

## INSTALLATION INSTRUCTION 0001-0795-999

# Style 401 Couplings & Fittings

With SEAL-PLUS™ Restraining Ends

### FOR POLYETHYLENE TUBING END:

#### Special instruction for PE to Copper transitions with copper tube stiffener

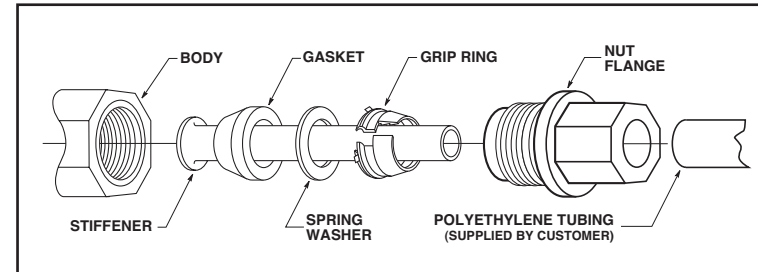
1. Cut tubing square and deburr. Tubing must be clean and free of longitudinal scratches. A slight chamfer approximately 1/16" x 45° on the end of tubing will facilitate insertion into the fitting.
2. Do not disassemble compression end(s).
3. Make sure nut flange is 1/4" to 5/16" from body contact.
4. 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).
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" on 1-1/4" CTS (1-3/8" O.D.) and 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.**



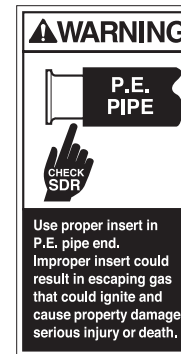
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### COLOR CODE CHART

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



Part No. 0001-0795-999  
BAG.10.2018

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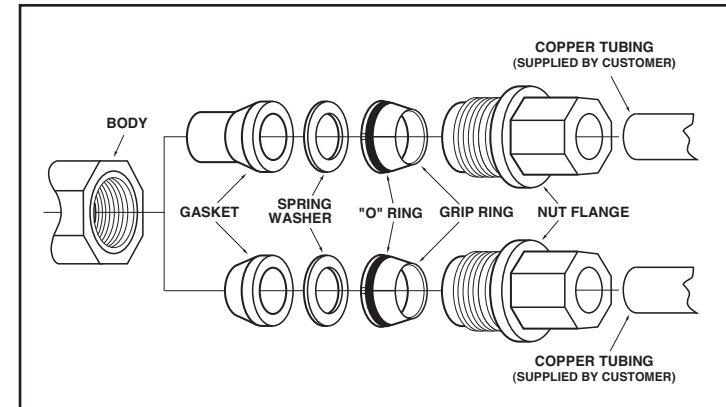
# Style 401 Couplings & Fittings

With SEAL-PLUS™ Restraining Ends

### FOR COPPER TUBE END:

#### Special instruction for PE to Copper transitions with copper tube stiffener

1. Cut tubing square and deburr. Tubing must be clean and free of dents and kinks (bends). Existing tubing should be cleaned to a smooth surface to allow gasket to seal. Excessive tubing out-of-roundness may cause difficulty in stabbing (rounding may be required equal to the stab length; a reforming tool may be helpful).
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. Install stiffener in the end of the copper tubing until the stiffener flange stops against the pipe end. Insert Stiffeners for Type K copper are color coded with green paint.
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. (If over 1/8", see step #9 below).
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" on 1-1/4" CTS (1-3/8" O.D.) and larger sizes, the end must be disassembled.
9. Disassembly: The tubing will be gripped when stabbed, therefore, the nut must be backed out of the body completely; the tubing can then be removed from the fitting. The nut and grip ring will be on tubing, and possibly spring washer and gasket. Remove components from tubing. **The grip ring will require spreading at the splits to remove it from tubing.** Replace components in proper order in fitting as shown. After disassembly, check to see if stab mark length is correct. Cut off tubing to eliminate gripper tooth marks. Repeat installation procedure.



### COLOR CODE CHART

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.062	Red
.077	Blue
.090	Silver
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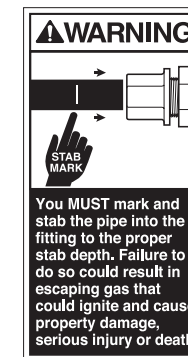
### NOTE:

#### 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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