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OPS SMALL HOT-TAP FITTINGS & ACCESSORIES UP TO 3" / DN80

When performing small Hot-Taps, the forces on the welded branch connections are subject to external forces due to the weight of the Hot-Tap machine and the rotating forces from the drill or hole saw. Also the orientation from the branch compared to the header can have a big impact on these forces during drilling, vertical on top has the least forces. Besides the mechanical aspects there is also the risk for a burnthrough during welding and with a splitted tee this is much easier to control compared to a Nipple or Stub-on Type fitting. Therefore OPS advises our customers to use the correct type of fitting for your application. In the table next to this you can find the solution that we propose for these small Hot-Taps. For most common sizes we have stock items and that's why it might be cheaper and quicker to go 1 size up because of availability of the materials. Below you can find all items that we try to have on stock all the time.

SMALL HOT-TAP FITTINGS UP TO 3" - DN80			Header Size					
			3/4"	1"	1 1/4"	1 1/2"	2"	3"
Branch Sizes	3/4"	DN20	EST	RST	RST	RST	N	N
	1"	DN25		EST	RST	RST	RST	N
	1 1/4"	DN32			EST	RST	RST	RST
	1 1/2"	DN40				EST	RST	RST
	2"	DN50					EST	RST
	3"	DN80						EST

On stock
 EST Equal Splitted Tee
 RST Reduced Splitted Tee
 N Nipple or Stub-on type

Nipple or Stub-on Type

Use of this type fitting is advised when ratio Branch / Header is smaller than 50%



Full Encirclement or Splitted Tee Type

Use of this type fitting is advised for installation on headers up to DN80



METRIC SIZES

OPS Hot-Tap Nipple type Threaded BSP

Sizes:	Steel	Stainless
DN20-BSP	OPS-SHTF-0010-0020-BSP-ST1	OPS-SHTF-0010-0020-BSP-SS1
DN25-BSP	OPS-SHTF-0010-0025-BSP-ST1	OPS-SHTF-0010-0025-BSP-SS1
DN32-BSP	OPS-SHTF-0010-0032-BSP-ST1	OPS-SHTF-0010-0032-BSP-SS1
DN40-BSP	OPS-SHTF-0010-0040-BSP-ST1	OPS-SHTF-0010-0040-BSP-SS1
DN50-BSP	OPS-SHTF-0010-0050-BSP-ST1	OPS-SHTF-0010-0050-BSP-SS1

OPS Hot-Tap Nipple type Flanged DIN2635-PN40

Sizes:	Steel	Stainless
DN20-PN40	OPS-SHTF-0010-0020-PN40-ST1	OPS-0010-0020-PN40-SS1
DN25-PN40	OPS-SHTF-0010-0025-PN40-ST1	OPS-0010-0025-PN40-SS1
DN32-PN40	OPS-SHTF-0010-0032-PN40-ST1	OPS-0010-0032-PN40-SS1
DN40-PN40	OPS-SHTF-0010-0040-PN40-ST1	OPS-0010-0040-PN40-SS1
DN50-PN40	OPS-SHTF-0010-0050-PN40-ST1	OPS-0010-0050-PN40-SS1
DN80-PN40	OPS-SHTF-0010-0080-PN40-ST1	OPS-0010-0080-PN40-SS1

OPS Hot-Tap Split Tee type Threaded BSP

Sizes:	Steel	Stainless
DN20xDN20-BSP	OPS-SHTF-0020-2020-BSP-ST1	OPS-SHTF-0020-2020-BSP-SS1
DN25xDN25-BSP	OPS-SHTF-0020-2525-BSP-ST1	OPS-SHTF-0020-2525-BSP-SS1
DN32xDN32-BSP	OPS-SHTF-0020-3232-BSP-ST1	OPS-SHTF-0020-3232-BSP-SS1
DN40xDN25-BSP	OPS-SHTF-0020-4025-BSP-ST1	OPS-SHTF-0020-4025-BSP-SS1
DN40xDN40-BSP	OPS-SHTF-0020-4040-BSP-ST1	OPS-SHTF-0020-4040-BSP-SS1
DN50xDN25-BSP	OPS-SHTF-0020-5025-BSP-ST1	OPS-SHTF-0020-5025-BSP-SS1
DN50xDN40-BSP	OPS-SHTF-0020-5040-BSP-ST1	OPS-SHTF-0020-5040-BSP-SS1
DN50xDN50-BSP	OPS-SHTF-0020-5050-BSP-ST1	OPS-SHTF-0020-5050-BSP-SS1
DN80xDN40-BSP	OPS-SHTF-0020-8040-BSP-ST1	OPS-SHTF-0020-8040-BSP-SS1
DN80xDN50-BSP	OPS-SHTF-0020-8050-BSP-ST1	OPS-SHTF-0020-8050-BSP-SS1

