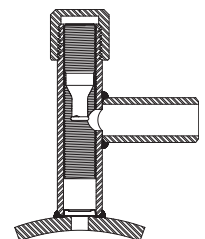
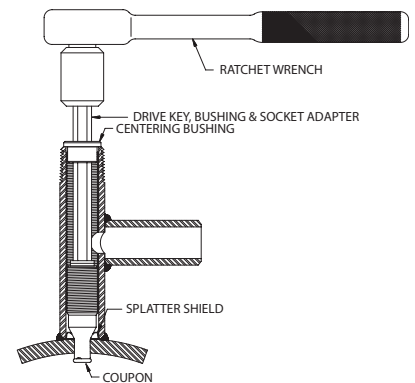
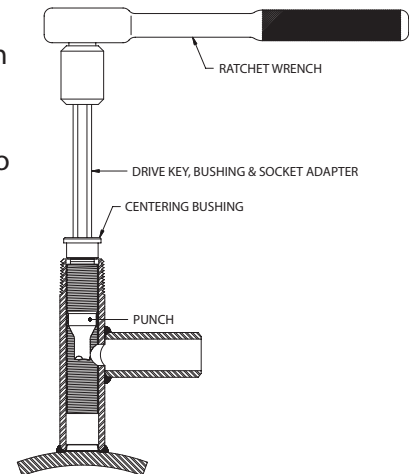
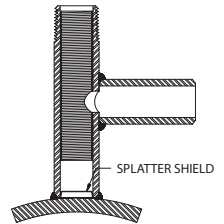


Service Punch Tee Installation Instructions: Weld Outlet

- Before installing the service tee, confirm the punch is rated for the steel pipe to be tapped.
 - 3/8" tip punches are rated for 0.280" maximum wall thickness and 70 ksi maximum yield strength.
 - 1/4", 1/2", 3/4" & 1" tip punches are rated for 0.250" maximum wall thickness and 65 ksi maximum yield strength.
- Verify that the outlet on the service tee is the correct size for the service line.
- Remove the pipe cap and the punch from the service tee and place in the plastic bag in which the service tee was shipped. Do not remove the splatter shield from the inlet.
- Clean the main of all coatings, rust, dirt, etc., in the area where the service tee is to be welded onto the main.
- Weld service tee to main per your company's welding procedures.
- Weld steel service line to outlet per your company's welding procedures.
- A pressure test is recommended before tapping the main.
- Lubricant must be applied to the punch threads and punch tip.** Acceptable lubricants include thread cutting oil, tapping fluid or tapping grease.
- Insert punch in service tee and turn clockwise by hand to avoid cross threading.
- Use a ratchet wrench with Continental adapter key and bushing to make the tap.
 - For 3/4" body tees, use 23-3692-00 Hex Drive Key, Bushing & Socket Adapter
 - For 1" body tees, use 23-0941-00 Hex Drive Key, Bushing & Socket Adapter



IMPORTANT: To insure retention of the coupon - coupon retaining punches should be run all the way down until the punch seats on the main.

- Back punch up until it is flush with the top of the tee.
- Apply thread sealant and install pipe cap.

NOTE: The service may be interrupted by running the punch down until it seats on the main.

IMPORTANT

Pressure Rating: 500 psig MAOP

Operating Temperature: -20 to 140° F

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