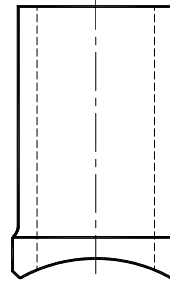


Fusion Parameters for Branch Saddles Butt Outlet Round Base



<u>Outlets Available</u>	<u>Main Size</u>	<u>Approximate Area (in²)</u>	<u>Bead Up Force (lb)</u>	<u>Joining Force (lb)</u>
3/4" IPS	1 1/4" - 18"	1.2	100	50
1" IPS		1.4		
1 1/4" IPS		1.4		
1 1/2" IPS	2" - 18"	1.7	155	80
2" IPS		2.6		
3" IPS	4"	12.2	730	365
	6" - 18"	14.3	860	430
4" IPS	6" - 18"	10.0	600	300
6" IPS	8" - 28"	22.6	The Approximate Area is used to calculate gauge pressure on the hydraulic unit.	
8" IPS	10" - 28"	50.0		

WARNING - Gas pipe should be fused only by qualified persons, and only in compliance with qualified fusion procedures from the gas utility (gas pipeline owner or operator).

Use the information on this publication only with the complete, detailed fusion procedures published in Performance Pipe Bulletin PP-750. If you have questions about saddle fusion, review Performance Pipe Bulletin PP-750 before making saddle fusion joints. If the gas utility procedure differs from Performance Pipe Bulletin PP-750, observe the gas utility's saddle fusion procedure, and do not use this publication.

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The information on this bulletin does NOT apply to DRISCOPIPE® 7000 and 8000 mains or fittings.

