1. Scope

This document is to be used for field make-up acceptance of the Bushmaster® GT Connection, and Bushmaster® GT-IPC Connection with no seal ring.

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

Bushmaster® GT Connection:

- Threaded and Coupled
- Constrictor® wedge locking thread form
- Metal Seal



Figure 1 – Product Image

1.2. Approvals

Created	Angela Hill – Product Engineer	11/13/2026
Reviewed	Israel Martinez – Quality Director	11/13/2026
Approved	Wesley Ott – Director of Engineering	11/13/2026

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1.3. Contents

1. Scope 1
1.1. Product Description 1
1.2. Approvals 1
1.3. Contents 2
1.4. Reference Documents 2
2. Connection Running 3
2.1. Connection Compatibility 3
2.2. Thread Compound Application 4
2.2.1. Approved Compounds 4
2.2.2. Compound Amount 4
2.2.3. Thread Compound Application 5
2.3. Connection Make-Up 6
2.3.1. General 6
2.3.2. Bushmaster® GT Torque-Turn Plot 6
2.3.3. Make-up Acceptance Criteria 7
2.3.3.1. Make-up Indicator 7
2.3.3.2. Graph Acceptance 8

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.

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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

- Common box connection for multiple pin weights.
- Different pin weights have different wall thickness and critical sections while box is unchanged.
- Different weights have different make-up torques. See CDS for torque range.

Table 1: Interchangeability Chart

OD (inches)	Compatible Weights (lb/ft)
2.875	6.40
	7.80
3.500	9.20
	10.20
	12.70
4.500	11.60
	12.60
	13.50
	15.10
5.000	18.00
	21.40
	23.20
5.500	15.50
	17.00
	20.00
	23.00

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7.000	23.00
	26.00
	29.00
	32.00
	35.00
7.625	26.40
	29.70
	33.70
9.625	36.00
	40.00
	43.50
	47.00
	53.50

Confirm compatibility in Table 1 and performance properties prior to running. Careful consideration of the performance properties of the weakest connection must be made by the operator.

2.2. Thread Compound Application

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

2.2.1. Approved Compounds

- Jet-Lube Seal-Guard or BESTOLIFE 72733

2.2.2. Compound Amount

Refer to Table 2 for the required thread compound volume:

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Table 2: Thread Compound Amount

OD (inches)	Volume (mL)
2.875	2.0
3.500	2.0
4.500	3.0
5.000	3.5
5.500	4.0
7.000	5.0
7.625	6.5
9.625	6.5

2.2.3. Thread Compound Application

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

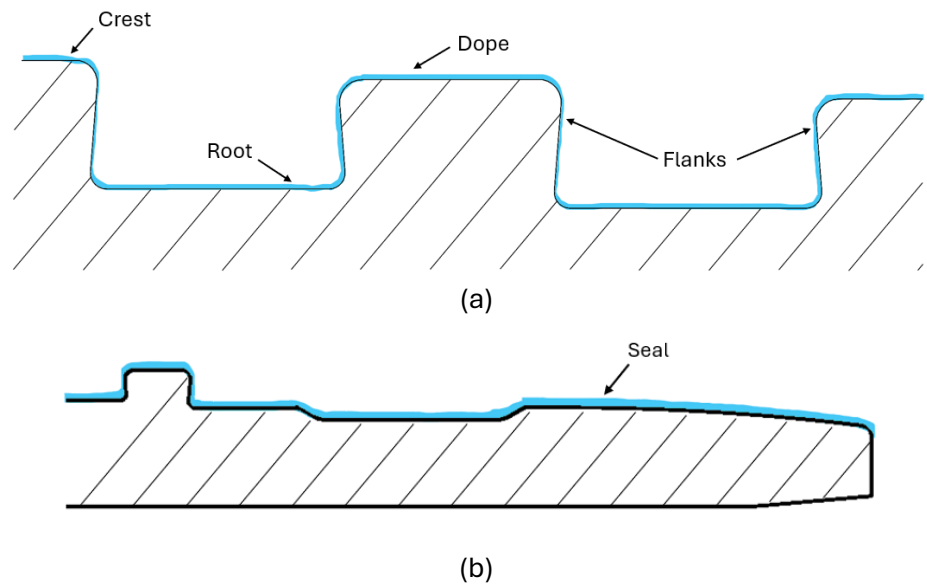


Figure 2 – Thread Form (a) and seal area (b).

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See Figure 3 and Figure 4 for visual reference.



