# INSTALLATION SHEET - HDPE

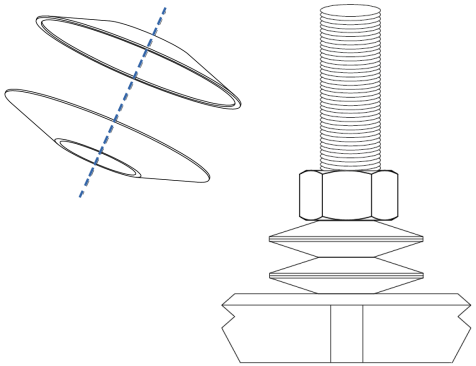
## MODEL 3416AS-PE

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**:

- Use cave-in protection during excavation and back-fill operations.
- Verify Pipe O.D. to make certain that the correct Service Saddle is being installed.
- Keep bolt threads clean and free from nicks, dents or other damage.
- If conditions permit, mark the pipe for a reference point to properly position the Saddle.
- Leave each connection exposed and field pressure test prior to backfilling and drilling to assure proper installation on the pipe.



1

Thoroughly clean the pipe so surface is smooth and free of dirty and other debris.

2

Loosen nuts until flush with top of studs.

3

Lubrication of the O-ring with a soap 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.

4

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

5

Close lug fingers and studs together by pulling the washer bar upward and snap the lip over the finger base plate. Fingers tighten nuts.

| RECOMMENDED TORQUE | |
|---|---|
| **Bolt Diameter** | **Torque (ft-lb)** |
| 5/8” | 100 - 140 |

**Waterworks pipes can experience changes due to temperature and pressure depending on the field conditions. High-Density Polyethylene Pipe (HDPE) possess mechanical and thermal properties that causes the expansion or contraction of the pipe because of these changes. Saddles with spring washers design will support those possible pipe changes without compromising the tightness of the saddle.**

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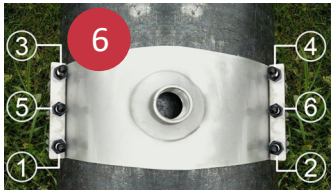
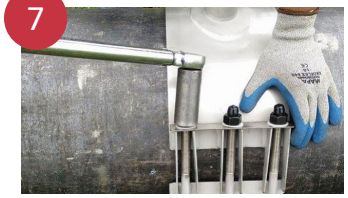



Tighten maintaining an even gap distance between the bolt lugs on both sides of the saddle. 25 ft-lb increments recommended.

Torque nuts at 100 - 140 ft-lb to form a gasket seal. Do not over torque as it will not increase sealing ability and may cause plastic pipe failure.

Tap through corporation stop utilizing a VegaDrill for best results on plastic pipe.




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

If necessary to reposition, loosen nuts prior to moving saddle and then re-torque.

If dry tapping follow the above, but also retorque the nuts after field testing to compensate for pipe expansion.

## PRE-INSTALL CHECKLIST:

**DID YOU:**

- Clean pipe surface thoroughly? [Y] [N]
- Check O.D. of pipe with measuring tape? [Y] [N]
- Lubricate the Pipe with Dishwashing Soap? [Y] [N]
- Verify Proper Torque Required? [Y] [N]
- Bring the proper equipment required to support the valve during the tap? [Y] [N]
- Warranty Checklist (*):
- Date of Installation __/__/____
- Time of Installation _____ [AM] [PM]
- Was Pre-Tap Pressure Test completed to appropriate pressure level? [Y] [N]

- What Pressure was it tested to? ____ psi
- (PowerSeal recommends torquing in 25 ft-lb increments) * Torque Applied: _____ ft-lbs
- Was standard re-torqueing applied 5 minutes after reaching torque requirements? [Y] [N]
- Was an even gap between top and bottom shell maintained while torquing the nuts in sequence? [Y] [N]
- Was the Valve Supported During Installation? [Y] [N]

If so, with what was it supported by?

_____

• Signature of On-Site Leadman: _____

*** Must be completed on day of installation to Validate Warranty**



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