



Continental Industries

ID CHAMFERING TOOLS For Use With Con-Stab ID Seal® Fittings

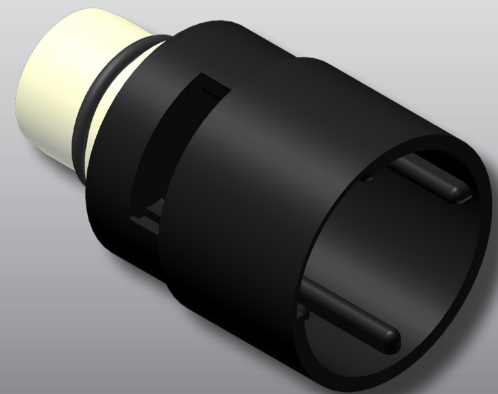
Double Ended ID Chamfer Tools

CATALOG NO.	DESCRIPTION
DOUBLE ENDED ID CHAMFER TOOLS	
0000-33-5647-00	1/2" IPS X 1/2" CTS (5/8" OD)
0000-33-5481-00	3/4" IPS X 1/2" CTS (5/8" OD)
0000-33-5652-00	3/4" IPS X 1/2" IPS
0000-33-5651-00	3/4" CTS (7/8" OD) X 1/2" CTS (5/8" OD)
0000-33-5609-00	3/4" CTS (7/8" OD) X 1/2" IPS
0000-33-5480-00	1" CTS (1 1/8" OD) X 1/2" CTS (5/8" OD)
0000-33-5963-00	1" CTS (1 1/8" OD) X 1/2" IPS
0000-33-5763-00	1" CTS (1 1/8" OD) X 3/4" CTS (7/8" OD)
0000-33-5589-00	1" CTS (1 1/8" OD) X 3/4" IPS
0000-33-5514-00	1" IPS X 1/2" CTS (5/8" OD)
0000-33-5516-00	1" IPS X 3/4" IPS
0000-33-5606-00	1" IPS X 1" CTS (1 1/8" OD)
0000-33-5515-00	1 1/4" CTS (1 3/8" OD) X 1/2" CTS (5/8" OD)
0000-33-5798-00	1 1/4" CTS (1 3/8" OD) X 3/4" IPS
0000-33-5631-00	1 1/4" CTS (1 3/8" OD) X 1" CTS (1 1/8" OD)
0000-33-6572-00	1 1/4" CTS (1 3/8" OD) X 1" IPS



ID Chamfer Tools With ID Gauge

CATALOG NO.	DESCRIPTION
ID CHAMFER TOOL WITH GAUGE	
0000-33-6580-04	1/2" CTS (5/8" OD) .090 WALL
0000-33-6580-06	3/4" CTS (7/8" OD) .090 WALL
0000-33-6580-02	1" CTS (1 1/8" OD) .090 WALL
0000-33-6580-08	1" CTS (1 1/8" OD) .099/.101 WALL
0000-33-6580-12	1/2" IPS SDR-9.3
0000-33-6580-13	3/4" IPS SDR-11
0000-33-6580-14	1" IPS SDR-11
0000-33-6580-03	1 1/4" CTS (1 3/8" OD) .090 WALL
0000-33-6580-10	1 1/4" IPS SDR-11 (.151 WALL)
0000-33-6580-15	1 1/4" IPS SDR-10 (.166 WALL)
0000-33-6580-09	1 1/4" IPS SDR-9.3 (.178 WALL)
0000-33-6580-16	1 1/2" IPS SDR-11
0000-33-6580-17	2" IPS SDR-11



ASSEMBLY INSTRUCTIONS : ID SEAL® CON-STAB

IMPORTANT

For use on: Polyethylene gas pipe meeting the requirements of ASTM D 2513
Pressure Rating: Designed to meet or exceed pressure rating of PE pipe per 49 CFR Part 192 and ASTM D 2513
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.



2 Cut pipe ends square.



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



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

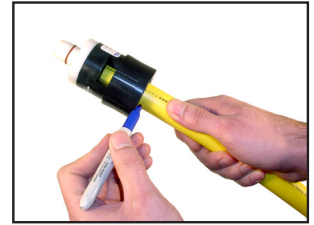
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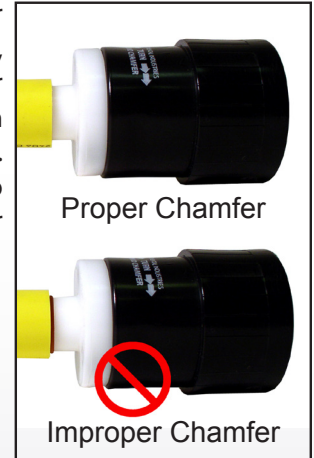
4b Chamfer end of pipe using [Continental's double ended ID chamfering tool](#).



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.



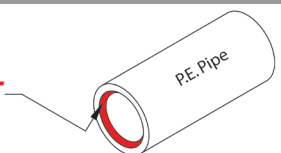
8 Stab pipe completely into fitting so that the mark on the pipe is within 1/8" from the fitting entrance.



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.

IMPORTANT
 CHAMFER THE
 ID OF PIPE



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