

ASSEMBLY INSTRUCTIONS FOR

CATALOG # 9957-54-0094-00

2" IPS SDR 11 x 2" IPS SDR 9.33 COMPRESSION COUPLING

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
2" IPS	1 1/2"	3"

4. Place two stab 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. **IMPORTANT:** Make sure corresponding size (SDR) stiffener is installed in corresponding size (SDR) pipe. Each stiffener has the size and SDR stenciled upon it.
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.

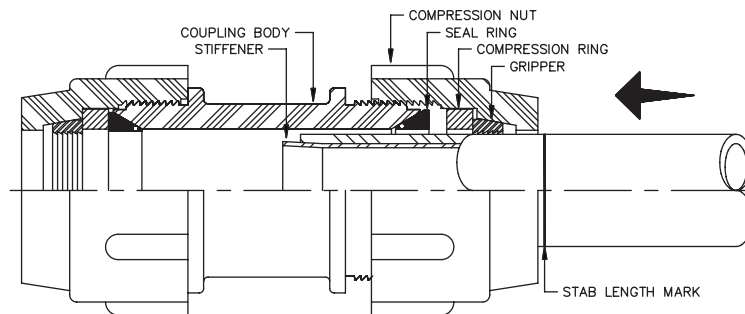


Figure 1

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.**

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