

MODEL 3425 POWERSTOP SADDLE

Quality Control Department SAFETY FIRST - Always use cave-in protection, gloves, sturdy works 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 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.**
- 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.



1 Check pipe diameter to insure that correct saddle is being installed and Thoroughly clean the pipe so surface is smooth and free of dirt and other debris.



2 Lubricate the gasket with a soap solution. For cold weather lubrication, ethylene glycol can be added to the soap solution to prevent freezing.



3 Loosen nuts until flush with top of studs, and place saddle around pipe.



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



5 Locate Nipple in desired position.



6 Torque nuts 50 to 70 ft/lbs to form a gasket seal. Do not over torque as it will not increase sealing ability and may cause plastic pipe failure.

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If necessary to reposition, loosen nuts prior to moving saddle and then retorque.

8



Tap through Corporation Stop using a VegaDrill for best results on plastic pipe.

9

Leave each connection exposed and field pressure test prior to backfilling to assure proper installation. If dry tapping follow the above, but also retorque the nuts after field testing.

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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