Tapping Band Fitting Instructions

1. **Prepare the area of the pipe to be covered by the tapping bands by removing all dirt and loose materials.**
2. **Position the bottom half of the tapping band making sure it's away from scored, pitted or damaged areas, as this will not provide a good sealing area.**
3. **Fit the top of the tapping band around the pipe so that the bolt passes through the bolt holes in the top of the tapping band.**
4. **With one hand underneath the bottom half of the tapping band pressing upwards, locate the bolt holes and screw on the nuts supplied with the other hand.**
5. **Finger tighten the nuts so that the gap between the two halves of the tapping bands is equal on both sides.**
6. **Tighten the nuts to 15ft lbs/20Nm torque. After 20 minutes, re-torque the bolts to the appropriate value of 10ft lbs/15Nm torque.**

When installing tapping bands with "O" Ring or E-lip seals, make sure the seal is in the correct position. When fitting curved E-Lip seals, position the lug into the matching notch in the band groove to ensure they are aligned correctly. The seal should be placed in the sealing groove, if the seal is placed in the incorrect position the joint may leak.

7. **Take-off fittings require no more than three wraps of thread tape to be applied to the full length of the male thread.**
8. **Take-off fittings need to be tightened to 20ft lbs/30Nm torque and Ferrules must not be screwed in beyond their thread depth. Hand tight plus half to full turn with a wrench is all that is necessary.**
9. **Service pipes should be orientated so that no undue leverage is exerted on the band.**
10. **Tap the pipe through the band being careful not to damage the band nor force swarf under the seal. (It is a good practice to mark the pipe so that if the band is removed for any reason, it may be replaced exactly and centrally over the tapped hole.**

NOTE: If any movement of the system is likely to occur through soil subsidence, water hammer, expansion etc, suitable precautions to prevent such forces moving the bands must be taken, e.g. thrust blocks.