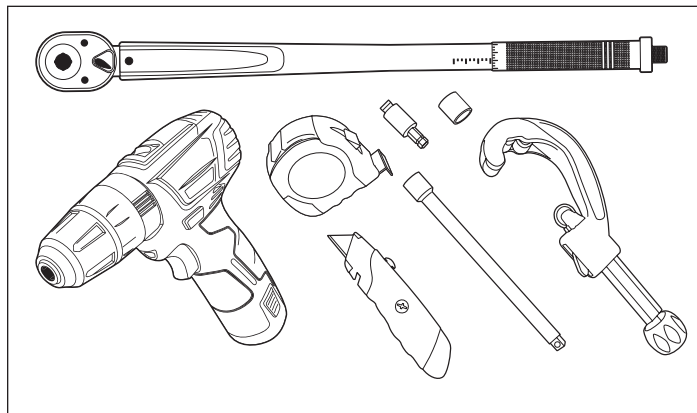


**ASSEMBLY of TracPipe® System
4-Bolt Fitting with Flip Sleeve Assembly**

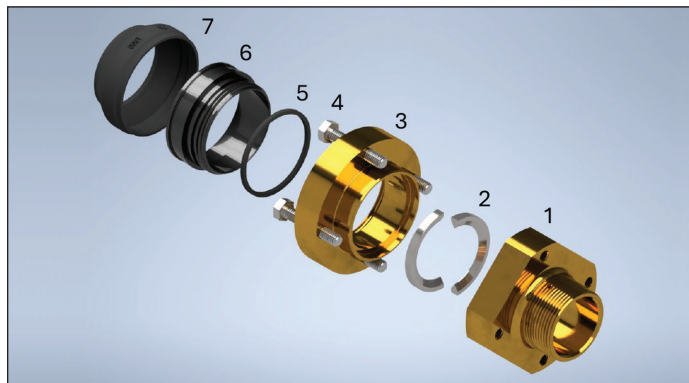
**1. Tools Required for Assembly
Components**

- Impact Driver (recommended) or Ratchet
- Tape Measure
- Utility Knife w/ Sharp Blade
- Swivel Socket Adapter
- 6-8" Socket Extension
- 1/2" Socket
- RIDGID 152 Tubing Cutter w/ FGP-E-5272 cutting wheel
- Torque Wrench



2. FGP-AF-S-SIZE (Straight Fitting Assembly)

1. Front Pipe Flange
 2. Split Rings
 3. Back Flange
 4. Hex Bolts (4) 5/16-18 x 1.75" lg. 18-8 SS
 5. Gasket
 6. Sleeve Adapter
 7. Flip Sleeve
- } Flip Sleeve Assembly



CAUTION

For your personal safety, the knife blade and cut tube ends are both very sharp. Use care when cutting the jacket and handling the tube.

3. CUT-TO-LENGTH

Determine proper length plus approximately three inches. Make a rough cut through the outer jacket and stainless-steel tubing, using a tubing cutter with a sharp cutting wheel. Use full circular strokes in one direction and tighten roller pressure slightly after each revolution. **DO NOT OVER TIGHTEN ROLLER**, which may flatten the tubing.

NOTICE:

A reciprocating saw can be used when rough cutting all sizes of tubing to length; however, the **FINAL CUT** must be performed using a suitable tubing cutter with a sharp cutting wheel.

NOTICE:

Due to the large diameter and depth of corrugations, 1 inch and above tubing must be cut with a **TracPipe CSST** cutting wheel P/N FGP-E-5272 installed in a standard RIGID 152 tubing cutter (remove standard RIGID 152 wheel and replace with FGP-E-5272). For use of P/N FGP-E-5272 cutting wheel with other tubing cutters contact the **TracPipe** engineering department.

CAUTION

The use of a small cutting wheel may flatten the first corrugation and make cutting and/or sealing fittings difficult.

4. STRIP JACKET & FINAL CUT

Using a sharp utility knife, strip back the jacket three inches. From the edge of the jacket, count out **EIGHT** full corrugations and make a final cut on the bare stainless in the valley between the eighth and ninth corrugations. **DO NOT** overtighten roller which may flatten the first corrugation (Figure 1-1, Figure 1-2, Figure 1-3).

