second paragraph of the Overview section of this procedure. However, wide variability on more than a few joints should be investigated for a root cause and, if necessary, a new **Running Torque** should be adjusted as described below.

If a connection appears to have shouldered but doesn't have at least 10% **Delta Torque**, the position relative to the API Triangle Stamp should be checked. In just about every instance, the position will have covered the triangle base, so additional torque can be added to complete the makeup as discussed in 3.b) above. Expect an instantaneous spike with showing more than 50% **Delta Torque** with application of additional torque. Under this condition, this makeup is acceptable.



Similarly, random connections here and there with more than 50% **Delta Torque** is generally not cause for concern. However, if overshooting the 50% maximum **Delta Torque** target occurs frequently, then the established **Running Torque** value should be walked down in 500 ft-lbs. to 1,000 ft-lbs. increments until connection makeup routinely falls in line with the stated acceptance criteria.

5. **Torque vs. Turn monitoring systems are recommended for field makeup of GB Connections.** While Torque vs. Turn plots provide good information about makeup, they **SHALL NOT BE SUBSTITUTED FOR DIRECT VISUAL OBSERVATION OF THE CONNECTION DURING ASSEMBLY.** There is no second chance to watch field assembly of a connection. Torque vs. Turn plots can always be viewed for verification purposes once a makeup is finished. When available, torque vs. turn plots shall finish with a clearly defined spike as shown in the graphic above. The general character of torque vs. turn plots for good makeups will become evident after the first ten (10) makeups (again, more may be necessary due to rig and/or equipment-specific conditions). Any makeup that results in a plot that is “out-of-character”² when compared with most plots from previous good makeups should be checked carefully. Torque vs. Time is not recommended unless it supplements the Torque vs. Turn Data.

When using Torque vs. Turn monitoring equipment, GB recommends setting a reference torque value of 500 ft-lbs. or 10% of the minimum makeup torque (whichever is lower) to help normalize the turns-to-power-tight variability in the Tq-Tn graphs. Setting a reference torque normalizes field stab variability resulting in more consistency in the Tq-Tn data. Plot scales should be set so data spans at least 2/3 of the turns scale on each plot (15 turns will usually be sufficient at the start and can be reduced based on data from the first few joints). **UNDER NO CIRCUMSTANCE SHOULD MAKEUP BE STARTED UNTIL THE MONITORING SYSTEM IS READY TO RECORD DATA.**

6. Occasionally the mill side of a GB Connection may turn during field makeup. When observed, the makeup should continue without stopping per this procedure. It may be helpful to scribe a vertical line across the coupling-pipe

² An “out-of-character” plot may initiate with a high torque, show significantly steeper slope from the start of makeup, wide torque undulations as makeup progresses, no clearly defined spike, insufficient/inconsistent turns, etc.

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interface to aid estimation of mill side turning if it is observed with some frequency. The amount of mill side turn should be carefully observed and estimated. If the mill side turns less than $\frac{1}{2}$ turn and all other aspects of the makeup are good, the connection is acceptable. If the mill side turns more than $\frac{1}{2}$ turn, troubleshooting should be initiated. Pay particular attention to amount and distribution of thread compound, vertical alignment, weight of joint, hooked end on pipe, and other possible factors that may contribute to possible high torque during field makeup. Counting turns can help to estimate if coupling will need to be stopped to avoid over rotation. It should be noted that mill side turning during field makeup occurs occasionally and should not be concerning. Frequent or persistent mill side turning is a symptom that needs troubleshooting and appropriate corrective action.

7. A double wrap of the pick-up sling should be used when raising casing into the derrick when lifting subs, single joint, side-door, or slip elevators are not being used.
8. Higher torque may be needed to achieve proper connection position when threadlock compounds are applied. User is advised to carefully follow the manufacturer's instructions with respect to mixing, application, temperature, and time. Torque ranges with threadlock compounds cannot be estimated due to many variables including but not limited to temperature, time, connection tolerances, and surface finish. In these cases, carefully monitor makeup to be sure shouldering occurs. The only exception to proper positioning is with float equipment (float shoe and float collar) that will be assembled with a threadlocking compound. In this case, makeup close to the base of API Triangle Stamp is considered satisfactory.
9. Manual and automated dump valves can overshoot the established **Running Torque** due to several factors. Slightly overshooting the **Running Torque** is not cause for concern as long as the final "dump" torque is not excessive, and the equipment used is generally consistent joint-to-joint. Overshooting the **Running Torque** with a final makeup speed greater than 10 RPMs is risky and potentially harmful to the connection as discussed below.
10. Attached is a "Worksheet for determining GB Connections **Running Torque** at the beginning of a Casing Run" for use at the start of any casing run using GB Connections. GB recommends that this worksheet be filled out and maintained with the casing run records.

