

ASSEMBLY INSTRUCTIONS : PA COMPRESSION FITTINGS

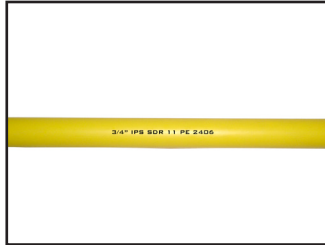
IMPORTANT

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



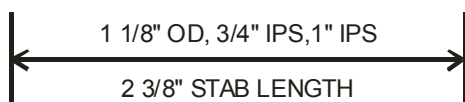
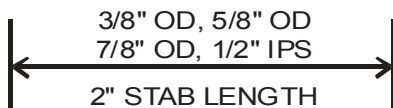
- 2** Cut pipe ends square.



- 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.)



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

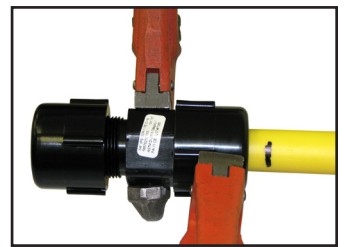


- 6** Insert pipe until it bottoms in outlet.



- 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.



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