1201 & 1302 Style Steel Transition Punch Tee Installation Instructions

Weld Inlet x Con-Stab ID Seal® Transition

IMPORTANT

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

For Use With: Natural Gas or Propane

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 transition tee is the correct size for the service line.
3. Remove the O-ring cap and punch and place in the plastic bag in which the transition 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 transition tee is to be welded onto the main.
5. Weld transition tee to main per your company's welding procedures. **Each company should follow their own procedures for protecting the plastic transition joint from excessive heat during the welding process.**
6. When the outlet is cool to the touch, make the service connection. See back of this sheet for P.E. Con-Stab outlets.
7. To assure proper assembly and to comply with 49 CFR 192 Subpart J—Test Requirements, the joint shall be leak tested.
8. The transition tee must be cool to the touch before reinserting the punch.
9. Prior to inserting the punch back into the tee, inspect the punch and remove any dirt, debris, or contamination.
10. **Lubricant must be applied to the punch threads and punch tip.** Acceptable lubricants include thread cutting oil, tapping fluid or tapping grease.
11. Insert punch in transition tee and turn clockwise by hand to avoid cross threading.
12. 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.

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.

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

IMPORTANT

For use on:
Polyethylene 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

1 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.

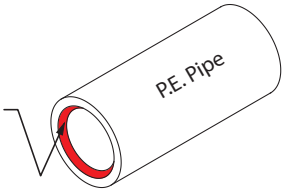
2 Cut pipe ends square.

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

4a Chamfer end of pipe using Continental's ID chamfering tool with ID gauge.

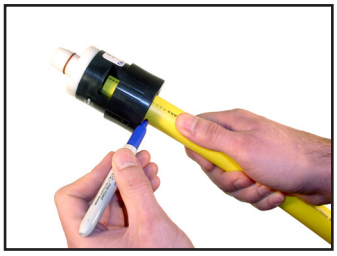
or

4b Chamfer end of pipe using Continental's double ended ID chamfering tool.



IMPORTANT
CHAMFER THE ID OF PIPE

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



6 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.

Proper Chamfer

Improper Chamfer

7 Stab pipe completely into fitting entrance.

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

9 Repeat steps 1 thru 8 for all Con-Stab joints.

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.