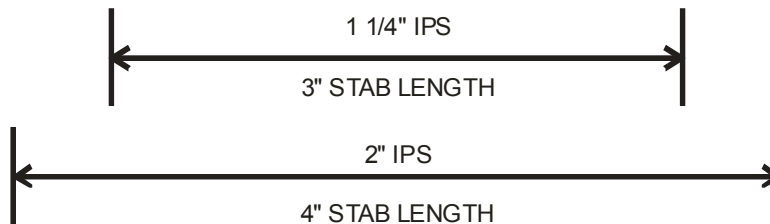


### ASSEMBLY INSTRUCTIONS

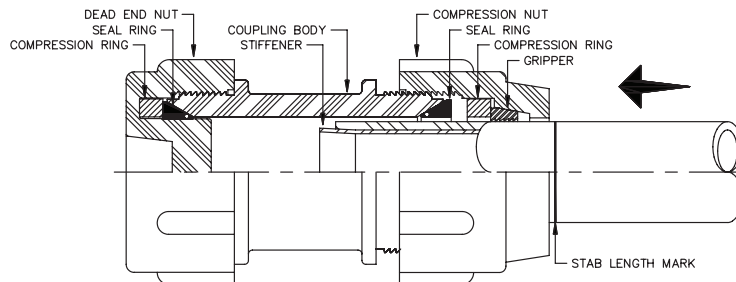
#### 1 1/4" IPS SDR 10, 1 1/4" IPS SDR 11 & 2" IPS SDR-11 END CAPS

**NOTE: Do not remove Dead End Nut.** PE compression end is the end with the red cap plug.

1. Cut pipe end 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.



3. Remove red cap plug and stiffener from PE compression end of coupling without removing the compression nut (discard cap plug). 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 end cap.
5. Stab end cap 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.

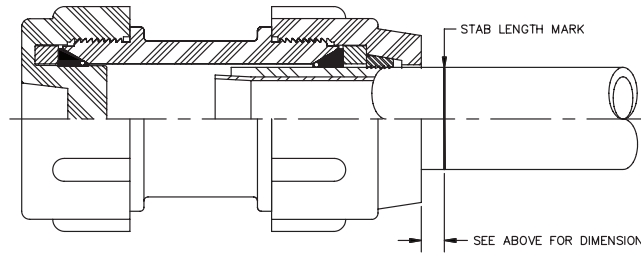


**Figure 1**

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.

Continued on back

Maximum distance from end of compression nut to stab mark on pipe is:  
5/8" for 1 1/4" IPS pipe  
1" for 2" IPS pipe



**Figure 2**

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