



- Position the saddle on the pipe and mark around the saddle base.
- Use a file, sander, or rough sandpaper (16 to 40 grit) to remove all surface gloss from the pipe O.D. where the saddle is to be bonded. (For large diameter pipe, a disc sander is usually more practical.) Use circular or random pattern motion during sanding to eliminate grooves on the pipe surface.
- After sanding, position the saddle on the pipe and mark the hole to be cut in the pipe. Cut a hole the same size as the saddle outlet using a pilot drill and circular hole saw or saber saw. Do not force the cutter, or it will fray the edges of the hole excessively.
- Clean all bonding surfaces as required. Note: Be sure cleaner (if used) has evaporated before applying adhesive to the bonding surfaces.
- Apply a **heavy** coat of adhesive to the O.D. of the pipe, I.D. of the saddle, and the edges of the pipe wall exposed by the hole.
- Place the saddle over the hole and clamp with two hose clamps or a banding tool. (Note: Banding tool must be a type that does not leave slack in the bands when the tool is removed. Use metal banding.) Using a large screw driver, hand tighten the hose clamps alternately until secure and adhesive squeezes out all the way around the saddle. This will ensure that the pipe O.D. conforms to the saddle I.D.
- Use two banding tools to pull the sides of the saddle down alternatively. If two tools are not available, tighten the first band **snug**, the second band **tight**, and a third band, pulled **tight**, on the first side. Three-quarter inch banding is recommended.
- You can remove the clamps or leave them in place after the adhesive is cured.
- **Allow adhesive to cure before bonding in the side run.**