1. Clean metal pipe end(s) removing oil, dirt, loose scale, and rust; gasket should seat on bare metal. Pipe ends must be cut square and polyethylene pipe must be free of dirt, longitudinal scratches, grooves and burrs.

2. 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.

3. Install proper insert in the P.E. pipe end.

4. For proper pipe insertion in coupling, mark each pipe as shown in chart at right.

5. Remove plastic spacer ring from inside the coupling.

6. Check inside of coupling to assure gaskets and grip rings are free of dirt or foreign matter.

7. After gaskets are clean, apply soap water to gaskets and pipe ends (anti-freeze should be added in freezing weather).

8. Without disassembling, stab coupling completely onto IPS pipe.

9. While holding plastic spacer ring between pipes, slide the coupling back over CIP pipe end and align with marks on pipes. Pipe end gap shall be approximately 2″.

10. Tighten nuts in a crisscross pattern. Apply only one or two turns at a time until all nuts have a uniform tightness to 80 ft. lbs. torque minimum.

11. Should field coating be desired, do not box coat with hot enamel coating.

*Polyethylene Pipe as listed in ASTM-D2513

<table>
<thead>
<tr>
<th>Pipe Size (OD)</th>
<th>Distance From Pipe End</th>
</tr>
</thead>
<tbody>
<tr>
<td>3.80 - 7.10″</td>
<td>4′</td>
</tr>
<tr>
<td>8.625 - 9.30″</td>
<td>5′</td>
</tr>
</tbody>
</table>

**WARNING**

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**
  - You MUST mark and stab the pipe into the coupling 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.

**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. If 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).

*Polyethylene Pipe as listed in ASTM-D2513