



Cascade

Manufacturers & Suppliers of Pipe Fittings
for the Water and Gas Industries



Mild Steel UPT Fitting Instructions

1. Ensure that the Pipe is clean and free of any loose particles before fitting the Tee.
2. Check whether the Energiser Sealing Ring has not been damaged in Transit. If Ok then lubricate with a WRAS Approved lubricant.
3. If the Energiser Sealing Ring has been damaged then it requires replacing.
4. Place the top half of the Tee onto the pipe and as near as possible to the required location and orientation. Then place the bottom half upwards and place the two centre bolts complete with washers and nuts in either side.
5. Check the location and orientation are OK and then tighten the two centre nuts until the Tee is securely fitted onto the pipe.
6. Now fit the remaining bolts complete with washers and nuts and begin to tighten them equally from the centre outwards.
7. Torque the bolts to 90NM if they are M16 or 280NM for M20. Once all have been torque down leave them to settle for 10 minutes and check them and re-torque if required.
8. Pressure test the Tee to 1.5 times the working pressure of the main. If no seal is achieved then Torque the bolts to 110NM for M16 and 300NM for M20 Bolts respectively. Then pressure test again.
9. Once a satisfactory pressure test has been achieved you can proceed to drill the main and make the connection etc.
10. A sacrificial full through bore Gate Valve is required for live Hot Taps but if the installation is not live then you can attach the drill plate directly onto the flanged outlet of the Tee.