

### CONTINENTAL MECHANICAL ADAPTER SADDLE INSTALLATION

#### Tools & Materials Required

- 1/4" hex bit and ratchet
- Marking pen
- Valve
- T.D. Williamson speed tapper (TDW pn# 05-0252-0000) & hole saw
  - Reference TDW Bulletin No. 1000.010.00
- Continental valve adapter (CI pn# 33-6449-01)
- Clean cotton cloth or paper towel

#### IMPORTANT

**For use on:**  
Polyethylene, PVC or ABS ASTM  
D 2513 pipe

**Pressure Rating: 125 psig MAOP**

#### Joining Procedure

1. Clean the main with a clean cotton cloth or paper towel.
2. Inspect the pipe to ensure there are no cuts or gouges located in the o-ring sealing area.
3. Remove the components from the plastic bags and examine for defects. Make sure the o-rings are clean and positioned properly.
4. Place the top half of the saddle on the main. Place the bottom half of the saddle under the top half with holes lined up to insert the bolts. Insert all of the bolts and start the threads. Tighten the two center bolts first, use care to pull the saddle down evenly by tightening the bolts alternately front and back. Tighten the remaining bolts evenly until the flanges of the saddle come together. Make sure the saddle is secured firmly to the main.

#### Tapping the Fitting

1. Remove the cap and completion plug from fitting. Ensure the o-ring and completion plug remain clean.
2. Install the Continental valve adapter to the valve.
3. Install the valve and adapter to the saddle.

**NOTE:** The maximum cutter diameter for the 2" mechanical adapter saddle is 1 7/8"  
The maximum cutter diameter for the 4" mechanical adapter saddle is 1 7/8"

#### Completion Procedure

1. Install the completion tool onto the T.D. Williamson speed tapper. Verify that the detents are in good condition. Install the completion plug onto the completion tool and lift the plug to the full upward position.
  - NOTE: Ensure the completion plug and o-ring are lubricated and free from any dirt, pipe chips, contamination, etc.
2. Install the T.D. Williamson speed tapper onto the valve. Ensure the purge valve is closed.
3. With the completion plug in the full upward position, open the valve and lower the completion plug into the Continental saddle.
  - NOTE: Opening the valve without the completion plug in the full upward position may cause a violent upward movement of the completion plug and speed tapper handle, possibly causing the completion plug to become detached from the completion tool and/or physical injury to the operator.
4. Rotate the completion plug (speed tapper handle) counterclockwise until the threads of the completion plug are aligned with the threads of the saddle. This can be felt and heard as a click.
5. Once the threads have been aligned, rotate the completion plug (speed tapper handle) clockwise approximately 11 full turns to seat the completion plug into the saddle. Do not over tighten.
6. Verify that the completion plug is seated in the saddle by opening the purge valve. If there is constant gas pressure exiting the purge valve, the completion plug may not be fully seated.

#### If the Completion Plug has not Sealed

1. Close the purge valve.
2. Rotate the completion plug (speed tapper handle) counterclockwise until the completion plug is disengaged.
3. Lift the completion plug fully upward into the T.D. Williamson speed tapper and close the valve.

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4. Remove the T.D. Williamson stuffing box from the valve and inspect the completion plug and o-ring for contamination or other defects. Repeat the completion plug procedure.

#### Finishing Procedure

1. Upon verification that the completion plug has sealed, remove the T.D. Williamson speed tapper (ensure the speed tapper is grounded).
2. Upon verification that the completion plug is leak free, remove the Shortcutt valve and valve adapter.
3. Make sure the o-ring is in the groove of the saddle top.
4. Install the cap on the saddle one quarter turn past hand tight.