

## 1214, 1315, 1416 & 1517 Style Steel Service Punch Tee Installation Instructions 1 1/4" IPS & Larger Mains x Compression Outlet for PE Pipe

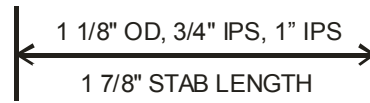
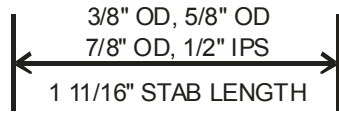
**IMPORTANT**  
**For use on:**  
Polyethylene (PE) gas pipe meeting  
the requirements of ASTM D 2513  
**Pressure Rating:** 125 psig MAOP  
**Operating Temperature:** -20 to 140° F  
**Material:** Carbon Steel

1. Verify that the compression outlet on the service tee is the correct size for the polyethylene (PE) pipe. Verify the SDR (or wall thickness) of the pipe matches the SDR (or wall thickness) stamped on the end of the stiffener.
  2. Clean the main of all coatings, rust, dirt, etc., in the area where the saddle is to be installed. The elastomer seal should not be installed over pits or gouges in the pipe where the sealing integrity might be compromised.
  3. Remove saddle bolt and place saddle in the desired position.
  4. Replace saddle bolt and tighten leak tight, taking care not to rotate saddle on the main. It is recommended that the bolt be tightened between 25 to 40 foot pounds of torque.  
**DO NOT OVER TORQUE BOLT.**
  5. Make the service connection. See other side for outlet assembly instructions.
  6. To assure proper assembly and to comply with 49 CFR 192 Subpart J—Test requirements, the joint shall be leak tested.
  7. Prior to tapping, it is recommended, that the punch be removed and a liberal amount of lubricant be applied to the internal threads of the service tee to greatly increase the tapping efficiency of the punch.
  8. Insert punch in service tee and turn clockwise by hand to avoid cross threading.
  9. Use a ratchet wrench with Continental drive 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
    - For 1" body tees, use 23-0941-00 Square Drive Key, Bushing & Socket Adapter
    - For 1 1/4" body tees, use 23-0940-00 Square 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.
10. To allow gas to the service line, back punch up until it is flush with the top of the tee.
  11. Apply thread sealant and install pipe cap leak tight.

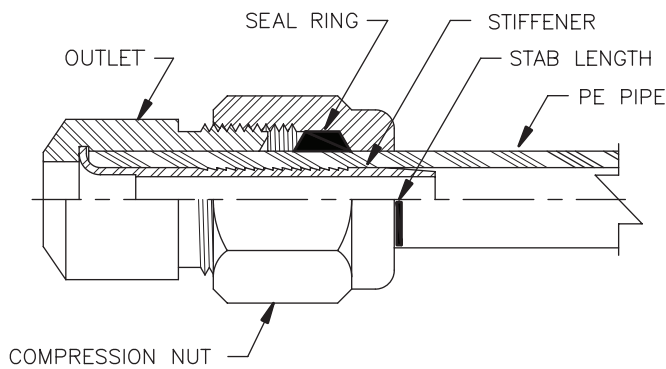
**NOTE:** If desirable at a later date, the service may be interrupted by running the punch valve down until it seats on the main.

## Compression Outlet for PE Pipe Installation Instructions

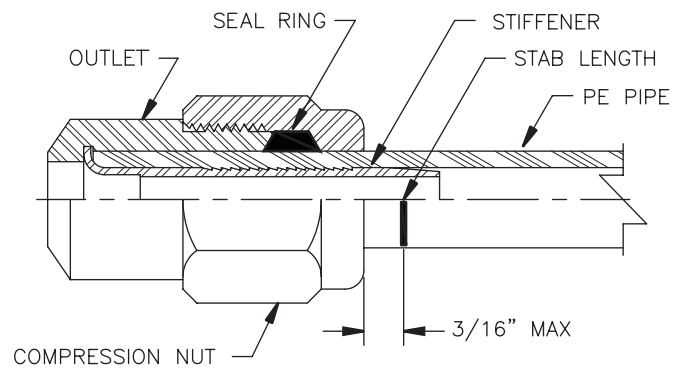
1. Install the compression nut and seal ring onto the outlet. Do not tighten the compression nut.
2. Cut polyethylene pipe end square, deburr inside and outside, clean thoroughly to assure there is no dirt, grease, oil, etc. on assembly area of pipe.
3. Mark stab length on pipe (see examples for correct pipe or tubing size and corresponding stab length).



4. Insert the polyethylene pipe through the compression nut until it bottoms in the outlet. (See detail "A")
5. Tighten compression nut until it bottoms on shoulder (metal to metal). (See detail "B") The stab length line should be no more than 3/16" from face of the compression nut.
6. If the stab length line is more than 3/16" from the face of the compression nut, disassemble the joint and repeat steps 1 through 5.



DETAIL "A"



DETAIL "B"

**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.