Branches for sewage pipes - round hole
90° saddle branches

1 BORE
Use a boring machine with a centering base.
Bore with a hole saw specifically for iron (Ø172 mm for 150 branches and Ø232 mm for 200 branches).
Lubricate with water.

2 PUNCH AND DRILL
Mark the position of the two holes with a center punch.
Drill a hole with a 13 mm diameter.
Preferably use a drill bit with a tungsten carbide tip for hardened steel and abrasive materials.

3 Deburr
Carefully deburr and break the angles.

4 COAT
Coat the exposed parts with ISOLARM paste (INTEGRAL, TAG32) or EUROKOTE (INTEGRAL PUX, INTEGRAL pH1).

5 MOUNT THE BOLTS
Mount the two bolts with their compressed plastic rings in the holes.
Branches for sewage pipes - round hole
Saddle branches

6 POSITION THE GASKET

Position the gasket according to the type of joint (see diagrams A and B).
Check that the gasket is properly seated.
Lubricate the gasket.

7 ASSEMBLE

Mount the fully assembled iron part with a single bolt.
Place a washer and nut on the bolt, but without tightening.
Finish mounting the iron part. If necessary, use a wooden lever to avoid damaging the coating. Gradually apply increasing pressure and avoid jerky movements.

8 TIGHTEN

Add the second bolt.
Tighten both nuts.
Hold the bolt by means of the flat sections at the end of the bolt (size 7 spanner).

Torque: 30 N.m

Hole saws that are suitable for iron are marketed by PAM.

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<th>DN</th>
<th>Ø bore (mm)</th>
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<td>150</td>
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Branches for sewage pipes - round hole
Swivel saddle branches
The contractor is responsible for analyzing and eliminating any risks during installation (especially the use of personal protective equipment).

1 BORE
Use a boring machine with a centering base and a hole saw specifically for iron (Ø172 mm for 150 branches and Ø232 mm for 200 branches).
Lubricate with water.

2 PUNCH AND DRILL
Position the template while respecting the pipe's centerline.
Mark the position of the two holes with a center punch.
Drill a hole with a 13 mm diameter.
Preferably use a drill bit with a tungsten carbide tip for hardened steel and abrasive materials (high performance).

3 Deburr
Carefully deburr and break the angles.

4 COAT
Coat the exposed parts with:
- ISOLARM paste ref. 179099 for INTEGRAL or TAG32 pipes
- IVORY paint ref. 220818 for INTEGRAL TT or INTEGRAL pH1 pipes

5 MOUNT THE BOLTS
Mount the two bolts with their compressed plastic rings in the holes.
Branches for sewage pipes - round hole
Swivel saddle branches

6 POSITION THE GASKET

Position the gasket according to the type of joint (see diagrams A and B).
Check that the gasket is properly seated.
Lubricate the gasket.

Unmount the branch so that the plate can first be fitted.

7 ASSEMBLE

Mount the fully assembled iron part with a single bolt.
Place a washer and nut on the bolt, but without tightening.
Finish mounting the iron part. If necessary, use a wooden lever to avoid damaging the coating. Gradually apply increasing pressure and avoid jerky movements.

8 TIGHTEN

Add the second bolt.
Tighten both nuts with a size 17 spanner.
Hold the bolt by means of the flat sections at the end of the bolt (size 7 spanner).
Branches for sewage pipes - round hole
Swivel saddle branches

9 ASSEMBLE

Re-mount the upper elements.
Turn the assembly towards its connection position and hold in place.
Fit and tighten the stirrups.

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