

Model 502 Stainless Steel Service Saddle

Read instructions before starting installation*

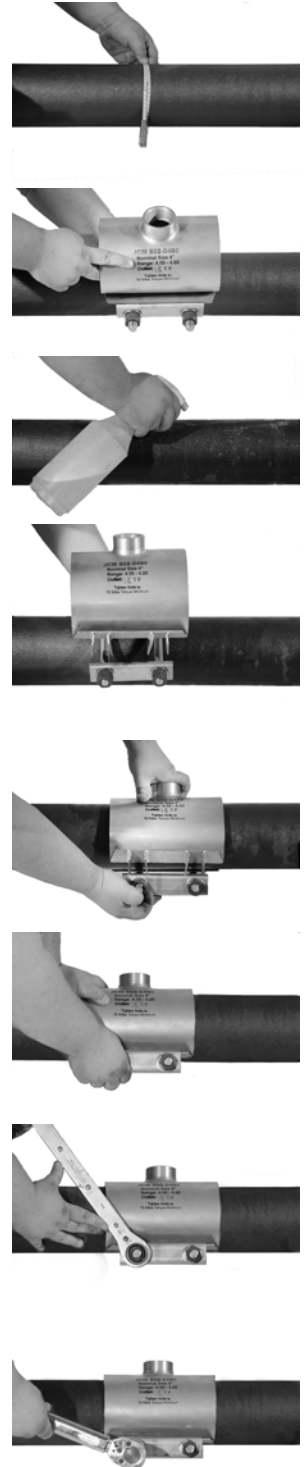
Review of "Tricks of the Trade" on the reverse will assist with installation.

1. Clean and scrape pipe. Remove any scale, pipe wrap, debris or dirt that may interfere with the complete sealing of the gasket around the outlet area. Inspect pipe for integrity, size, outside diameter and surface irregularities. Confirm the proper size and range of service saddle. Inspect fitting to ensure all parts are included. Fitting furnished with stainless steel hardware; see reverse for fastener management.
2. Lubricate the pipe and the fitting gasket with soapy water. **Do not use oil base pipe lubricant.**
3. Open the service saddle by loosening (without removing) the nuts to the top of the stainless studs/bolts. Disengage the locking "C-Plate" and lift plate to open saddle. Wrap service saddle around the pipe positioning the outlet in the proper position on the pipe. Do not rotate the saddle when the gasket is engaged and seated on the pipe, this may cause the gasket to seat improperly.
4. Loosely close the saddle around the pipe by lifting the C-Plate(s) lip over the lug system stainless receiver bar, meeting the stud and fingers, and lock in place.
5. Complete tightening of the saddle by squeezing the lugs together and tighten the nuts. **Two stud saddle:** alternate from one end to the other for equal gap between saddle halves. **Three stud saddle:** start at the center bolt and work out toward saddle ends, alternating across from one end to the other for equal gap between saddle halves. Continue tightening sequence to reach the appropriate torque levels.
6. Tighten the nuts evenly with a hand wrench to the following torque values. To ensure proper torque level, wait 15 minutes and retighten to recommended torque. *Trick of the Trade: Pneumatic wrenches could cause the stainless nuts to seize on the stainless steel studs.*

5/8" Bolts/Studs tighten to 75 Foot Pounds of Torque*

7. Proceed with tapping process.

***Ensure proper torque level with a field grade torque wrench equal to the JCM 905 Torque Wrench. Thin wall, small diameter & flexible types of pipe are subject to many variables which affect torque values. Use discretion when tightening fittings on thin wall, small diameter & flexible pipe in order to not crush or severely deform the pipe.**



INT502-0115

*Ensure fitting is suitable for application (confirm size, materials, pressure ratings, line content, meets local governing & association standards, etc.). Pipeline operation forces, including pressure fluctuations, thermal expansion/contraction, movement/shifting, etc. will influence the success of the application. Proper anchorage, restraint, harnessing, thrust blocks or other devices must be provided to prevent pipe movement (lateral, angular, axial) or pipe pullout from the bolt-on fitting. Inspection of the pipe integrity is the responsibility of the end user. JCM recommends the use of calibrated torque wrench. Failure to follow installation instructions will result in voided product warranty.



Stainless Steel Fastener Management

Model 502 Stainless Steel Service Saddle

This JCM Quality Fitting is equipped with 18-8 stainless steel bolts and nuts for superior corrosion resistance. When not properly handled it is the nature of stainless steel fasteners to gall and freeze (seize up). This is due to the inherent properties of the stainless material. Galling and freezing is often triggered by the presence of metal chips, burrs and grains of sand on the threads of the bolts and nuts. Extra care has been taken by JCM prior to assembly and packing of this fitting to assure a trouble-free installation.

1. The nuts and bolts are made from material of different hardness so that they have different strengths.
2. Standard 5/8" and 3/4" nuts are coated with a special blue or green (antiseize) coating. Additional lubricant may be needed. Uncoated stainless steel hardware is provided without lubrication to prevent a build up of dirt, sand or grit during shipment. **A Molybdenum-Base lubricant is recommended.**
3. Each nut is assembled by hand to be sure that it went on the bolt freely.
4. The bolts and nuts are handled carefully to avoid damage to the threads.
5. The bolts and nuts are made to exacting specifications to assure that the correct material is used and that the thread form is correct.

Stainless hardware is especially susceptible to galling. JCM supplies specially coated nuts to eliminate the galling caused by overtorquing, but **the bolt threads must be kept clean, free from nicks and not pitched or thrown into the tool bucket during the installation process.** Use of the **JCM 901 Master Wrench or JCM 905 Torque Wrench with Deep Socket is highly recommended.** Use of pneumatic wrench for installation could cause hardware to seize and is not recommended.