TRULINK™

Saddle Clamp Install Guide & Torque Requirements

Outlet Saddle Clamp (25mm - 220mm)

FITTING NAME	SIZE (mm)	DRILL SIZE (mm)	GUIDE	TORQUE SPECS (ft-lbs)
Outlet Saddle Clamp [NPT]	25, 32	19	Y	5
Outlet Saddle Clamp [NPT]	40, 50, 63	22	Y	5
Outlet Saddle Clamp [NPT]	73	47	N	10
Outlet Saddle Clamp [NPT]	90, 115	63	N	10
Outlet Saddle Clamp [NPT]	168, 220	93	N	20

FITTING NAME	SIZE (mm)	DRILL SIZE (mm)	GUIDE	TORQUE SPECS (ft-lbs)
Outlet Saddle Clamp [PTC]	32	19	Y	10
Outlet Saddle Clamp [PTC]	40	22	Y	10
Outlet Saddle Clamp [PTC]	50	22	Y	20
Outlet Saddle Clamp [PTC]	63	2	Y	20

FITTING NAME	SIZE (mm)	DRILL SIZE (mm)	GUIDE	TORQUE SPECS (ft-lbs)
Outlet Saddle Clamp [CTC]	168	93	N	20
Outlet Saddle Clamp [CTC]	220	93	N	20

Each TruLink saddle clamp includes a top and bottom mounting bracket with outlet connection, a nitrile saddle clamp seal, two zinc grade 5 carriage bolts, washers and nuts.

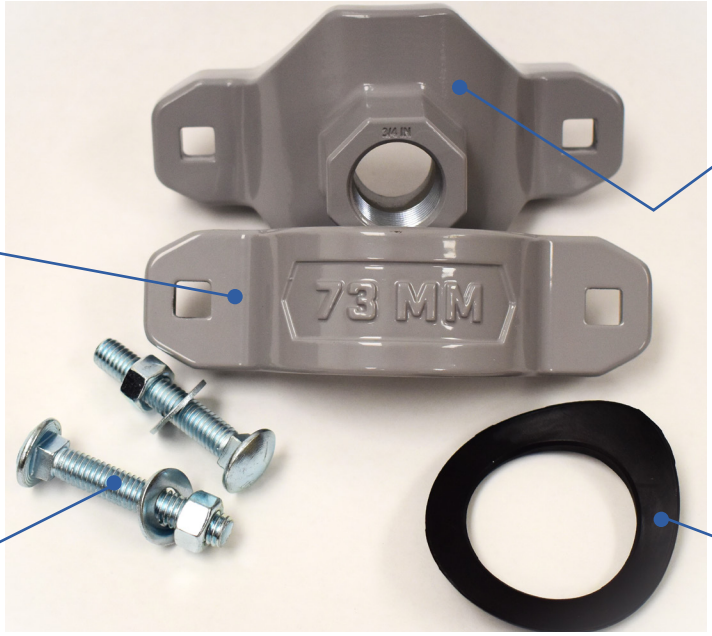
TruLink Saddle Clamp Install Tips

To properly install the TruLink saddle clamps, please follow the saddle clamp instruction guide

OVER TIGHTENING OF SADDLE CLAMP AND BOLTS CAN RESULT IN DAMAGED SADDLE CLAMP AND TUBING. ALWAYS USE RECOMMENDED TORQUE SPECS AND GUIDE SUGGESTIONS FOR TRULINK SADDLE CLAMPS.

Each TruLink saddle clamp includes a top and bottom mounting bracket with outlet connection, a nitrile saddle clamp seal, two zinc grade 5 carriage bolts, washers and nuts.

Top Mounting Bracket



Bottom Mounting Bracket with Outlet Connection

Zinc Grade 5 Carriage Bolts with Washer & Nuts

Buna-Nitrile Seal

Place the tubing on a clean, flat surface, away from anything that can damage the tubing or cause it to move. Be sure to clean any debris or metal shavings from tubing.

