INSTALLATION SHEET

MODEL 3450AS SaddleCorp - Pack Joint, PowerJoint and Flare

Quality Control Department SAFETY FIRST - Always use cave-in protection, gloves, sturdy work boots, and eye protection when tapping pipe.

PowerSeal PIPELINE PRODUCTS CORPORATION

GENERAL NOTES:

Notes:

- Over torqueing will not increase the ability of the saddles to seal
- Length of bolt thread protruding past top of nut should be equal distance on both sides
- Use cave-in protection during excavation and back-fill operations.
- Verify pipe O.D. to make certain that the correct range saddle is being used.
- Keep all threads clean and free from nicks, dents or other damage.
- Lubrication of the gasket with soap solution reduces friction and more evenly distributes clamping force.
- Hydrostatic pressure test of the SaddleCorp must be done before drilling into the pipe
- When using poly tubing pipe, stiffener must be use.

Always re-tighten nuts after installation of the valve or service line.

RECOMMENDED TORQUE	
Bolt Diameter	**Torque (ft-lb)**
5/8”	50-70

1 Clean outside of pipe thoroughly, particularly in area where Twin Seal gasket will compress.

2 Confirm the PowerSeal Twin Seal saddle gasket is in the proper position in the saddle body.

3 Lubricate pipe and face of gasket with soap and water. For cold weather lubrication, ethylene glycol can be added to the soap solution to prevent freezing.

4

Position the saddle top on the pipe in the location where it is to be tapped. Rotation of the saddle should be avoided at all times.

5

Loosen nuts to the end of the bolt and install strap (s), around the pipe and through the saddle body bolt opening.

6

Tighten nuts evenly per the specifications below until saddle body conforms to pipe.

7 After drilling the pipe, close the valve on the fitting. Ensure pipe/tubing end is in good shape. If not, use a proper tool to fix the pipe/tubing to be inserted. Make sure pipe surface is smooth and free of debris or corrosion.

Note: MAKE SURE THE VALVE IS OPEN PRIOR OPERATION. Remove the adapter nut and attach pressure testing equipment pressure test to guarantee proper seal of the saddle drill following drilling equipment manufacturers recommendations.

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PACK JOINT

8

Re-install the pack joint nut. Insert pipe/tubing into the fitting until it has passed the seal gasket. Ensure the pipe/tubing diameter size corresponds with the nut that is to be installed.

9

Once the gasket begins to compress, tighten the pack joint nut 1 to 1-1/2 rotations. DO NOT USE A PIPE WRENCH. We recommend using a flat adjustable wrench. Make sure to securely tighten the clamp screw with a socket to avoid a pipe/tubing blowout.

POWERJOINT

8

Re-install the grip joint nut. Insert pipe/tubing into the fitting until it has passed the seal gasket, then leave 1/8” space from the bottom of the corp. Ensure the pipe/tubing diameter size corresponds with the nut that is to be installed.

9

Start to tighten the PowerJoint nut. Once the gasket begins to compress, tighten the PowerJoint nut all the way to the bottom. DO NOT USE A PIPE WRENCH. We recommend using a flat adjustable wrench.

FLARE

8

Re-install the flare joint nut. Insert the flare joint nut the pipe/tubing first. Use a swaging tool with the same diameter as the pipe/tubing to open the end of the pipe/tubing.

9

Tighten the flare joint nut all the way to the bottom, until making contact with the corp. DO NOT USE A PIPE WRENCH. We recommend using a flat adjustable wrench.

10 Point the end of pipe/tubing towards a free area, open the SaddleCorp valve to flush the new service line.