MAKEUP SPEED

To reiterate: Use of high gear at no more than 40 RPMs is permissible once proper starting thread engagement has occurred. **THE FINAL TWO (2) FULL TURNS, AT A MINIMUM, SHALL BE COMPLETED IN LOW GEAR AT LESS THAN 10 RPMs.** Be sure that the final 2 turns occur after the tong speed has slowed completely to less than 10 RPMs.

Making up connections at RPM exceeding those listed above may result in unsatisfactory connection performance downhole. Risks associated with excessive makeup RPMs are common for any connection with internal pin nose engagement. High speed makeup can:

1. Impart an unnecessary impulse load at nose contact. Certain materials are more susceptible to cracking under sudden or instantaneously applied loads.
2. Inhibit efficient movement of and trap thread compound under high pressure causing additional and unquantifiable high hoop stresses in the connection.
3. Result in significant overshoot of established dump torque value due to equipment latency between signal and equipment shut down resulting in higher but unknown actual final torque value. Excessive overshoot can result in pin nose yielding.

PROCEDURE SUMMARY

1. Remove coupling protectors after casing is set in V-Door and apply fresh thread compound to coupling threads.

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2. Raise joint in derrick, remove pin protectors, and apply fresh thread compound to pin threads and pin nose.
3. Carefully stab pin into coupling and makeup to pin nose engagement. Try to stop makeup without exceeding the **Maximum MU Torque** (shown on GB Connections Performance Property Sheets). Carefully watch for and note the **Shoulder Torque**.
4. Record **Shoulder Torque** and Final Torque values, and position relative to API Triangle Stamp for first ten (10) connections, more if necessary due to run/rig-specific conditions.
5. The **Running Torque** is (a) the **Minimum MU Torque** shown on the GB Connections Performance Property Sheet or (b) the maximum torque required for shoulder engagement + 20% **Delta Torque** determined from the first 10 makeups, **whichever is higher**. Use the attached Worksheet to record this data and determine the **Running Torque**.
6. Make up the rest of the string at the **Running Torque** determined in the previous step verifying each connection has shouldered with between 10% and 50% **Delta Torque**. Small incremental adjustments to the established Running Torque (500 to 1,000 ft-lbs) are advised if delta torques routinely fall short of the 10% requirement or routinely exceed the 50% requirement.

NOTES:

- ***This procedure summary is not a substitute for the comprehensive procedure provided above and does not apply to threadlock connections.***

DO's and DONT's

1. **DO** check vertical alignment.
2. **DO** apply thread compound to all pin and coupling threads, pin nose and coupling shoulder area.
3. **DO** establish the **Running Torque** in accordance with GB Procedures.
4. **DO** make adjustments to **Running Torque** if indicated by inconsistent makeups during the casing run.
5. **DO** check every makeup for a clear indication of shouldering with a minimum **Delta Torque** $\geq$ 10% of the **Shoulder Torque**.
6. **DO** reject any coupling that is not properly made up after two (2) attempts.
7. **DO** carefully stab pins into coupling (use a stabbing guide for casing smaller than 9 5/8" OD).
8. **DO** finish the makeup with at least two (2) full turns in low gear at 10 RPMs or less.
9. **DO** make up every connection continuously to pin nose engagement without stopping.
10. **DO** make note of anything that occurs with any connection makeup such as backup grips slipped, connection inspected and remade, etc.
11. **Do** check out every connection that appears out of character relative to the population. An example would be a connection that is completed with significantly fewer turns than most others. Check the triangle stamp and record position and take corrective action if needed.
12. **DO** add torque to any connection that appears to achieve pin nose engagement but not 10% delta torque.

