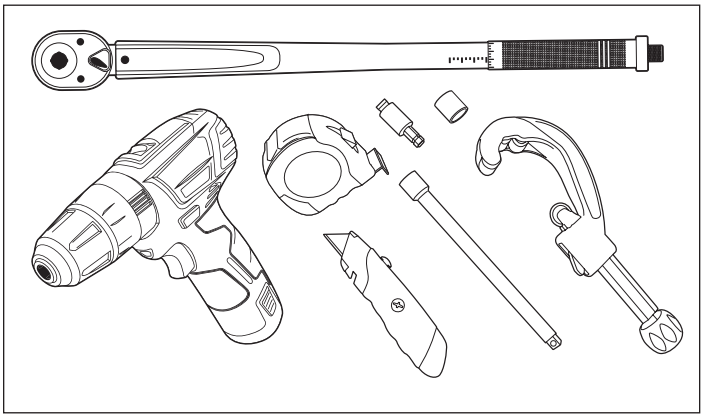
ASSEMBLY of TracPipe® System 4-Bolt Rectangular Flange Termination Fitting

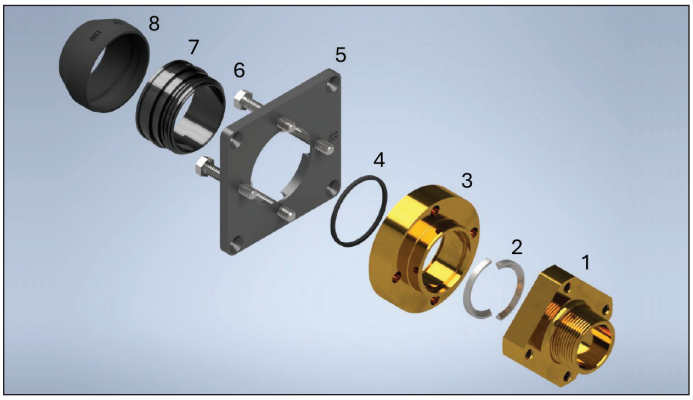
1. Tools Required for Assembly

- 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-RF-1250 (Rectangular Flange Fitting Assembly) Components

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



⚠ 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).

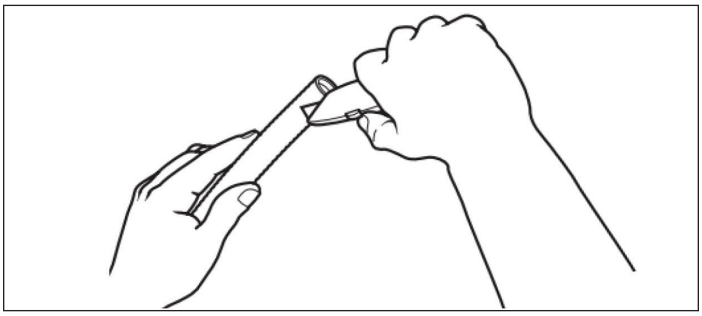


Figure: 1-1

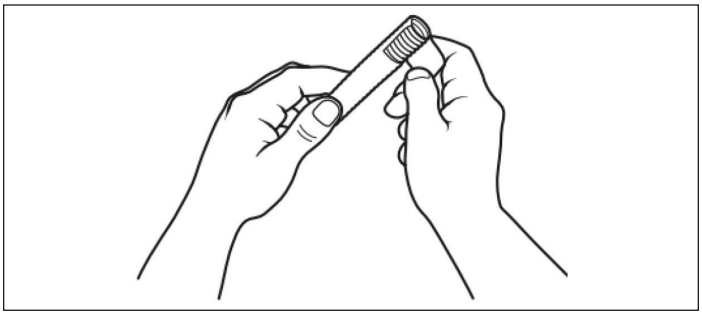


Figure: 1-2

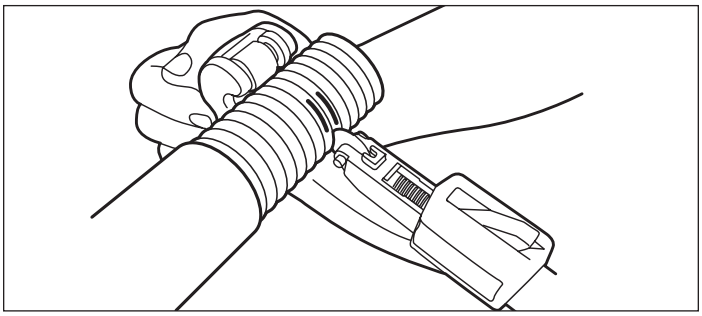


Figure: 1-3

⚠ 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).

