

Service Punch Tee Installation Instructions: Compression Outlet for PE Gas Pipe

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 compression outlet on the service tee is the correct size for the polyethylene pipe.
3. Remove the pipe cap and the punch from the service tee and place in the plastic bag in which the service tee was shipped. Do not remove the splatter shield from the inlet.
4. Remove the compression nut and seal ring from the outlet to prevent heat damage to the seal ring during the welding procedure. Place them in the plastic bag in which the service tee was shipped.
5. Clean the main of all coatings, rust, dirt, etc., in the area where the service tee is to be welded onto the main.
6. Weld service tee to main per your company's welding procedures.
7. Install the compression nut and seal ring onto the outlet. Do not tighten the compression nut.
8. Cut polyethylene pipe end square, deburr inside and outside, clean thoroughly to assure there is no dirt, grease, oil, etc. on assembly area of pipe.
9. Mark stab length on pipe (see examples for correct pipe or tubing size and corresponding stab length).

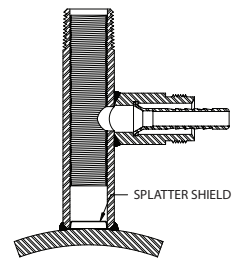
IMPORTANT

For use on:

Polyethylene gas pipe meeting the requirements of ASTM D 2513

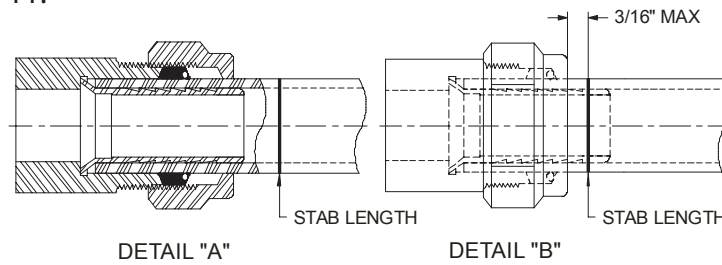
Pressure Rating: Designed to meet or exceed pressure rating of PE pipe per 49 CFR Part 192 and ASTM D 2513

Operating Temperature: -20 to 140° F



10. Insert the polyethylene pipe through the compression nut until it bottoms in the outlet. (See detail "A")
11. Tighten compression nut until it shoulders against the outlet. (See detail "B") The stab length line should be no more than 3/16" from face of the compression nut.

12. If the stab length line is more than 3/16" from the face of the compression nut, disassemble the joint and repeat steps 7 through 11.



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.

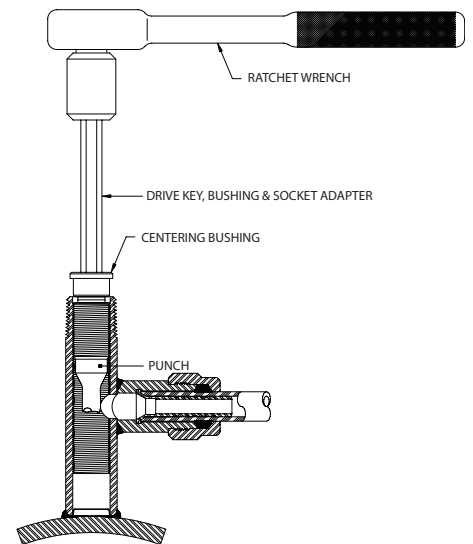
13. A pressure test is recommended before tapping the main.

14. **Lubricant must be applied to the punch threads and punch tip.** Acceptable lubricants include thread cutting oil, tapping fluid or tapping grease.

15. Insert punch in service tee and turn clockwise at least two turns by hand to avoid cross threading.

16. Use a ratchet wrench with Continental adapter key and bushing to make the tap.

- For 3/4" body tees, use 23-3692-00 Hex Drive Key, Bushing & Socket Adapter
- For 1" body tees, use 23-0941-00 Hex Drive Key, Bushing & Socket Adapter



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

17. Back punch up until it is flush with the top of the tee.

18. Apply thread sealant and install pipe cap.

NOTE: The service may be interrupted by running the punch down until it seats on the main.

