



HOBAS®

## TECHNICAL ADVICE SHEET

03-25-2022

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# TAPPING SADDLES

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### General:

Tapping Saddles are used to establish branch connections to existing pipelines.

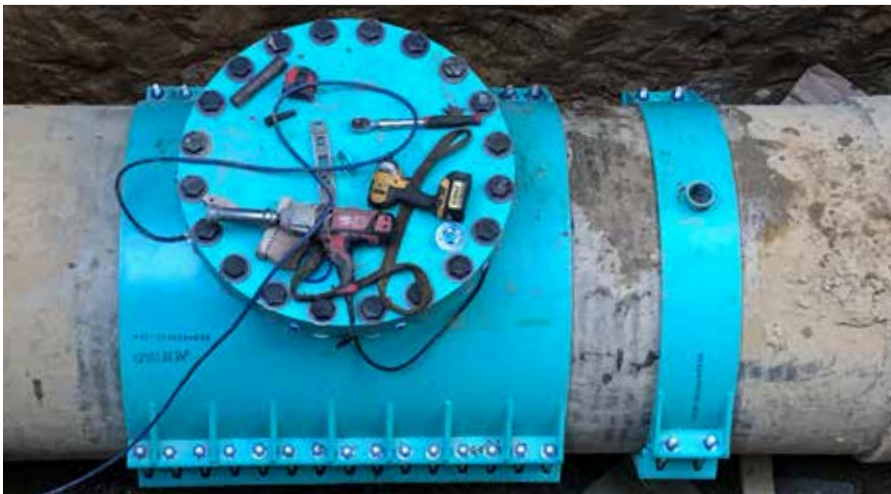
HOBAS Pipe USA does not supply inventory or provide full sleeve tapping saddles.

If in doubt, seek advice from: HOBAS Pipe USA | 800-856-7473



### Guidelines regarding saddles:

- The full sleeve tapping saddles are required to be full circumferential and full face gasketed
- The sleeve tapping saddles shall be of high strength steel or equal having a wide body which conforms to and reinforces the pipe.
- Flexible steel or stainless steel (steel with appropriate corrosion protection should be used - Epoxy Coated etc.) full sleeve tapping saddles are best suited to ensure that a good seal is accomplished on the pipe
- It is recommended that a 1/8" by 40 durometer rubber pad be installed between the full sleeve tapping saddle and the pipe over the entire bearing surface.
- Gussets must be used on the sleeve tapping saddle at the bolt flange to prevent the saddle from bending inward and pinching the pipe when the bolts are torqued. (This may require a modified saddle to prevent inward bending as it is tightened. (Consult with the saddle manufacture informing them that the installation is for flexible pipe.)
- The pressure rating of the full sleeve tapping saddle must meet the required operating and surge pressure for the application
- Please consult with HOBAS Pipe to ensure torque from bolt tightening of saddle does not exceed contact pressure limit of pipe.
- Ensure fully support the pipe, before the sleeve tapping saddle is installed and after completed installation



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### **Cutting HOBAS Pipe:**

HOBAS pipes may be cut using core drill with diamond coated and should have small, closely spaced teeth.

Care must be taken to ensure that a good seal is achieved on the pipeline and that no damage is done to the pipe or tapping sleeve during the cutting process

Here are a few manufactures that have supplied contractors Tapping Sleeves and or fittings for HOBAS Pipe installation.

JCM Industries  
Romac Industries Inc.  
Smith-Blair

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