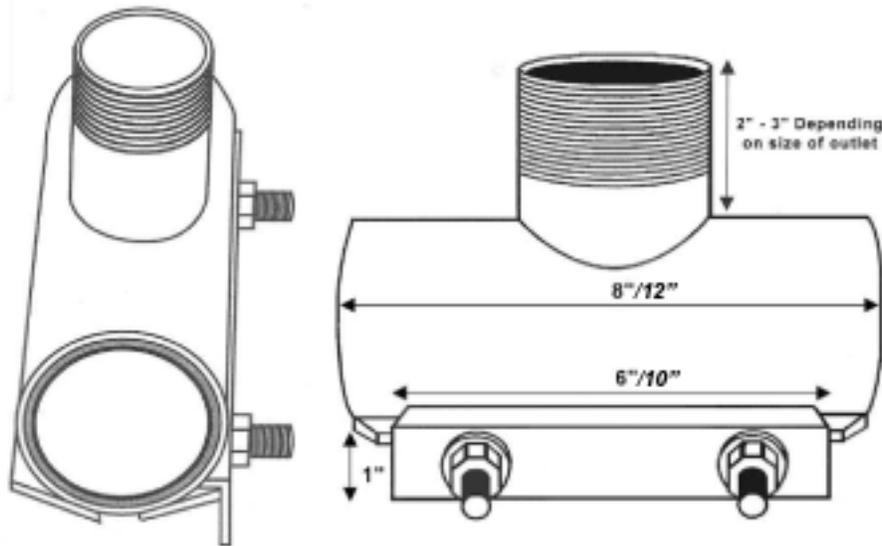




499G Copper Pipe & Small Pipe Service Saddle Installation Guide for Natural Gas/Petro Chemicals

1. Thoroughly clean the pipe surface, and inspect the area where the saddle will be installed for flaws, gouges, protrusions, excessive corrosion, etc. Irregular surfaces should be avoided to assure maximum gasket sealing.
2. Lubricate the pipe and gaskets with a light soap/water solution and center the outlet of the saddle over the desired area and continue around the pipe with the saddle.
3. Install washers, bars, flat Teflon washers and nuts. Apply anti seize lubricant to stainless studs. Evenly tighten the nuts and maintain an even gap between the ends of the panel.
4. Tighten nuts evenly, alternating from one to the other always maintaining an even gap distance between both panels. Tighten nuts in this sequence to a minimum of 50-70 ft/lb. Wait 10-15 minutes to allow the gaskets to fully compress. Minimum Maximum torque can vary depending on temperature and pipe size.
5. After 10-15 minutes, check torque again.
6. On hot water lines, especially over 130-140F degrees, allow the gaskets to fully compress, and recheck the nut's tightness after 60-90 minutes. (After adding insulation, the heat to the gasket can increase, causing additional gasket compression.)



Specifications:

- Panel: Type 304 (18-8) Stainless steel per ASTM A240
- Gasket: (60/70 SDH-Nitrile, Acrylonitrile/Butadienepolymer) with multi o-ring sealing ribs from 100% new rubber to ensure performance under varying pressures with superior storage characteristics. Suitable for oils, acids, alkalines, most Hydrocarbon Fluids (aliphatic), portable water and other chemicals within temperature range of -40 - + 180F per ASTM D2000
- Lugs: Type 304 (18-8) Stainless steel per ASTM A240.
- Bolts and Nuts: Type 304 (18-8) Stainless steel per ASTM A193 & A194.
- Note: Hex nuts are furnished with fusion bonded coating to prevent seizing and galling.
- Outlet: Type 304 (18-8) Stainless steel per ASTM A276
- All outlets are "Male Threaded NPT"
- Working Pressure: All 499G saddles are Water/Sewer Maximum of 150psi., Air/Natural Gas of 30psi.

Note: It is highly recommended by the factory that all tapping saddles be hydro tested before performing tap.

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