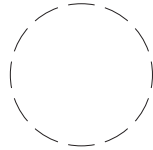


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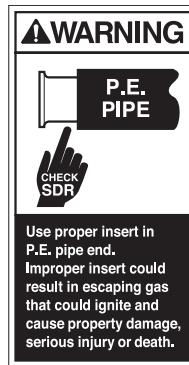
Style 711 Couplings, Reducing Couplings and Single-End Weld Fittings

For PE* to PE, PE to Steel and Steel to Steel Connections

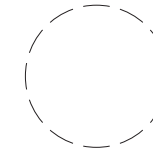
- Clean steel pipe end(s) removing oil, dirt, loose scale, and rust; gasket should seat on bare metal. Pipe ends must be cut square. Polyethylene pipe must be free of dirt, longitudinal scratches, grooves and burrs. NOTE: For installing weld end fittings, See instruction No.11 below
- On all P. E. pipe ends, the recommended insert stiffener must be installed. Before inserting in pipe end, each insert should be checked to ensure that the SDR indicated on the insert branding corresponds to the SDR of the pipe being used.
- Install proper insert in the P. E. pipe end.
- For the purpose of proper pipe insertion in reducing and straight couplings, mark pipe end as follows: This should be a minimum of one half the middle ring (body) length, plus 1/2". For 7" long middle ring, mark should be 4" from pipe end; for a 5" long middle ring the mark should be 3" from pipe end. Resulting pipe gap will be approximately 1".
- Check inside of line cap to assure gaskets and grip rings are free of dirt or foreign matter.
- After gaskets are clean, apply soap water to gaskets and pipe ends (anti-freeze should be added in freezing weather).
- Without disassembling, stab coupling to mark on pipe.
- Stab other pipe to mark located on pipe end.
- Tighten nuts uniformly and evenly in a crisscross pattern. Apply only one or two turns at a time, up to a final torque of 35 ft. lbs. minimum on the 1-1/4" size, and 80 ft. lbs. torque minimum for all other sizes.
- If field coating be desired, do not box coat with hot enamel coating.
- If single-end weld adapters are being used, proper welding techniques must be followed in welding to pipes. (It is not necessary to disassemble compression parts during welding). Mark pipe 3" from end of pipe for proper insertion depth and tighten nuts to torques values shown in No. 9.

*Polyethylene Pipe as listed in ASTM-D2513

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Style 711 Couplings, Reducing Couplings and Single-End Weld Fittings

Product Ratings for Style 711 Couplings with the Same Pipe Diameter on Both Ends.
(For reducing sizes, the DOT rating for the smallest diameter applies.)

Pipe Size Nom. (IN)	Pipe Size O.D.	Max. Sealing Pressure (Notes 3)	Max. CIP/Steel Pipe Pullout Resistance	Polyethylene Pipe* Pullout Resistance up to Max. wall listed in table meets or exceeds the requirements as specified in DOT 192.283 (b). (See Notes 1&2)	
				Type 2306/2406	Type 3406/3408
1-1/4	1.660	150 PSI	2500 lbs.	SDR 10	SDR 9.3
2	2.375	150 PSI	6300 lbs.	SDR 9.3	SDR 9.3
3	3.500	300 PSI	13000 lbs.	SDR 9.3	SDR 9.3
4	4.500	300 PSI	14000 lbs.	SDR 9.3	SDR 9.3
6	6.625	300 PSI	22000 lbs.	SDR 11	SDR 11

Note 1 - For wall thickness greater than SDR listed, contact Dresser for recommendation.

Note 2 - Pullout resistance is based on using reinforcing pipe inserts that conform to Dresser specifications.

Note 3 - Unless noted on body.

*Polyethylene Pipe as listed in ASTM-D2513



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CAUTION!

Never reuse this coupling for making a joint in accordance with D.O.T. Title 49 Part 192, Subpart F, Paragraphs 192.273(b), 192.283(b), & 192.285 unless grip ring, backup ring, gasket, bolts, nuts, and followers have been replaced OR the installer has determined these components have not been damaged in any way, are in new condition, and an applicable joining procedure is used.

When used for test purposes only, the installer shall determine conformance with Part 192 Subpart J, Paragraph 192.515(a).

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