Figure 3 – Pin Connection

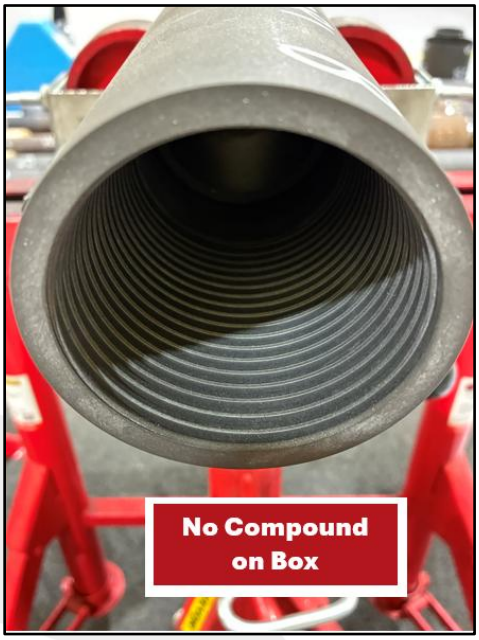


Figure 4 – Box Connection (**no** compound)

2.3. Connection Make-Up

2.3.1. General

See FT-RP-000 General Running Procedure

2.3.2. Bushmaster® GT Torque-Turn Plot

- Verify the make-up result against Figure 5.
- For Bushmaster® GT, 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.

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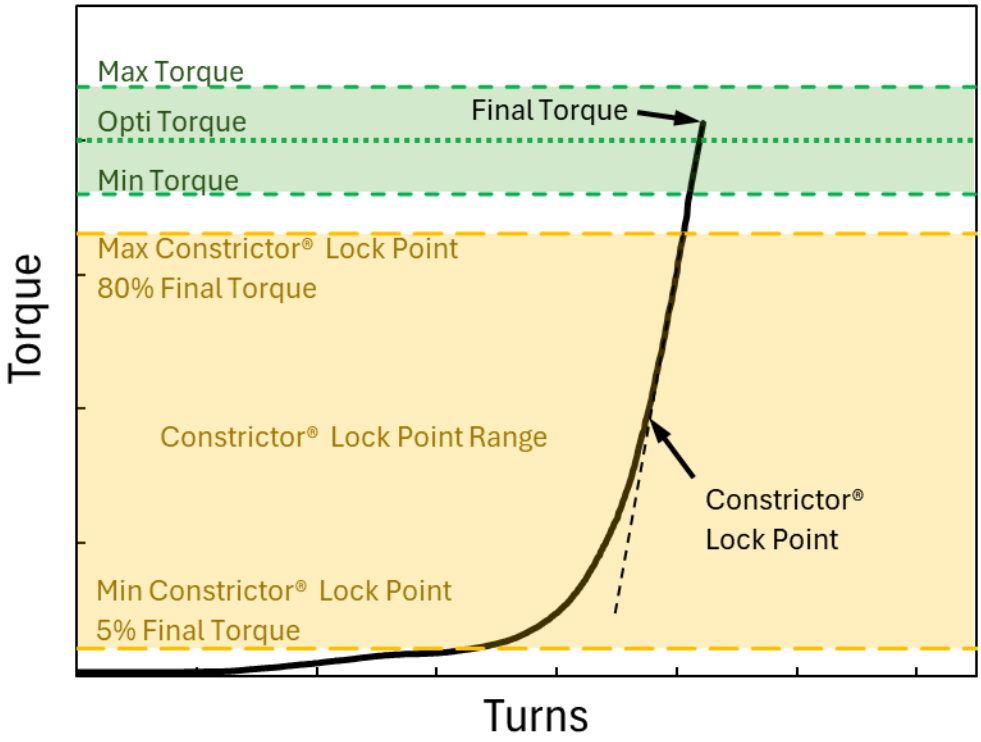


Figure 5 – Bushmaster® GT Torque-Turn Signature

2.3.3. Make-up Acceptance Criteria

Connections are accepted based on required graph elements (2.3.2), and Knurling/Triangle stamp make-up indicators.

2.3.3.1. 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 at least to the base of the triangle but not past the tip.

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 at least to the base of the knurl but not pass over full width.

