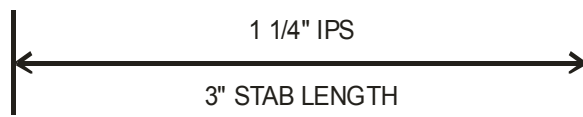


ASSEMBLY INSTRUCTIONS FOR CATALOG #'s 5657-54-1015-0A & 2957-54-1015-0A 1 1/4" IPS SDR 10 x 1 1/4" IPS SDR 11 COMPRESSION COUPLING

1. Cut pipe ends square and deburr I.D. Clean thoroughly to ensure there is no dirt, grease, oil, etc. on O.D. or I.D. of pipe.
2. Mark the maximum stab depth (see example for corresponding stab depth) from end of pipe.



IMPORTANT
For use on:
Polyethylene (PE) 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

3. Remove red cap plug and stiffener from both ends of coupling without removing the compression nut (discard cap plugs). Tap the stiffener into the pipe until the I.D. of the pipe rests on the knurl of the stiffener.
IMPORTANT: Make sure corresponding size (SDR) stiffener is installed in corresponding size (SDR) pipe. Each stiffener has the size and SDR stenciled upon it.
4. **NOTE:** If protective sleeve is required, slip it over pipe now, before making up coupling.
5. Stab coupling onto the pipe end up to (not past) the stab mark. (When stabbing the pipe, the nut should be loosened to the point that at least three to five threads are showing). See figure 1.

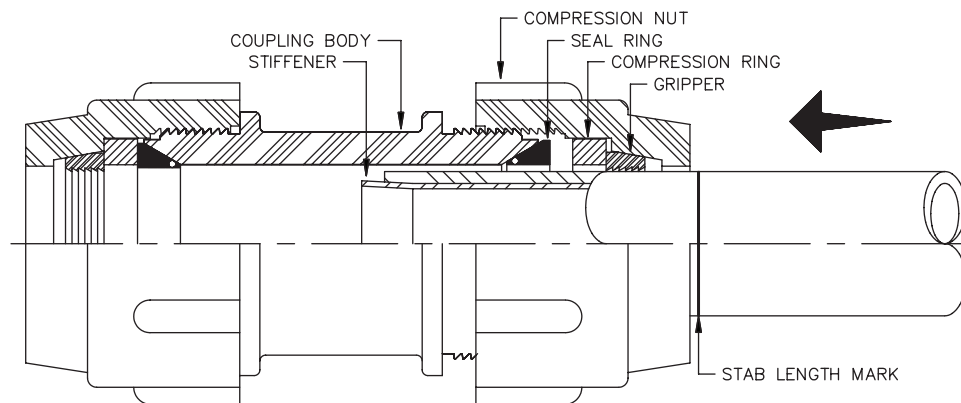


Figure 1

6. Tighten compression nut until it shoulders against the body of the coupling. Do not over tighten. If you cannot see the stab mark or the end of the compression nut is not within the distance listed below, reassemble fitting. See figure 2.

Maximum distance from end of compression nut to stab marks on pipe are:

5/8" for 1 1/4" IPS pipe

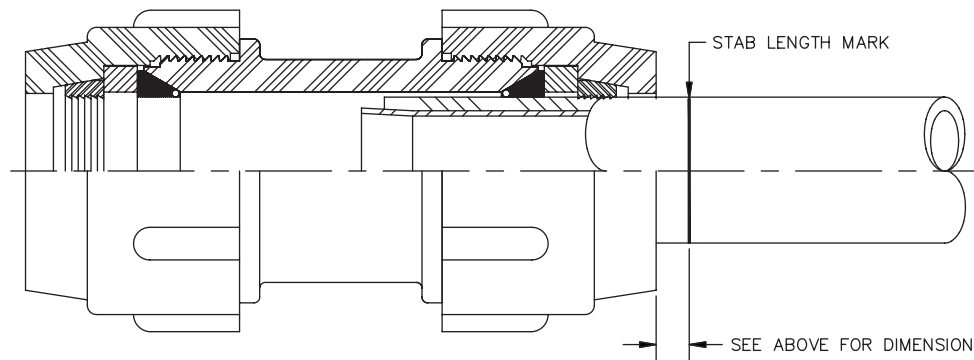


Figure 2

7. Stab and tighten other end following the same procedures listed above.

Guidelines:

1. For repairing buried pipe, the maximum gap between the ends of the pipe is listed below:
1 1/4" IPS coupling ~ 2" maximum gap
2. For repairing buried pipe, the minimum gap between the ends of the pipe is listed below:
1 1/4" IPS coupling ~ 1" minimum gap