

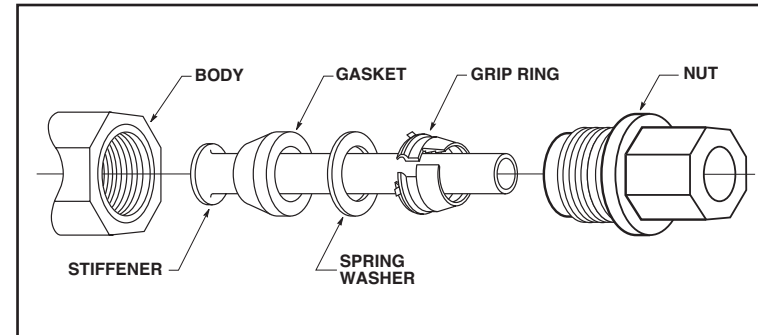
INSTALLATION INSTRUCTION 0001-0771-999

Style 403 Couplings

With SEAL-PLUS™ Restraining Ends

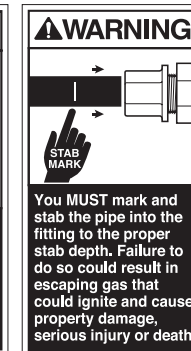
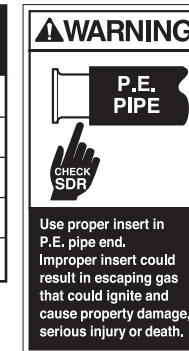
1. Cut tubing square and deburr. Tubing must be clean and free of longitudinal scratches. A slight chamfer approximately 1/16" x 45° on the end of tubing will facilitate insertion into the fitting.
2. The gap between the tubing ends should be in the 3/16" to 5/16" range.
3. Mark tubing for stab depth 2-3/4" for 5/8" O.D. thru 1-1/8" O.D., 3" for larger sizes.
4. Check stiffener to assure it is for wall thickness of tubing used (See the color code chart at right).
5. Install the properly identified Dresser stifener into each P.E. tubing end.
6. Make sure nut flange is 1/4" to 5/16" from body.
7. Straighten tubing. Excessive bend in tubing may cause difficulty is stabbing. Stab the coupling over one of the tubing ends, sliding tubing entirely through coupling. If difficulty is encountered, place finger inside nut and push the grip ring back into position or remove nut, slide grip ring over tubing, reassemble nut into body, then slide the tubing through the coupling.
8. Align the ends of the tubing and position coupling equidistant between the stab marks on both tubes and then **HAND-TIGHTEN THE NUT TO ACTUATE THE GRIP RINGS TO HOLD THE COUPLING IN POSITION DURING FINAL TIGHTENING.**
9. Tighten nut while holding octagon closest to nut until flange contacts body. (Do not overtighten)
10. Check stabbing marks on tubing. If mark is over 9/16" from the tightened nut on 5/8" O.D. thru 1-1/8" O.D., and over 5/8" on larger sizes, the end must be disassembled. After disassembly, check if stab mark lengths correct. In reassembling an improperly stabbed end, cut off tubing to eliminate the gripper teeth marks, reassemble parts in proper order, remark tubing, and then repeat the connection procedure.

NOTE: The gasket, spring washer and grip ring are held in place with shrink-wrap to facilitate assembly at the factory. The shrink-wrap does not need to be removed and is designed to break away during installation. However, if the fitting is disassembled following an improper installation, the shrink-wrap must be discarded prior to reassembly of the fitting as noted in Step 10 above.



COLOR CODE CHART

Tubing Wall (Any Diameter)	Stiffener Color
.062	Red
.077	Blue
.090	Silver
.099/.101/.103	Gold
.121	Black



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