



January 25, 2010

To whom it may concern:

Find below recommended procedure for gluing saddle tees for pressure applications.

Glue-on Saddle Fittings:

Saddles to be installed without a base gasket will require solvent cementing the base to the line. Because a saddle does not compression fit like a solvent weld bell, it simply sits on top of the pipe, making it more difficult to glue. First, set the saddle on the pipe where it will be placed, and make a reference mark. Take the saddle off, and use sandpaper to rough up the pipe, removing the waxy exterior preparing it for a better glue joint. Then rough up the underside of the saddle base. Specified Fittings recommends using IPS brand P-70 primer, and 719 glue for PVC gluing. The proper primer and glue will depend on the specifics of the end use. To begin, apply a generous amount of primer to the base of the saddle; work the primer in with the brush until the plastic gets soft. To check the softness of the pipe, you should be able to scratch the plastic with a fingernail. Quickly follow these same steps for the pipe. Working quickly, apply a generous amount of glue to the saddle and pipe and spread it evenly. Do not allow primer to dry before applying glue. Once primer and glue has been applied, the saddle will need to be set in place. Specified Fittings suggests that ratchet straps be used to pull the saddle tight, and the provided stainless steel straps provided be used to hold it in place once tight. After stainless steel straps have been installed, ratchet straps can be removed. Stainless steel straps can be left on indefinitely. If for some cosmetic reason they should need to be removed, allow proper drying time to elapse for the glue to set before removing straps. Proper gluing time will be enumerated on the product label. Be sure to consider gluing temperature in figuring dry time. When properly glued, saddles can be used in pressure applications, working adequately up to the maximum pressure rating of the mating pipe.

If you have any other questions, please get in touch.

Sincerely,

Brad Sukolsky
Specified Fittings