

# 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 FTS420T Fabricated Steel Service Saddle

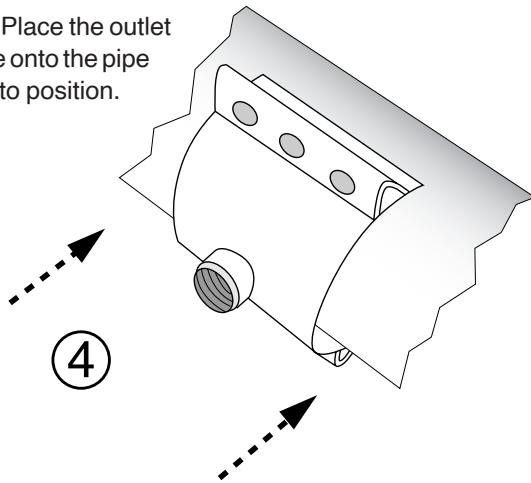
(Not recommended for IPS size PVC pipe)

**Step 1** • Clean pipe surface, particularly in the gasket sealing area.

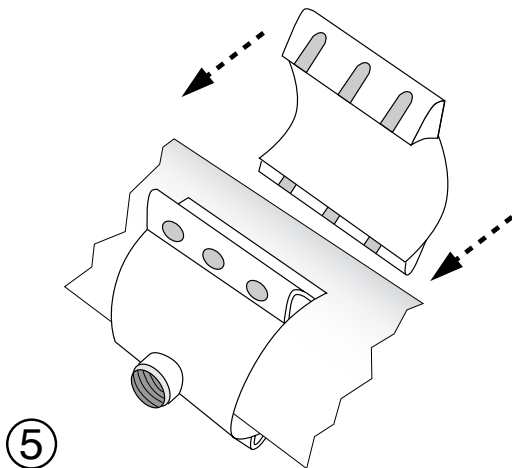
**Step 2** • Remove bolts and separate sleeve halves.

**Step 3** • Lubricate gasket and pipe surface in the gasket sealing area with a suitable gasket lubricant.

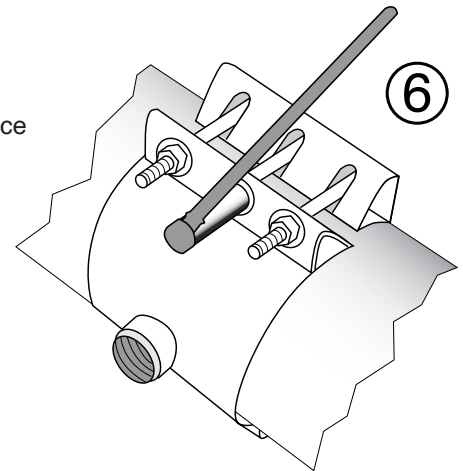
**Step 4** • Place the outlet half of sleeve onto the pipe and move into position.



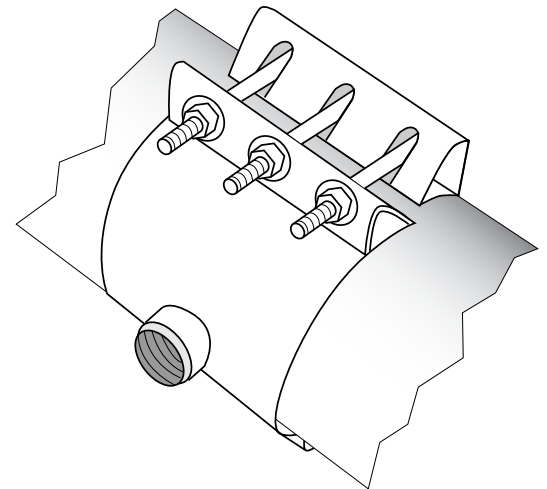
**Step 5** • Bring the back half of sleeve into position, and insert the bolts.



**Step 6** • Replace bolts and tighten uniformly to 90-100 ft-lbs. torque.



**Step 7** • Install tapping equipment.



**Step 8** • Tapping equipment must be supported so that its weight is not supported by the sleeve

## Style FTS420T Fabricated Steel Service Saddle (Not recommended for IPS size PVC pipe)

### PRECAUTIONS

1. Check diameter of pipe to make sure you are using the correctly sized sleeve.
2. Clean pipe to remove as much dirt and corrosion as possible from the surface.
3. Make sure no foreign materials stick to the gasket as it is brought around the pipe, nor become lodged between gasket and pipe as nuts are tightened.
4. Avoid loose fitting wrenches, or wrenches too short to achieve proper torque.
5. Keep threads free of foreign material to allow proper tightening.
6. Bolts are often not tightened enough when a torque wrench is not used. Take extra care in this situation to make sure proper tightening occurs.
7. Use suitable pipe thread sealant when making connection to saddle.
8. Always pressure test for leaks before tapping pipe.
9. Backfill and compact carefully around sleeve.
10. Do not slide gasket on pipe surface.
11. For personal safety reasons, do not use a compressible fluid (such as air) to check for water tightness.
12. **CAUTION:** 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 ERRORS

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| <ol style="list-style-type: none"><li>1. Not enough torque on bolts.</li><li>2. Rocks or debris cutting gasket.</li><li>3. Dirty threads on bolts or nuts.</li><li>4. Allowing saddle to support the cantilever load of the valve and tapping machine.</li><li>5. Not using the proper size sleeve for the pipe.</li></ol> | <ol style="list-style-type: none"><li>6. Not using thrust block or other form of restraint.</li><li>7. Using on IPS size PVC pipe.</li></ol> |
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**NOTE: Service Saddles are designed for sealing purposes only, not structural support or restraint.**