

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

#### Weld Inlet x Weld or Threaded Outlets

1. Verify that the outlet on the service tee is the correct size for the service line.
2. Remove the pipe cap and the valve stem 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.
  - For weld outlets, follow your company's welding procedures.
  - For threaded outlets, apply thread sealant to male thread and screw mating thread onto outlet.
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: 500 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 tapper.
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.