COMPRESSION COUPLING

ASSEMBLY INSTRUCTIONS 1-1/4” IPS AND 2” IPS

NEW INSTALLATION

IMPORTANT

For use on:
Polyethylene (PE) gas pipe meeting the requirements of ASTM D 2513

Pressure Rating: Designed to meet or exceed pressure rating of PE pipe per 49 CFR Part 192 and ASTM D 2513

Operating Temperature: -20 to 140°F

1. Clean pipe ends. The pipe ends should be undamaged and squarely cut. Deburr inside of pipe ends if necessary.
2. Inspect the pipe to ensure that there are no cuts or gouges located in the sealing area of the pipe.
3. Mark the maximum stab depth (see example for correct pipe size and corresponding stab depth) from the end of the pipe.

1-1/4” IPS

3” STAB LENGTH

2” IPS

4” STAB LENGTH

4. Remove the red cap plug and stiffener from end of outlet without removing the compression nut (discard the cap plug). Tap the stiffener into the pipe until the ID of the pipe rests on the knurl of the stiffener.

NOTE: If protective sleeve is required, slip it over pipe now, before making up outlet.

5. Stab the pipe into outlet up to (not past) the stab mark. (When stabbing the pipe, the compression nut should be loosened to the point that at least three to five threads are showing). See figure 1.

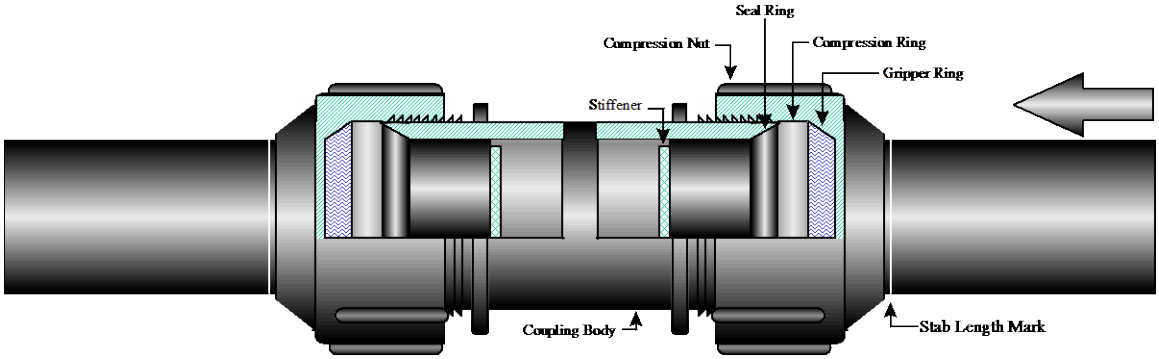

Figure 1

6. Tighten the compression nut until it shoulders against the body of the coupling. **Do Not Over Tighten**. If you cannot see the stab mark or the end of the compression nut is not within the distances listed below, reassemble the fitting. See figure 2.
7. Maximum distance from the end of the compression nut to the stab marks are shown below:

Pipe Size (Inches)	Maximum Distance (Inches)
1-1/4	5/8
2	1

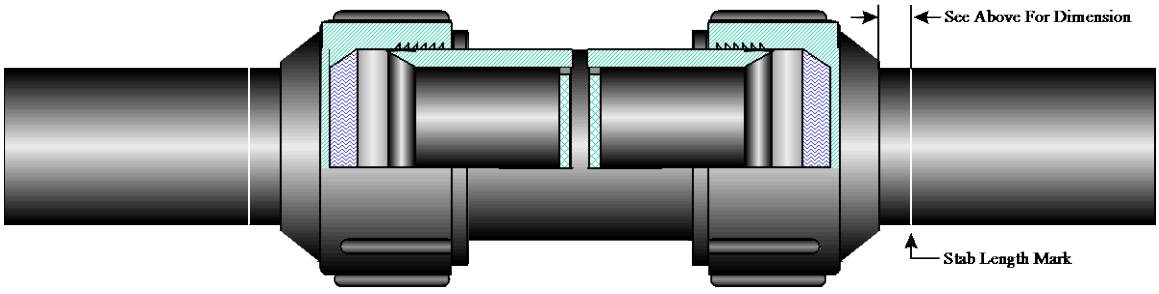

Figure 2

8. Stab and tighten other end following the same procedures listed above.

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EXISTING INSTALLATION (REPAIR)

