

**The Skinner Company**  
 1519 Evans Pond Road  
 Greenwood, South Carolina 29649  
 USA  
 877-923-7700 (Ph)  
 864-953-9724 (Fx)  
[www.skinnerco.com](http://www.skinnerco.com)

## INSTALLATION PROCEDURE

### SERVICE SADDLES:

The Skinner SERVICE SADDLES are designed for use on Steel, Ductile and Cast Iron pipes to allow use to connect secondary line to main line. These Service Saddle can be used on pipes for Gas, Water, Oil, or Ammonia. Sizes and pressure ratings are as follows:

| Size                  | Bolt Torque | Max. Working Pressure |
|-----------------------|-------------|-----------------------|
| 1 1/4"                | 50 ft/lb    | 500 psi               |
| 1 1/2"                | 50 ft/lb    | 500 psi               |
| 2" x 1" & smaller     | 60 ft/lb    | 500 psi               |
| 2" x 1 1/4" & larger  | 60 ft/lb    | 200 psi               |
| 3" x 1" & smaller     | 60 ft/lb    | 200 psi               |
| 3" x 1 1/4" & larger  | 60 ft/lb    | 250 psi               |
| 4" x 1 1/4" & smaller | 60 ft/lb    | 300 psi               |

| Size                  | Bolt Torque | Max. Working Pressure |
|-----------------------|-------------|-----------------------|
| 4" x 1 1/2" & larger  | 60 ft/lb    | 200 psi               |
| 6" x 1 1/4" & smaller | 60 ft/lb    | 200 psi               |
| 6" x 1 1/2" & larger  | 60 ft/lb    | 200 psi               |
| 8" x 1 1/4" & smaller | 150 ft/lb   | 200 psi               |
| 8" x 1 1/2" & larger  | 150 ft/lb   | 250 psi               |
| 10" all               | 150 ft/lb   | 250 psi               |
| 12" all               | 150 ft/lb   | 200 psi               |

### Installation Procedure:

|         |   |
|---------|---|
| Step #1 | Thoroughly clean the selected area with a wire brush. Remove all pipe scale, rust, and foreign material. This will help insure a "bubble tight" seal.   |
| Step #2 | Make sure the gasket is properly positioned and firmly bonded to the top half of saddle before you place your saddle on pipe or gas line. If gasket is not properly positioned or loose, dangerous or even fatal gas leakage may occur. |
| Step #3 | Place the Saddle in position and then tighten the bolt to the proper torque (see above table).  |
| Step #4 | Make the service line connection with the method chosen, eg. Drilling Device, etc.  |
| Step #5 | Pressure test the complete installation for leaks.  |
| Step #6 | Check for leaks before leaving repair site.   |

**GASKET Material: Buna-N (Nitrile Rubber) rated at 250 F Max to -20 F Min Temp.**

**IMPORTANT:  
DO NOT EXCEED TEMPERATURE OR PRESSURE RATINGS!**