1201 & 1302 Style Steel Service Punch Tee Installation Instructions
Weld Inlet x Weld or Threaded Outlets

IMPORTANT

Pressure Rating: 500 psig MAOP

Operating Temperature: -20 to 140° F

Material: Carbon Steel

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 service tee is the correct size for the service line.
3. Remove the O-ring 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. Clean the main of all coatings, rust, dirt, etc., in the area where the service tee is to be welded onto the main.
5. Weld service tee to main per your company's welding procedures.
6. Make the service connection.
   - For weld outlets, follow your company's welding procedures.
   - For threaded outlets, apply thread sealant to male thread and screw mating thread onto outlet.
7. To assure proper assembly and to comply with 49 CFR 192 Subpart J—Test Requirements, the joint shall be leak tested.
8. The service tee must be cool to the touch before reinserting the punch.
9. **Lubricant must be applied to the punch threads and punch tip.** Acceptable lubricants include thread cutting oil, tapping fluid or tapping grease.
10. Insert punch in service tee and turn clockwise by hand to avoid cross threading.
11. Use a ratchet wrench with Continental adapter 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

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

12. To allow gas to the service line, back punch valve up until it protrudes 2 to 3 threads above top of tee.
13. Insert the hex drive of the O-ring plug cap into the socket of the punch valve and run the unit down until it is leak tight. Take care as the threads of the O-ring plug cap engage the threads of the tee body to prevent cross threading.

NOTE: If desirable at a later date, the service may be interrupted by running the punch valve down until it seats on the main.