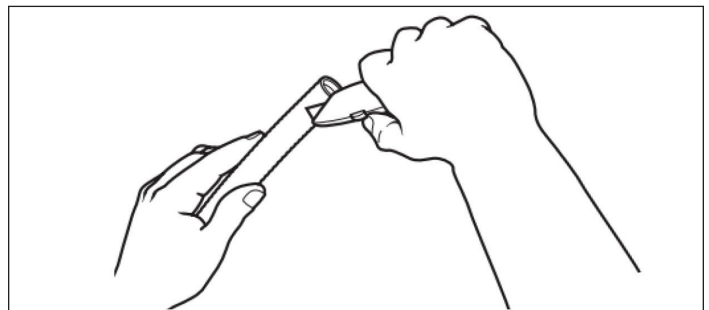


Figure: 1-1

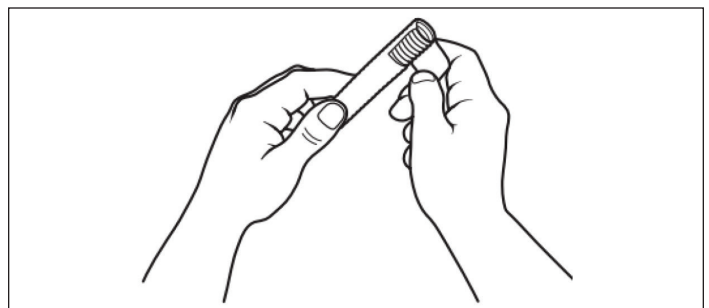


Figure: 1-2

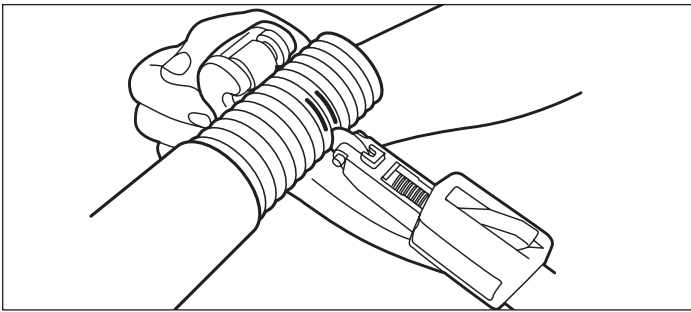


Figure: 1-3

⚠ CAUTION

To separate the two cut tubing ends, gently bend the faces of the tubing back and forth against each other. Do not twist or pull the tubing to break it loose. This may cause an improper seal.

5. DIS-ASSEMBLE FITTING

Unscrew Flip Sleeve Assembly from the Back Flange. Remove all Hex Bolts, separate the Front Pipe Flange from the Back Flange, and remove the two Split Rings (Figure 1-4).

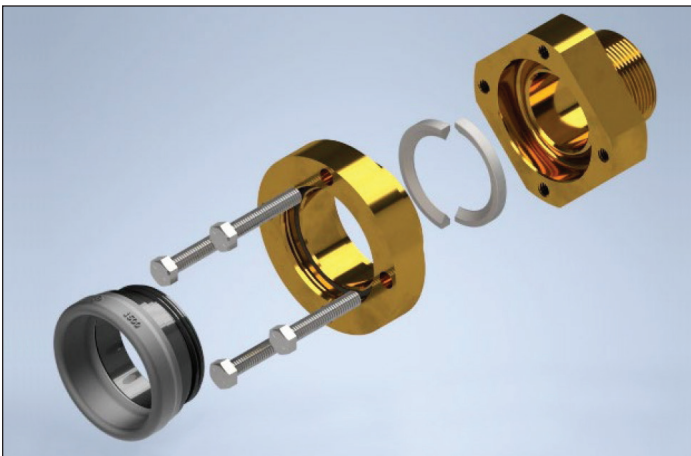


Figure: 1-4

6. INSTALL FITTING

Ensure the Flip Sleeve is tucked into the Sleeve Adapter, then slide the Flip Sleeve Assembly over the cut end of the tubing. Slide the Back Flange over the tubing until the Back Flange bottoms out against the jacket. Place two Split Rings into the first corrugation next to the tube cut (Figure 1-5).

