

Hydril PH-6 Minimum Make-Up Torque*

OD (in.)	(mm)	Weight (lb/ft)	Torque (ft-lb) (kg-m)			
			Grade			
			L-80 & N-80		P-110	
2.375	60,3	5.95, 6.20 & 7.70	2200	305	2700	375
		7.9 & 8.7	3000	415	3500	485
2.875	73,0	9.5 & 10.7	4500	620	5500	760
3.500	88,9	12.95 & 15.8	5500	760	7000	970
4.000	101,6	13.4	5500	760	7000	970
4.500	114,3	15.5	6000	830	7500	1035
		19.2	7500	1035	9500	1315

Hydril PH-4 Minimum Make-Up Torque*

OD (in.)	(mm)	Weight (lb/ft)	Torque (ft-lb) (kg-m)			
			Grade			
			L-80 & N-80		P-110	
2.875	73,0	11.0 & 11.65	5000	690	6500	900
		16.7	7500	1035	9500	1315
3.500	88,9	17.05	8000	1105	10000	1385
		19.0	8500	1175	10500	1450
4.000	101,6	22.5	9500	1315	11500	1590
		21.6	9500	1315	12000	1660
4.500	114,3	24.0	10000	1385	13000	1800
		26.5	11500	1590	14500	2005

*Data reprinted from Hydril Bulletin No. 9204. Hydril recommends using a figure of 12-1/2% over minimum to ensure that minimum torque is obtained since many factors influence torque application. Torque should never exceed 25% over minimum.