

## Saddle Tees

| Item         | Pipe Size   | Outlet Size                    | Color |
|--------------|-------------|--------------------------------|-------|
| SaddleTee150 | 1.5" saddle | Fits .75" spigot or .5" socket | Black |
| SaddleTee200 | 2" saddle   | Fits .75" spigot or .5" socket | White |
| SaddleTee250 | 2.5" saddle | Fits .75" spigot or .5" socket | Grey  |
| SaddleTee300 | 3" saddle   | Fits .75" spigot or .5" socket | Brown |
| SaddleTee400 | 4" saddle   | Fits .75" spigot or .5" socket | Green |
| SaddleTee600 | 6" saddle   | Fits .75" spigot or .5" socket | Blue  |



- Use a 15/16" or 1" drill bit to drill the pipe.

## Dimensions

- 1/2" socket by 3/4" spigot  
 0.848" entrance - 0.836" socket bottom (+ or -) .004" total out of round tolerance (+ or -) .008", Spigot 1.050" (+ or -) .005" total out of round tolerance (+ or -) .010"--- socket depth 1.10" (+ or -) .020"
- 3/4" socket by 1" spigot  
 0.1.058" entrance-1.046" socket bottom (+ or -) .004" total out of round tolerance (+ or -) .008", Spigot 1.315" (+ or -) .005" total out of round tolerance (+ or -) .010"---socket depth 1.100" (+ or -) .020
- 1" socket by 1-1/4" spigot  
 0.1.325" entrance-1.310" socket bottom (+ or -) .005" total out of round tolerance (+ or -) .010", Spigot 1.660" (+ or -) .005" total out of round tolerance (+ or -) .010"---socket depth 1.20: (+ or -) .020"

## PVC Saddle Specification

|                                               |                                |         |
|-----------------------------------------------|--------------------------------|---------|
| Material:                                     | Rigid PVC                      |         |
| Specific gravity:                             | ASTM D-792.....                | 1.39    |
| Shore "D" hardness:                           | ASTM D-2240.....               | 81      |
| IZOD Impact Strength, Notched, Ft-lb/in 73°F: | ASTM D-256.....                | 75      |
| Tensile Strength, PSI:                        | ASTM D-638.....                | 7,000   |
| Tensile Modulus, PSI:                         | ASTM D-638.....                | 425,000 |
| Flexural Strength, PSI:                       | ASTM D790.....                 | 13,000  |
| Heat Deflection Temperature 264 PSI:          | ASTM D-648.....                | 166     |
| Flammability:                                 | Meets UL-94 V-O Classification |         |
| Contact surface area:                         | 7.8 square inches              |         |
| Pipe hole size:                               | 1.000"                         |         |

## Bonding Saddles to PVC Pipe

These are recommended instructions to properly join Saddles to PVC Pipe. Care must be taken when installing Saddles since pipe manufacturing tolerances vary widely.

### Procedure:

- The surfaces of the PVC pipes and saddles to be joined must be clean and dry.
- Drill 15/16th or 1 inch hole on the PVC pipe. Clean hole edges (no rough edges), clean pipe (make sure a smooth surface)
- Use the appropriate sized applicator of the primer and cement
- Apply two coats of primer to the surfaces to be joined on the saddle and pipe.
- Immediately apply generous coating of solvent cement to saddle inner (radial) surface, then to the pipe surface, covering an area slightly larger than the saddle, and then another coat to the saddle inner (radial) surface.
- Immediately place the saddle onto the pipe. Press and hold saddle very firmly, rotating slightly to spread cement and hold firmly for a minimum of 30 seconds This will help distribute the cement evenly on the effective gluing area.
- Clamps or strapping devices, such as rubber bands, are highly recommended to further aid in the securing of the join as the cement cures. Removal of these clamps or strapping devices is at the discretion of the user.
- Immediately apply straps or clamps around the pipe and fitting near each end of the saddle connection to continue to secure the joint until set (30 minutes if ambient temperature is above 60 °F or up to two hours for ambient temperatures 40 °F to 60 °F). Do not pressurize for 24 hours if more than 60 °F (48 hours if 40-60 °F).

- Allow cement to cure according to the cement manufacturer's recommendations. The integrity of glue-on saddle connections is dependent on the solvent cement process used during installation. Exercise care during assembly to insure that a secure joint is obtained.
- Do not bond hose or pipe to socket or spigot for 24 hours, allow cure and drying time of 24 hours. Attaching to socket or spigot before 24 hours may cause failure of saddle bond to pipe.
- Geoflow, Inc. and it's affiliates are not responsible for product that has not been assembled as per these minimum recommendations.

### The PVC Glue / Cement:

|                                                               |           |
|---------------------------------------------------------------|-----------|
| Saddle to PVC manifold                                        | IPS # 719 |
| Flex PVC to Saddle or Fitting                                 | IPS # 795 |
| If the fitting is made of PVC                                 | IPS # 711 |
| ABS fittings (i.e. compression adapters)<br>into PVC Fittings | IPS # 793 |

Instructions for solvent welding PVC fittings please visit <http://www.weldon.com/howtovideo>

