

1214, 1315, 1416 & 1517 STYLE TRANSITION SADDLE TEE INSTALLATION INSTRUCTIONS

1" IPS & Smaller Steel Mains X Con-Stab ID Seal® Transition

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. Verify that the outlet on the transition tee is the correct size for the service line.
3. Clean the main of all coatings, rust, dirt, etc., in the area where the saddle is to be installed. The elastomer seal should not be installed over pits or gouges in the pipe where the sealing integrity might be compromised.
4. Remove saddle bolt and place saddle in the desired position.
5. Replace saddle bolt and tighten leak tight, taking care not to rotate saddle on the main. It is recommended that the bolt be tightened to 25 foot pounds of torque.
DO NOT OVER TORQUE BOLT.
6. Make the service connection. See back of this sheet for P.E. Con-Stab outlets.
7. To assure proper assembly and to comply with 49 CFR 192 Subpart J—Test Requirements, the joint shall be leak tested.
8. Remove pipe cap and punch.
9. **Lubricant must be applied to the punch threads and punch tip.** Acceptable lubricants include thread cutting oil, tapping fluid or tapping grease.
10. Insert punch in transition tee and turn clockwise by hand to avoid cross threading.
11. Use a ratchet wrench with Continental drive key and bushing to make the tap.
 - For 1/2" body tees, use 23-3691-00 Hex Drive Key, Bushing & Socket Adapter
 - For 3/4" body tees, use 23-3692-00 Hex Drive Key, Bushing & Socket Adapter
 - For 1" body tees, use 23-0941-00 Square Drive Key, Bushing & Socket Adapter
 - For 1 1/4" body tees, use 23-0940-00 Square Drive Key, Bushing & Socket Adapter

IMPORTANT

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

For Use With: Natural Gas or Propane

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

12. To allow gas to the service line, back punch up until it is flush with the top of the tee.
13. Apply thread sealant and install pipe cap leak tight.

NOTE: If desirable at a later date, the service may be interrupted by running the punch valve down until it seats on the main.

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.

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ASSEMBLY INSTRUCTIONS : I.D. SEAL® CON-STAB

IMPORTANT

For use on:

Polyethylene 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 Verify the stab fitting is the correct size for the polyethylene (P.E.) pipe. Verify 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.



4a Chamfer end of pipe using [Continental's ID chamfering tool with ID gauge](#).

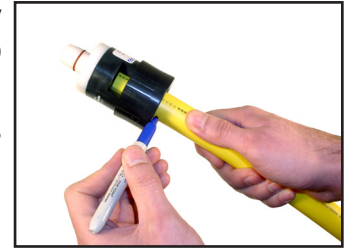
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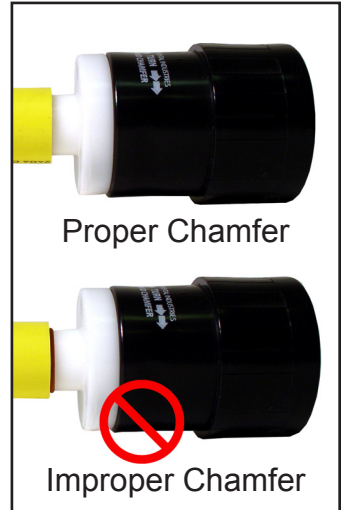
4b Chamfer end of pipe using [Continental's double ended ID chamfering tool](#).



5 Mark the stab depth by inserting pipe into ID chamfer tool and marking the pipe at the entrance as shown.



6 If using ID chamfer tool with gauge, check for proper chamfer by inserting pipe on gauge up to the o ring. With proper chamfer, o ring will begin to enter pipe.



7 Stab pipe completely into fitting entrance.



8 Stab pipe completely into fitting so that the mark on the pipe is within 1/8" from the fitting entrance.



9 Repeat steps 1 thru 8 for all Con-Stab joints.

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

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.

IMPORTANT
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ID OF PIPE