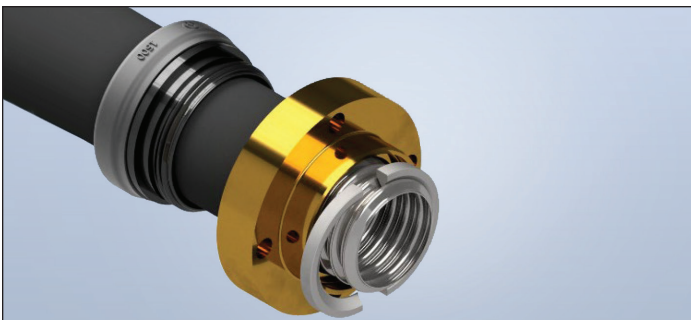


Figure: 1-5

- Slide the Back Flange forward to trap the Split Rings. While applying forward pressure to the Back Flange, slide the Front Pipe Flange onto the Back Flange ledge. Insert and align Hex Bolts, then partially tighten, which will allow the fitting to swivel (Figure 1-6).

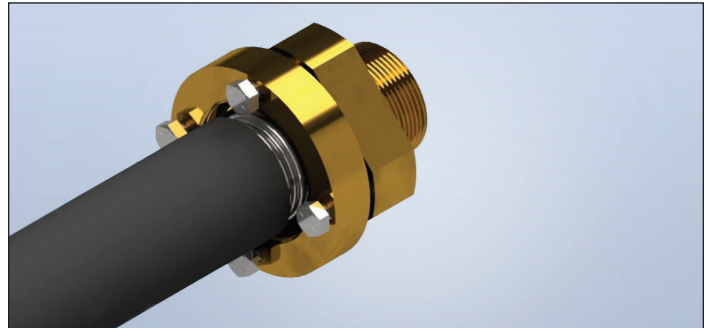


Figure: 1-6

⚠ CAUTION

If forward pressure is not maintained, the split rings may dislodge from the Flange Body pocket, causing an improper seal.

- Apply pipe dope or thread sealant to the NPT threads of the Front Pipe Flange as needed. Tighten the NPT threads of the Front Pipe Flange into the NPT threads of the mating pipe component. Sealants are to be used on the NPT connection only (Figure 1-7)!



Figure: 1-7

⚠ CAUTION

Do not use any pipe dope or thread sealants on the self-flaring connection. This connection is a metal to metal seat and will not seal properly if pipe dope or thread sealants are used. Sealants are to be used on the NPT connector to the equipment only.

9. Tighten all Hex Bolts in an alternating pattern to the torque value listed in Table 1 (Figure 1-8). Note that the **TracPipe** System fitting is designed to form a leak tight seal on the stainless-steel tubing as the fitting is tightened. **DO NOT overtighten bolts.** When fully tightened, there should be a small and uniform gap around the circumference of the fitting between the Front Pipe Flange and the Back Flange.

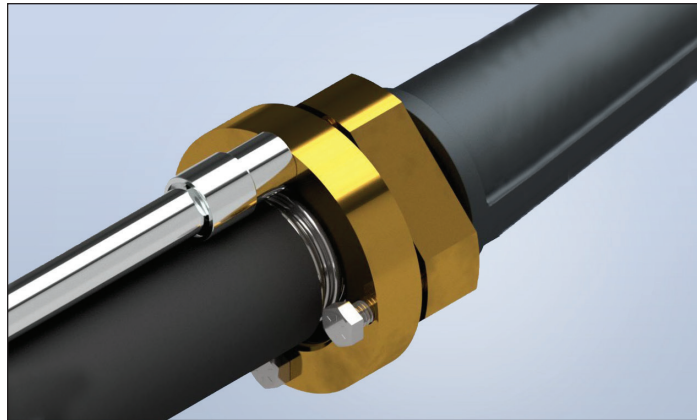


Figure: 1-8

Table 1
TracPipe System 4-Bolt Fitting Torque Values

TracPipe System 4-Bolt Pipe Size	Torque Settings
1-1/4"	25 FT-LBS
1-1/2"	25 FT-LBS
2"	25 FT-LBS

10. In a quick motion, pull the Flip Sleeve Assembly forward. This will untuck the Flip Sleeve onto the outer jacket. Slide up and hand-tighten the Flip Sleeve Assembly into the Back Flange (Figure 1-9). With the Flip Sleeve Assembly installed, there will be no exposed stainless steel.

