

## 1. Intended use / product description



<b>Medium:</b>	Potable water / municipal sewage
<b>Max. operating temperature:</b>	0° to 40°
<b>Max. operating pressure:</b>	PE pipes PE80/100 DIN 8074 / DIN EN 12201 Pipe wall thickness SDR 11: 16 bar Pipe wall thickness SDR 7.4: 16 bar PVC pipes DIN 8062 / DIN EN ISO 1452-2 Pipe wall thickness SDR 21: 10 bar Pipe wall thickness SDR 13.5: 16 bar
<b>Material:</b>	Body: GJS-400, Hawle epoxy powder coating Gaskets: EPDM acc. to DVGW W 270 Screws, washers: stainless steel
<b>Standards applied:</b>	Flanged outlet EN 1092-2

HAKU pipe saddles with flanged outlet are to be used for installation on PE and PVC pipes as specified above.

**Attention:** Not suitable for thin-walled PE pipes, e.g. pipes SDR 17!

The two saddle halves are exactly calibrated to the respective outside diameter. When connecting the saddle halves, an inadmissible deformation of the pipe is prevented by metal stops.

The flanged outlet is used for connecting valves and fittings (e.g. gate valves, hydrants, air valves, etc.)

In combination with the auxiliary shut-off facility via intermediate flange (Order No. 373-00, DN 80) and the appropriate drilling device, pipe saddles with flanged outlet DN 80 permit the trouble-free drilling of the main line, even with the line in service.

For installation, assembly, and maintenance, the applicable standards and regulations, accident prevention regulations, as well as the trade associations' provisions shall be observed and complied with.

Installation, assembly, and maintenance shall be performed by skilled personnel only.

### Accessoires:



373-00

Auxiliary shut-off device via  
intermediate flange

## 2. Installation



Open-ended wrench, torque wrench

1. The surface of the pipe must be free from dirt, soil, or grease, and the pipe has to be cleaned accordingly.
2. Place the HAKU shut-off saddle at the desired position.
3. Fix the HAKU top and bottom halves by means of the four screws included in the scope of supply, observing following torques:

M10:	max. torque	50 Nm
M12:	max. torque	70 Nm
M14:	max. torque	80 Nm
M16:	max. torque	90 Nm

### Standard installation:

Tighten the hexagon head screws evenly and crosswise until the two parts get in contact and the maximum torque is reached.

**Important:** Do not use any extensions!

### Installation on old pipes:

When the pipe saddle is to be installed on existing PE lines (old pipes), the outside diameter may be beyond the standard tolerance. Pretighten the HAKU with two longer screws, if necessary.

After final assembly of the saddle, check the maximum torque **twice after 15 minutes**, each!

4. Drill the pipe using a appropriate drilling device. Observe the relevant operating instructions. A special tapping bell (art. no. on request) must be used for tapping.

## 3. Servicing and maintenance

Hawle HAKU pipe saddles do not require any maintenance.

## 4. Commissioning and pressure-testing

After the successful installation, the device has to be subjected to pressure testing in the open trench considering the maximum operating pressures as specified in the DVGW regulations.

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

Hawle Armaturen GmbH  
- Application Engineering -  
Liegnitzer Str. 6  
83395 Freilassing  
Telephone: +49 (0)8654 6303-0  
Telefax: +49 (0)8654 6303-222  
E-Mail: [info@hawle.de](mailto:info@hawle.de)  
Internet: [www.hawle.de](http://www.hawle.de)