



DOWNHOLE MOTOR TECHNICAL BULLETIN

TDT-TB006

Rev. 3

SUBJECT: Rig Make Up Torque for Toro Downhole Motors

CHANGE; DESCRIPTION; REASON: This bulletin documents rig connection make up torque applicable to Toro Downhole Motor. **Note that the ABH torque for the 650 Motor has been increased.**

OPERATION / INSTRUCTIONS: The following chart must be utilized when making up or breaking out Toro Motor rig applicable threaded connections:

Description	375		475		650		675		800	
	Thread	Ft. Lbs.	Thread	Ft. Lbs.	Thread	Ft. Lbs.	Thread	Ft. Lbs.	Thread	Ft. Lbs.
Float Sub Box	2-7/8" Reg.	4,500 - 5,500	3-1/2" Reg.	7,000 - 9,000	4-1/2" Reg.	16,500 - 18,500	4-1/2" Reg.	16,200 - 19,200	6-5/8" Reg.	46,000 - 48,000
Float Sub Box			3-1/2" IF	10,000 - 12,000	4-1/2" IF	22,800 - 24,800	4-1/2" XH	17,600 - 19,600		
Float Sub Box					4-1/2" XH	17,600 - 19,600				
ABH		4,400 - 4,800		6,500 - 7,000		30,000 - 33,500		30,000 - 33,500		35,800 - 38,000
Bit Box	2-7/8" Reg.	4,500 - 5,500	3-1/2" Reg.	7,000 - 9,000	4-1/2" Reg.	12,000 - 16,000	4-1/2" Reg.	12,000 - 16,000	6-5/8" Reg.	28,000 - 32,000
Sleeve (Thread Protector)		2,000 - 2,500		2,500 - 3,500		7,500 - 8,500		7,500 - 8,500		9,000 - 10,000
Changeable Stabilizer		3,500 - 4,000		4,000 - 5,000		9,000 - 10,000		9,000 - 10,000		11,000 - 12,000

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Any threaded connection not shown can be accessed by contacting your Toro Representative or directly through Toro Downhole Tools Technical Services:

Toro Downhole Tools

16626 FM 2920

Tomball, TX 77377

(281) 580-8676

Randall Slack, Technical Services

Date: 6/24/13

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