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13. **DO** adjust the **Running Torque** up or down in increments to achieve consistent **Delta Torque** between 10% and 50%.
14. **Do** make note of any anomaly during any connection makeup, such as backups slipped, mill side turned, etc.
15. **DO** minimize the weight on the connection, i.e. weight neutral, during break out as much as possible to minimize thread galling.
16. **Do** Reduce RPM's on any join racking around in the derrick during make up. Erratic joint movement while rotating may contribute or cause thread galling during make-up.
17. **DO NOT** over dope.
18. **DO NOT** exceed the **Maximum MU Torque** as shown on the GB Connections Performance Property Sheets during assembly.
19. **DO NOT** make up any misaligned connection.
20. **DO NOT** exceed 40 RPMs in high gear and 10 RPMs in low gear for the final two (2) full turns.
21. **DO NOT** remove pin thread protectors until pipe is hanging in the derrick.
22. **DO NOT** ever back a connection up a couple of turns and remake. Any connection requiring this type of attention **SHALL** be broken out completely, cleaned, visually inspected, and if OK, re-doped and remade.
23. **DO NOT** hesitate to contact GB Connections with questions before and during any casing run.

RECOMMENDED EQUIPMENT

- Stabbing Guide
- Mustache Brush
- Torque vs. Turn Monitoring Equipment or Dump Valve

Worksheet for determining GB Connection Running Torque at the beginning of a Casing Run

Ignore joints that are assembled with threadlock compounds. See "Addendum Procedure for GB Connections Assembled with Threadlocking Compounds" available at www.gbconnections.com.

Pertinent Excerpt from GB Running Procedure

5. Stab the pin carefully into the coupling of the joint hanging in the rotary table. A stabbing guide is recommended to protect the pin nose and leading thread from physical damage that may contribute to thread galling. Make up each connection until shoulder engagement plus Delta Torque. Record the Shoulder Torque observed for the first 10 joints (excluding threadlocked accessory joints). The Running Torque is (a) the Minimum MU Torque shown on the GB Connections Performance Property Sheets or (b) the Maximum Shoulder Torque recorded from the first 10 makeups + 20%, whichever is higher (rounded to the next highest 500 ft-lbs.) Delta Torque should be between 10% and 50% of the Shoulder Torque. Running Torque shall not exceed the Maximum MU Torque. When making up the initial joints for establishing the Running Torque carefully watch the torque gauge for the Shoulder Torque and try to manually shut down the tongs before reaching Maximum MU Torque shown on the GB Connections Performance Property Sheets. Alternately, the dump valve should be set to **80% of the Maximum MU Torque** during this initial process.

6. After the first 10 makeups (more if necessary due to conditions at the time of the run), use the "Running Torque" established in Step 5 for the remainder of the string. A dump valve is strongly recommended to stop makeup once the established Running Torque is achieved.

Casing Data		Comment
OD (in)		See GBC Performance Property Sheet
Weight (ppf)		See GBC Performance Property Sheet
Grade		See GBC Performance Property Sheet
Min MU Torque (ft-lbs)		See GBC Performance Property Sheet
Max MU Torque (ft-lbs)		See GBC Performance Property Sheet
Max Operating Torque (ft-lbs)		The Maximum Operating Torque is NOT the Maximum Makeup Torque and is NOT a sustainable rotating torque. Operating at the Maximum Operating Torque for any length of time will likely damage the connection.

Notes	Joint No.	Shoulder Torque (ft-lbs)	Final Torque (ft-lbs)	Triangle Stamp Position Sketch ($\triangle$)
Required	1			
Required	2			
Required	3			
Required	4			
Required	5			
Required	6			
Required	7			
Required	8			
Required	9			
Required	10			
Optional	11			
Optional	12			
Optional	13			
Optional	14			
Optional	15			
Max. Shoulder Torque				
A Max. Shoulder Torque + 20%				
B Min. Makeup Torque (from GB Conn. Data Sheet)				
Running Torque (ft-lbs)		-	A or B, whichever is greater.	

Optional joints should be added if there is wide variability in shoulder torques recorded during the initial 10 joints. Judgement should be used to determine if more than 10 joints are needed for the purpose of establishing the Running Torque and, if so, how many more should be added.

Wide variations in Shoulder Torque during the first ten (10) joints suggest other issues requiring attention such as poor alignment, improper amount and distribution of thread compound, etc. Refer to 2nd paragraph of GB Running Procedure for possible contributing factors to aid troubleshooting.

GB Connections

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Houston TX 77079
Toll Free: 1-888-245-3848
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