

MODEL

3416AS All Stainless Saddles for Pipe OD's 24" and above.



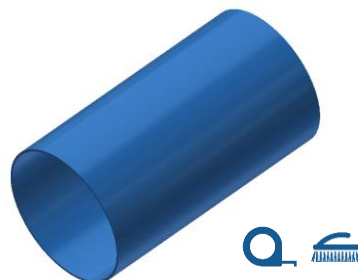
PowerSeal
PIPELINE PRODUCTS CORPORATION

Quality control department **SAFETY FIRST** - Always use cave in protection, gloves, sturdy work boots and eye protection when tapping pipe

GENERAL NOTES:

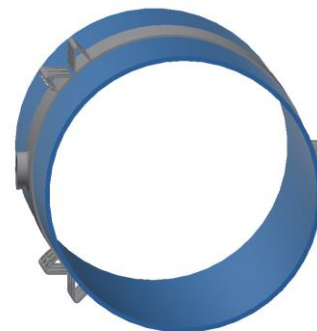
- 1 - Use cave-in protection during excavation and back-fill operations.
- 2 - Verify Pipe O.D. to make certain that the correct Service Saddle is being installed.
- 3 - Keep bolt threads clean and free from nicks, dents or other damage.
- 4 - If conditions permit, mark the pipe for a reference point to properly position the Saddle.
- 5 - Lubrication of the twinseal with a soapy solution reduces friction and more evenly distributes clamping force. For cold weather lubrication, ethylene glycol can be added to the soap solution to prevent freezing.
- 6 - Bolt threads must be kept clean and free from damage. The fitting should not be thrown around or otherwise be abused, i.e. stored on truck without box, dropped from top of ditch, etc.
- 7 - Installation of this fitting with a pneumatic wrench may cause seizure of the nut. A deep socket and ratchet wrench is recommended.

1



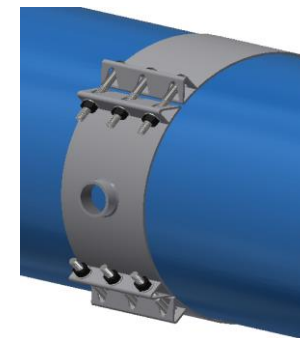
Thoroughly clean the pipe where the saddle will be installed. There should be no foreign debris between the Gasket and the pipe surface. Double check OD so that it matches part size.

2



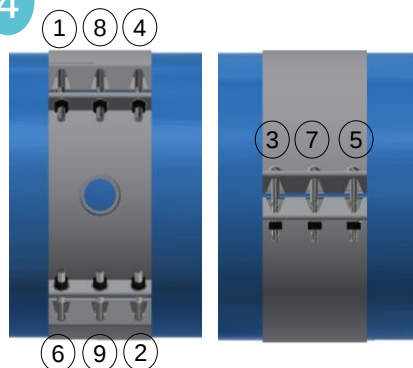
Position both back panels and top panel (outlet side) of the saddle locating the outlet in the desired position.

3



Install bolts, washer, and nuts on drop in lugs. Tighten maintaining an even gap distance between the bolt lugs on all three sides of the saddle. 25ft-lb increments recommended.

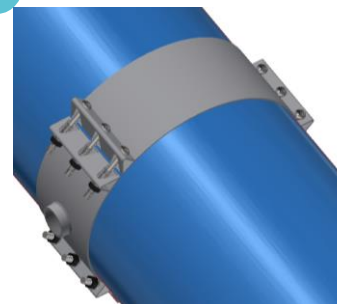
4



Tighten bolts in sequence, beginning at the ends of the saddle and alternating on all three sides. **The gap between the lugs must be equal distance when saddle is fully tightened.**

RECOMMENDED TORQUE	
Bolt Diameter	Torque (ft-lb)
5/8"	70 - 100

5



If necessary, to reposition loosen nuts prior to moving saddle and then re-torque. Hydrostatically pressure test the saddle before tapping the pipe.

Notes

- Tap through corporation stop Utilizing a **Vega Drill** for best results on plastic pipe.
- **Leave each connection exposed and field pressure test prior to backfilling to assure proper installation on the pipe.**
- Retorque the nuts after field testing to compensate for pipe expansion.