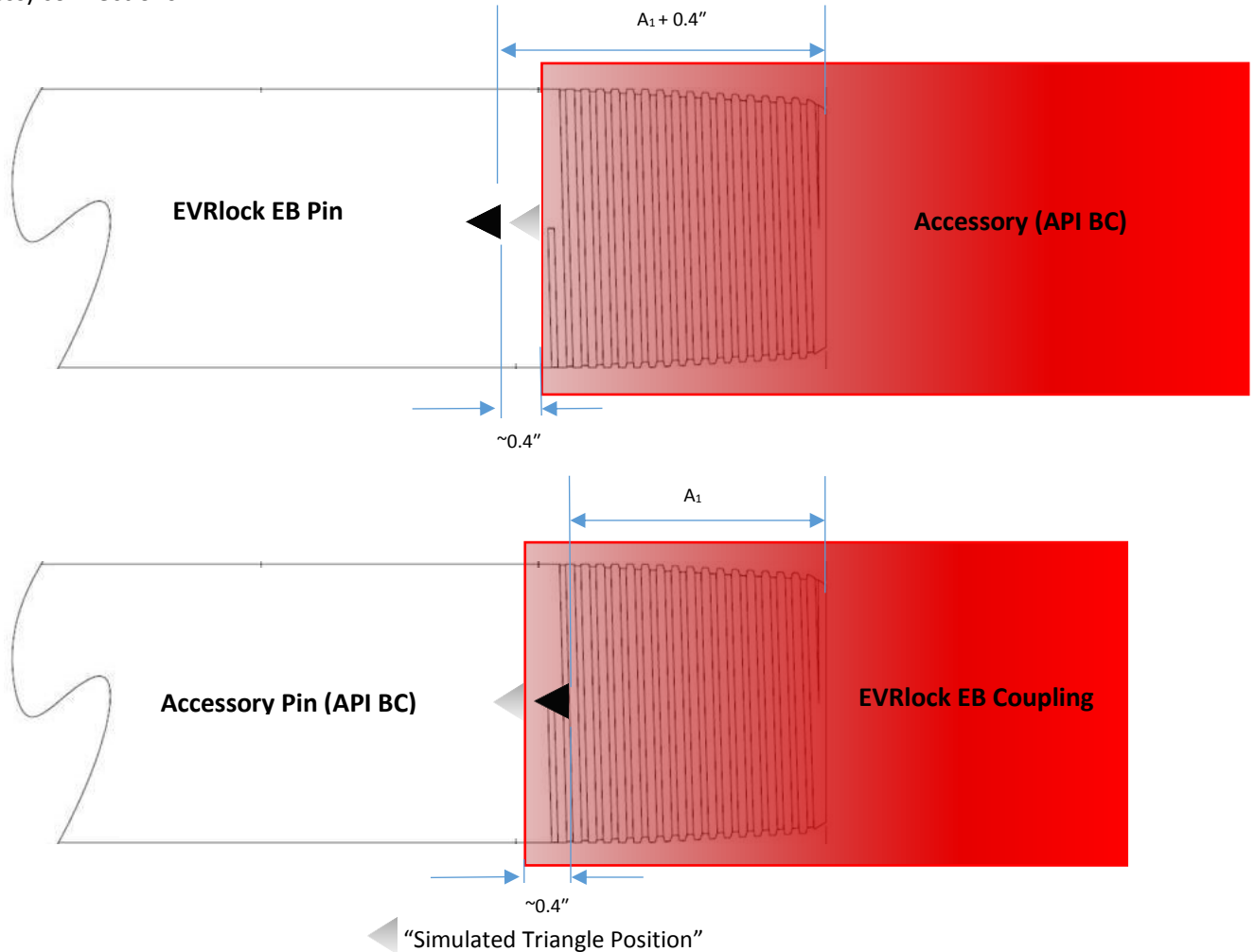


Making-Up Accessories - USC

OCTG supplied with EVRlock EB connections exhibit field end make-up triangles located at distance $A_1 + \sim 0.4''$

When EVRlock EB field pins and the field side of EB couplings are mated with string accessories such as float collars and guide shoes an offset factor should be applied to triangle position if they are used to confirm make-up position.

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



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

The face of the Coupling Advances to Within One Turn of the Base of the Triangle Stamp for Minimum Power-Tight and to the Apex of the Triangle for the Maximum Makeup

This represents a final position variance of $\pm 0.290''$ - this tolerance applies to the simulated triangle seen above

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 weight's and grades of EVRlock EB.
- Refer to API 5TP (or other reputable sources) for recommended torques for API BC connections.