

1218, 1319, 1420 & 1521 Style Steel Service Safe-T Valve Tee Installation Instructions

Weld Inlet x Metallic Pipe (Conductive) Compression Outlet

1. Verify that the outlet on the service tee is the correct size for the service line.
2. Remove the pipe cap, the valve stem, outlet seal ring and compression nut from the service tee and place in the plastic bag in which the service tee was shipped.
3. Clean the main of all coatings, rust, dirt, etc., in the area where the service tee is to be welded onto the main.
4. Weld service tee to main per your company's welding procedures.
5. Make the service connection. See other side for outlet assembly instructions.
6. To assure proper assembly and to comply with 49 CFR 192 Subpart J—Test Requirements, the joint shall be leak tested.
7. Using proper size adapters, secure control chamber of gate valve to tee.

IMPORTANT

Pressure Rating: 300 psig MAOP

Operating Temperature: -20 to 140° F

Material: Carbon Steel

Body Size	Adapter #
3/4" IPS	23-7317-02
1" IPS	23-7317-01
1 1/4" IPS	23-7317-00

8. For drilling operation, refer to drilling machine manufacturer's instructions and your companies qualified drilling procedures. Drilling machines such as TD-101 and TD-12 have been used with Continental Safe-T Valve Tees.
9. After the drilling operation has been completed, install the valve stem in the tee using CI pn# 23-7216-00 insertion adapter or equal. This insertion adapter has been designed to work with the TDW Speed taper.
10. After the valve stem has been installed into the tee, remove the gate valve and size adapter.
11. Apply thread sealant and install pipe cap leak tight.

Compression Outlets — 1/2" OD & 5/8" OD Lock Type Conductive

1. Clean metallic pipe ends thoroughly. Remove any coatings, dirt, etc.
2. Loosen compression nut and insert pipe until it bottoms in outlet.
3. Tighten compression nut until it bottoms on shoulder (metal to metal).

Size	Metallic Pipe Pullout Resistance
1/2" OD	500 lbs
5/8" OD	2,000 lbs

NOTE: The conductive compression outlet is not a full restraint joint. WHERE PIPE PULLOUT COULD OCCUR, THE PIPE JOINT MUST BE ANCHORED.

Compression Outlets — 3/4" IPS & Larger Non-Lock Type Conductive

1. Clean metallic pipe ends thoroughly. Remove any coatings, dirt, etc.
2. Loosen compression nut and insert pipe until it bottoms in outlet. Pipe misalignment shall be no more than 3 1/2°.
3. Tighten compression nut to the torque values listed.

Size	Torque Ftlbs	Metallic Pipe Pullout Resistance
3/4" IPS	120-140	575 lbs
1" IPS	120-140	900 lbs
1 1/4" IPS	280-300	1,000 lbs

NOTE: The conductive compression outlet is not a full restraint joint. WHERE PIPE PULLOUT COULD OCCUR, THE PIPE JOINT MUST BE ANCHORED.