



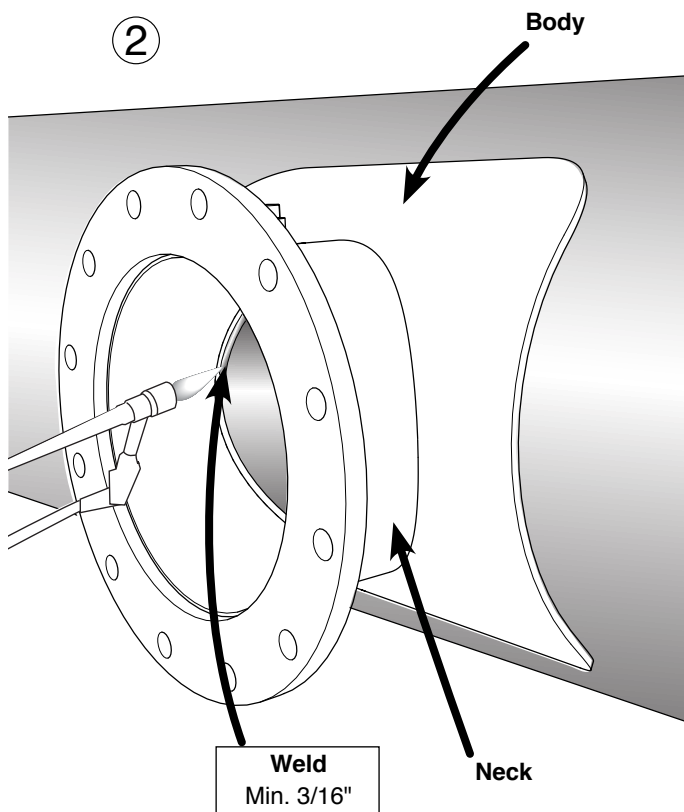
# INSTALLATION INSTRUCTIONS

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 size marked on the tapping sleeve to ensure you have the proper size.

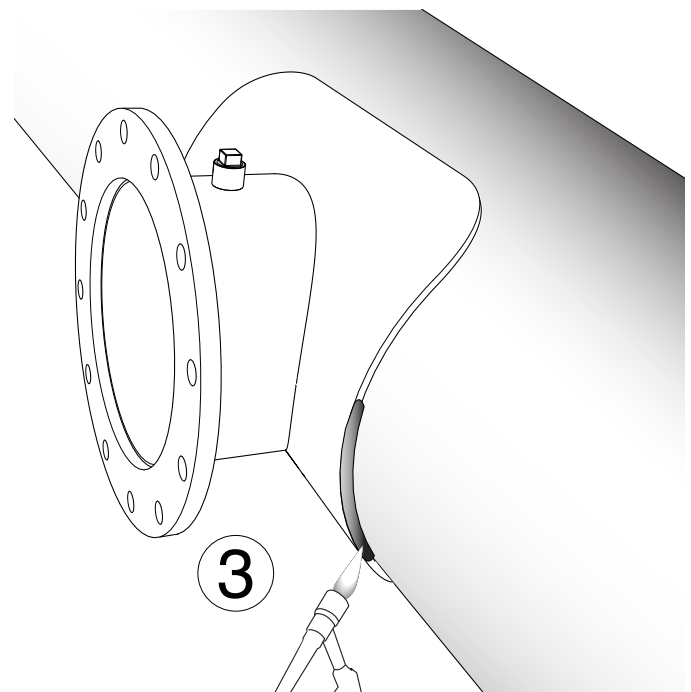
## FTS 445 Weld-On Tapping Sleeve

**Step 1** • Clean the pipe surface where the sleeve is to be welded to the pipe. Remove all loose scale, rust, paint, or other contaminants from the weld area.

**Step 2** • Care should be taken in welding the tapping sleeve to the pipe. Inside the tapping sleeve, a groove weld must be made around the inside of the neck where the neck contacts the pipe. The weld must be a minimum of 3/16".



**Step 3** • After completion of the weld inside the neck, place a fillet weld around the body of the tapping sleeve. This weld must be equal in leg length to the thickness of the pipe or the tapping sleeve body, whichever is less.



### Fillet weld

Leg length equal to thickness of pipe or tapping sleeve body, whichever is less

**Step 4** • Remove test plug and pressure test assembly to the rating of the Tapping Sleeve or the rating of the pipe, whichever is less.

**Step 5** • After pressure test of the tapping sleeve is completed, proceed with the tapping operation.

## Style FTS 445 Fabricated Steel Tapping Sleeve

### PRECAUTIONS

1. Check diameter of pipe to make sure you are using the correctly sized sleeve.
2. Always pressure test for leaks before tapping pipe.
3. Backfill and compact carefully around sleeve.
4. For personal safety reasons, do not use a compressible fluid (such as air) to check for water tightness.

**NOTE: Tapping sleeves are designed for sealing purposes only, not structural support or restraint.**