



GPK Saddle Installation

Without Protrusions:

1. Place saddle on pipe in the desired location. Draw the hole size by placing a marking pencil inside the branch opening and marking the pipe.
2. Using a saw (key hole or electric saber), cut $\frac{1}{4}$ " outside the line. Remove coupon from inside of pipe. Scrape any burrs that appear around the hole with a pocket knife or similar scraping tool.
3. Place saddle on pipe to assure that the pipe opening is large enough to prevent obstruction. Enlarge hole if necessary.

With Protrusions:

1. Place saddle on pipe in the desired location.
2. Draw the hole size by placing marking pencil inside the branch opening and marking the pipe.
3. Cut outside this line a distance equal to the wall thickness of the protruding lead plus $\frac{1}{4}$ ". Place saddle on pipe to assure that the pipe opening is large enough to accept the protruding lead. Enlarge hole if necessary.

Solvent Skirt:

4. Saddle and pipe surface areas that will be joined must be cleaned of dirt, moisture and other foreign materials. Use an approved PVC primer to clean and soften both surfaces.
5. While surfaces are still wet with primer apply a liberal coat of heavy body, slow set PVC cement to both the saddle and pipe.
6. Place saddle on pipe immediately and assure proper positioning. Alternate tightening of both clamps, using equal pressures, until saddle is pulled down securely. Two or more people may be required to perform the installation.
7. Wipe excess solvent cement off the pipe and saddle.

Gasket Skirt (Not recommended when air test is needed).

4. Remove dirt and foreign material from saddle gasket and wipe pipe clean.
5. Position saddle over hole, place straps into place and lightly tighten.
6. Pull side skirts of saddle outward to allow gasket to seat itself properly on the pipe.
7. Alternate tightening of both clamps, using equal pressures, until saddle is pulled down securely. Do this until a desired 60 inch-pounds is reached for each strap. A small gap will remain between the pipe and saddle.
8. Check saddle for alignment to assure that service line is clear of obstruction.
9. Wait 5 minutes and retighten straps, if necessary, so that each band is tightened to 60 inch-pounds.