1. Clean pipe ends. The pipe ends should be undamaged and squarely cut. Deburr inside of pipe ends if necessary.
2. Inspect the pipe to ensure that there are no cuts or gouges located in the sealing area of the pipe.
3. When repairing pipe, the maximum and minimum acceptable gaps are shown in the following table.

Allowable Gap		
Pipe Size	Minimum	Maximum
1-1/4” IPS	1”	2”
2” IPS	1-1/2”	3”

4. Place two reference marks (one on each pipe end) 6” from the end of the pipe.
5. Remove the red cap plugs and stiffener from both ends of the coupling without removing the compression nut. Discard the cap plugs. Tap the stiffeners into each pipe end until the ID of the pipe rests on the knurl of the stiffener.
6. Loosen the compression nuts to the point that approximately three to five threads are showing. Slide the repair coupling over one end of the pipe until the pipe end makes contact with the grip ring located at the opposite end of the repair coupling.

Note: It may be necessary to deflect the pipe in order to install the repair coupling onto the pipe.

7. Realign the pipe ends so they are in axial alignment with the repair coupling. Remove the compression nut, grip ring, compression ring and seal ring from the end of the repair coupling closest to the cut section of pipe and slide them onto the pipe.

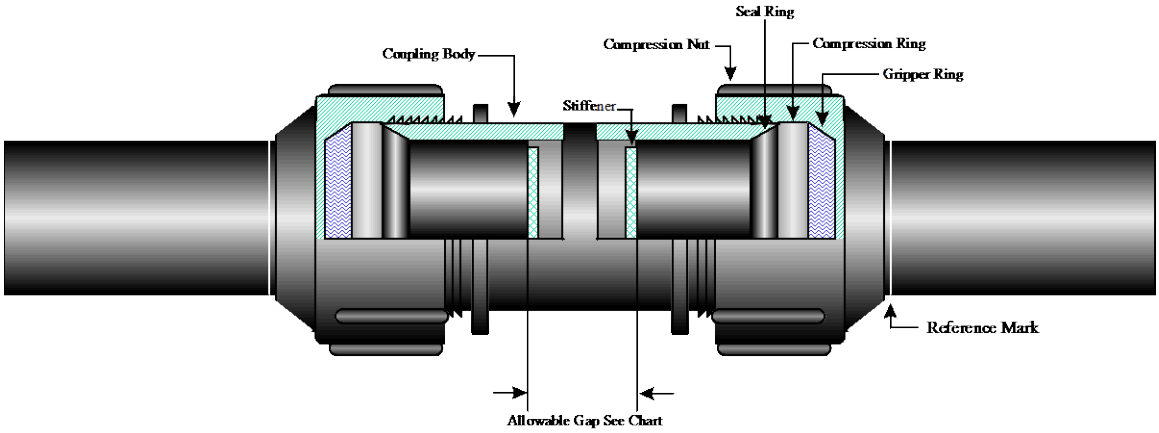

Figure 1

8. Remove the compression nut, grip ring, compression ring, and seal ring from the opposite end of the repair coupling so the body of the coupling is free to move along the pipe.
9. Position the repair coupling body over the center of the gap between the pipe ends and reassemble the seal ring, compression ring, grip ring and compression nut onto both ends of the repair coupling.
10. Tighten the compression nuts hand tight and verify that the repair coupling body is centered over the gap between the pipe ends by measuring from the two reference marks. The reference mark measurements should be an equal distance from the edge of the compression nut for both ends of the repair coupling.
11. Tighten the compression nuts until they shoulder against the body of the repair coupling. **Do not over tighten**.