



Installation Instructions

Type 623

Tapping Sleeve

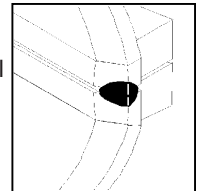
with Ductile Iron Followers and Connector Links

Step 1

Thoroughly clean the pipe surface three inches on either side of the gasket sealing areas. Be sure the gasket bearing surfaces are free of blemishes that may impair the fitting seal.

Step 2

Lightly lubricate the side gaskets with potable lubricant. Mount both halves of the tapping sleeve around the pipe. Install the side bolts and nuts. Verify side gaskets are lined up in the mating sidebar grooves.



Step 3

Tighten the side bolts (from the center toward the ends) until the side lugs just start to compress the side gaskets.

Step 4

Center the assembled body around the pipe OD. Using a razor sharp knife, trim the ends of the side gaskets flush with the flare face. The ends of the gaskets must be flat and smooth

Step 5

Torque the side bolts to 20 ft-lbs.

Step 6

Lightly lubricate the end gaskets with potable lubricant. Place the end gaskets around the pipe with the taper toward the body. Position the end gaskets against the body with the split seam rotated about 45-degrees from the side bars.

Note: For ease of assembly, the cut ends may be held in place by staples or sparing use of glue (super glue). If glue is used, ensure no glue is left on the gasket sealing surfaces.

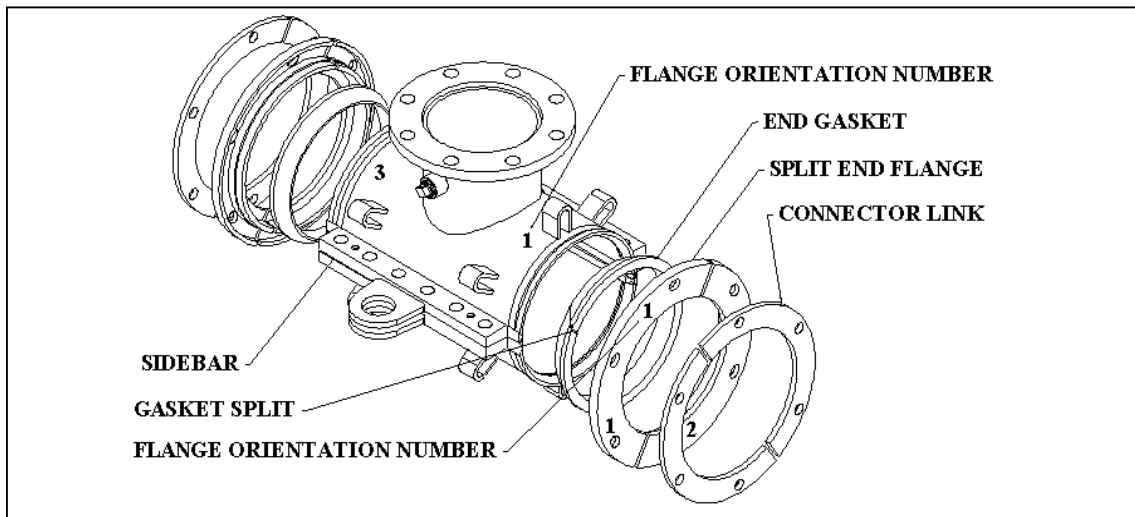
Step 7

Position the split follower flanges (with the identification numbers on the body and on the followers lining up) against the end gaskets with the split rotated about 45-degrees from the side bars and the end gasket seam. Position the connector link against the follower flange with the connector link split rotated about 45-degrees to the follower flange split and the sidebar split.

Note: The orientation numbers on the body and on the followers must line up.

Step 8

Install the follower flange bolts and nuts. Torque the follower flange bolts to 30 ft-lbs. Re-torque the sidebar bolts to 80 ft-lbs. Re-torque the follower flange bolts to 60 ft-lbs. Check that all the bolts are at their recommended torque values.



Step 9

Hydrostatic pressure test the completed assembly. Smith-Blair Inc **does not recommend** pneumatic pressure testing of tapping sleeves for safety reasons.

