INSTALLATION SHEET - TAPPING SLEEVE

MODEL 3480CS – 3480AS – 3480CS MJ – 3480AS MJ Tapping for HDPE

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 backfill operations.
- Verify Pipe O.D. to make certain that the correct tapping sleeve 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 tapping sleeve.
- Before start, the installer shall determine the suitability of the product for his intended use and the installer assumes all risk and liability for the application of the product.

OTHER INFO:

- **FOR SS BOLTS:** To avoid galling during installation, the 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. A deep socket and ratchet wrench is recommended.
- Test the final assembly seals using the test plug on the sleeve, valve, or tapping machine. **Failure to pressure test before tapping voids all warranties expressed or implied**. **Testing with air only is prohibited and not recommended for safety reasons.**
- All PowerSeal stainless steel tapping sleeves are hydrostatically tested at the factory to qualify welds and proper forming, but field testing is required to assure sound installation.
- When certain that all seals are leak tight, proceed with the tapping operation.
- All valves and tapping equipment must be blocked (supported) before, during and after installation. Failure to do so voids all warranties.

1

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

2

Check the main outside diameter (OD) and confirm that it falls within the tapping sleeve pipe OD range.

3

Lubricate pipe and gasket with soap/water solution. **Do not use grease or pipe lubricant.**

4

Position flanged (or MJ-Mechanical Joint) half of sleeve on pipe making sure outlet is properly aligned with branch-line to be connected. Make certain that the tapered ends of the complete circle gasket are smooth against the pipe. **Never position so that rotation of sleeve is required**.

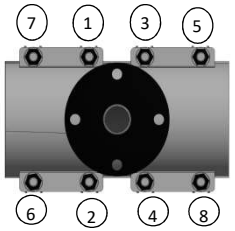
5

Position back half of sleeve over the tapered ends of the gasket being careful not to fold or roll the edges under themselves. Locate Bolts between fingers on the flanged half of sleeve.

RECOMMENDED TORQUE	
Bolt Diameter	Torque (ft-lb)
5/8″	70-100
3/4″	100-140
1″	140-200

6

Install washer bar, spring washers and nuts. Tighten maintaining an even gap distance between the panels on both sides of the sleeve. Nuts must be tighten in the order shown in the image.



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7

Begin tightening bolts in sequence, beginning at the center of the sleeve and alternating on both sides. The gap between the two halves must be of equal distance when sleeve is fully tightened.

8 Tighten both top and bottom bolts evenly, alternating from one side of the sleeve to the other. Torque according to the specifications.
Wait approximately 5 minutes to allow the gasket to fully compress and then re-tighten bolts.

9 **Pressure test the sleeve before tapping the pipe. Make sure to support the valve and the tapping equipment .Sleeve was not designed to carry the weight of the valve and tapping machine. Failure to do so voids all warranties.**

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]

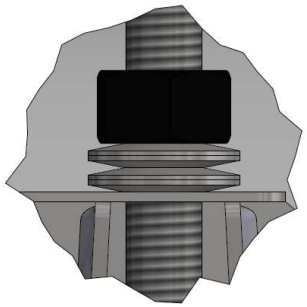
WARRANTY CHECKLIST (*):

- 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**



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. Repair clamps with spring washers design will support those possible pipe changes without compromising the tightness of the sleeve.