

# INSTALLATION INSTRUCTIONS

Read installation instructions first before installing. Check parts to ensure that no damage has occurred during transit and that no parts are missing. Also check the diameter of the pipe and the range marked on the saddle to ensure you have the proper size.

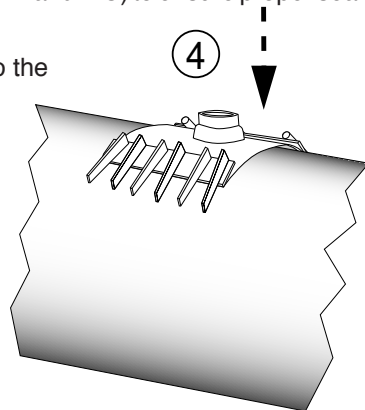
## Style 305 Stainless Steel Service Saddle

**Step 1** • Check the saddle parts to ensure that no damage has occurred during transit and that no parts are missing.

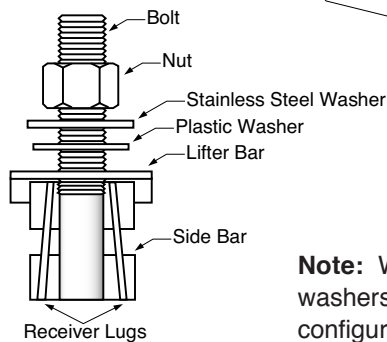
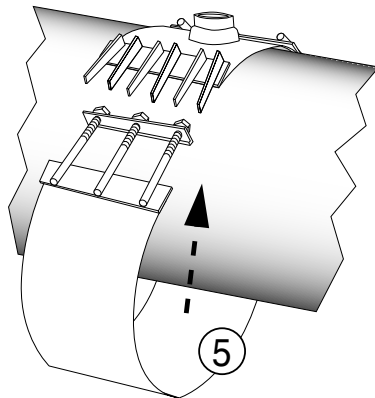
**Step 2** • Check the diameter of the pipe and the range marked on the saddle to ensure you are using the correct size saddle.

**Step 3** • Thoroughly clean pipe surface that will be covered by the saddle. A suitable gasket lubricant should be used on rough surface pipe (such as DI and A/C) to ensure proper seal.

**Step 4** • Back off nut to the end of the bolt – DO NOT REMOVE. Separate saddle sections. Place outlet half of saddle on pipe and move into position.

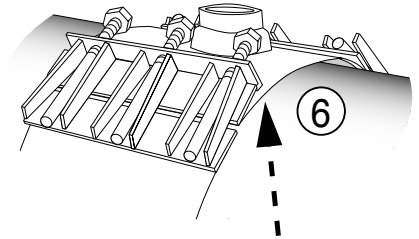


**Step 5** • Place the other section in position so that bolts are in alignment for assembly and tightening.

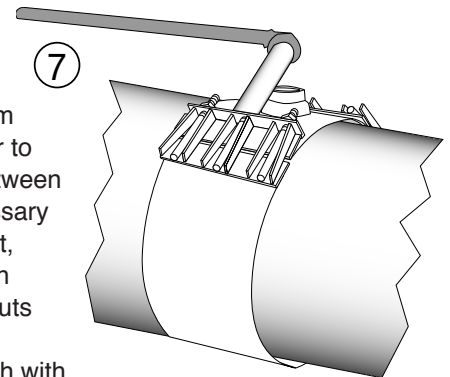


**Note:** When stainless steel washers are provided, follow configuration shown.

**Step 6** • Slide lifter bar up the receiver lug profile and snap into place over the sidebar edge. Make sure the gasket has seated itself flat onto the pipe face.



**Step 7** • Tighten all nuts evenly in 25 ft-lbs. increments. Alternate from one side to the other to equalize the gap between sections. It is necessary to retorque every nut, several times (4-8) in order to get all the nuts to stay at the proper torque. Use a wrench with at least a 12 inch handle.



Nom. Pipe Diameter	Torque
All sizes	Min. 75 ft-lbs.

**Note:**  
75 ft-lbs. torque = 12" wrench w/75 lbs. force

For best results, wait 10 minutes and then re-tighten to proper torque.

Pressure test before tapping.

Backfill and compact carefully around saddle and service line.

## Style 305 Stainless Steel Service Saddle

### PRECAUTIONS

1. Check diameter of pipe to make sure you are using correctly sized saddle.
2. Clean pipe to remove as much dirt and corrosion as possible from the surface.
3. Make sure no foreign material comes between the gasket and the pipe as the nuts are being tightened.
4. Avoid loose fitting wrenches, or wrenches too short to achieve proper torque on the nuts.
5. Keep threads free of foreign material to facilitate tightening.
6. Bolts are often not tightened enough when a torque wrench is not used. Take extra care in this situation to make sure that proper tightening occurs.
8. Pressure test for leaks before backfilling.
9. Backfill and compact carefully around saddle.
10. When reinstalling parts with stainless steel hardware there may be a loss in pressure holding ability due to worn or damaged threads during the original installation.

### COMMON INSTALLATION PROBLEMS

1. Bolts are not tightened to the proper torque.
2. Rocks or debris between pipe and gasket.
3. Dirt on threads of bolts or nuts.
4. Not properly supporting the branch pipe.
5. Improper backfilling around branch pipe.
6. Gap between sections not equal.
7. Receiver lugs are pinned against the edge of the shell, instead of overlapping.