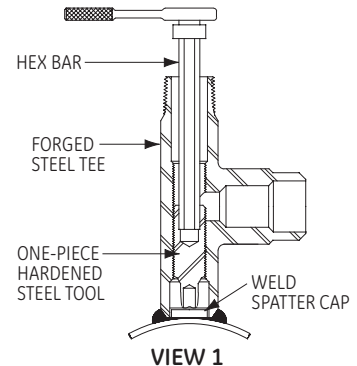


INSTALLATION INSTRUCTION 0001-0826-999

Style 90 TAP-N-VALVE Tee

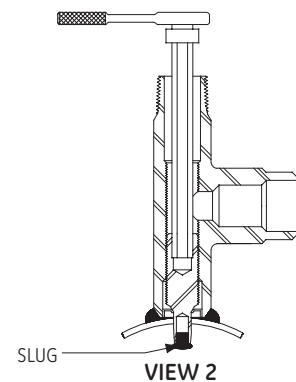
VIEW 1

1. Tapping tee is assembled in saddle or welded to main. Tee is supplied with spatter cap to prevent spatter from entering the internal threads. If inlet must be ground to fit small pipe sizes and cap must be removed, anti spatter welding compound should be applied to reduce the likelihood of spatter entering the threads causing tool seizure. Spatter cap can be pushed further into tee if required. Tapping tool must be removed from inside the tee while welding.
IMPORTANT: Place tool in plastic bag while welding. (After welding, tee must be cool to touch before reinserting tool.)
2. Hollow, cutting end of tapping tool is then inserted in top of tee and threads are engaged. Leave weld spatter cap in place to prevent slag from entering threads.
3. A hex bar and 14" ratchet wrench are used to rotate the tapping tool in a clockwise direction. Turn down until cutting edge touches the main.



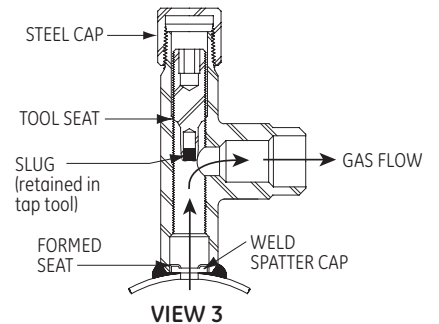
VIEW 2

4. To make the tap, continue clockwise wrenching. Once tap has been started in pipe, tool should not be retracted until tap is completed and tool is seated. As tip of tool penetrates through the pipe wall, the required wrench pull or torque will decrease. The operator will feel the seating of the tool on the pipe because the pull will again increase sharply. Apply sufficient torque to seat the tool.
5. Tap is now completed. The tool is seated and the slug is retained in the tool.

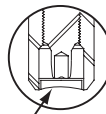


VIEW 3

6. To admit gas to branch, the wrench is rotated in counter-clockwise direction until top of the tool is flush with top of tee body.
7. Apply thread sealing compound to both the cap and tee thread.
8. Cap is tightened on tee body and service connection is complete.
9. Compression branches – Refer to Style 65B, 88 or 90 coupling Installation Instructions.



NOTE: Field contouring of the tee weld inlet to the pipe radius is suggested to improve weld prep and helps to reduce weld burn-through and internal weld spatter.



Field-contoured inlet

TAP TOOL APPLICATION CHART

TAPPING TOOL (DIAM)	MAXIMUM PIPE WALL	MAXIMUM PIPE SMYS
1/4"	3/8"	52,000 PSI
3/8"	3/8"	42,000 PSI
1/2"	1/4"	42,000 PSI

WARNING

On Weld Inlet Tees, remove tapping tool and all compression end components before welding. Failure to do so could damage the tapping tool and destroy the gasket, resulting in escaping gas that could ignite and cause property damage, serious injury or death.



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