

ASSEMBLY INSTRUCTIONS : PA COMPRESSION FITTINGS

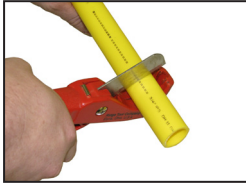
IMPORTANT

For use on:
 Polyethylene gas pipe meeting the requirements of ASTM D 2513
Pressure Rating: 125 psig MAOP
Operating Temperature: -20 to 140° F

1 Verify the fitting is the correct size for the polyethylene (P.E.) pipe. Verify that the SDR (or wall thickness) of the pipe matches the SDR (or wall thickness) printed on the fitting label.



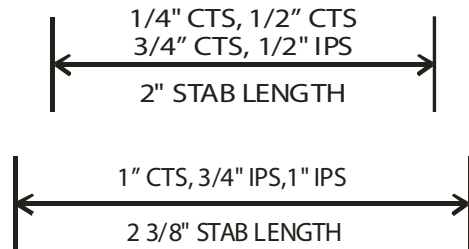
2 Cut pipe ends square.



3 Clean piping thoroughly to assure there is no dirt, grease or oil in assembly area.



4 Mark the stab depth on pipe. (See below. Stab Depth Lengths are to scale and may be used to measure stab depth.)



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Continental Industries

A Division of  BURNDY LLC

Phone No. 918-627-5210
 Fax No. 918-622-1275
www.conind.com

NOTE: TEXT & GRAPHICS TO HAVE WHITE BACKGROUND

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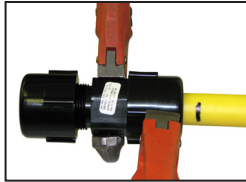
5 Loosen compression nut until seal ring is no longer compressed.
NOTE: In most instances, it is unnecessary to remove compression nut.



6 Insert pipe until it bottoms in outlet.



7 Tighten compression nut until it shoulders against the outlet. Do not overtighten.
CAUTION: To prevent inadvertent pull-out of the P.E. tubing during the assembly process, complete step 7 immediately after step 6, without delay and ensure work is not being performed on the free end of the P.E. tubing.



8 Line marked for stab depth should be no more than 3/4" from face of compression nut.



9 Repeat steps 1 thru 8 for all compression joints.

10 To assure proper assembly and to comply with 49 CFR 192 Subpart J—Test Requirements, the joint shall be leak tested.