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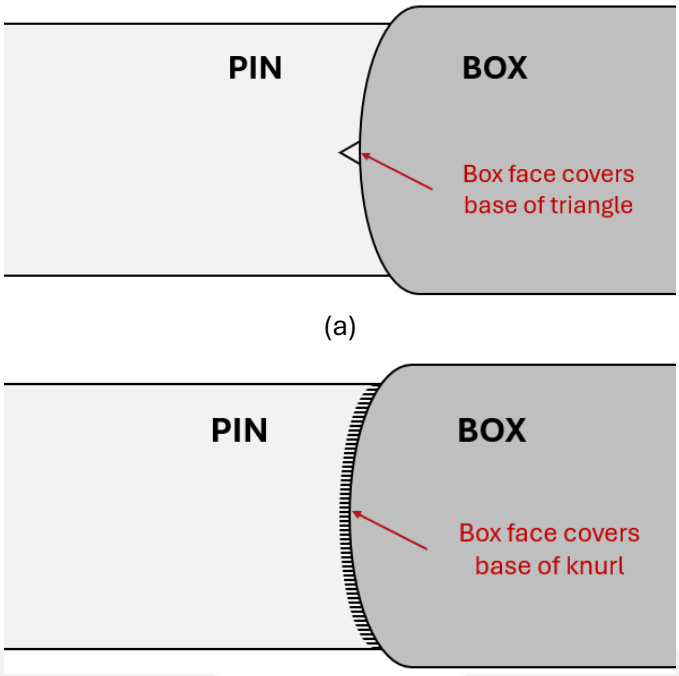
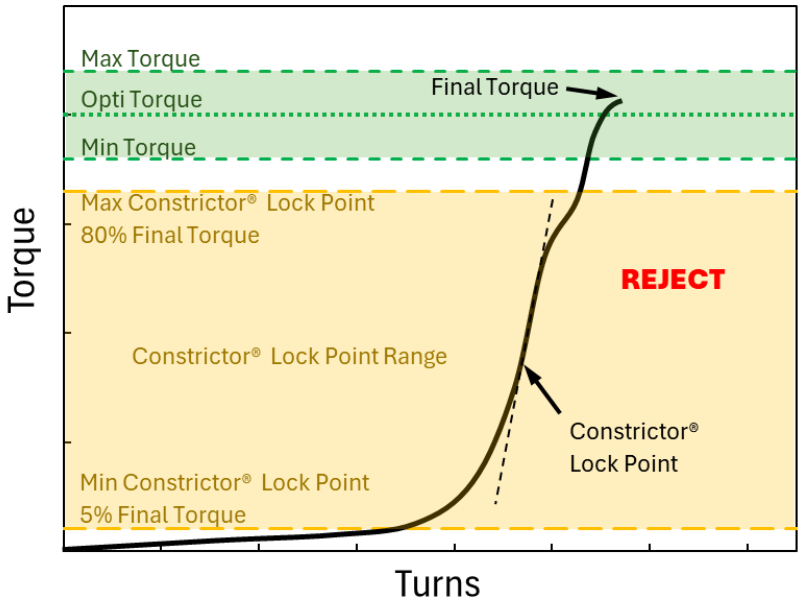


Figure 6 – Triangle stamp after make-up (a) and knurl after make-up (b).

2.3.3.2. Graph Acceptance

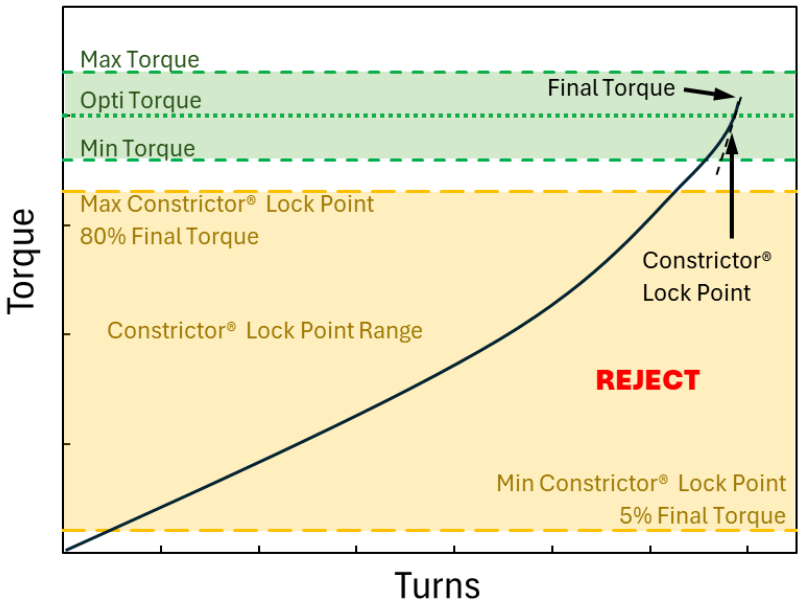
- Figure 5 shows an example of an acceptable make-up signature.
- Figure 7 shows examples of unacceptable make-up graphs.
- Contact Fermata® Support for any graph irregularities acceptance.
- See FT-RP-000 General Running Procedure for further examples.

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NOTE: Irregular toque 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.

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Contact Information:

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Field Services 24/7 Operations: (855) 322-7104

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