

## ASSEMBLY INSTRUCTIONS : I.D. SEAL® CON-STAB

**IMPORTANT**

For use on:  
Polyethylene gas pipe meeting the requirements of  
ASTM D 2513

Pressure Rating: 125 psig MAOP

Operating Temperature: -20 to 140° F

**1** Verify the stab fitting is the correct size for the polyethylene (P.E.) pipe. Verify the SDR (or wall thickness) of the pipe matches the SDR (or wall thickness) printed on the fitting label.



**4a** Chamfer end of pipe using [Continental's ID chamfering tool with ID gauge.](#)



or

**2** Cut pipe ends square.



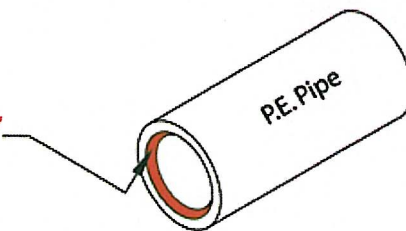
**4b** Chamfer end of pipe using [Continental's double ended ID chamfering tool.](#)



**3** Clean piping thoroughly to assure there is no dirt, grease or oil in assembly area.



**IMPORTANT**  
CHAMFER THE  
ID OF PIPE

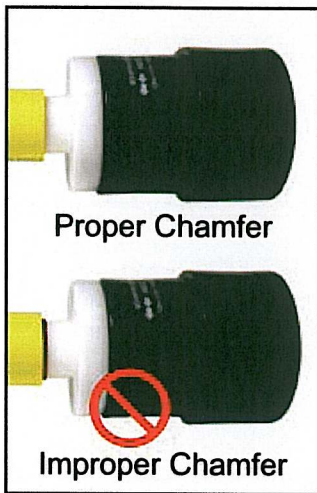


CONTINUED ON OTHER SIDE

**5** Mark the stab depth by inserting pipe into ID chamfer tool and marking the pipe at the entrance as shown.



**6** If using ID chamfer tool with gauge, check for proper chamfer by inserting pipe on gauge up to the o ring. With proper chamfer, o ring will begin to enter pipe.



**7** Stab pipe completely into fitting entrance.



**8** Stab pipe completely into fitting so that the mark on the pipe is within 1/8" from the fitting entrance.



**9** Repeat steps 1 thru 8 for all Con-Stab joints.

**10** To assure proper assembly and to comply with 49 CFR 192 Subpart J—Test Requirements, the joint shall be leak tested.