MAKE UP TORQUE

Make up torque is vital to achieving maximum strength and proper sealing of threaded connections.

With the increased use of tapered threaded drill rods the need to apply make up torque prior to going into the drill hole has become more important.

In addition the application of make up torque when casing the hole will result in better shoulder sealing and joint strength.

Since make up torque is normally shown as "pound feet force" it is important to provide a means to apply a measured amount of force in a smooth manner.

The following chart lists products produced to DCDMA standards and suggested make up torques for maximum results.

A good rule is to apply at least 20% more torque at make up than the torque that will be transmitted while drilling, reaming or rotating.

EXAMPLE: If you expect to transmit 400 pound feet force while drilling the make up torque should be 480 pound feet.

	IDENTIFICATION	SUGGESTED MAKE UP TORQUE
RODS	RW Rod	250
	EW Rod	250
	AW Rod	350
	BW Rod	400
	NW Rod	600
	HW Rod	800
	AWJ Rod	400
	BWJ Rod	500
	NWJ Rod	1000
	KWJ Rod	1500
	HWJ Rod	2000
CASINGS	RW - EW Casing	100
	AW - BW Casing	250
	NW - HW Casing	300
	PW thru ZW	400
	RX - EX Casing	80
	AX - BX Casing	150
	NX - HX Casing	250

Note: "X" series casing has more threads per inch than "W" series and will make up tighter with less torque.

MAKE UP TORQUE
DRILL ROD AND
CASING