

**Large EF Branch Saddle  
Pipe Diameters 6" IPS/DIPS – 63" IPS & 48" DIPS  
Outlet Diameters 3" IPS/DIPS – 20" IPS/DIPS**



**EF SADDLE & HOLD-DOWN HARDWARE  
BEFORE WELDING**

**1**



**PLACE EF SADDLE AT THE  
WELDING LOCATION OF THE PIPE**

**DRAW INTERIOR OUTLET &  
EXTERIOR POSITIONING LOCATIONS**

**2**



**DRILL A 3/8" HOLE  
INSIDE THE OUTLET LOCATION**

**3**



**WITH A JIGSAW OPEN  
OUTLET LOCATION**

**4**



**SADDLE LOCATION READY  
FOR PREPARATION**

**5**



**REMOVE OXIDE LAYER & ANY FOREIGN  
OBJECTS BY SCRAPING  
BETWEEN THE INTERIOR  
OUTLET HOLE & FUSION ZONE**

**6**



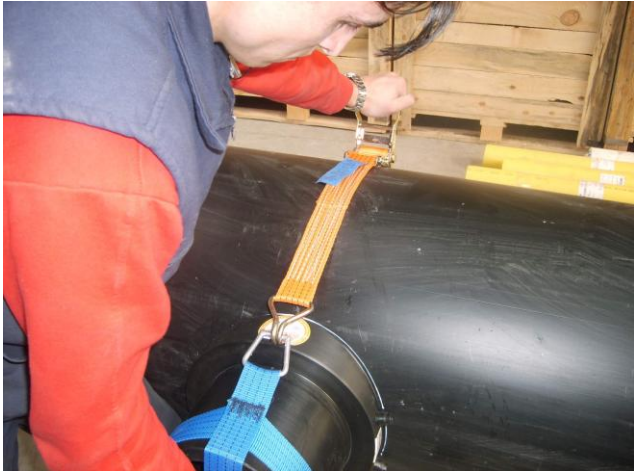
**CLEAN SCRAPED AREA  
WITH ISOPROPYL ALCOHOL(AT LEAST  
90%) USING A CLEAN LINT-FREE  
COTTON CLOTH**

**7**



**BEFORE WELDING  
IT IS RECOMMENDED TO CLEAN  
THE FUSION ZONE ON THE SADDLE  
AS SHOWN IN PREVIOUS STEP**

**8**



**POSITION THE SADDLE  
ONTO THE PIPE USING AN  
APPROVED HOLD-DOWN STRAP  
HAND TIGHTEN ONLY  
ENSURE THE SADDLE IS POSITIONED  
DIRECTLY OVER THE OUTLET HOLE  
PRIOR TO STARTING  
THE FUSION PROCESS**

**9**



**PLACE FUSION CABLES ON SADDLE  
AS DETAILED BY THE FUSION  
PROCESSOR MANUAL  
SCAN SADDLE BARCODE  
USING THE LASER PENCIL  
TO ENSURE FUSION MACHINE  
IDENTIFIES THE SADDLE**

**10**



**AFTER COMPLETION OF FUSION, LEAVE  
STRAP SYSTEM IN PLACE UNTIL COOL  
DOWN PERIOD IS COMPLETE**

**11**



**REMOVE STRAP AND CONNECT LATERAL  
SYSTEM BY USING AN ELECTROFUSION  
COUPLING OR BUTT FUSION**

**12**