



# INSTALLATION INSTRUCTIONS

## ULTRA-Sleeve® Large Diameter Bell Joint Repair PATENT PENDING

**Step 1.** Loosen bolts and disassemble the product.

**Note:** Each Shell half has a sealing gasket attached each shell.  
**Do not remove the sealing gaskets.**  
See Fig. 1

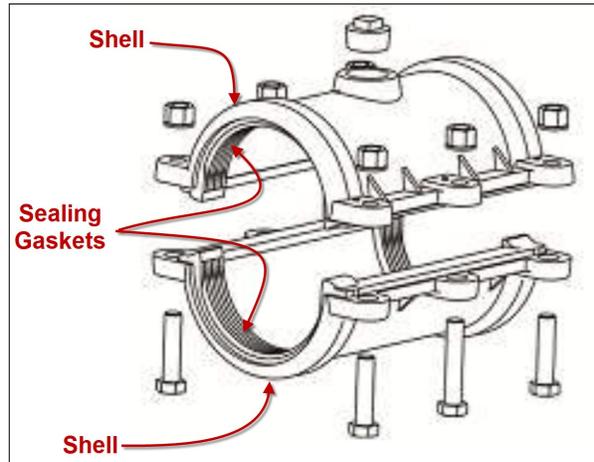
**Step 2.** Prepare pipe surface by thoroughly cleaning surface of all rust, dirt, scale, and debris (See Fig. 2). Verify that the sleeve is the proper diameter for the main pipe on which it is to be installed. Use a pipe outside diameter (OD) tape to confirm main pipe diameter (See Fig. 3). Verify that the pipe to be repaired has the structural integrity to withstand the fitting's mechanical forces. Consult with a piping engineer if needed.

**NOTE: Maximum Pipe out-of-roundness for this product is 0.16"**

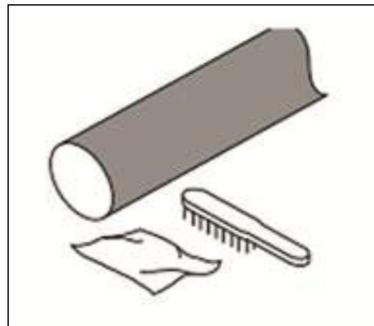
**CAUTION**  
**NOTE: REMOVE OR GRIND OFF ANY RAISED LETTERING PRESENT ON PIPE SURFACE THAT MAY INTERFERE WITH GASKET SEALING.**

**Step 3.** Verify sealing surface is free of debris prior to installation. De-scale pipe surface if necessary

**Step 4.** Lubricate entire gasket sealing surface on both shells with NSF 61 Approved **SILICONE** Lubricant. (see Fig. 4)



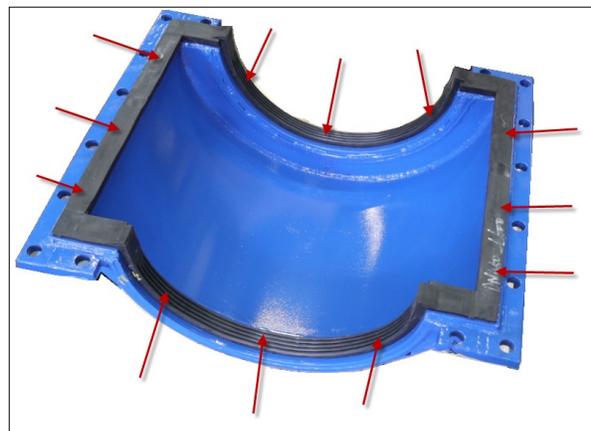
**Fig. 1**



**Fig. 2**



**Fig.3**



**Fig. 4**  
Shell Half



**Step 5.** Install the top and bottom shells on the pipe using the longer starter bolts, in the middle of the unit, to draw the shells together.

Once the starter bolts are drawn together install the remaining bolts.

Keep even gaps on both sides of shell while tightening the bolts.

Tighten the bolts in an alternating crisscross pattern.

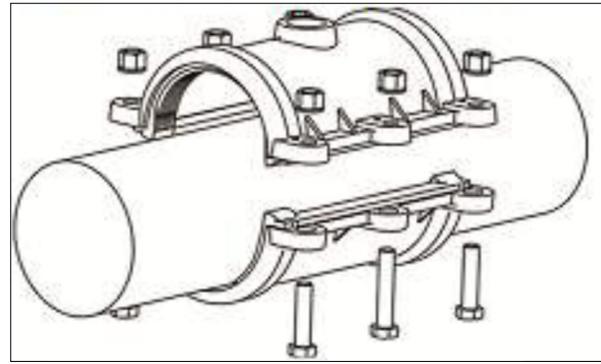
Tighten the bolts in accordance with the required torque shown on the product label. After 10 minutes, retighten bolts to required torque.

