

## 1. Intended use / product description



**Medium:** Gas

**Max. operating temperature:** -10° to 40°

**Max. operating pressure:** 1 bar (PVC pipes only)

**Material:** Body: GJS-400  
Hawle epoxy powder coating  
Gaskets: NBR  
Screws, washers: stainless steel

**Standards applied:** Female and male threads acc. to DIN ISO 228-1

HAKU pipe saddles for bladder setting devices with female and male threads are to be used for installation on PVC pipes acc. to DIN 8062.

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.

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.

## 2. Installation

	Open-ended wrench, torque wrench
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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.



**ATTENTION:** The HAKU pipe drilling saddle must be installed at a distance of 5x DN but must be installed at least 0.5 metres away (in accordance with DVGW W 333).

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!

#### **4. Pressure-testing**

After successful installation, a pressure test must be carried out in the open pipe trench, taking into account the maximum operating pressures in accordance with DVGW regulations, in particular G469 A4 Leak test of gas house connection and gas supply lines.

#### **5. Drilling with a commercially available drilling machine suitable for gas and gas bladder setting:**

The following instructions / regulations must be observed:

Corresponding operating instructions for the drilling machine and gas bladder setting device:

DVGW G452-1 Drilling and shut-off work on gas pipes

BGR 500 Operation of work equipment

Explosion protection regulations

For the maximum drilling diameter, the nominal diameter and the condition of the pipe as well as the instructions in accordance with DVGW G465 and G466 must be observed.

#### **6. Pressure-testing**

After using the bladder setting device, the pipe drilling saddle must be sealed with a threaded plug with an O-ring.

A pressure test must then be carried out in the open pipe trench, taking into account the maximum operating pressures in accordance with DVGW regulations, in particular G469 A4 Leak test for gas house connections and gas supply lines.

#### **3. Commissioning and pressure-testing**

For commissioning and pressure testing, see the instructions in the installation procedure!

#### **4. Servicing and maintenance**

Hawle HAKU pipe saddles do not require any maintenance.

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

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