

# INSTALLATION INSTRUCTIONS

## CONDUCTIVE COMPRESSION X PE COMPRESSION COUPLINGS

**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**

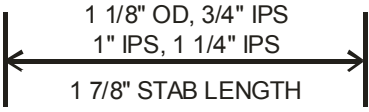
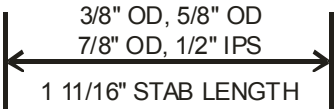
**Material: Carbon Steel**

### CONDUCTIVE COMPRESSION END (3/4" IPS & LARGER)

1. CLEAN METALLIC PIPE ENDS THOROUGHLY. REMOVE ANY COATINGS, DIRT, ETC.
2. LOOSEN COMPRESSION NUT AND INSERT PIPE UNTIL IT BOTTOMS IN COUPLING. PIPE MISALIGNMENT SHALL BE NO MORE THAN 3 1/2°.
3. TIGHTEN CONDUCTIVE COMPRESSION NUT TO THE TORQUE VALUES LISTED.

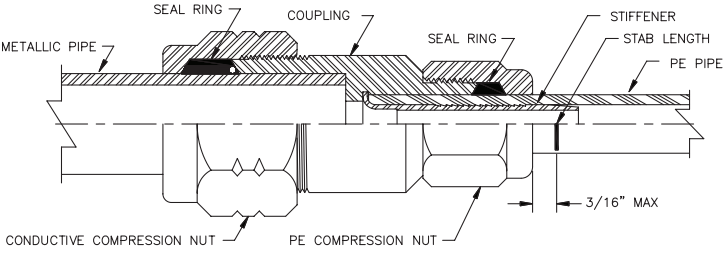
Size	Torque Ftlbs	Metallic Pipe Pullout Resistance
3/4" IPS	120-140	575 lbs
1" IPS	120-140	900 lbs
1 1/4" IPS	280-300	1,000 lbs

**NOTE:** THE CONDUCTIVE COMPRESSION END IS NOT A FULL RESTRAINT JOINT. WHERE PIPE PULLOUT COULD OCCUR, THE PIPE JOINT MUST BE ANCHORED.



### PE COMPRESSION END

4. VERIFY THAT THE COUPLING 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.
5. CUT PE PIPE ENDS SQUARE, DEBURR INSIDE AND OUTSIDE, CLEAN THOROUGHLY TO ASSURE THERE IS NO DIRT, GREASE, OIL, ETC. ON ASSEMBLY AREA OF PIPE.
6. MARK STAB LENGTH ON PE PIPE (SEE EXAMPLES FOR CORRECT PIPE OR TUBING SIZE AND CORRESPONDING STAB LENGTH).
7. LOOSEN COMPRESSION NUT AND INSERT PE PIPE UNTIL IT BOTTOMS IN COUPLING.
8. TIGHTEN COMPRESSION NUT UNTIL IT SHOULDERS AGAINST THE COUPLING. LINE MARKED FOR STAB LENGTH SHOULD BE NO MORE THAN 3/16" FROM FACE OF NUT, IF NOT, REASSEMBLE.
9. TO ASSURE PROPER ASSEMBLY AND TO COMPLY WITH 49 CFR 192 SUBPART J—TEST REQUIREMENTS, THE JOINT SHALL BE LEAK TESTED.



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