

# 4N Tapping Band Installation Instructions



- 1.** Clean the pipe area where the tapping band is to be installed. Ensure no dirt or pipe surface defects are present.
- 2.** Prior to installation inspect the tapping band parts to ensure the seals are clean and defect free.
- 3.** Position the tapping band bottom-half under the pipe and hold in place.
- 4.** O-ring or Multi-Lip seal tapping bands – check the seal is correctly positioned prior to fitting the tapping band onto the pipe.
- 5.** E-lip seal tapping bands – check the seal is correctly positioned prior to fitting the tapping band onto the pipe. Position the lug into the matching band groove notch to ensure correct alignment and to avoid leaks.
- 6.** Fit the tapping band top-half over the pipe so the bottom-half bolts pass through the top-half bolt holes.
- 7.** Continue to hold the bottom-half while fitting washers and nuts. Finger tighten the nuts ensuring equal gaps between the tapping band halves on both sides.
- 8.** Position and level the tapping band if required.
- 9.** Using a torque wrench, tighten the nuts evenly in stages to 15Nm (10ft/lbs). Ensure even gaps on both sides if applicable. Re-torque after approximately 20 minutes.
- 10.** Apply no more than three wraps thickness of AGA (gas) or WaterMark (Water) approved premium PTFE thread tape to the full length of male take-off fittings threaded into the tapping bands.
- 11.** Maximum recommended installation torque for take-off fittings is 30Nm (20ft/lbs). Recommended installation when not using a torque wrench is hand-tight plus half to one-full turn. Ferrules must not be screwed in deeper than their thread depth.
- 12.** Take-off pipes must be oriented to avoid exerting undue leverage force on tapping bands.
- 13.** Take care not to damage the band or force swarf under the seal when tapping the pipe through the tapping band.
- 14.** A good practise after tapping is to permanently mark the pipe so the tapping band can be replaced exactly centrally over a tapped hole if removed later for any reason.

*N.B. Installers must employ suitable precautions, (E.g. thrust blocks), to prevent tapping band movement that may occur due to water hammer, pipe expansion, soil subsidence or other environmental factors.*