



Smith-Blair  
a xylem brand

# Installation Instructions

## 325

### Bronze/Brass Service Saddle

#### **STEP 1**

Inspect the shipment received to ensure no damage has occurred during transit and that no hardware is missing. Ensure the received saddle is the proper type, tap size, and correct pipe size range for the installation prior to beginning.

#### **STEP 2**

Clean pipe surface thoroughly, particularly in area where gasket will seat. Be sure to remove any scale, dirt, or debris that could affect the gasket seal.

#### **STEP 3**

Check gasket for proper positioning in saddle body. If loose, position gasket in saddle body.

#### **STEP 4**

Lubricate pipe and face of gasket with suitable lubricant. Antifreeze should be added in freezing weather.

#### **STEP 5**

Mount saddle body (with gasket in place) on pipe. Care should be taken to mount saddle body as close to final tap position as possible.

#### **STEP 6**

Install saddle bale(s), nut(s), and washer(s). Washer(s) are to be used on the open lug side of the saddle body.

#### **STEP 7**

Prior to tightening, check the position of the saddle body to ensure correct location on pipe. Moving or rolling the saddle body while on the pipe is not recommended and may cause damage to the gasket resulting in product failure.

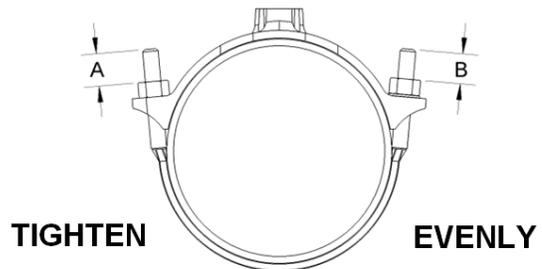
#### **STEP 8**

Tighten nuts progressively and uniformly to recommended torque values below. **DO NOT OVER TORQUE.** Bolt length A & B must be kept equal. See below.

NUT SIZE	TORQUE VALUE*
5/8"	60-70 FT. LBS.

*Use of a calibrated torque wrench is recommended!*

*\*The torque requirements above are only intended to provide an effective seal between the saddle gasket and the pipe. The saddle assembly is not designed to provide structural rigidity for connections, equipment, or any alternate use of the saddle assembly.*



#### **STEP 9**

Make connection to the saddle boss. Suitable pipe thread sealant is recommended. Care should be taken not to cross thread or twist/rock the saddle body while making the connection. Pressure testing for leaks prior to making the tap is recommended.



# Installation Instructions

## 325

### Bronze/Brass Service Saddle

*This section was intentionally left blank*

#### **California Proposition 65 Warning**

**⚠ WARNING:** This product can expose you to chemicals including lead and lead compounds, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov).

#### **WARRANTY**

Smith-Blair® warrants its products only against defects in materials and workmanship. Smith-Blair's liability and customer's exclusive remedy under this warranty or any warranty extends for a period of one (1) year from the date of Smith-Blair's ship date and is expressly limited to repayment of the purchase price, repair, or replacement, at Smith-Blair's option, during said period, upon proof satisfactory to Smith-Blair® and upon customer's returning and prepaying all charges on such products to factory or warehouse designated by Smith-Blair.

This warranty is made expressly in lieu of all other warranties, expressed, implied or statutory, with respect to quality, merchantability or fitness for a particular purpose.

10/11

#### **NOTICE**

Metal products are subject to corrosion, particularly when used outdoors and/or underground. A large number of factors and local conditions affect the rate of corrosion. Consult a local corrosion expert to determine the life expectancy of this product when used with your pipeline content, soil, and environment. Also, consult your system designer to determine the suitability of this product in your piping system. Failure to determine the suitability of this product in your application, soil, and/or environment can result in premature product failure. Smith-Blair® will provide additional information about this product's material specifications at your request. You may also obtain product information at [www.smith-blair.com](http://www.smith-blair.com).

2/17