Step 10

Install a properly cribbed tapping valve and tapping machine. Proceed with tapping the pipe.

Step 11

Recheck that all bolts are at their recommended torque value prior to backfill.



Installation Instructions

Type 623

Tapping Sleeve

with Tabbed Steel Follower Flanges

Step 1

Thoroughly clean pipe surface three inches on either side of the gasket sealing areas. Be sure the gasket bearing surfaces are free of blemishes that may impair the fitting seal.

Step 2

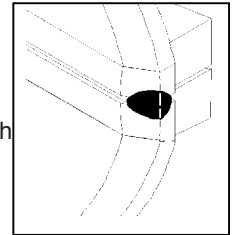
Lightly lubricate the side gaskets with potable lubricant. Mount both halves of the tapping sleeve around pipe. Install the side bolts and nuts. Verify side gaskets are lined up in the mating sidebar grooves.

Step 3

Tighten the side bolts (from the center toward the ends) until the side lugs just start to compress the side gaskets.

Step 4

Center the assembled body around the pipe O.D. Using a razor sharp knife, trim the ends of the side gaskets flush with the flare face. The ends of the gaskets must be flat and smooth



Step 5

Torque the side bolts to 20 ft-lbs.

Step 6

Lightly lubricate the end gaskets with potable lubricant. Place the end gaskets around the pipe with the taper toward the body. Position the end gaskets against the body with the split seam rotated about 45-degrees from the side bars.

Note: For ease of assembly, the cut ends may be held in place by staples or sparing use of glue (super glue). If glue is used, ensure no glue is left on the gasket sealing surfaces.

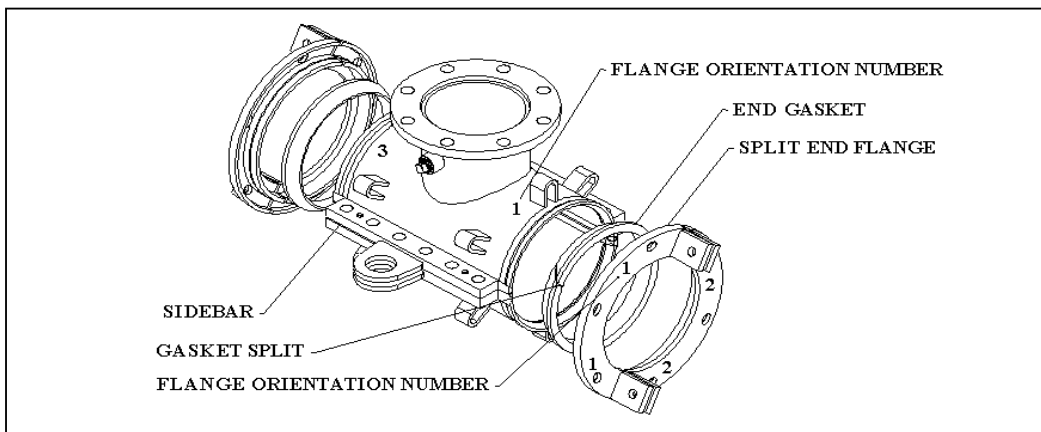
Step 7

Position the split follower flanges (with the identification numbers on the body and on the followers lining up) against the end gaskets with the split rotated about 45-degrees from side bars and the end gasket seam. Install the tab bolts and torque them to 80 ft-lbs.

Note: The orientation numbers on the body and on the followers must line up.

Step 8

Install the follower flange bolts and nuts. Torque the follower flange bolts to 30 ft-lbs. Re-torque the sidebar bolts to 80 ft-lbs. Re-torque the follower flange bolts to 60 ft-lbs. Check that all the bolts are at their recommended torque values.



Step 9

Hydrostatic pressure test the completed assembly. Smith-Blair Inc **does not recommend** pneumatic pressure testing of tapping sleeves for safety reasons.

Step 10

Install a properly cribbed tapping valve and tapping machine. Proceed with tapping the pipe.

Step 11

Recheck that all bolts are at their recommended torque value prior to backfill.