

INSTALLATION INSTRUCTIONS

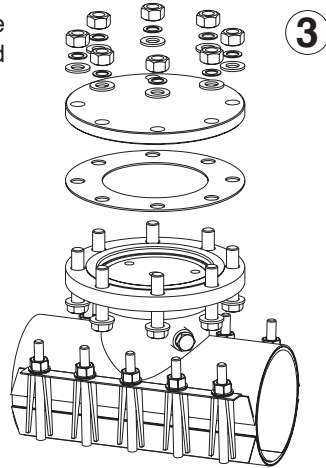
Read installation instructions first before installing. Check parts to ensure that no damage has occurred during transit and that no parts are missing. Also check the diameter of the pipe and the range marked on the tapping sleeve to ensure you have the proper size.

SST-X Stainless Steel Line Stopping Sleeve

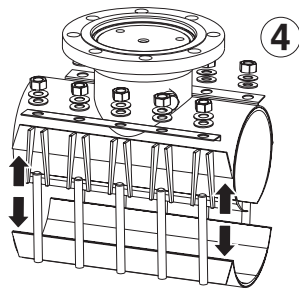
Step 1 • Confirm the diameter of the pipe and the range marked on the line stop sleeve to ensure you are using the correct size sleeve.

Step 2 • Thoroughly clean pipe surface, remove all dirt, rock, scale and foreign material in area where line stop sleeve is to be installed. A suitable lubricant should be used on rough surface pipe (Iron and A/C) to assure proper seal.

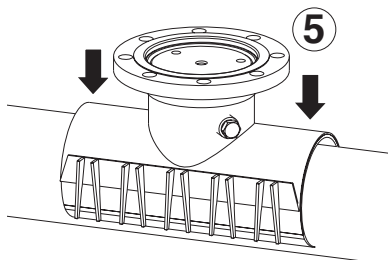
Step 3 • Remove blind flange, flange gasket and hardware.



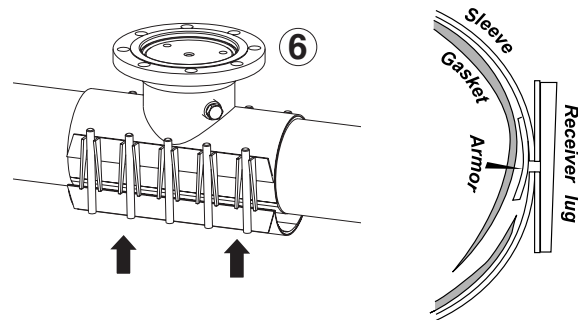
Step 4 • Remove nuts, washers, and lifter bars from bolts. Be careful not to lose any parts. Separate top and bottom sleeve halves.



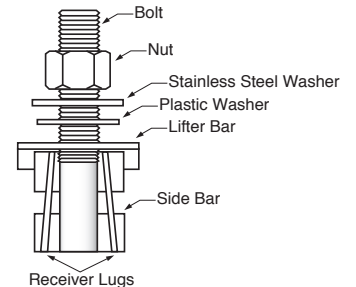
Step 5 • Place outlet half of sleeve on top of the pipe and move into position, being careful not to fold the gasket.



Step 6 • Bring the back half of the sleeve into position, making sure that the bolts are located between the mating receiver lugs on the outlet half of the sleeve. Check all gasket edges to be sure they overlap and are not folded. Confirm that the armor is between the back half and the pipe.



Step 7 • Replace lifter bars first, washers and nuts in the sequence shown at right. Make sure that the plastic washer goes on **FIRST**, followed by the stainless steel washer and then the nut. It is important that the washers are installed in this order.



Step 8 • Well-tightened nuts are important to ensure a full-circle seal. Tighten nuts, starting with center bolts, alternating on either side of the sleeve. Tighten all nuts evenly in 25 ft-lb. increments maintaining an even gap between the sleeve halves. After reaching the appropriate torque on the final nut, retighten all nuts using the same alternating pattern, to the minimum torque value listed below.

Nom. Pipe Diameter	Torque
4"	60 ft-lbs.
6" - 12"	minimum 75 ft-lbs.

Note:
60 ft-lbs. = 12" wrench w/ 60lb. force applied
75 ft-lbs. = 12" wrench w/ 75 lb. force applied

For best results, wait 10 minutes minimum and then re-tighten to the recommended torque value.

Installation Instructions continued on back

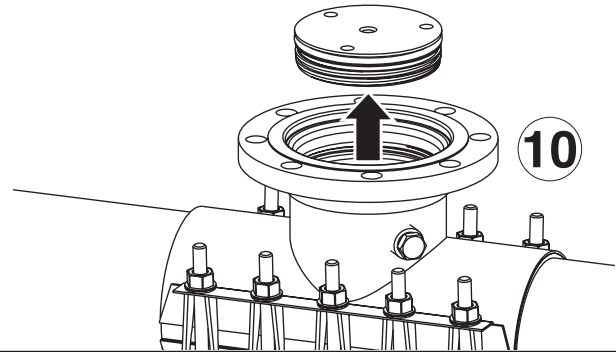
INSTALLATION INSTRUCTIONS

Step 9 • Remove the test plug and connect test apparatus to line stop sleeve assembly. Test pressure up to 1.25 times the pressure in the pipeline or to the maximum in the table (below), whichever is less. If the assembly leaks, check the following:

1. Confirm that all nuts have been torqued to the recommended torque, and retest assembly.
2. Verify that the Completion Plug is completely threaded into the neck.

Pipe Size	Working Pressure	Test Pressure
4"-8"	250	312 psi
10"-12"	200	300 psi

Step 10 • Remove the Completion Plug. Block or otherwise support the pipe and sleeve.



PRECAUTIONS

1. Check diameter of pipe to make sure you are using the correct size sleeve.
2. Clean pipe to remove as much dirt and corrosion as possible from the pipe surface.
3. Make sure that no foreign materials stick to the gasket as it is brought around the pipe, and that nothing becomes lodged between gasket and pipe.
4. Make sure that the gasket overlaps are not folded over.
5. Avoid loose fitting wrenches and wrenches that are too short to achieve proper torque.
6. Keep threads free of foreign material to allow proper tightening.
7. Use a torque wrench. Bolts are often undertorqued when a torque wrench is not used. Take extra care in this situation to make sure proper tightening occurs.
8. Install sleeve with outlet pointing up. Do not spin or rotate line stop sleeve on pipe.
9. Pressure test for leaks before tapping pipe.
10. Utilize high grade backfill and compact carefully around sleeve.
11. Bolts are quite often not tightened evenly to the proper torque. Check torque across each bolt several times before pressurizing.
12. Wear safety glasses to protect eyes during installation.
13. 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.
14. For personal safety reasons, do not use a compressible fluid (such as air) to check the assembly is water tight.

COMMON INSTALLATION PROBLEMS

1. Not enough torque on bolts.
2. Rocks or debris cutting gasket.
3. Gasket overlaps are folded over.
4. Dirty threads on bolts or nuts.
5. Line stop sleeves are designed for sealing purposes only, not structural support or restraint.
6. Sleeve size doesn't match pipe size.
7. When insufficiently restrained and supported, pipe pullout or movement may occur. To prevent movement, sufficient support must be provided using: thrust blocks, anchors, soil friction, or other restraint devices.
8. Spinning or rotating tapping sleeve on the pipe.