

Installation Instructions

623 Tapping Sleeve Coupling Seal

STEP 1

Thoroughly clean the pipe surface three inches on either side of the gasket sealing areas. Be sure the gasket bearing surfaces are free of blemishes that may impair the fitting seal.

STEP 2

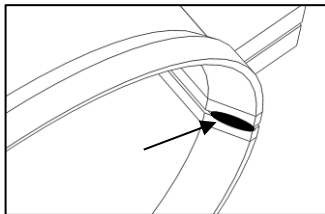
Verify lug bar gaskets are properly seated in the lug bar grooves. Lubricate the lug bar gaskets using a soap and water solution (anti-freeze may be required). All lubricant solutions should meet the requirements of the water and pipe supplier. Mount both halves of the tapping sleeve around the pipe. Install the lug bar fasteners.

STEP 3

Tighten the lug bar fasteners (from the center to the ends) until the lug bars just start to compress the lug bar gaskets (10 ft-lb).

STEP 4

Center the assembled body on the pipe O.D. Using a razor sharp knife, trim the ends of the lug bar gaskets flush with the flared/beveled face. The ends of the gaskets must be flat and smooth.



STEP 5

Torque the lug bar fasteners to 20 ft-lb.

STEP 6

Lubricate the pipe surface and end gaskets using a soap and water solution (anti-freeze may be required). All lubricant solutions should meet the requirements of the water and pipe supplier. Place each end gasket around the pipe with the taper toward the body. Position each end gasket against the body with the split rotated about 45° from the lug bars.

Note: For ease of assembly, the cut ends may be held in place with staples or sparing use of super glue. If glue is used, ensure none is left on the gasket sealing surfaces.

STEP 7

Position each split follower flange (with the identification markings on the body and follower flanges lined up) with the split rotated about 45° from the lug bars. **Do not** position the follower flange split near the end gasket split. Install the tab fasteners hand-tight.

Note: The orientation markings on the body and follower flanges must line up.

STEP 8

Install the follower flange fasteners. Torque the follower flange fasteners to 30 ft-lb. Torque the lug bar fasteners to the recommended torque. Torque the follower flange fasteners to the recommended torque. Double-check that all fasteners are at the recommended torque.

Recommended Torque	
5/8"	70 ft-lb
3/4"	90 ft-lb
1"	110 ft-lb
1-1/8"	120 ft-lb
1-1/4"	135 ft-lb

STEP 9

Proper blocking of the valve and/or tapping equipment is required. Following the manufacturer's instructions, install the tapping valve while providing thrust blocking and a permanent support beneath the valve.

Note: Smith-Blair recommends using 1/8" thick, ring style elastomeric valve flange gaskets. For mechanical joint (MJ) outlets use only gaskets, hardware, and installation procedure per AWWA C111.

STEP 10

Hydrostatic pressure test the tapping sleeve, flange gasket, and tapping valve to ensure all joints are tight and that gaskets are properly seated. **Do Not Air Test! Use Hydrostatic Test Only! Pressure test should not exceed 1.5 times actual line pressure.**

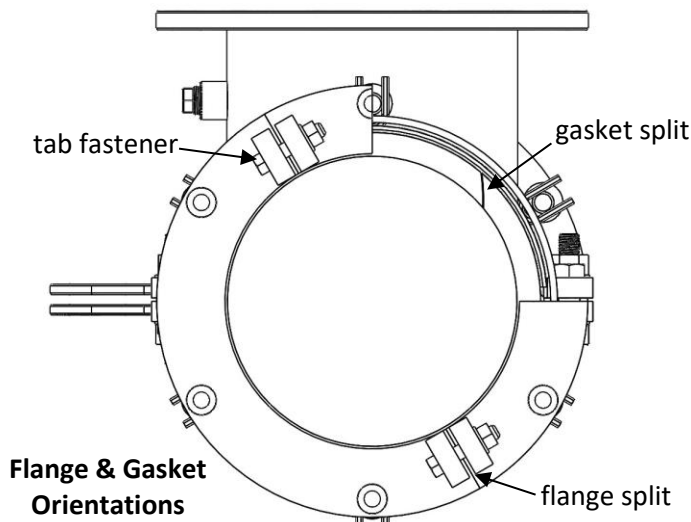
STEP 11

Using the tapping machine's manufacturer instructions, install the tapping machine to the valve and perform the tap.

Note: For size-on-size applications on I.P.S. pipe, Smith-Blair recommends a minimum of 1/2" smaller cutter. Example, for a 12" outlet on 12.75" pipe use an 11.5" cutter. Also, do not exceed the maximum cutter size your pipe manufacturer recommends for any given pipe diameter and SDR.

