

Style 90 'PLASTI-LOK' Couplings & Fittings

For use with PLASTI-LOK Compression Ends on Polyethylene* Pipe and Steel Pipe

Style 90 PXP and SXP couplings and fittings are for use on polyethylene to polyethylene and transition from steel to polyethylene pipe. Transition couplings are furnished with ball lock gasket and nut on steel end.

Polyethylene Pipe (PLASTI-LOK) End:

1. P. E. pipe surface must be clean and free of linear scratches or gouges that would affect the sealing ability of gasket for not less than 3" from end of pipe. Squareness of the cut must be such that when insert is in place with flange butted to the pipe end there shall be no gap between flange and pipe end in excess of 1/8". Use a pipe cutter or miter box to ensure squareness. Remove all burrs from inside and outside of plastic pipe after cutting. (Fig. 1)
2. Remove nut, gasket, retainer cup and lock insert.
3. Assemble nut, gasket, and retainer cup as a unit and slip onto pipe end before installing lock insert into plastic pipe (Fig. 2) (lock insert flange is larger in diameter than the I.D. of the gasket or nut). Gasket for plastic is un-notched and unbuffered with armor set back from tip and must not be interchanged with regular armored gasket.
4. Install lock insert into plastic pipe. Lock insert is designed to have a friction fit in plastic pipe and may require light blows of a hammer to prevent bending or damaging flange, use a block of wood as surface to hammer insert in place (Fig. 3). Mark pipe 2" from end (add 1/4" additional stab depth for Plastisol coated fittings). Stab plastic pipe into coupling or fitting body to mark on pipe.
5. Tighten nut while holding body from rotating (Fig. 4). Recommended torque for the plastic end is 75 lbs. of pull on the end of the wrench. Wrench sizes are specified at right.

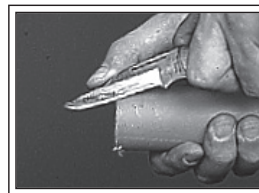


Fig.1

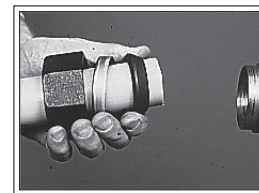


Fig.2

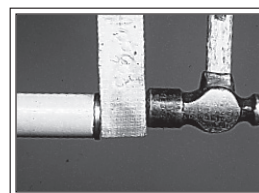


Fig.3

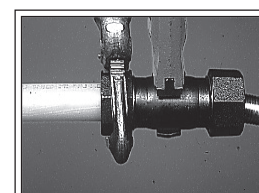
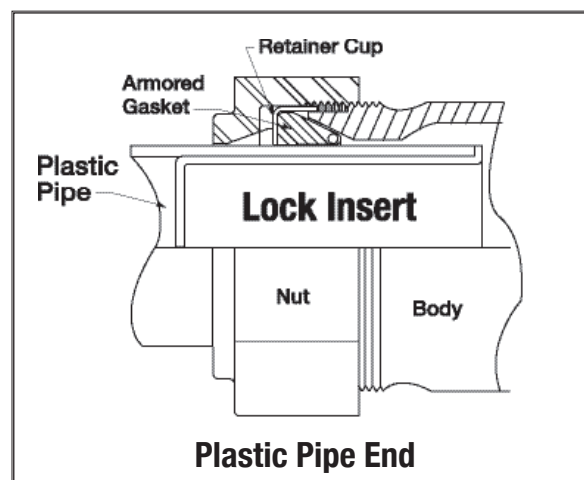


Fig.4



(See back for Steel Pipe Ends)

* Polyethylene Pipe as listed in ASTM D-2513.

Nominal Steel Pipe Size (ID)	Wrench Size (in)
3/4"	14
1"	18
1-1/4"	18
1-1/2"	24
2"	24

DRESSER
NATURAL GAS SOLUTIONS
Dresser™ Pipeline Solutions
41 Fisher Avenue
Bradford, PA 16701
P: 814.362.9200
F: 814.362.9344
www.dresserngs.com

© 2018 Natural Gas Solutions North America, LLC. The Dresser Logo and all Trademarks containing the term "Dresser" are the property Dresser, LLC, a subsidiary of Baker Hughes, a GE Company.

