

1. Intended Use

HAWLE Universal pipe saddle for bag positioning device can be used in the gas sector for installation on cast iron and steel pipelines up to a maximum medium temperature of 45° C and a maximum operating pressure of 5 bar.

During installation and maintenance operations, the applicable standards and guidelines, accident prevention regulations and the regulations of professional associations are to be observed and complied with. Installation and maintenance operations should only be carried out by qualified personnel.

2. Product Description

Universal pipe saddle for bag positioning device with female and male threads according to DIN ISO 228-1 are to be used for installation on cast iron, steel and AC pipes from DN65 - DN500. Drilling operations without the use of an auxiliary shut-off device (ball valve) can only be carried out when the pipeline is depressurised! Connection to the main pipe is made via retaining strap and saddle seal (Order No. 310-00 or Order No. 311-00) in the corresponding nominal width.

		
Bag positioning saddle	vulcanized Hawle strap	Saddle seal

3. Installation

- Before installing, PE coatings or other forms of casing on the pipeline must be professionally removed to the bare metal surface in accordance with the specifications of the pipe manufacturer.
- Any adhesive residues or uneven surfaces (especially on cast iron pipes) must be completely sanded off in the contact area of the saddle seal. In the case of „old“, brittle pipelines, we recommend that, after sanding, a sealing coat be applied to the area of the bore hole.
- The surface of the pipe must be free of dirt, soil and grease in the area of the bore hole before mounting the saddle.



- Place the seal and saddle on the pipe.

- Then align the saddle and seal horizontally using a spirit level.



- Hook the vulcanized Hawle strap on one side of the HAWLE Universal pipe saddle body and bend it around the pipe.

- Fit the second clamping jaw.

- Tighten the hexagon head screws with the specified torque (60 - 70 Nm / max. 100 Nm) alternately and evenly. Do not use a key!
- Carry out drilling operations using a drilling device. (Follow the operating instructions for the drilling device). For drilling diameters > 45 mm please use a special saddle seal with an inner diameter of 57 mm. CAUTION: The pipeline must be in a depressurised state.

Please refer to the following table for the maximum bore diameters:

Ord. No.	Opening	max. bore diameter
352 150 0000	41 mm	40 mm
352 163 0000	53 mm	52 mm
352 163 1000	53 mm	52 mm
352 163 2000	57 mm	56 mm
352 163 3000	57 mm	56 mm
352 163 3500	57 mm	56 mm
352 163 4000	57 mm	56 mm
352 163 5000	57 mm	56 mm

10. Perform leak test.

11. Finally, the unprotected pipe area between the vulcanized Hawle strap, Universal pipe saddle and saddle seal is to be protected by means of secondary coating measures as recommended by the pipe manufacturer (e.g. suitable pipe lagging, heat shrink tubing solutions). These guidelines apply unless the pipe manufacturer recommends otherwise.

4. Maintenance and Repair

Hawle Universal pipe saddles for bag positioning devices are maintenance-free.

5. Commissioning and Pressure Test

After being successfully installed, a pressure test must be performed in an open pipe trench in accordance with the German Association for Gas and Water (DVGW) regulations.

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

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