

Type 105/205 Saddle Seal Installation Procedure



The 105/205 Saddle Seal is welded to the wall of a pipe as follows:

- 1.) A hole of the following diameter must be drilled in the pipe:
 - For a 3" diameter pipe drill a 2 $\frac{1}{8}$ " diameter hole.
 - For a 4" diameter hole and larger pipe drill a 3" diameter hole.
- 2.) Remove upper housing of the seal from the lower housing by removing (8) bolts. Use care so as not to damage the .004" thick diaphragm and Teflon gasket.
- 3.) Weld lower housing to the pipe as specified by the piping engineer.
Note: Excess heat from welding could distort the sealing surface inside the lower housing. It is recommended a wet rag or metal sink be placed against the sealing surface inside the lower housing.
- 4.) Reassemble the top housing to the lower housing using the (8) bolts removed in Step 2.
Note: Using a uniform cross tightening procedure, initially tighten bolts finger tight, then 3 ft-lbs, 6 ft-lbs, and a final torque of 10 to 13 ft-lbs.
- 5.) A leak test of the piping system is recommended after assembly.