

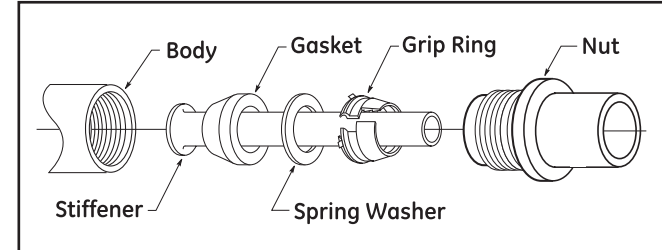
INSTALLATION INSTRUCTION 0001-0774-999

Style 501 Couplings & Fittings

With SEAL-PLUS™ Restraining Ends

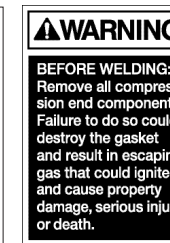
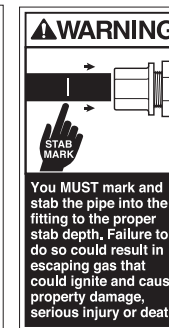
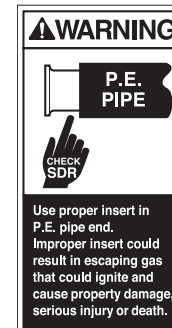
1. Cut tubing square and deburr. Tubing must be clean and free of longitudinal scratches. A slight chamfer of approximately 1/16" x 45° on the end of the tubing will facilitate insertion into the fitting.
2. IF WELDING is required, remove components prior to welding, then reassemble parts in the sequence and orientation shown.
3. Make sure nut flange is 1/4" to 5/16" from body contact.
4. Mark tubing for stab depth 2-3/4" for 1/2" CTS (5/8" O.D.) thru 1"CTS (1-1/8" O.D.), 3" for larger sizes.
5. Check stiffener to assure it is for wall thickness of tubing used (see color code chart).
6. Stab tubing into fitting until it bottoms. If properly stabbed, the tube markings will be inside or not over 1/8" from the UNTIGHTENED nut. **STABBING NOTE:** This fitting does not grip when the tubing is stabbed. If difficulty is encountered in stabbing, withdraw the tubing and try reinserting again. (Be sure nut flange is at least 1/4" from body.) After proper stabbing is determined, **THE NUT MUST BE HAND TIGHTENED TO ACTUATE THE GRIP RING FOR HOLDING THE TUBING IN PLACE DURING FINAL TIGHTENING.**
7. Tighten nut while holding body until flange contacts the body. (Do not overtighten.)
8. Check stabbing marks on tubing. If mark is over 9/16" from the tightened nut on 1/2" CTS (5/8" O.D.) thru 1"CTS (1-1/8" O.D.) sizes and over 5/8" on larger sizes, the end must be disassembled. After disassembly, check if stab mark length is correct. In re-assembling an improperly stabbed end, cut off the 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 of these components. This material is designed to break away during installation, and should be removed if the fitting is disassembled following an improper installation as noted in Step 8 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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