

1. Scope

This document is to be used for field make-up acceptance of the Cobra® SP Connection.

This procedure shall be used in conjunction with FT-RP-000 General Running Procedure and the latest revision of the Connection Data Sheet (CDS). Where conflicts exist, this connection-specific running procedure and CDS shall govern.

1.1. Product Description

Cobra® SP Connection:

- Flush
- Constrictor™ wedge locking thread form
- Thread sealing



Figure 1 – Product Image

1.2. Approvals

Created	Angela Hill – Product Engineer	09/10/2026
Reviewed	Israel Martinez – Quality Director	09/10/2026
Approved	Wesley Ott – Director of Engineering	09/10/2026

1.3. Contents

- 1. Scope.....1
 - 1.1. Product Description.....1
 - 1.2. Approvals1
 - 1.3. Contents2
 - 1.4. Reference Documents2
- 2. Connection Running3
 - 2.1. Connection Compatibility3
 - 2.2. Thread Compound Application.....3
 - 2.2.1. Approved Compounds3
 - 2.2.2. Compound Amount3
 - 2.2.3. Thread Compound Application4
 - 2.3. Connection Make-Up5
 - 2.3.1. General5
 - 2.3.2. First Article Make-up5
 - 2.3.3. Cobra® SP Torque-Turn Plot5
 - 2.3.4. Make-up Acceptance Criteria6
 - 2.3.4.1. Make-up Indicator6
 - 2.3.4.2. Graph Acceptance7

1.4. Reference Documents

Document Number	Document
FT-RP-000	General Running Procedure
FT-FI-001	Fermata Connections Field Visual Inspection and Repair Requirements

Available online: fermata-connections.com/running-procedures/

*Always confirm the most current Running Procedure through the online portal or by contacting Field Service.

2. Connection Running

For general running see FT-RP-000 General Running Procedure

Fermata® strongly recommends using a Fermata® certified thread representative for all casing runs. If not used, the operator is responsible for ensuring all make-ups meet Fermata® criteria.

See Section 4.1 in the FT-RP-000 General Running Procedure for Field Service details.

2.1. Connection Compatibility

Cobra® SP does **NOT** have compatibility with differing weights within the same OD.

2.2. Thread Compound Application

See FT-RP-000 General Running Procedure Section 4.2 for thread compound application.

2.2.1. Approved Compounds

- Fermata® Constrictor® Advanced Thread Sealant.

2.2.2. Compound Amount

Refer to Table 1 for the required thread compound volume:

Table 1: Thread Compound Amount

Size	Volume (mL)
2.375" 4.60#	2.0
3.500" 9.20#	2.0
3.500" 10.20#	2.0
4.000" 10.70#	3.0
4.000" 11.60#	3.0
4.500" 11.60#	3.0
4.500" 13.50#	4.0
4.500" 15.10#	3.0
5.000" 18.00#	4.0
5.500" 15.50#	4.0
5.500" 17.00#	4.0
5.500" 20.00#	5.0

5.500" 23.00#	5.0
5.500" 26.00#	4.0
7.000" 26.00#	5.0
7.000" 29.00#	5.0
7.000" 32.00#	6.0
7.625" 26.40#	6.0
7.625" 29.70#	6.0
7.625" 33.70#	7.0
7.625" 39.00#	8.0
7.625" 47.10#	9.0
8.625" 32.00#	8.0
10.750" 45.50#	10.0
18.625" 94.50#	30.0
18.625" 139.00#	20.0

2.2.3. Thread Compound Application

- Apply thread compound only on the pin connection.
- Coat full thread form (flanks, roots, and crests).

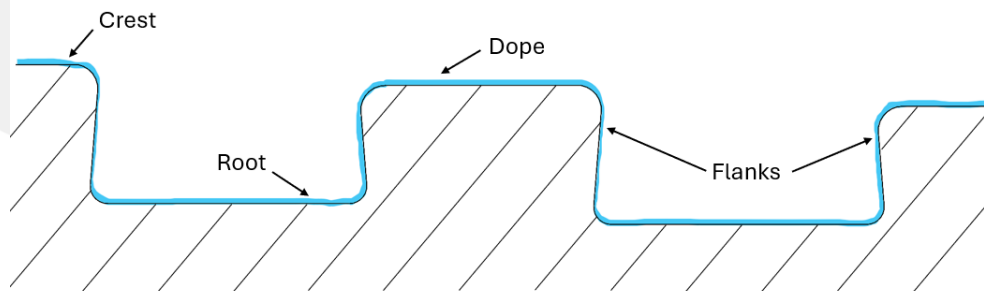


Figure 2 – Thread Form

See Figure 3 and Figure 4 for visual reference.