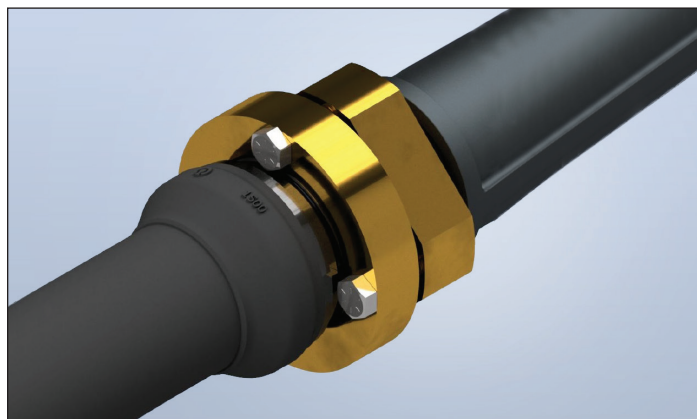


Figure: 1-9

11. Pressure test **TracPipe** System pipe and fitting in accordance with state and local codes and Section 6 of the **TracPipe** System Flexible Gas Piping Design Guide & Installation Instructions (D&I Guide).

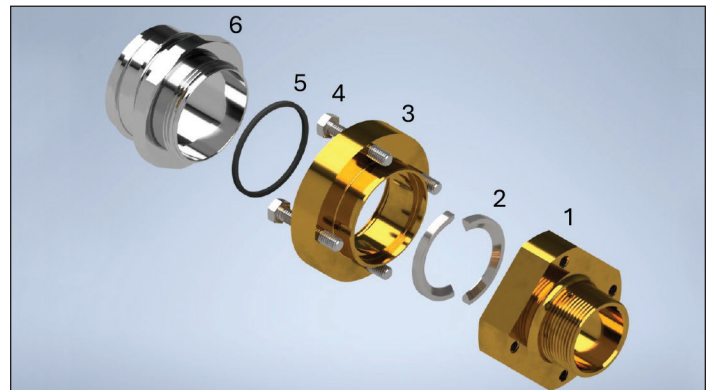
NOTICE:

The same instructions apply when installing the following: FGP-AF-CPLG-SIZE (Coupling Fitting Assy)

ASSEMBLY of TracPipe System 4-Bolt Fitting with Floppy Conduit Adapter

1. Components

1. Front Pipe Flange
2. Split Rings
3. Back Flange
4. Hex Bolts (4) 5/16-18 x 1.75" lg. 18-8 SS
5. Gasket
6. Floppy Conduit Adapter



2. Standard FGP-AF-S-SIZE fittings come with the Flip Sleeve Assembly. If fitting installation requires a Type RW floppy steel conduit to be used as protection, a Floppy Conduit Adapter can be used in place of the Flip Sleeve Assembly. Refer to **TracPipe** System Flexible Gas Piping D&I Guide Section 4.4 for additional piping protection information.

3. Follow **TracPipe** System 4-Bolt Fitting Installation Steps 3-5 for standard jacket stripping and final cut procedures.

4. **BEFORE** installing the fitting, slide the floppy conduit then the Floppy Conduit Adapter over the tubing. Ensure the finer pitch thread of the Floppy Conduit Adapter faces the Back Flange (Figure 1-10).

