



INSTALLATION INSTRUCTIONS

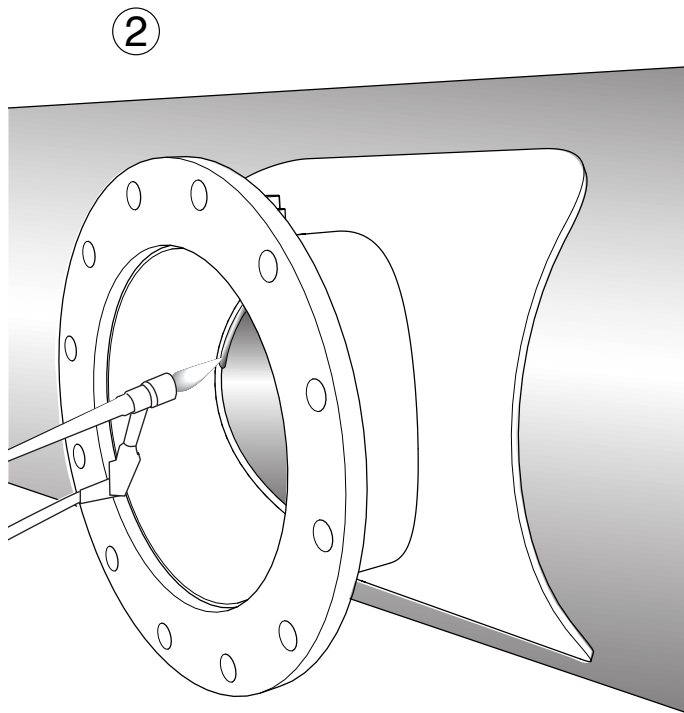
Read installation instructions first before installing. Check parts to ensure that no damage has occurred during transit and that no parts are missing. Also check the diameter of the pipe and the range marked on the tapping sleeve to ensure you have the proper size.

FTS 445 Weld-On Tapping Sleeve

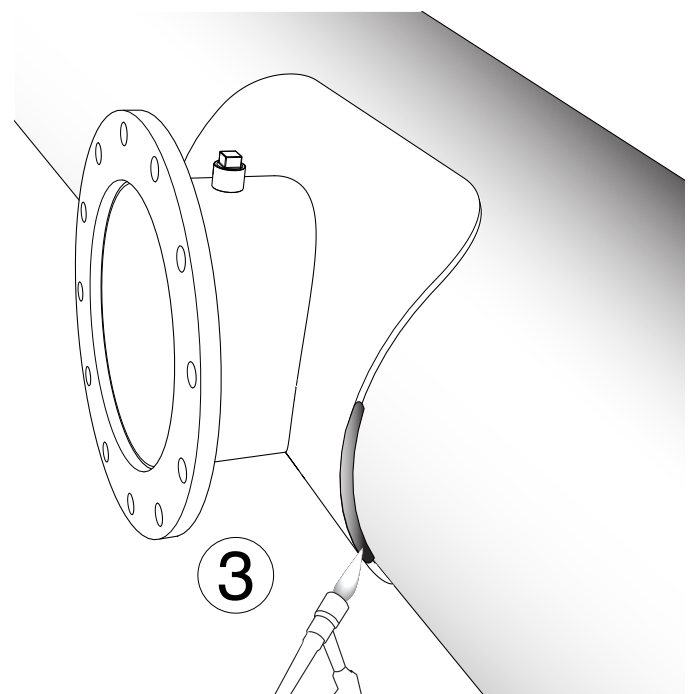
Step 1 • Clean the pipe surface where the sleeve is to be welded to the pipe. Remove all loose scale, rust, paint, or other contaminants from the weld area.

Step 2 • Care should be taken in welding the tapping sleeve to the pipe. Inside the tapping sleeve, a groove weld must be made around the inside of the neck where the neck intersects the pipe. If the tapping sleeve is epoxy coated, grind off epoxy where the weld is to be made on the I.D. of the neck. The weld must be 0.19" thick.

Step 3 • After completion of the weld inside the neck, place a fillet weld around the outside of the tapping sleeve. This weld must be equal in leg length to the thickness of the pipe or the tapping sleeve body, whichever is less.



Weld
0.19" thick



Fillet weld

Leg length equal to thickness of pipe or tapping sleeve body, whichever is less

Step 4 • Pressure test the weldment to be certain there are no leaks. Remove test plug and pressure test assembly to determine a tight joint. Test at pressure up to 1.25 times flange rating. AWWA Class D flanges, sizes 4-12 inch, maximum working pressure is 175 psi and a maximum test pressure of 220 psi. For flange sizes 14 inch and larger the maximum working pressure is 150 psi and the maximum test pressure is 188 psi.

Step 5 • After pressure test of the tapping sleeve is completed, proceed with the tapping operation.

Style FTS 445 Fabricated Steel Tapping Sleeve

PRECAUTIONS

1. Check diameter of pipe to make sure you are using the correctly sized sleeve.
2. Always pressure test for leaks before tapping pipe.
3. Backfill and compact carefully around sleeve.
4. For personal safety reasons, do not use a compressible fluid (such as air) to check for water tightness.

NOTE: Tapping sleeves are designed for sealing purposes only, not structural support or restraint.