

SPD FAST CURE BAKERLOK® FORMULA “C” THREAD-LOCKING COMPOUND



FEATURES/ADVANTAGES

Withstanding High Breakout Torque. Tests under bottom hole temperatures ranging from 50° through 400° F

showed Bakerlok® withstood greater torque than a standard joint welded in three places with 2 inch beads.

Unaffected by Vibration. At 400° F Bakerlok® **was subjected to a steady breakout torque for 8 hours** while under continuous vibration from a 6 pound air hammer. Breakout torque was increased until six times the 3,300 ft-lb makeup torque finally broke the joint.

High Lubricity. Tests were made using Bakerlok® on one side of a standard coupling and API Modified **Thread Dope on the other. Identical pin threads** were made up into the coupling. For the same amount of torque, the joint with Bakerlok® made up further and was cooler than the joint lubricated with standard thread dope. Bakerlok® has a 1,18 Friction Factor/Torque Factor.

Leak proof Seal. Joints made up with Bakerlok® **using standard torque were tested with water** pressures in excess of the listed burst pressure of the casing. The joint showed no leakage.

Corrosion Resistant. Five different samples of Bakerlok® covered steel and underwent a 96 hour ASTM and salt spray test. The result: no visible change in Bakerlok®; no acceleration of the normal corrosion rate on the five samples of steel.

Unaffected by Low Temperature Storage.

Bakerlok® was stored at -50° F and then thawed, mixed, applied, cured and tested for breakout torque. No detrimental effects due to freezing were detected.

BAKERLOK® Number of Joints

Casing OD (in.)	Each Bakerlok® Kit Will Lock
4-1/2.....	10
5-1/2.....	6
6-5/8 or 7.....	4
7-5/8, 8-5/8 or 9-5/8.....	3
10-3/4, 11-3/4 or 13-3/8.....	2
16 or 20	1

EMERGENCY

In case of emergency, Bakerlok® can be released by heating the joint from 500° to 600° F and applying breakout torque immediately.

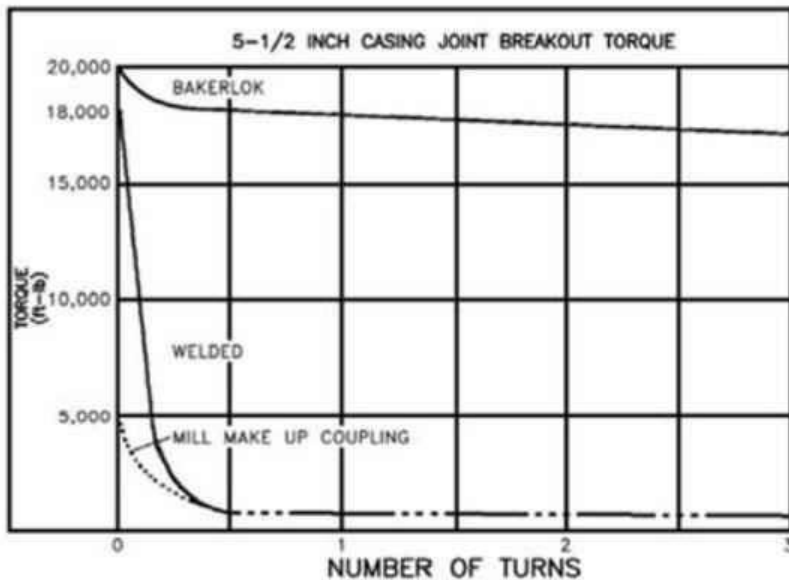


Chart shows average torque required to breakout welded joints compared with joints locked with Bakerlok®. Note that the welded joint after initially breaking out, almost immediately drops down to the same torque required for unscrewing a mill coupling. Bakerlok® joint breaks out initially at a higher value than the welded joint, and provides continued high resistance to turning.

APPLICATION:

For best results, the actual casing temperature during application of BAKERLOK® should be between 02 and 110° F. (-18 and 432 C.).

1. All pin and box threads should be cleaned with solvent until they are free from excessive moisture, grease and foreign matter; then rinsed with water. Any frost on threads should be removed with a wire brush.
2. Thoroughly mix the contents of large container, using a putty knife. If compound is too stiff for mixing readily, warm to 75 F. (24° C.). Shake the bottle well and add entire contents to compound. It is essential that the complete contents of both containers be mixed together.

NOTE:

If the mildly irritant chemical in the bottle is spilled on hands, wash off with soap and water.

3. Stir with putty knife until the mixture is completely blended and no streaks are visible.
4. Apply a thin layer of BAKERLOK® around the first two-thirds of the PIN thread only. Do not use thread dope. BAKERLOK® is an efficient lubricant.
5. Make up the joint to recommended API torque values. BAKERLOK® will attain maximum breakout strength before drilling-out operations are commenced. If bottom-hole temperature is 100°F. (38° C.), maximum strength is reached in 7 to 10 hours; if temperature is 1502 F. (66° C.), or higher, maximum strength is attained in 4 to 6 hours following the application of BAKERLOK®. Joints locked with BAKERLOK® can be broken out by heating the joint to 5002 to 600° F. (2602 to 320° C.) and immediately applying torque.

AVAILABILITY:

BAKERLOK® is available in standard 8 oz. kit size.

SHELF LIFE:

The shelf life of BAKERLOK®, provided the hermetically sealed containers have not been opened, is three (3) years.

POT LIFE:

Time periods shown are for length of time after entire contents of both containers have been mixed.

Volume	At 70° F (21° C)	At 90' - 100' F (32° - 38° C)
8 Oz	45 Min.	30 Min.
1 US. Qt .or four 8 Oz kits	40 Min.	25 Min.

One (1) Bakerlok® kit contains:

- One (1) 8 oz per can of Bakerlok® thread-locking compound
- One (1) Hardener vial
- One (1) Applicator.