See Fig. 5-7

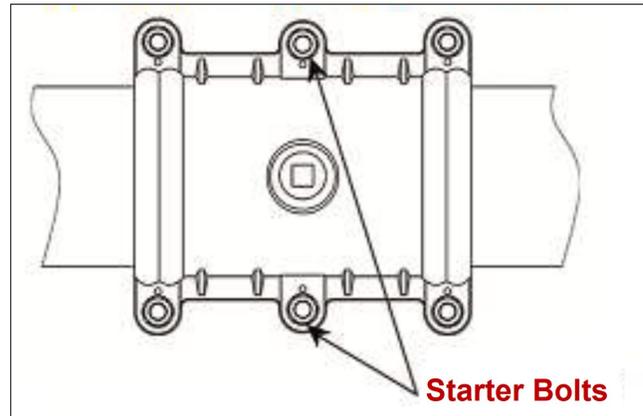
**Step 6.** Install the test plug into the test port using Teflon thread sealing tape or pipe dope.

See Fig. 8.

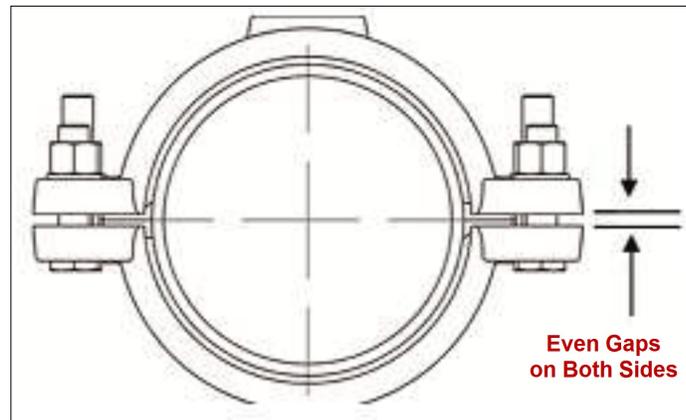
**NOTE:** An NPT valve may be substituted for the test plug.



**Fig. 5**



**Fig. 6**



**Fig. 7**

	<b>WARNING</b> This product is not intended for use on natural gas piping or any other type of gas piping. To do so could result in escaping gas that could ignite and cause property damage, serious injury or death.
	<b>WARNING</b> This is a non-restraining product. If pipe pullout can occur, proper anchoring of the pipe joint is required. Failure to anchor the pipe could result in the escape of line content, and may cause property damage, serious injury or death.
	<b>WARNING</b> This product is intended for use on HDPE SDR-17 or greater wall thicknesses, and shall be used for buried service only. The TPS Triple Tap product line is not approved for above ground applications on HDPE or other plastic pipe

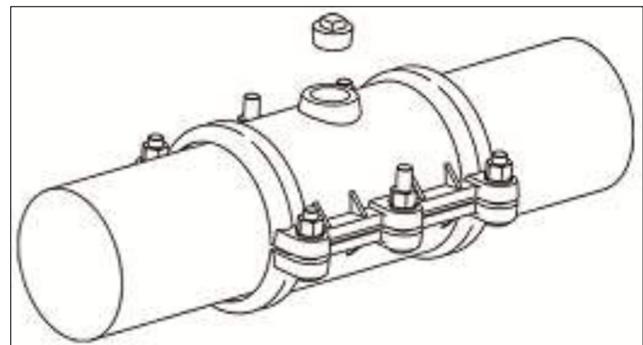
**\*\*\*SEE PRODUCT LABEL FOR BOLT TORQUE, PRESSURE RATINGS, APPROVED LINE CONTENT, AND TEMPERATURE RATING.\*\*\***

**INSTALLATION NOTES**

**Note 1:** Refer to individual product label for actual pressure rating. Pressure rating will never be greater than Pressure rating of main pipe.

**Note 2:** Maximum Fitting Operating Temperature: See Product Label

**Note 3:** Use of a pipe diameter (PI) tape is strongly recommended to verify main conductor pipe diameter prior to final installation.



**Fig. 8**