

## 1. Intended use:

HAWLE double bracket saddle clamps with auxiliary shut-off devices are used to connect fittings to piping made of cast iron, steel and AC materials.

Max. operating pressure (potable water/waste water): 16 bar max.

operating pressure (natural gas): 4 bar

maximum bore diameter: 75 mm

During assembly, it is necessary to comply with applicable standards and regulations, accident prevention regulations and regulations from trade associations.

## 2. Product description:

HAWLE double bracket saddle clamps with auxiliary shut-off devices are used in particular for retrofitting of hydrants and air release valves on pipelines made of cast iron, steel and AC.

They can be installed under pressure (i.e. the pipeline need not be taken out of operation).

The saddle clamp is fixed to the pipe with two retaining brackets. The respective bracket length depends on the outside diameter of the pipe (please specify when ordering). The seal between the saddle clamp and the pipe is provided by the saddle seal that comes with the bracket.



Fig. 1: Double bracket saddle clamp



Fig. 2: Mounting bracket



Fig. 3: Saddle seal

## 3. Assembly:

### 3.1 Drinking water (preparation of the pipeline)

- Procedure for metal pipes with a jacket near the tapping valve: When using with a water medium, proceed according to DVGW-Merkblatt W 333 „Tapping valves and tapping process in water supply systems“.
- For ductile cast iron pipes with polyethylene-coatings in accordance with DIN 30674-1, the coating may remain on the pipe if sufficient adhesion is ensured.
- The extra cement mortar coating on a PE-coated pipe should be removed from around the tapping valve site, unless the borehole wall is sealed using appropriate measures.
- Cement mortar coating on cast iron pipes in accordance with DIN 30672-2 may remain as long as it complies with the KTW recommendations and the requirements listed in DVGW-W 347. In addition, the cement mortar coating needs to be checked for sufficient adhesion and surface smoothness as well as low mortar porosity in the vicinity of the tapping valve on the pipe.

### 3.2 Gas (preparation of the line)

- Prior to installation, any PE sheathing or other sheathing on the pipe must be professionally removed in accordance with the pipe manufacturer's specifications until only the bare metal surface is showing.
- Any existing adhesive residue and unevenness (especially in the case of cast iron pipes) must be sanded to remove all residues in the contact area for the saddle seal. In the case of „old“ and brittle lines, we also recommend applying a sealing coat around the tapping area after sanding.

### 3.3 Installation of the double bracket saddle clamp (water and gas)

- Before carrying out the following steps, the pipe that is to be tapped needs to be checked for leaks.
- The surface of the pipe needs to be free of dirt, soil or grease prior to placing the saddle clamp in the tapping area.
- Place the saddle seal and saddle clamp on the pipe.
- Align the saddle clamp and seal horizontally using a level.
- Hang the bracket on one side of the clamp body and bend it around the pipe.
- Mount the second clamp.
- Tighten the hexagonal screws alternately and evenly using the specified torque (60 - 70 Nm / max 100 Nm).  
Note: Do not use an extension!
- Tap with tapping device - (please refer to the tapping device operating instructions). The saddle clamp can be installed while the pipe is under pressure. After retracting the drill spindle, it can be temporarily closed off with a plug (feeler gauge).
- Perform pressure testing.
- After proper installation of the tapping valve, the unprotected area of the pipe between the tensioning bracket, the armature and the saddle seal needs to be properly protected by means of post-coating measures in accordance with the pipe manufacturer's recommendations (for example, suitable winding tape, shrink sleeving solutions). These instructions apply provided that the pipe manufacturer has made no other recommendations.

### 4. Maintenance:

Hawle double bracket saddle clamps are maintenance-free.

### 5. Commissioning and leakage test:

After installation, please perform pressure testing in an open trench in accordance with the DVGW regulations.

**If you have any other questions or if you need more information please contact:**

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