Use only TruLink saddle clamp drills when installing saddle clamps. Use TruLink saddle clamp drill guide where applicable.

DO NOT DRILL THROUGH TUBING ON A PRESSURIZED SYSTEM

Drill through tubing at a steady pace, and consistent angle, so that excessive pressure is not placed on drill or tubing.

Use the recommended size TruLink Drill bits, and jig for proper installation and saddle clamp hole.

Each TruLink saddle clamp includes a top and bottom mounting bracket with outlet connection, a nitrile saddle clamp seal, two zinc grade 5 carriage bolts, washers and nuts.

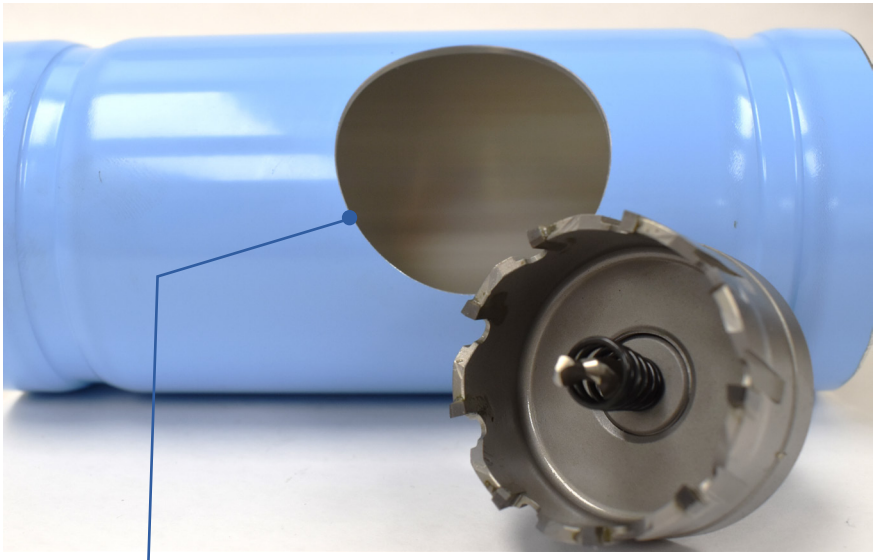


Fig 1: Clean the sealing surface of the tubing saddle clamp hole after drilling tubing.

