

Tubing Make-Up Torque Guide																	Threaded and Coupled Joints																				
Joint Name	Tubing Grade	3/4			1			1 1/4			1 1/2			2 1/16			2 3/8			2 7/8			3 1/2			4			4 1/2								
		1.050" OD			1.315" OD			1.660"OD			1.900"OD			2.063" OD			2.375" OD			2.875" OD			3.500" OD			4.000" OD			4.500" OD								
		Min.	Opt.	Max.	Min.	Opt.	Max.	Min.	Opt.	Max.	Min.	Opt.	Max.	Min.	Opt.	Max.	Min.	Opt.	Max.	Min.	Opt.	Max.	Min.	Opt.	Max.	Min.	Opt.	Max.	Min.	Opt.	Max.						
API Non-Upset	H-40	110	140	180	160	210	260	200	270	340	240	320	400					350	470	590	600	800	1000	840	1120	1400	710	940	1180	990	1320	1650					
	J-55	140	180	230	200	270	340	260	350	440	310	410	500					460	610	760	790	1050	1310	910	1210	1510	910	1240	1550	1310	1740	2180					
	C-75	170	230	290	270	360	450	350	460	580	410	540	680					600	800	1000	1200	1600	2000	1200	1600	2000	1230	1640	2050	1730	2300	2880					
	N-80	190	250	310	290	380	480	370	490	610	430	570	700					640	850	1060	1100	1470	1840	1280	1700	2130	1310	1740	2180	1830	2440	3050					
P-105																		960	1280	1600	1290	1850	1390	1970	2620	3280											
API External Upset	H-40	350	460	580	330	440	550	400	530	660	500	670	840					740	990	1240	940	1250	1560	1300	1730	2160	1460	1940	2430	1620	2160	2700					
	J-55	450	600	750	430	570	710	520	690	860	660	880	1100					970	1290	1610	1240	1650	2060	1710	2280	2850	1920	1560	3200	2150	2860	3180					
	C-75	590	780	980	560	740	930	680	910	1140	860	1150	1440					1280	1700	2130	1630	2170	2710	2260	3010	3760	2540	3390	4240	2840	3780	4730					
	N-80	620	830	1040	590	790	990	720	960	1200	920	1220	1530					1350	1800	2250	1730	2300	2880	2400	3200	4000	3400	4560	5700	3020	4020	5030					
P-105																		1700	2270	2840	2180	2910	3640	3040	4050	5060											
Armco Seal-Lock																		800	1000	1200	1000	1200	1400	1600	1800	2000											
Armco Nu-Lock	Make-up to the shoulder: ft lb torque ratings in API range.																						1000		2000	1500		2500	2000		3000						
Jones & Laughlin8-Acme	Power-tight position indicated by make-up to base of J-L stamped on tubing.																																				
Wheeling Pittsburg 8-Acme	Power-tight positioin indicated by make-up to base of P stamped on tubing: ft lb torque ratings in API range.																																				
Republic 8-Acme	Power-tight positioin indicated by make-up to base of R stamped on tubing: ft lb torque ratings in API range.																																				
Rucker Atlas Bradford Modified Coup	Same as recommended API minimum torque																																				
Rucker Atlas Bradford TC-4S	J-55																																				
	C-75, N-80																																				
	P-105																																				
U.S. Stell Imp. Buttress	Minimum power make-up should be to the leading edge of the first knurl on the tubing: torque ratings in the API range.																																				
Mannesmannrohren-Werke AG. TDS, also avail in I.J.*	J-55																																				
	C-75, N-80																																				
	P-105																																				
Vallourec VAM*	K-55																																				
	C-75, N-80																																				
	P-105																																				
Hydril CTS	J-55, C-75 N-80, P-105	Not yet established																																			