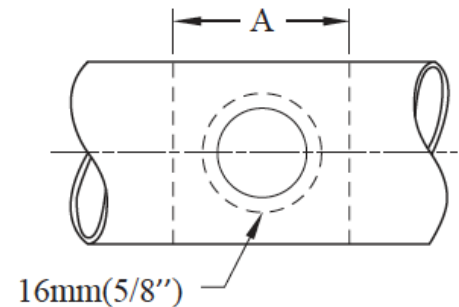


## HOLE SIZE CHARTS

The hole-cut method of pipe preparation is required when using mechanical tees, mechanical crosses, and saddle-lets. The method of pipe preparation requires the cutting or drilling of a specified hole size on the centerline of the pipe.

NOTE: always use the correct hole saw size as listed in this catalog and never use a torch for cutting a hole.

After the hole has been cut, all rough edges must be removed, and the area within 5/8" (16mm) of the hole should be inspected to ensure a clean smooth surface, free of any indentations or projections that could affect proper gasket sealing. The area within the "A" dimension should also be inspected and must be free of dirt, scale or any imperfection that could affect proper sealing or assembly of the fitting.



Hole Sizes for Mechanical Tees

31MT and 31MG Mechanical Tees Threaded and Grooved			
Mechanical Tees Branch Size	Hole Dimensions		Surface Preparation "A"
	Hole Saw Size	Max Dia. Allowed	
1/2, 3/4, 1 15, 20, 25	1-1/2 38	1-5/8 41	3-1/2 89
1-1/4 32	1-3/4 45	1-7/8 47	4 102
1-1/2 40	2 51	2-1/8 54	4 102
2 50	2-1/2 64	2-5/8 67	4-1/2 114
2-1/2 65	2-3/4 70	2-7/8 73	4-3/4 121
3 80	3-1/2 89	3-5/8 92	5-1/2 140
4 100	4-1/2 114	4-5/8 118	6-1/2 165

41 Saddle-Let Outlet Tee			
U Bolt Mechanical Tee Branch Size	Hole Dimensions		Surface Preparation "A"
	Hole Saw Size	Max Dia. Allowed	
1/2, 3/4, 1 15, 20, 25	1-3/16 30	1-1/4 32	3-1/2 89