INSTALLATION INSTRUCTIONS
Model 425 Service Saddle
Concrete Steel Cylinder Pipe

Read instructions before starting installation*
For purposes other than water, contact JCM Industries for application and product assistance.
For additional guidance, visit https://acppa.org/technical-resources/video-tapping-cpp/

1. Clean pipe in area where saddle is to be installed. Remove any large lumps of concrete extending beyond the normal contour of the pipe surface. Check all measurements to be certain saddle is correct size for the pipe. Check the saddle to make certain you have all necessary bolts, nuts and washers. Remove outlet gland from saddle body.
2. Position the saddle body on the pipe where the tap is to be made. Mark the area of the body opening and a 1" diameter area at the top of saddle in the "U" section between the strap receivers (this is to provide the grout opening for regrouting around the outlet). This is the area where the concrete coating is to be removed.
3. Set the saddle body aside. Connect the marked grout opening area to marked saddle opening area. Carefully strip away the concrete in the marked area, exposing the reinforcing wires and steel cylinder. Check to see if there is a weld seam in the area where the saddle gasket will seat. If there is, relocate the saddle slightly to avoid the seam. **DO NOT CUT THE REINFORCING WIRE UNTIL AFTER THE SADDLE BODY IS INSTALLED.**
4. Check the fit of the saddle body and tapped outlet to make certain that the stripped area is large enough to allow proper seating of the outlet and re-grouting around the outlet from the top of the saddle body.
5. Install the 4 oval neck outlet bolts in the saddle body (if not already installed) using the plastic washers to hold them in place. Install the straps taking care to maintain the saddle body in its proper place. Install the straps taking care to maintain the saddle body in its proper position. Install with the washers provided. If the straps do not fit the contour of the pipe, remove and reform them until they fit into the saddle. Tighten the straps evenly, alternating from one side of the saddle to the other. Tighten to approximately 70-80 foot pounds of torque.
6. Check the outlet fit once more. If everything is proper, carefully cut and remove the exposed reinforcing wires. Clean the steel cylinder of any remaining concrete and check the area where the gasket will seat to make certain it is free of seams, gouges or laminations.
7. Check the saddle gasket to make certain it is undamaged and in its retaining groove.
8. For cast ductile iron saddles, match up the flat on the outlet with the flat side of the saddle body. For fabricated saddles, inspect the outlet gland portion and note the curvature of the pressure plate (gasket side) and ensure the curvature lines up/matches the curvature of the pipe. This is especially important on large diameter pipe as the curved plate will be less obvious Install the outlet in the saddle using the 4 draw bolts previously installed around the saddle body opening. If the strap studs interfere with the outlet, they can be cut while in place. Tighten the 4 draw bolts evenly to approximately 45-55 foot pounds of torque. Note: do not exceed recommended maximum torque value on draw bolts. Excessive torque could lift the saddle body away from the pipe. Gap between saddle body and pipe surface should be 1/2" (.50 inch) or less.
9. Install the valve or corporation stop using a good thread sealant. Test all seals prior to making the tap.
10. Re-grout around the outlet and over the entire saddle assembly to provide protection to the cylinder and saddle. A mixture of 2 parts sand to 2 parts cement is recommended.

*Ensure fitting is suitable for application (confirm size, materials, pressure ratings, line content, meets local governing & association standards, etc.). Pipeline operation forces, including pressure fluctuations, thermal expansion/contraction, movement/shifting, etc. will influence the success of the application. Proper anchorage, restraint, harnessing, thrust blocks or other devices must be provided to prevent pipe movement (lateral, angular, axial) or pipe pullout from the bolt-on fitting. Inspection of the pipe integrity is the responsibility of the end user. JCM recommends the use of calibrated torque wrench. Failure to follow installation instructions will result in voided product warranty.

NSF
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To View Installation Video, Scan QR Code

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For application review or questions contact JCM Industries at 1-800-527-8482, 903-832-2581