

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

Weld Inlet x PE 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. Remove the pipe cap and punch and place in the plastic bag in which the transition tee was shipped. Do not remove the splatter shield from the inlet (1/2" IPS & 3/4" IPS tee bodies only).
4. Clean the main of all coatings, rust, dirt, etc., in the area where the transition tee is to be welded onto the main.
5. Weld transition tee to main per your company's welding procedures. **Each company should follow their own procedures for protecting the plastic pipe from excessive heat during the welding process.**
6. When the outlet is cool to the touch, make the service connection following your company's qualified joining procedures for the PE.
7. To assure proper assembly and to comply with 49 CFR 192 Subpart J—Test Requirements, the joint shall be leak tested.
8. The transition tee must be cool to the touch before reinserting the punch.
9. Prior to inserting the punch back into the tee, inspect the punch and remove any dirt, debris, or contamination.
10. **Lubricant must be applied to the punch threads and punch tip.** Acceptable lubricants include thread cutting oil, tapping fluid or tapping grease.
11. Insert punch in transition tee and turn clockwise by hand to avoid cross threading.
12. 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.

13. To allow gas to the service line, back punch up until it is flush with the top of the tee.
14. 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.