



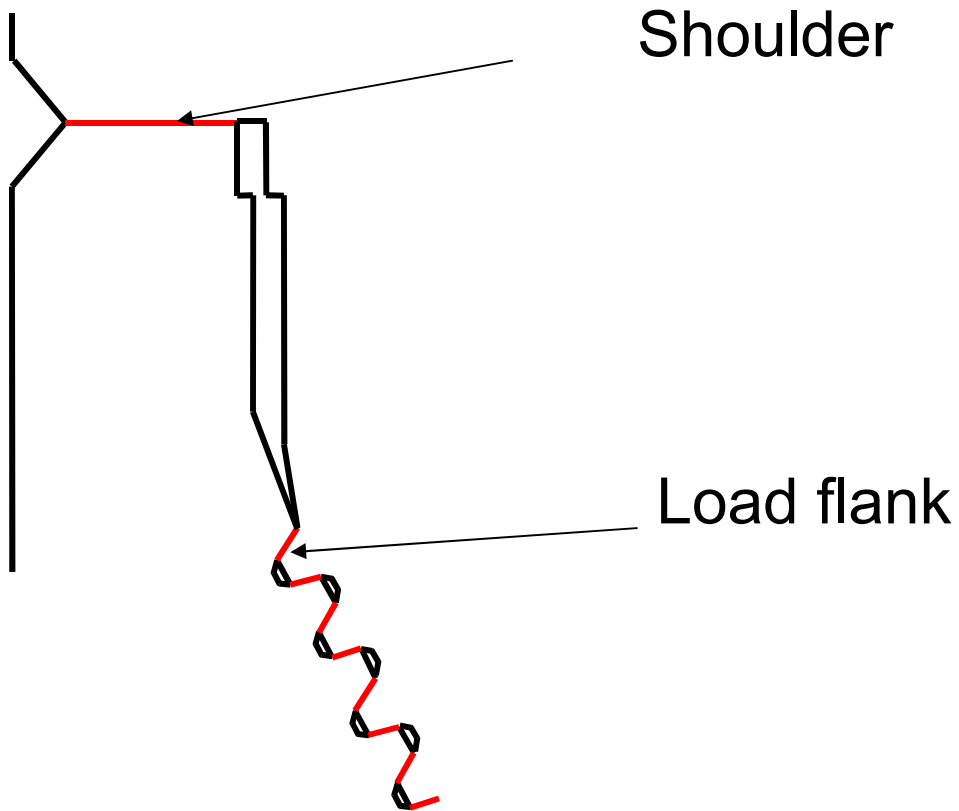
Make and break

Make and break



- All connections should be broken in before put in service.
- Reduces galling on the load flank of the thread and on the shoulders.
- Does not replace cold rolling of the root of the thread.

Make and break



BREAK IN Procedures

- Make up **slowly** at nominal make up torque
- Break the connection, monitor break out torque, the break out torque should be around 80 - 90 % of the make up torque.
- Make up again at nominal make up
- Break out, monitor break out torque
- Visually inspect and re-dope
- The connection is ready !

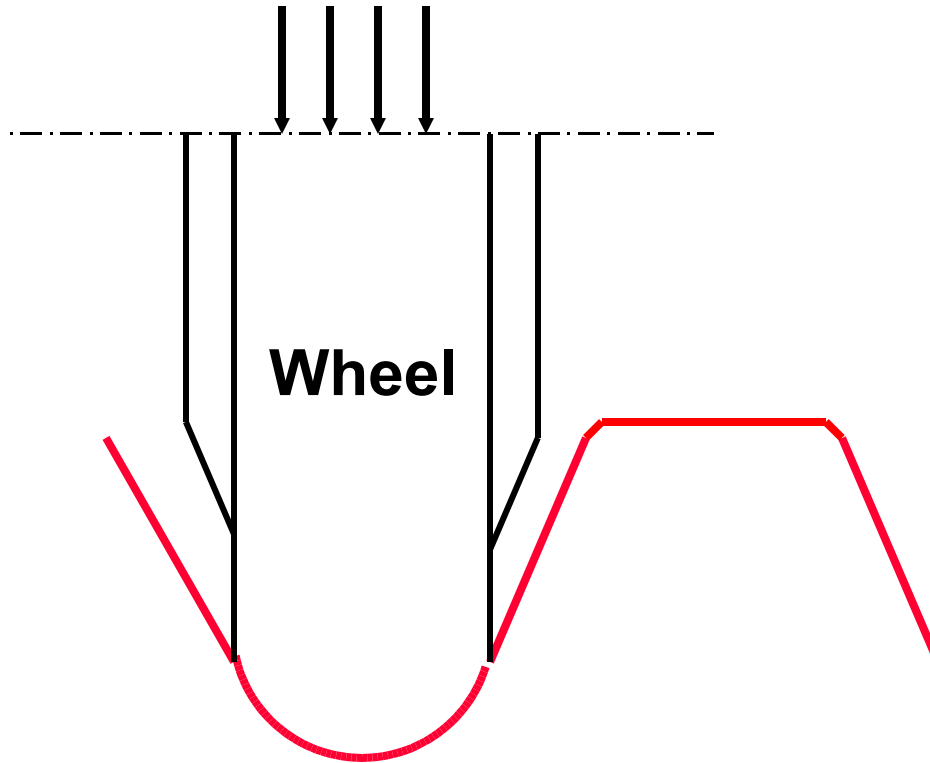


Make and break

- Drill pipe and welded heavy weight can be done in the plant before welding the tool joints to the pipe.
- Break in option when ordering pipes is a rig time saving, is accurate process.



Cold rolling



**Fibers in
compression
after cold
roll**