

SOUTHWEST GAS INSTALLATION INSTRUCTIONS FOR 3/4" X 5/8" OD & 3/4" X 1 1/8" OD SERVICE TEES PART # 9902-99-0059-00 & # 9902-99-0060-00

CAUTION!

DO NOT APPLY EXTREME HEAT TO TEE WITH TOP SEAL PLUG AND COMPRESSION COMPONENTS INSTALLED

1. 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.

2. Remove perforator, seal plug cap, and compression nut with rubber grommet from the tee, place in the plastic bag. Do not remove steel dirt and splatter shield from inlet.

3. Weld service tee to main utilizing the approved welding procedure.

4. Allow the assembly to cool to ambient temperature.

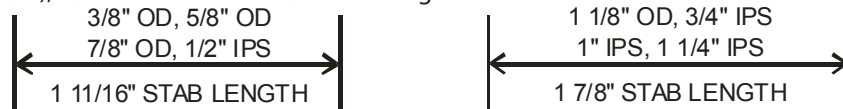
5. Connect service piping to outlet of service tee utilizing the following procedure:

5a. Cut pipe ends square, deburr outside and inside, if necessary, clean thoroughly to ensure there is no dirt, grease, oil, etc. on the assembly area of the pipe.

5b. Mark stab length on the pipe. Stab lengths are:

1/2" CTS (5/8") = 1 11/16" stab length

1" CTS (1 1/8"), 3/4" IPS & 1" IPS = 1 7/8" stab length



5c. Replace compression nut and rubber grommet loosely and insert pipe until it bottoms out in the outlet. (See detailed drawing "A")

5d. Tighten compression nut until it shoulders against the outlet. (See detailed drawing "B") Line marked for stab length should be no more than 3/16" from the face of the compression nut.

IMPORTANT

For use on:

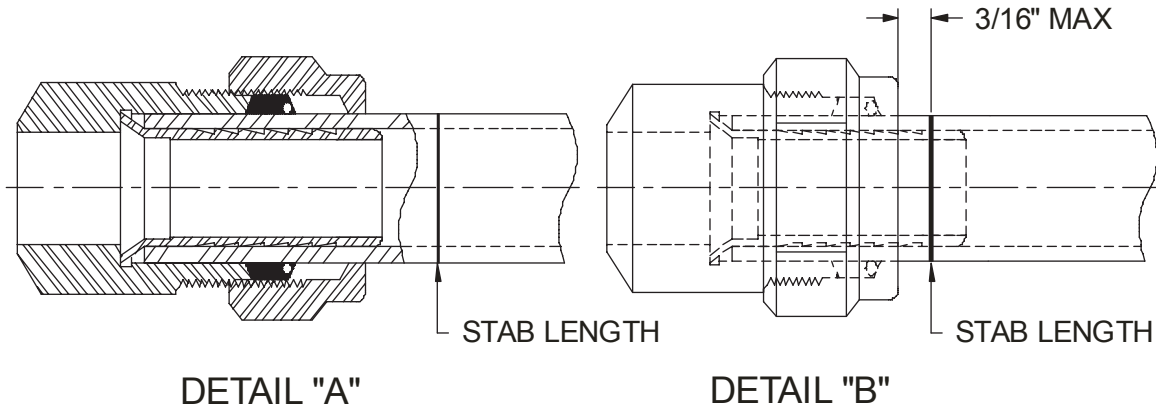
Polyethylene (PE) gas pipe meeting the requirements of ASTM D 2513

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

Material: Carbon Steel

NOTE: It is advisable to limit shear at main connections. In this regard, your company's policies should be followed. For further information, reference; ASTM D 2774 Standard Practice for Underground Installation of Thermoplastic Pressure Piping; Code of Federal Regulations, Title 49, Transportation Part 192; AGA Plastic Pipe Manual and/or The Guidance Manual for Operators of Small Gas Systems by the U.S. Department of Transportation.



6. Install seal plug cap on service tee and pressure test entire assembly.
7. After leak test, remove seal plug cap, apply cutting oil on the internal threads of the tee and insert perforator
Lubricant must be applied to the punch threads and punch tip. Acceptable lubricants include thread cutting oil, tapping fluid or tapping grease.

NOTE: Insert the perforator at least two turns by hand to prevent cross threading

8. Use a ratchet wrench with the Continental adapter key and bushing to complete the tap. Run the perforator all the way down until it seats on the main.
9. Back the perforator up until it protrudes 2-3 threads above the top of the tee. (As the perforator is backed into the up position, gas will flow into the outlet piping.)
10. Insert the hex drive of the seal plug cap into the socket of the perforator and run it down until it is leak tight. Care should be taken as the threads of the o-ring cap engage the threads of the tee body to prevent cross threading.
10. Leak test fitting with soap solution