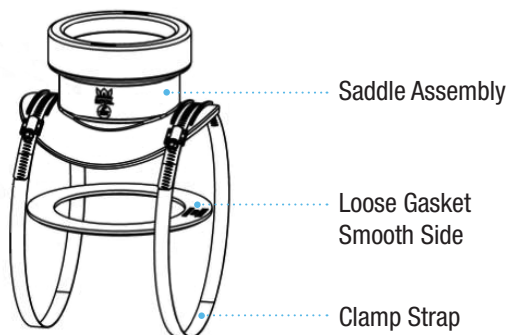




## H-Series Repair Saddles

### REHAB SADDLE WITH SKIRT GASKET

- Place the saddle (without skirt gasket) on the pipe in the desired location and orientation. Using the branch hole as a size/shape template, trace a guideline onto the pipe to mark the hole cut-in with a marking pencil. Then remove the saddle from the pipe.
- Cut a hole through the pipe wall approximately 1/4 inch (6mm) outside the guideline. Remove burrs from the cut hole.
- If the skirt has a locating ring, test fit the saddle without the skirt gasket to make sure the locating ring fits completely inside the cut hole.
- Wrap the clamp straps (provided) loosely around the pipe, engage, and slide one to each side of the cut hole.
- Clean, dry and inspect the saddle surface, gasket and pipe surface.
- Place the loose gasket on the rehab saddle skirt. Position the rehab saddle with gasket, on the pipe making sure the branch and pipe hole are aligned.
- Slide the clamp straps over the saddle skirt and into the clamp strap guides. Tighten clamp straps, alternating between them until a torque of 60 lbf\*in (6.78 N\*m) is reached. Do not over tighten. (lbf\*in = in-lb torque)
- Place and tamp the select backfill around the pipe and saddle to provide firm and continuous support for both.



### SOLVENT WELD REHAB SADDLE (WITHOUT SKIRT GASKET)

- Place the saddle (without skirt gasket) on the pipe in the desired location and orientation. Using the branch hole as a size/shape template, trace a guideline onto the pipe to mark the hole cut-in with a marking pencil. Then remove the saddle from the pipe.
- Cut the hole through the pipe wall approximately 1/4 inch (6mm) outside the guideline. Remove burrs from the cut hole.
- If the skirt has a locating ring, test fit the saddle to make sure the ring fits completely inside the cut hole.
- Wrap the clamp straps (provided) loosely around the pipe, engage, and slide one to each side of the cut hole.
- Clean, dry and inspect the saddle surface, gasket and pipe surface.
- Solvent weld the rehab saddle skirt to the pipe adapting the procedure for solvent welding joints.
- Position the rehab saddle on the pipe making sure the branch and pipe hole are aligned.
- Slide the clamp straps over the saddle skirt and into the clamp strap guides. Tighten clamp straps, alternating between them until a torque of 60 lbf\*in (6.779 N\*m) is reached. Do not over tighten. (lbf\*in = in-lb torque)
- Place and tamp the select backfill around the pipe and saddle to provide firm and continuous support for both.

