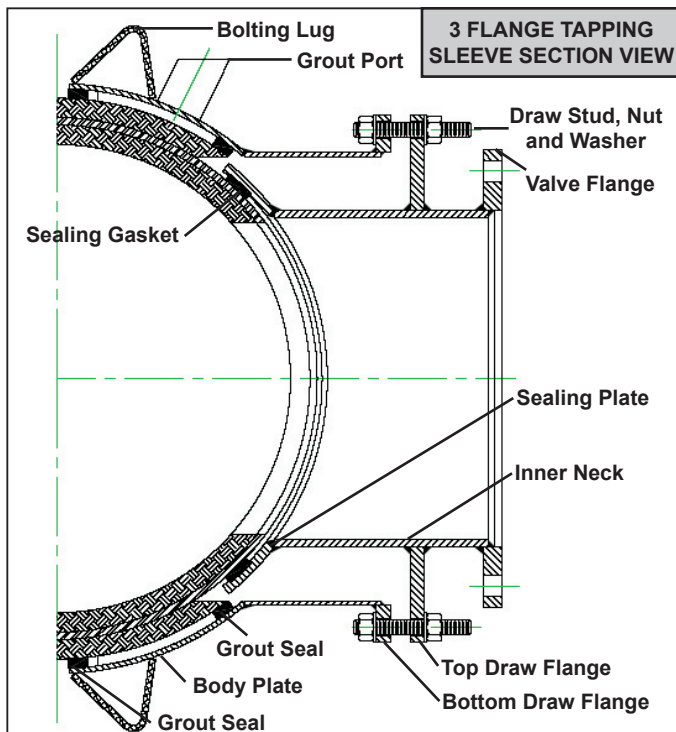
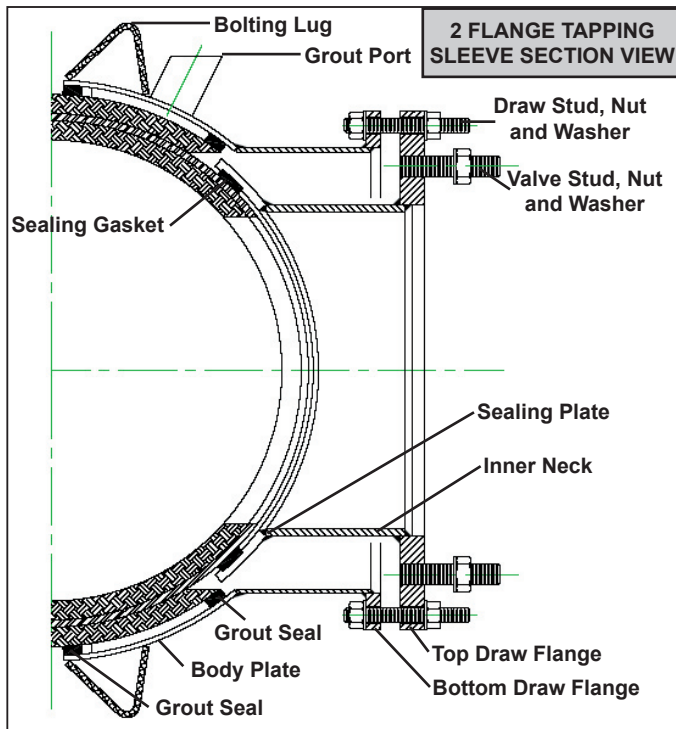




Smith-Blair
a xylem brand

Installation Instructions Type 625 Tapping Sleeve



Step 1

Verify that you have received all the proper components of your tapping sleeve. Check to make certain all grout seal gaskets are in place around the edge of the tapping sleeve body

Step 2

Excavate, expose, and clean the pipe exterior of the main pipe where tapping sleeve is to be installed.

Step 3

Remove any irregularities extending beyond the normal contour of the pipe surface.

Step 4

Position the tapping sleeve gland on the pipe and mark the area where the mortar coating is to be removed.

Step 5

Remove the gland and set it aside. Carefully remove the concrete coating from the area where tap is to be made, exposing but not damaging the pretension wires.

Step 6

Determine steel cylinder diameter.

Step 7

Check all measurements to be certain tapping sleeve is the correct size for the pipe.

Step 8

Check to make certain all grout gaskets are in place around the edge of the tapping sleeve body. Position the tapping sleeve body over the opening in the mortar coating. Verify that the grout ports are in the correct position and that you have not dislodged the grout gaskets. Install the straps (or back half) and tighten the nuts with only sufficient torque to lightly seal the grout gaskets. Alternately tighten the nuts from one side of the tapping sleeve to the other-side, starting at the outside nuts and working in toward the center of the tapping sleeve.

Step 9

Pour cement grout into the grout ports in the tapping sleeve, filling the space between the tapping sleeve and the pipe. Carefully vibrate the grout into place by pounding on the tapping sleeve with a hammer.



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Step 10

After the grout has set, torque each nut to 90 ft/lbs.

Step 11

Carefully cut and remove the exposed pretension wires. Remove the remaining portion of the concrete core to expose the steel cylinder. Clean the steel cylinder surface of any remaining mortar. If there is a weld seam on the steel cylinder in the area of the tap, carefully flatten the weld so that the tapping gland gasket will seal on it. Do not grind the weld.

Step 12

Check the gasket in the gland to make certain it is undamaged and in its retaining groove. Remove any tape used to secure the gasket in place during shipment. Back out the load bearing set screws located between the draw bolts of the outer circle.

Step 13

Install the four threaded studs in the saddle outlet to assist in properly aligning the gland. Install the gland in the saddle outlet so that the contour of the gasket seat exactly matches the contour of the steel cylinder.

Step 14

Install the remainder of the draw bolts. Check the gasket seat and all for alignment. Tighten the draw bolts evenly to compress the gasket. A feeler gauge can be used to check gasket position during tightening. When completely tightened there should be approximately 1/8" between the gland pressure plate and the steel cylinder. Do not over torque the draw bolts as damage to the steel cylinder might occur.

Step 15

After installation of the tapping gland, tighten the load bearing set screws located between the draw bolts. This

locks the gland in place and transfers any loading from the gland onto the tapping sleeve body and away from the steel cylinder.

Step 16

Install the tapping valve. Provide proper support beneath the valve.

NOTE

Smith-Blair recommends using 1/8" thick, ring style, elastomeric valve flange gaskets

Step 17

Hydrostatic pressure test the gland seal, flange gasket, and tapping valve to assure all joints are tight and the gaskets are properly seated.

Step 18

Install the tapping machine to the valve. Provide proper support beneath the tapping machine. Using the tapping machine manufacturer's instructions tap the pipe.

Step 19

Remove the tapping machine.

Step 20

Pour mortar into the opening between the tapping sleeve gland and body. Completely filling the space around the gland. A grout diaper or other wrap may be required to prevent the mortar from escaping between the draw flanges. Encase the tapping sleeve in a protective coating of mortar or concrete to a minimum thickness of 1" over the entire assembly including the straps (or back half).

Step 21

Provide thrust blocking and a permanent support beneath the valve.