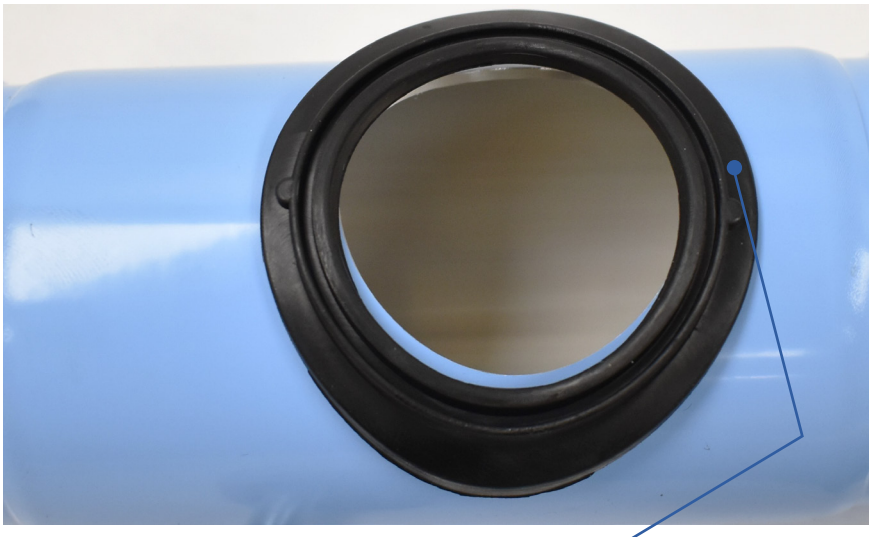
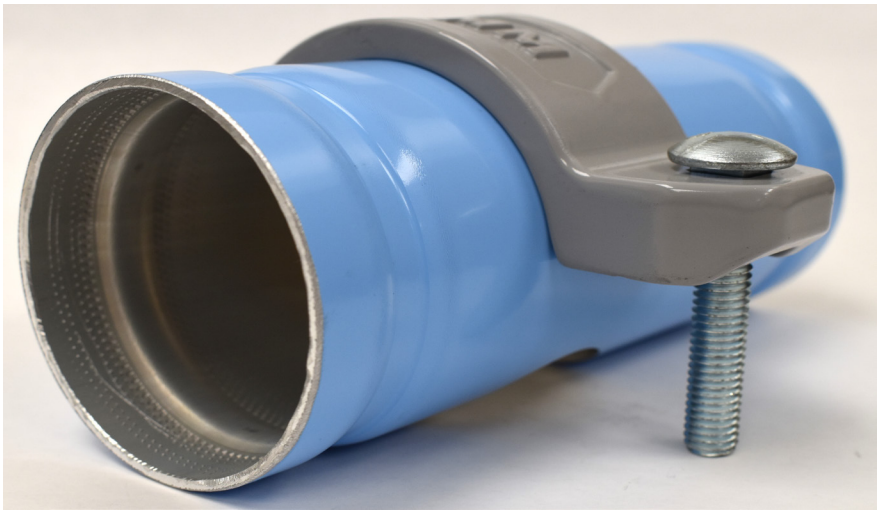
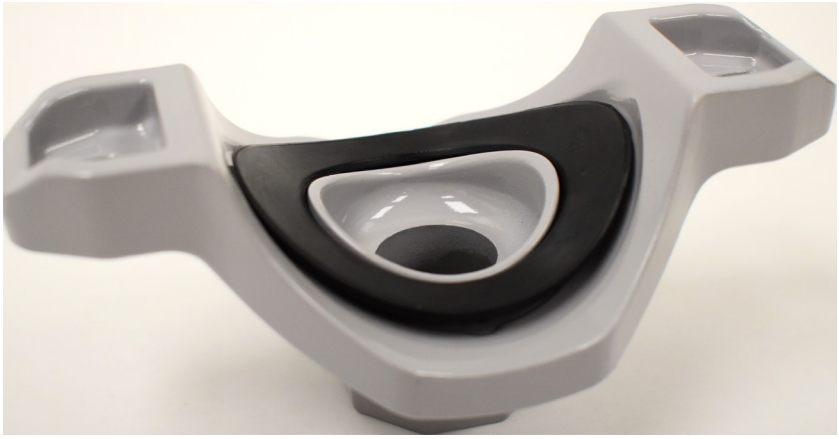


Fig 2: Example of how the nitrile seal will sit over the tubing hole for saddle clamp.

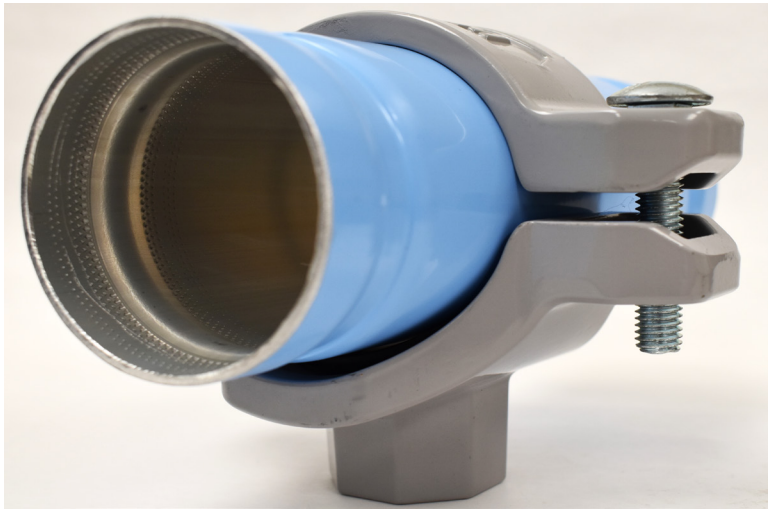
Place the top mounting bracket over the tubing with bolts facing down.