OPS Hot-Tap Split Tee type DIN2635-PN40

Sizes:	Steel	Stainless
DN20xDN20-PN40	OPS-SHTF-0020-2020-PN40-ST1	OPS-SHTF-0020-2020-PN40-SS1
DN25xDN25-PN40	OPS-SHTF-0020-2525-PN40-ST1	OPS-SHTF-0020-2525-PN40-SS1
DN32xDN32-PN40	OPS-SHTF-0020-3232-PN40-ST1	OPS-SHTF-0020-3232-PN40-SS1
DN40xDN25-PN40	OPS-SHTF-0020-4025-PN40-ST1	OPS-SHTF-0020-4025-PN40-SS1
DN40xDN40-PN40	OPS-SHTF-0020-4040-PN40-ST1	OPS-SHTF-0020-4040-PN40-SS1
DN50xDN25-PN40	OPS-SHTF-0020-5025-PN40-ST1	OPS-SHTF-0020-5025-PN40-SS1
DN50xDN40-PN40	OPS-SHTF-0020-5040-PN40-ST1	OPS-SHTF-0020-5040-PN40-SS1
DN50xDN50-PN40	OPS-SHTF-0020-5050-PN40-ST1	OPS-SHTF-0020-5050-PN40-SS1
DN80xDN40-PN40	OPS-SHTF-0020-8040-PN40-ST1	OPS-SHTF-0020-8040-PN40-SS1
DN80xDN50-PN40	OPS-SHTF-0020-8050-PN40-ST1	OPS-SHTF-0020-8050-PN40-SS1
DN80xDN80-PN40	OPS-SHTF-0020-8080-PN40-ST1	OPS-SHTF-0020-8080-PN40-SS1

IMPERIAL SIZES

OPS Hot-Tap Nipple type Threaded NPT

Sizes:	Steel	Stainless
3/4" - NPT	OPS-SHTF-0010-0020-NPT-ST1	OPS-SHTF-0010-0020-NPT-SS1
1" - NPT	OPS-SHTF-0010-0025-NPT-ST1	OPS-SHTF-0010-0025-NPT-SS1
1 1/4" - NPT	OPS-SHTF-0010-0032-NPT-ST1	OPS-SHTF-0010-0032-NPT-SS1
1 1/2" - NPT	OPS-SHTF-0010-0040-NPT-ST1	OPS-SHTF-0010-0040-NPT-SS1
2" - NPT	OPS-SHTF-0010-0050-NPT-ST1	OPS-SHTF-0010-0050-NPT-SS1

OPS Hot-Tap Nipple type LWNF (150#-300#-600#)

Sizes:	Steel	Stainless
3/4" - 150#	OPS-SHTF-0010-0020-150-ST1	OPS-SHTF-0010-0020-150-SS1
1" - 150#	OPS-SHTF-0010-0025-150-ST1	OPS-SHTF-0010-0025-150-SS1
1 1/4" - 150#	OPS-SHTF-0010-0032-150-ST1	OPS-SHTF-0010-0032-150-SS1
1 1/2" - 150#	OPS-SHTF-0010-0040-150-ST1	OPS-SHTF-0010-0040-150-SS1
2" - 150#	OPS-SHTF-0010-0050-150-ST1	OPS-SHTF-0010-0050-150-SS1
3/4" - 300#	OPS-SHTF-0010-0020-300-ST1	OPS-SHTF-0010-0020-300-SS1
1" - 300#	OPS-SHTF-0010-0025-300-ST1	OPS-SHTF-0010-0025-300-SS1
1 1/4" - 300#	OPS-SHTF-0010-0032-300-ST1	OPS-SHTF-0010-0032-300-SS1
1 1/2" - 300#	OPS-SHTF-0010-0040-300-ST1	OPS-SHTF-0010-0040-300-SS1
2" - 300#	OPS-SHTF-0010-0050-300-ST1	OPS-SHTF-0010-0050-300-SS1

