

### HVT ELIMINATOR WITH CON-STAB ID SEAL® OUTLET OPERATING INSTRUCTIONS

#### SADDLE INSTRUCTIONS

1. Mounting surface must be clean and free of cuts and scratches.

NOTE: If the pipe has minor scratches, less than 10% of the pipe wall thickness, repair the scratched PE pipe before installing the mechanical fittings.

1. Thoroughly clean the entire pipe surface where the mechanical fitting will be installed.
  2. Mark the proposed location of the mechanical fitting.
  3. Use 80-grit emery cloth and sand the area evenly until most of the scratches are removed.
  4. Continue removing scratches with 180-grit emery cloth until no scratches remain.
  5. Continue removing scratches with 240-grit emery cloth.
  6. Wipe the sanded surface clean with a wet towel or lint free cloth.
  7. Proceed with mechanical fitting installation.
2. Place top half of the saddle on the main. Place the bottom half of the saddle on the main with the holes lined up to insert the bolts. Insert all bolts and start the threads. Tighten two center bolts first using care to pull the saddle down evenly by tightening alternately front and back bolts, taking care not to rotate saddle on main. Do not move saddle after bolts are started. Tighten remaining bolts evenly until flanges of saddle come together.

#### CON-STAB OUTLET INSTRUCTIONS

1. See other side for stab outlet assembly instructions.

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.

#### TAPPING INSTRUCTIONS

1. Remove cap and o-ring, insert tapping tool (33-4363-00) into punch.
2. Screw punch clockwise until the stop on tapping tool contacts the top of the tee. (If possible, avoid pausing until tap is complete).
3. To allow flow thru the service, rotate the punch counter-clockwise until top of the punch is flush with the top of the tee. It is important that the punch does not protrude above the tee.
4. Inspect o-ring for debris and clean if necessary. Replace o-ring and cap and screw cap down 1/4 turn past hand tight.

#### IMPORTANT

##### For use on:

Thermoplastic gas pipe meeting the requirements of ASTM D 2513

Pressure Rating: 100 psig MAOP

Operating Temperature: -20 to 140° F

# ASSEMBLY INSTRUCTIONS : ID 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](#).

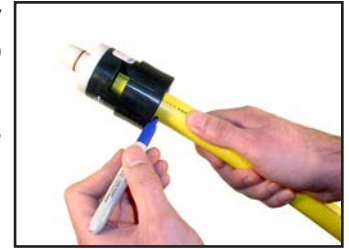
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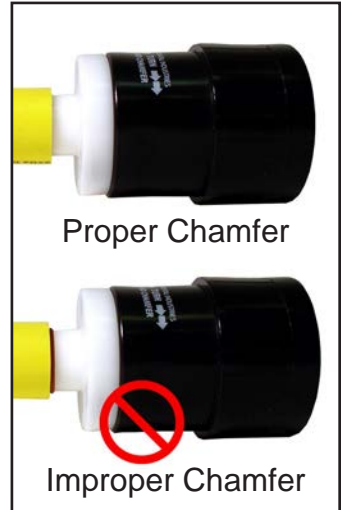
**4b** Chamfer end of pipe using [Continental's double ended ID chamfering tool](#).



**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**  
CHAMFER THE  
ID OF PIPE