Figure 3 – Pin Connection Application

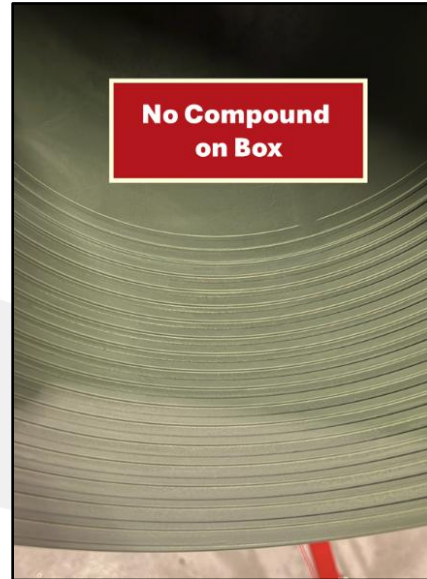


Figure 4 – Box Connection (no compound)

2.3. Connection Make-Up

2.3.1. General

See FT-RP-000 General Running Procedure

2.3.2. First Article Make-up

Cobra® SP requires First Article Make-Up, see FT-RP-000 General Running Procedure Section 4.4.3 for the detailed process.

2.3.3. Cobra® SP Torque-Turn Plot

- Verify the make-up result against Figure 5.
- For Cobra® SP, the Constrictor® Lock Point is defined as the point where the slope changes from curved to linear. Maintain the Constrictor® Lock Point between 5% and 80% of makeup torque.

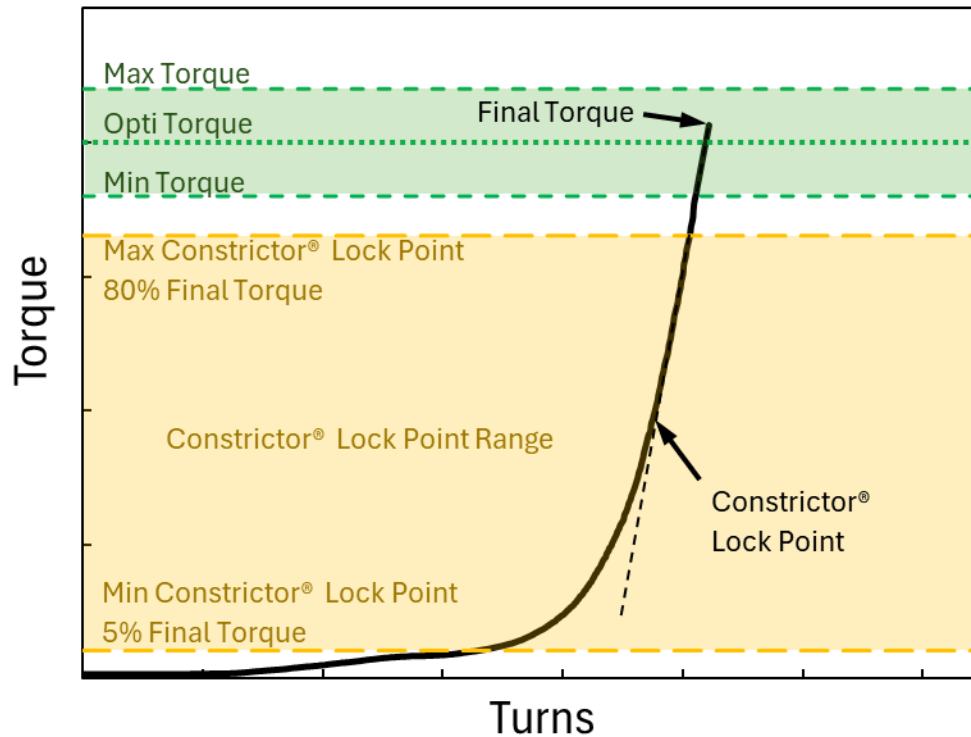


Figure 5 – Cobra® SP Torque-Turn Signature

2.3.4. Make-up Acceptance Criteria

Connections are accepted based on required graph elements (2.3.3), and Knurling/Triangle stamp make-up indicators.

2.3.4.1. Make-up Indicator

Verification of connection make-up can be made by checking the triangle stamp or knurling.

Triangle:

- To locate the triangle there is a 1" wide X 24" long white paint stripe is applied to the field end pin.
- After make-up, the box face must be within a tolerance of ± 0.063 " from the triangle base.

Knurl:

- The knurl is applied around the circumference of the pin.
- After make-up, locate a region around the circumference that has full knurl width indented. The box face must be within a tolerance of ± 0.063 " from the knurl base.