OPS Hot-Tap Split Tee type Threaded NPT

Sizes:	Steel	Stainless
3/4" x 3/4" - NPT	OPS-SHTF-0020-2020-NPT-ST1	OPS-SHTF-0020-2020-NPT-SS1
1" x 1" - NPT	OPS-SHTF-0020-2525-NPT-ST1	OPS-SHTF-0020-2525-NPT-SS1
1 1/4" x 1 1/4" - NPT	OPS-SHTF-0020-3232-NPT-ST1	OPS-SHTF-0020-3232-NPT-SS1
1 1/2" x 1 1/2" - NPT	OPS-SHTF-0020-4025-NPT-ST1	OPS-SHTF-0020-4025-NPT-SS1
1 1/2" x 1 1/2" - NPT	OPS-SHTF-0020-4040-NPT-ST1	OPS-SHTF-0020-4040-NPT-SS1
2" x 1" - NPT	OPS-SHTF-0020-5025-NPT-ST1	OPS-SHTF-0020-5025-NPT-SS1
2" x 1 1/2" - NPT	OPS-SHTF-0020-5040-NPT-ST1	OPS-SHTF-0020-5040-NPT-SS1
2" x 2" - NPT	OPS-SHTF-0020-5050-NPT-ST1	OPS-SHTF-0020-5050-NPT-SS1
3" x 1 1/2" - NPT	OPS-SHTF-0020-8040-NPT-ST1	OPS-SHTF-0020-8040-NPT-SS1
3" x 2" - NPT	OPS-SHTF-0020-8050-NPT-ST1	OPS-SHTF-0020-8050-NPT-SS1

OPS Hot-Tap Split Tee Type Flanged (150#-300#)

Sizes:	Steel	Stainless
3/4" x 3/4" - 150#	OPS-SHTF-0020-2020-150-ST1	OPS-SHTF-0020-2020-150-SS1
1" x 1" - 150#	OPS-SHTF-0020-2525-150-ST1	OPS-SHTF-0020-2525-150-SS1
1 1/4" x 1 1/4" - 150#	OPS-SHTF-0020-3232-150-ST1	OPS-SHTF-0020-3232-150-SS1
1 1/2" x 1 1/2" - 150#	OPS-SHTF-0020-4025-150-ST1	OPS-SHTF-0020-4025-150-SS1
1 1/2" x 1 1/2" - 150#	OPS-SHTF-0020-4040-150-ST1	OPS-SHTF-0020-4040-150-SS1
2" x 1" - 150#	OPS-SHTF-0020-5025-150-ST1	OPS-SHTF-0020-5025-150-SS1
2" x 1 1/2" - 150#	OPS-SHTF-0020-5040-150-ST1	OPS-SHTF-0020-5040-150-SS1
2" x 2" - 150#	OPS-SHTF-0020-5050-150-ST1	OPS-SHTF-0020-5050-150-SS1
3" x 1 1/2" - 150#	OPS-SHTF-0020-8040-150-ST1	OPS-SHTF-0020-8040-150-SS1
3" x 2" - 150#	OPS-SHTF-0020-8050-150-ST1	OPS-SHTF-0020-8050-150-SS1
3" x 3" - 150#	OPS-SHTF-0020-8080-150-ST1	OPS-SHTF-0020-8080-150-SS1

Sizes:	Steel	Stainless
3/4" x 3/4" - 300#	OPS-SHTF-0020-2020-300-ST1	OPS-SHTF-0020-2020-300-SS1
1" x 1" - 300#	OPS-SHTF-0020-2525-300-ST1	OPS-SHTF-0020-2525-300-SS1
1 1/4" x 1 1/4" - 300#	OPS-SHTF-0020-3232-300-ST1	OPS-SHTF-0020-3232-300-SS1
1 1/2" x 1 1/2" - 300#	OPS-SHTF-0020-4025-300-ST1	OPS-SHTF-0020-4025-300-SS1
1 1/2" x 1 1/2" - 300#	OPS-SHTF-0020-4040-300-ST1	OPS-SHTF-0020-4040-300-SS1
2" x 1" - 300#	OPS-SHTF-0020-5025-300-ST1	OPS-SHTF-0020-5025-300-SS1
2" x 1 1/2" - 300#	OPS-SHTF-0020-5040-300-ST1	OPS-SHTF-0020-5040-300-SS1
2" x 2" - 300#	OPS-SHTF-0020-5050-300-ST1	OPS-SHTF-0020-5050-300-SS1
3" x 1 1/2" - 300#	OPS-SHTF-0020-8040-300-ST1	OPS-SHTF-0020-8040-300-SS1
3" x 2" - 300#	OPS-SHTF-0020-8050-300-ST1	OPS-SHTF-0020-8050-300-SS1
3" x 3" - 300#	OPS-SHTF-0020-8080-300-ST1	OPS-SHTF-0020-8080-300-SS1