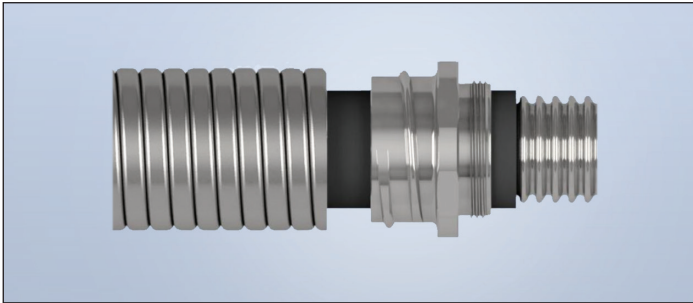


Figure: 1-10

5. Slide the Back Flange over the tubing until it bottoms out against the jacket. Place two Split Rings into the first corrugation next to the tube cut (Figure 1-11).

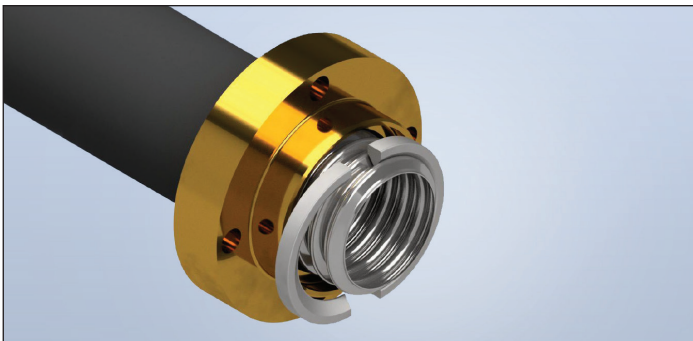


Figure: 1-11

6. Follow the **TracPipe** System 4-Bolt Fitting Installation Steps 7-9.

7. Slide up and tighten the Floppy Conduit Adapter into the Back Flange (Figure 1-12). **DO NOT** overtighten the Floppy Conduit Adapter!

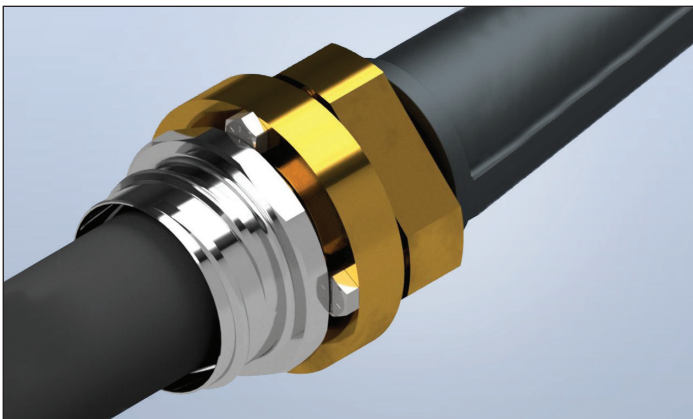


Figure: 1-12

8. Thread floppy conduit onto Floppy Conduit Adapter until it stops. This will secure the floppy conduit to the fitting (Figure 1-13). **NO additional fastening or adhesives required!**

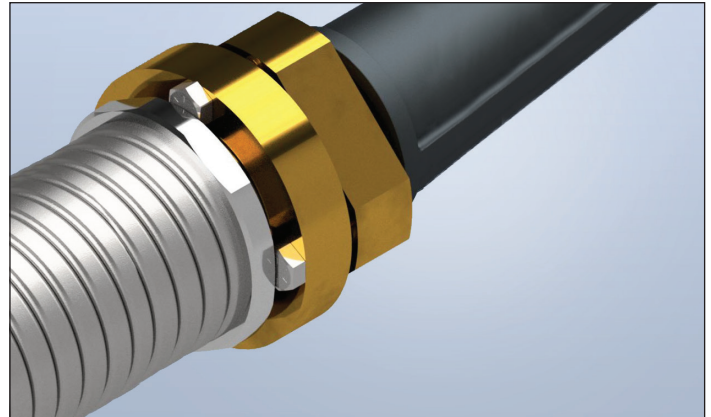


Figure: 1-13

9. Pressure test **TracPipe** System pipe and fitting in accordance with state and local codes and Section 6 of the **TracPipe** System Flexible Gas Piping Design Guide & Installation Instructions (D&I Guide).

NOTICE:

The same instructions apply when installing the following: FGP-AF-CPLG-SIZE (Coupling Fitting Assy)

Refer to the following QR code to access assembly videos and instructions for other products.



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