

## INSTALLATION INSTRUCTION 0001-0780-999

# Style 401 Couplings & Fittings

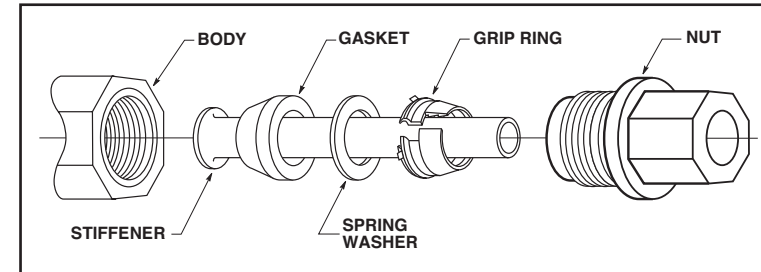
With SEAL-PLUS™ Restraining Ends

See other side for Stab Instructions

For splice-in applications on 401 couplings where it is advantageous to slide the tubing entirely through the coupling body, the following procedure should be followed:

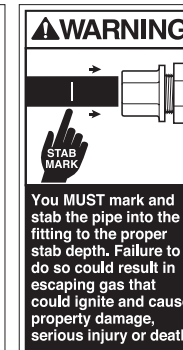
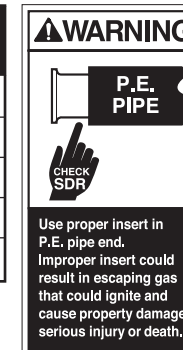
1. Cut tubing square and deburr. Tubing must be clean and free of longitudinal scratches. A slight chamfer approximately 1/16" x 45° on the end of tubing will facilitate insertion into the fitting.
2. The gap between the tubing ends should be in the 3/16" to 5/16" range.
3. Mark tubing for stab depth 2-3/4" for 1/2" CTS (5/8" O.D.) thru 1"CTS (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. Remove components from one end of the coupling and slide them in proper order and position (refer to exploded view) onto the tube ends, and insert the stiffener. Remove the components from the opposite end and place them onto the other tube end, except the stiffener.
6. To remove the body stop, place the stiffener in a 6" length of tubing. Stand the body on end on a rigid surface and insert the piece of tubing with the stiffener flange against the stop ring. Strike the end of the tubing with a hammer to knock out the breakaway center stop.
7. BE SURE to remove the stiffener from the knock-out tube piece and place it in the joint tube end. Slide the body over one end of the tube ends, align the ends, then position the body over the joint and assemble the components into the body. Start the nuts into the body leaving a space of 1/4" to 5/16" between the nut shoulder and the body. Position the coupling equidistant between the stab marks on both tubes, then hand-tighten the nuts to actuate the grip rings to hold the coupling in position during final tightening.
8. Tighten nut while holding body octagon closest to nut until flange contacts body. (Do not overtighten.)
9. After tightening, the tubing stab marks on either end must not be over 9/16" from the nut on 1/2" CTS (5/8" O.D.) thru 1"CTS (1-1/8" O.D.) and not over 5/8" on larger sizes. (Refer to No. 8 stab installation on other side if correction is required)

**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 7 above.



### COLOR CODE CHART

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



**Dresser™ Pipeline Solutions**

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**Part No. 0001-0780-999**  
**BAG.10.2018**

## INSTALLATION INSTRUCTION 0001-0780-999

# Style 401 Couplings & Fittings

With SEAL-PLUS™ Restraining Ends

See other side for Splice-in Instructions

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. Do not disassemble compression end(s).
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 1-1/4" CTS (1-3/8" O.D.) and larger sizes.
5. Check stiffener to assure it is for wall thickness of tubing used (See the color code chart at right).
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 octagon closest to nut until flange contacts 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.), and over 5/8" larger sizes, the end must be disassembled. After disassembly, check if stab mark length is correct. In reassembling 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.

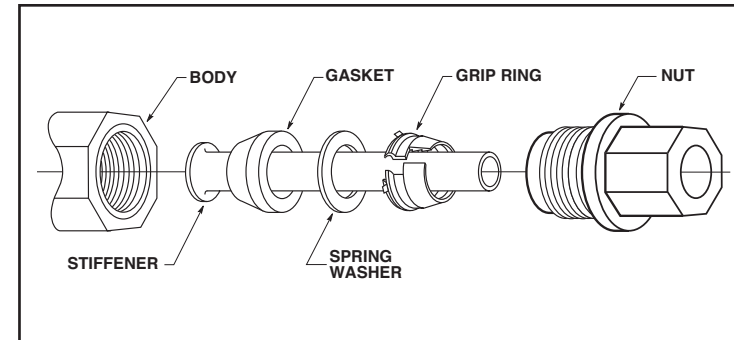
**NOTE:** The gasket, spring washer and grip ring are held in place with shrink-wrap to facilitate assembly at the factory. The shrink-wrap does not need to be removed and is designed to break away during installation. However, if the fitting is disassembled following an improper installation, the shrink-wrap must be discarded prior to reassembly of the fitting as noted in Step 8 above.



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**NOTE:**

**2-3/4" Stab Length:**

For 1/2" CTS (5/8" O.D.) thru 1" CTS (1-1/8" O.D.)

**3" Stab Length:**

For 1-1/4" CTS (1-3/8" O.D.) and larger.



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