

# Permasert® Mechanical Couplings

## Installation Guide

- 1 Cut the PE piping so that the end is square.
- 2 Wipe with a clean dry cloth. Inspect the last several inches of PE piping for damage. If any, cut again to remove damaged area.



- 3 Use the Elster Perfection chamfering tool for a proper O.D. chamfer. This chamfer permits the PE piping to be completely stabbed without affecting the internal seals.



- 4 Use a soft felt tip pen, crayon or grease pencil to mark the stab depth as indicated on your Permasert package instructions. The stab depth is the approximate distance from the edge of the fusion bead to the end of the fitting body.

- 5 Stab the PE piping into the Permasert fitting so that the stab depth mark is visible:

- Within 1/8" of moisture seal on 1/2" CTS and 1" CTS sizes
- Within 1/4" on all other sizes through 1-1/4" CTS
- Approximately 3/8" on 1-1/4" IPS and 2" IPS sizes

The PE piping must bottom out in the fitting. Pressure test the joint in accordance with your standard procedures. The reference mark can move outward up to an additional 3/8" during pressure testing.



## About Elster

Elster Group is the world's leading manufacturer and supplier of highly accurate, high quality, integrated metering and utilization solutions to the gas, electricity and water industries. In addition, through its subsidiary Ipsen International, it is the leading global manufacturer of high level thermo-chemical treatment equipment.

The group has over 7,000 staff, operations in 38 countries and serves over 115 markets around the world. Elster's high quality products and systems reflect the wealth of knowledge and experience gained from over 170 years of dedication to measuring precious resources and energy.

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