

INSTALLATION INSTRUCTION 0001-0843-999

Style 501 Transition Couplings With Seal-Plus™ Restraining Ends

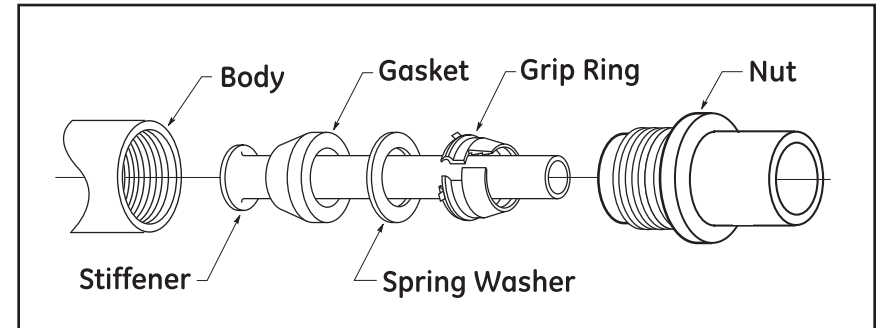
(See reverse side for Universal 90 ends)

Seal-Plus™ End

1. Cut tubing square and deburr. They must be clean and free of longitudinal scratches. A slight chamfer of approximately 1/16 x 45 degrees on the end of the tubing will facilitate insertion into the fitting.
2. Make sure the nut flange is 1/4" to 5/16" from body contact.
3. Mark tubing for stab depth; 2-3/4 for 5/8 O.D. thru 1-1/8 O.D., and 3" for larger sizes.
4. Check stiffener to ensure it is for wall thickness of tubing used (see color code chart).
5. 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 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 the 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.
6. Tighten nut while holding the body until the flange contacts the body. (DO NOT OVER-TIGHTEN.)
7. Check stabbing marks on tubing. If mark is over 9/16" from the tightened nut on 5/8 O.D. thru 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 reassembling an improperly stabbed end, cut off the tubing to eliminate the gripper teeth marks. Discard shrink wrap. Reassemble parts in proper order, remark tubing, 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 7 above.

Part No. 0001-0843-999
10.2018



COLOR CODE CHART

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

WARNING

P.E. PIPE

CHECK SDR

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.

WARNING

STAB MARK

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



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Style 501 Transition Couplings With Style 90 Universal x Seal-Plus™ Restraining Ends

(See reverse side for Seal-Plus ends)

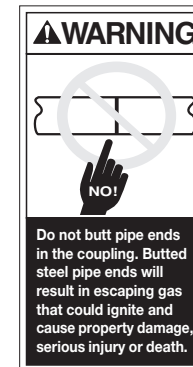
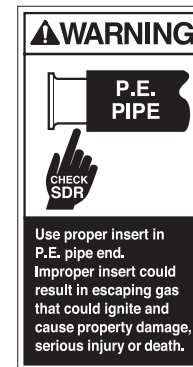
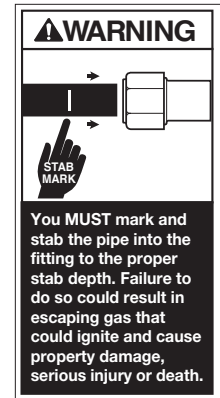
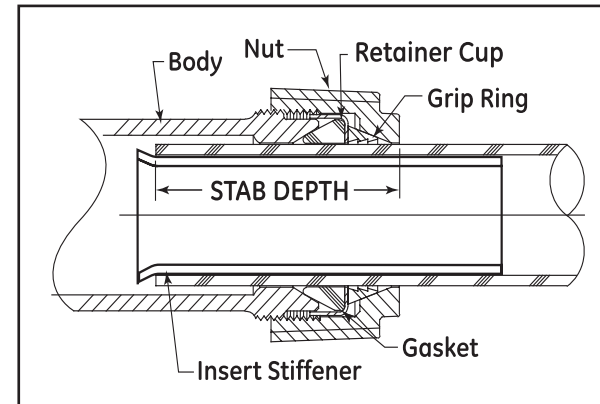
Universal End for P. E. and Steel Pipe

1. For steel pipe, clean pipe ends to bare metal removing oil, dirt, loose scale and rust. For polyethylene pipe, O.D. must be free of dirt, longitudinal scratches, grooves and burrs for a distance of 4" from pipe end.
2. On all P.E. pipe ends, the recommended Dresser insert stiffener must be installed. Before inserting in pipe end, each insert should be checked to ensure that the SDR indicated on the branding corresponds to the SDR on the pipe being used.
3. Loosen nut (DO NOT DISASSEMBLE) and check inside of the fitting to assure gasket and grip ring are loose and free of dirt or foreign matter.
4. Apply soap-water to the gaskets, only necessary when installing on steel pipe, but also acceptable on plastic pipe. (Anti-freeze may be added in freezing weather).
5. Mark each pipe a minimum of 2" from pipe end (add 1/4" additional stab depth for Plastisol coated fittings). Stab the pipe into the fitting until the mark on the pipe is even with the edge of the nut or inside the nut. The insert stiffener must extend beyond the nut as shown in the illustration at right.

CAUTION: A minimum of 1/2" is required between the pipe end and pipe stop, when connecting steel pipe.

6. Tighten nut while holding the body from rotating. Use 100 lb minimum pull with the recommended wrench size on chart at right.

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



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