

INSTALLATION INSTRUCTIONS FOR All Clamp Saddles ON POLYETHYLENE PIPE—IPS



Step 1

1. **Identify the point of installation** and make sure the external surface of the pipe is free from soil, imperfections or indentations in the area of contact with the gasket.
2. **Position** the gasket in the saddle seat.
3. **Place the lower part of the saddle (i.e. the base) in the chosen point.** Couple the upper part of the saddle (i.e. the branch) with the lower one.
4. **Insert the screws from below** (the bottom part of the saddle has a recess to receive the head of the screws). Tighten the nuts alternately.
5. **Drill a hole in the pipe wall** being careful not to damage the saddle screw thread and the O-ring. Use a spacer to avoid drilling the other side of the pipe. It would be better to use a milling drill not to damage the saddle screw thread and the O-ring and in order to reduce the scraps into the pipe.



Step 2

Clamp saddles - alternative procedure -

1. **Use a white indelible felt-tip pen** to draw a reference point on the pipe to allow repositioning of the saddle. Remove the saddle from the pipe.
2. **Drill the hole in the pipe wall** and remove the scraps.
3. **Assemble the saddle according to the marked lines;** to keep the hole in axis with the branch direction It can help to use a pin, such as the drill used to make the hole.

Step 3

- **ALWAYS PRESSURE-TEST SYSTEM FOR LEAK TIGHTNESS PRIOR TO BURYING AND PUTTING INTO SERVICE.**

1. End User's Responsibility

- Ensure pipe is correct specification and that valves, fittings and pipe meet local authority requirements.
- Designed for applications up to 232psi at 68°F up to 4"
- Chemical resistance— for special applications check suitability of materials with manufacturer.



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