WARNING

You **MUST** mark and stab the pipe into the fitting to the proper stab depth. Failure to do so could result in escaping line content that could cause property damage, serious injury or death.

WARNING

P.E. PIPE

Use proper insert in P.E. pipe end. Improper insert could result in escaping gas that could ignite and cause property damage, serious injury or death.

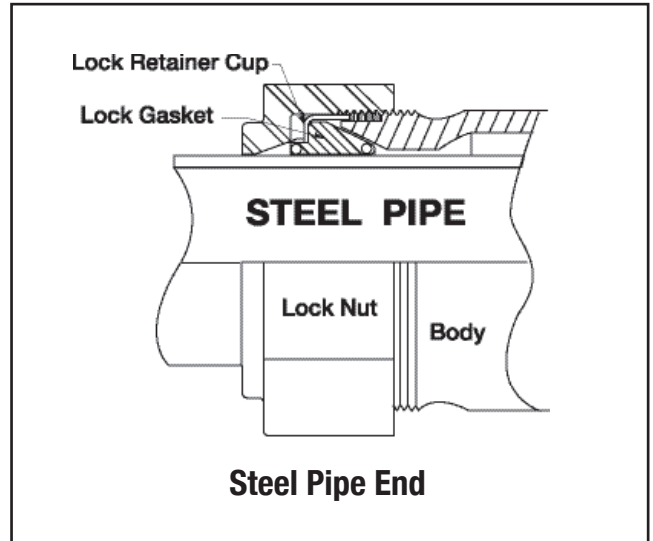
Style 90 'PLASTI-LOK' Couplings & Fittings

For use with PLASTI-LOK Compression Ends on Polyethylene* Pipe and Steel Pipe

Steel Pipe End:

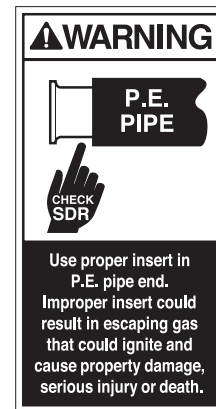
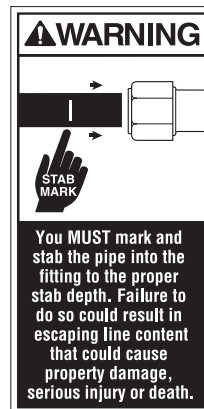
1. Clean pipe end and remove metal burr, loose scale, rust dirt that would affect the sealing ability of gasket for not less than 3" from pipe end. Apply soapy water to gasket (anti-freeze may be added in freezing weather).
2. Loosen nut about one-quarter turn and relieve gasket with fingers. Mark pipe 2-1/2" from end of pipe (add 1/4" additional stab depth for Plastisol coated fittings). Then stab pipe end into coupling to mark on pipe.
3. Tighten nut while holding body from rotating. The recommended torque for the steel pipe end with ball-lock is 100 lbs. of pull on the end of the wrench. Wrench sizes are specified below.

Nominal Steel Pipe Size (ID)	Wrench Size (in)
3/4"	14
1"	18
1-1/4"	18
1-1/2"	24
2"	24



IMPORTANT:

Coupling or fittings must be used with all parts as furnished from the factory and installed on pipe end as designated by markings on the coupling. Transition couplings and fittings from steel to plastic must be equipped with Dresser ball lock gasket and nut on steel pipe. Dresser lock insert must be used with polyethylene pipe of the SDR as designated on the body or flange of the insert.



* Polyethylene Pipe as listed in ASTM D-2513.

DRESSER
 NATURAL GAS SOLUTIONS
 Dresser™ Pipeline Solutions
 41 Fisher Avenue
 Bradford, PA 16701
 P: 814.362.9200
 F: 814.362.9344
 www.dresserngs.com