Operating and maintenance instructions for

HAKU Pipe Saddle With Female Thread Outlet and Auxiliary Shut-off Facility Ord.No. 521-00

1. Intended use / product description

Medium: Potable water / municipal sewage (acc. to EN1085)

Max. operating pressure: Potable water / sewage: 16 bar

Material:
Body: GJS-400
Hawle epoxy powder coating
Gaskets: EPDM acc. to DVGW W 270
Screws, washers: stainless steel
Auxiliary shut-off facility: glass fibre reinforced POM

HAKU pipe saddles with female thread outlet acc. to ISO 228-1 and auxiliary shut-off facility are to be used for installation on PE pipes PE80/100 acc. to DIN 8074/DIN EN 12201 and PVC pipes acc. to DIN 8062/DIN EN ISO 1452-2. 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.

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In combination with a pipe drilling device (e.g. Hawle drilling device HAWLOMAT, Ord. No. 830-00) the shut-off system with integrated auxiliary shut-off facility permits the easy and trouble-free drilling of the main line, even with the line in service.

On drilling, the bore is temporarily shut off via by means of a suitable shut-off blade/saddle blade Ord. No. 840-00 after pulling out the drilling spindle. The saddle blade is available as accessory. After drilling, valves and fittings can be integrated.

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

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 the HAWLE drilling device. Observe the relevant operating instructions.

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:

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