STEP 12

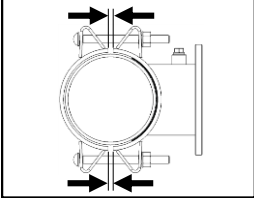
Check that all fasteners are at the recommended torque prior to backfill. If possible, check torque 12-24 hours after installation.



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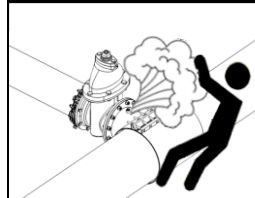
NOTICE



THIS PRODUCT REQUIRES UNIFORM TORQUE TO PROVIDE AN EFFECTIVE SEAL AGAINST THE PIPE SURFACE.

Gap distances between product halves must remain equal while product is installed. The product must be evenly tightened across the sleeve to the required torque. The product will not function properly if the nuts on only the top or bottom side of the tapping sleeve are tightened. Failure to uniformly torque the product may cause damage to the pipe and/or sleeve resulting in product failure.

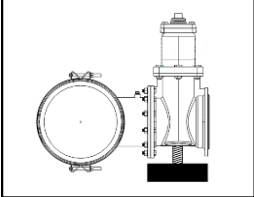
WARNING



DO NOT USE COMPRESSED AIR OR GAS TO PRESSURE TEST THIS PRODUCT.

Testing with compressed air or gas can result in violent pipe content escape resulting in property damage, serious injury, and/or death. Only a hydrostatic (water) pressure test should be used to test the integrity of the product(s) seal(s). Read the product installation instructions prior to installing this product.

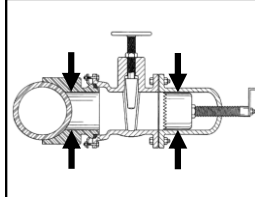
NOTICE



THIS PRODUCT IS NOT DESIGNED TO PROVIDE STRUCTURAL RIGIDITY FOR CONNECTIONS, EQUIPMENT, OR ANY ALTERNATE USE OF THE PRODUCT.

Permanent blocking and/or support for connections, equipment, or any alternate use of the product must be provided. Failure to do so may cause damage to the pipe and/or sleeve resulting in product failure.

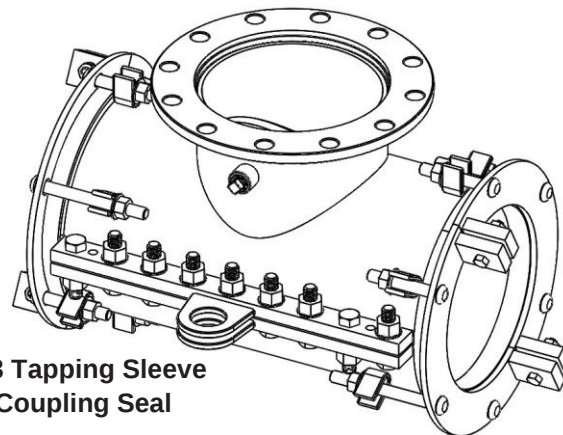
NOTICE



SLEEVE NECK/OUTLET INNER DIAMETER AND TAPPING MACHINE'S CUTTING DIAMETER MAY DIFFER.

Ensure proper clearance between cutter outside diameter and neck/outlet inside diameter by measuring. For size-on-size applications on LP S size pipe, Smith-Blair recommends a minimum of 1/2" smaller cutter. Also, do not exceed the maximum cutter size your pipe manufacturer recommends for any given pipe diameter and SDR. Failure to do so may cause damage to the pipe, sleeve, and/or tapping machine resulting in product failure.

**623 Tapping Sleeve
Coupling Seal**



WARRANTY

Smith-Blair, Inc. warrants its products to be free of defects in materials and workmanship for a period of one (1) year from the date of shipment by Smith-Blair, Inc. (the "Warranty Period"). Dated proof of purchase, such as a bill of sale, is required to establish warranty eligibility. If a product fails to perform due to a defect in materials or workmanship during the Warranty Period, Smith-Blair, Inc. will repair or, at Smith Blair, Inc.'s option, replace the product with the same or comparable item. In the event that the product cannot be repaired and a suitable replacement item is not available, Smith-Blair, Inc. will refund the original purchase price shown on the proof of purchase. In all cases, the customer is responsible for returning the allegedly defective product to the factory or warehouse designated by Smith-Blair, Inc.

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CORROSION & PRODUCT SELECTION NOTICE

Metal products are subject to corrosion, particularly when used outdoors and/or underground. A large number of factors and local conditions affect the rate of corrosion. Consult a local corrosion expert to determine the life expectancy of this product when used with your pipeline content, soil, and environment. Also, consult your system designer to determine the suitability of this product in your piping system. Failure to determine the suitability of this product in your application, soil, and/or environment can result in premature product failure. Smith-Blair will provide additional information about this product's material specifications at your request. You may also obtain product information at www.smith-blair.com.

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