

I.D. SEAL® CON-STAB FUSION SADDLE INSTALLATION INSTRUCTIONS

IMPORTANT

For use on:
Polyethylene gas pipe meeting the requirements of ASTM D 2513

Pressure Rating: 125 psig MAOP

Operating Temperature: -20 to 140° F

SADDLE INSTRUCTIONS

- 1 Follow your companies procedures for heat fusing the saddle to the main.

ASSEMBLY INSTRUCTIONS : I.D. SEAL® CON-STAB

- 2 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.



- 3 Cut pipe ends square.



- 4 Clean piping thoroughly to assure there is no dirt, grease or oil in assembly area.



- 5a Chamfer end of pipe using [Continental's ID chamfering tool with ID gauge](#).

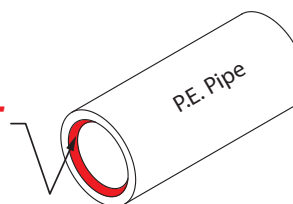
or



- 5b Chamfer end of pipe using [Continental's double ended ID chamfering tool](#).



IMPORTANT
CHAMFER THE
ID OF PIPE



PATENT #'S 5,366,260, 5,692,785 & 5,853,272

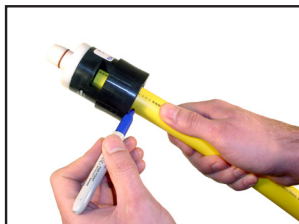
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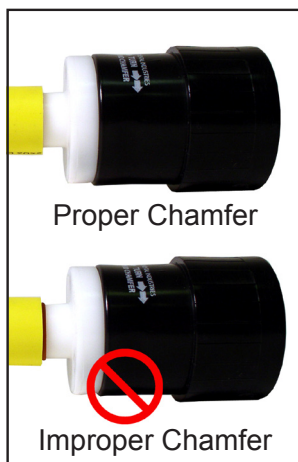
Continental Industries
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6 Mark the stab depth by inserting pipe into ID chamfer tool and marking the pipe at the entrance as shown.



7 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.



8 Stab pipe completely into fitting entrance.



9 Stab pipe completely into fitting so that the mark on the pipe is within 1/8" from the fitting entrance.



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.