Make sure the seal is placed correctly in the bottom mounting bracket. The smooth side of the seal should be facing up to make contact with the tubing.

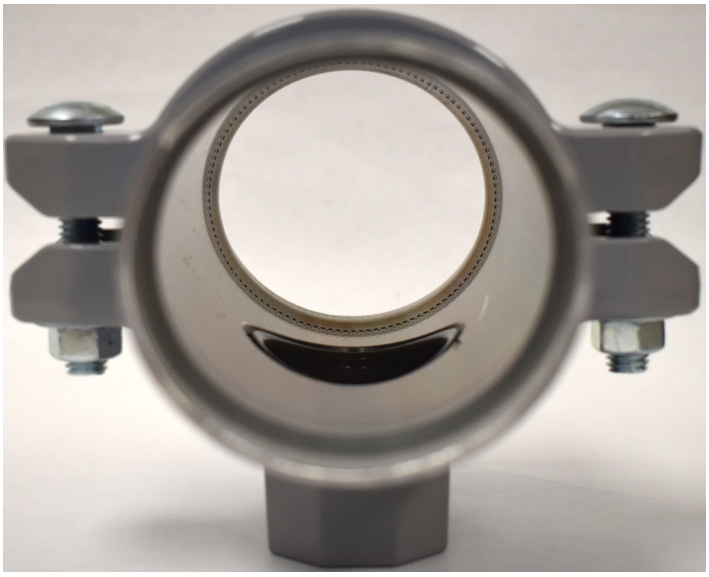


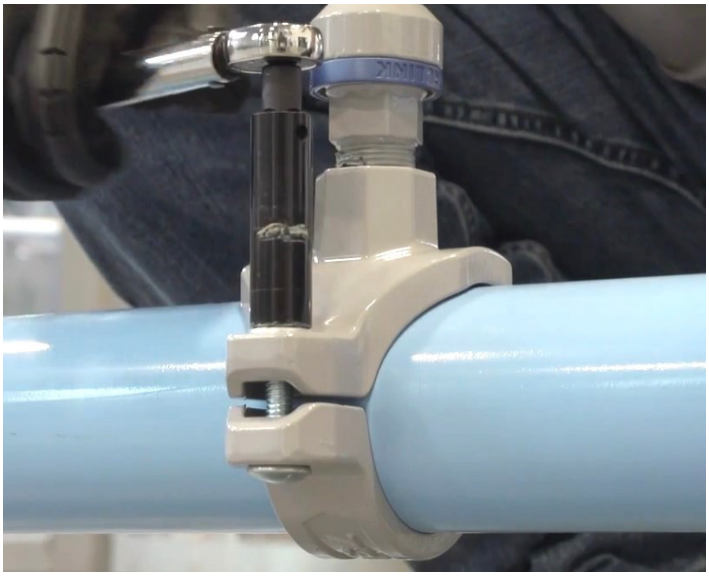
Then insert the bottom mounting bracket over the hole location with seal,directing the bolts through the bottom mounting bracket.



Ensure the lip on the bottom mounting bracket fits inside the hole, preventing it from moving.

Place washers and nuts on bolts and tighten the nuts evenly from side-to-side using a torque wrench until the maximum torque is achieved as shown in the O&M Manual.





The saddle clamp mounting brackets do not have to touch. Use the recommended torque specs for the corresponding saddle clamp size to ensure proper installation and assembly.

Snug all saddle clamps onto tubing ensuring not to over tighten as to crush the tubing. Never exceed maximum torque.

The end result and completed saddle clamp should now be ready to tie in to additional components, lines, or drops.