OPS VALVES & PACKING-BOLT SETS FROM STOCK FOR HOT-TAP APPLICATIONS

Ball Valves Stainless Steel Metric



Sizes	Stainless
DN20-BSP	OPS-BVLV-0010-0020-NPT-SS1
DN25-BSP	OPS-BVLV-0010-0025-NPT-SS1
DN32-BSP	OPS-BVLV-0010-0032-NPT-SS1
DN40-BSP	OPS-BVLV-0010-0040-NPT-SS1
DN50-BSP	OPS-BVLV-0010-0050-NPT-SS1

Sizes	Stainless
DN20-PN40	OPS-BVLV-0010-0020-PN40-SS1
DN25-PN40	OPS-BVLV-0010-0025-PN40-SS1
DN32-PN40	OPS-BVLV-0010-0032-PN40-SS1
DN40-PN40	OPS-BVLV-0010-0040-PN40-SS1
DN50-PN40	OPS-BVLV-0010-0050-PN40-SS1
DN80-PN40	OPS-BVLV-0010-0080-PN40-SS1

Gate Valves Steel Imperial sizes



Sizes	Steel
3/4" - NPT	OPS-GVLV-0010-0020-NPT-ST1
1" - NPT	OPS-GVLV-0010-0025-NPT-ST1
1 1/4" - NPT	OPS-GVLV-0010-0032-NPT-ST1
1 1/2" - NPT	OPS-GVLV-0010-0040-NPT-ST1
2" - NPT	OPS-GVLV-0010-0050-NPT-ST1

Sizes	Steel
3/4" - 150#	OPS-GVLV-0010-0020-150#-ST1
1" - 150#	OPS-GVLV-0010-0025-150#-ST1
1 1/4" - 150#	OPS-GVLV-0010-0032-150#-ST1
1 1/2" - 150#	OPS-GVLV-0010-0040-150#-ST1
2" - 150#	OPS-GVLV-0010-0050-150#-ST1
3" - 150#	OPS-GVLV-0010-0080-150#-ST1

Sizes	Steel
3/4" - 300#	OPS-GVLV-0010-0020-300#-ST1
1" - 300#	OPS-GVLV-0010-0025-300#-ST1
1 1/4" - 300#	OPS-GVLV-0010-0032-300#-ST1
1 1/2" - 300#	OPS-GVLV-0010-0040-300#-ST1
2" - 300#	OPS-GVLV-0010-0050-300#-ST1
3" - 300#	OPS-GVLV-0010-0080-300#-ST1

BAU Packing & steel bolt set Metric



Sizes	Steel - BAU
DN20-PN40	OPS-FLSD-0010-0020-PN40-ST1
DN25-PN40	OPS-FLSD-0010-0025-PN40-ST1
DN32-PN40	OPS-FLSD-0010-0032-PN40-ST1
DN40-PN40	OPS-FLSD-0010-0040-PN40-ST1
DN50-PN40	OPS-FLSD-0010-0050-PN40-ST1
DN65-PN40	OPS-FLSD-0010-0080-PN40-ST1

SW Packing & Steel Stud bolt set Imperial



Sizes	Steel - Spiral
3/4" - 150#	OPS-FLSA-0010-0020-150#-ST1
1" - 150#	OPS-FLSA-0010-0025-150#-ST1
1 1/4" - 150#	OPS-FLSA-0010-0032-150#-ST1
1 1/2" - 150#	OPS-FLSA-0010-0040-150#-ST1
2" - 150#	OPS-FLSA-0010-0050-150#-ST1
3" - 150#	OPS-FLSA-0010-0080-150#-ST1

Sizes	Steel - Spiral
3/4" - 300#	OPS-FLSA-0010-0020-300#-ST1
1" - 300#	OPS-FLSA-0010-0025-300#-ST1
1 1/4" - 300#	OPS-FLSA-0010-0032-300#-ST1
1 1/2" - 300#	OPS-FLSA-0010-0040-300#-ST1
2" - 300#	OPS-FLSA-0010-0050-300#-ST1
3" - 300#	OPS-FLSA-0010-0080-300#-ST1