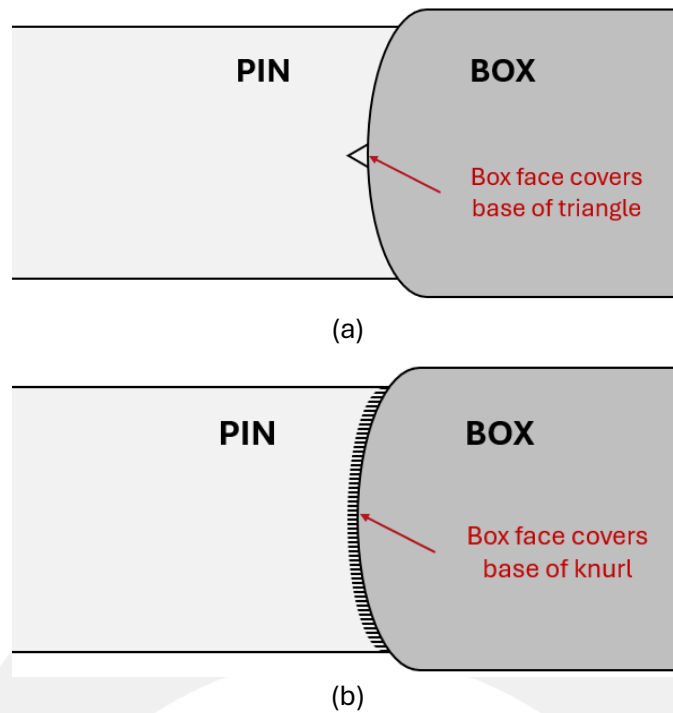
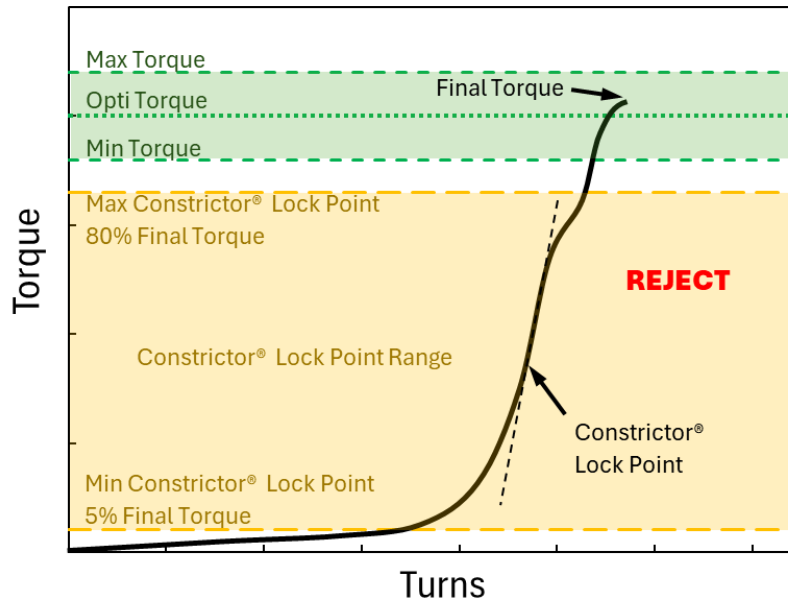


Figure 6 – Triangle stamp after make-up (a) and knurl after make-up (b).

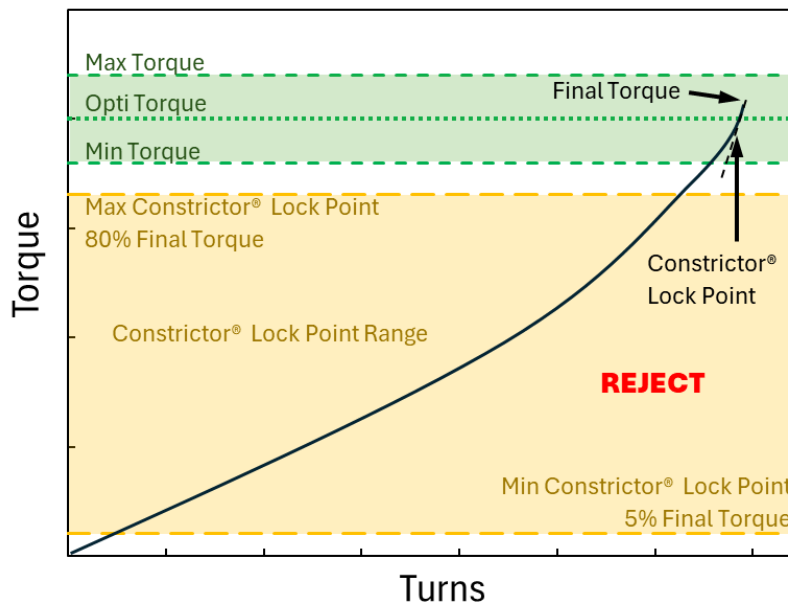
2.3.4.2. Graph Acceptance

- Figure 5 shows an example of an acceptable make-up signature.
- Figure 7 shows examples of unacceptable make-up graphs.
- Contact Fermata® Support for any graph irregularity's acceptance.
- See FT-RP-000 General Running Procedure for further examples.



NOTE: Irregular torque build and loss of linearity near final torque. Break-out, inspect the connection and remake-up with less thread compound.

(a)



NOTE: High or unachieved lock point. Break-out, inspect the connection and remake-up with less thread compound.

(b)

Figure 7 – Examples of unacceptable make-up graphs.

Contact Information:

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