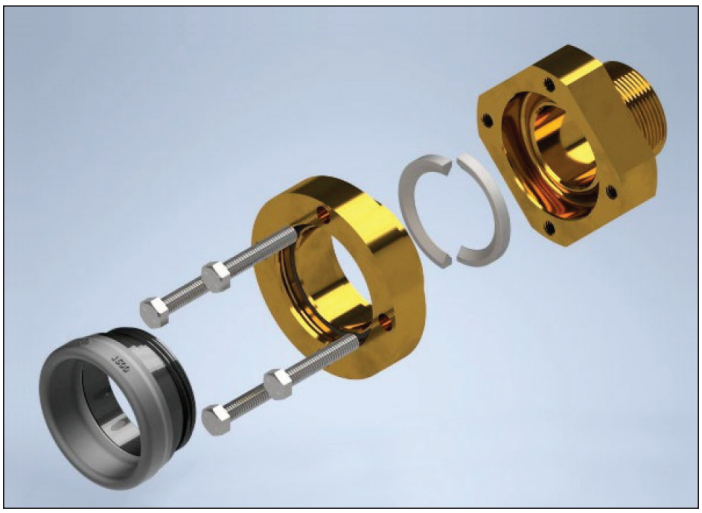


Figure: 1-4

6. CLEARANCE HOLES

If mounting the flange to the floor, drill a clearance hole. It is recommended to have a 2-5/8” sized hole to fit the Flip Sleeve Assembly.

7. INSTALL FITTING

Feed **TracPipe** System tubing through clearance hole. Ensure the Flip Sleeve is tucked into the Sleeve Adapter, then slide the Flip Sleeve Assembly and the Rectangular Steel Flange 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

8. Slide the Back Flange and Steel Rectangular Flange forward to trap the Split Rings. While applying forward pressure to the Back Flange and Rectangular Flange, slide the Front Pipe Flange onto the Back Flange ledge. Insert and align Hex Bolts (Figure 1-6).

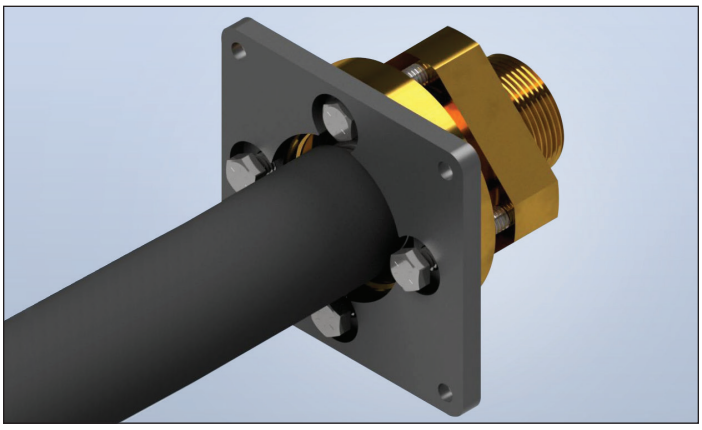


Figure: 1-6

⚠ CAUTION

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

9. Tighten all Hex Bolts in an alternating pattern to the torque value listed in Table 1 (Figure 1-7). 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.

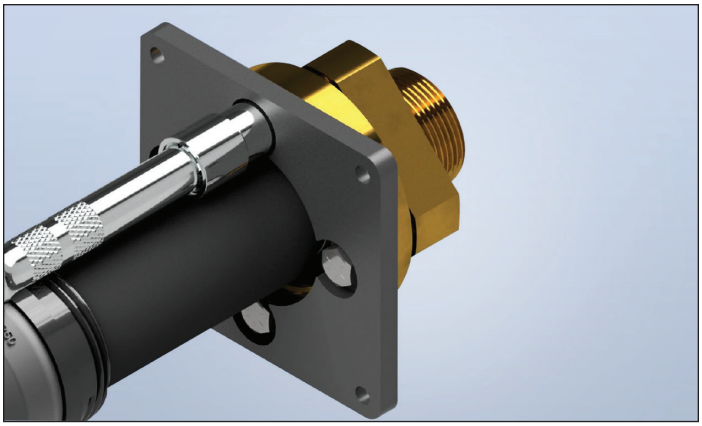


Figure: 1-7

Table 1
TracPipe System 4-Bolt Fitting Torque Values

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

⚠ 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.

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 1-8). With the Flip Sleeve Assembly installed, there will be no exposed stainless steel.

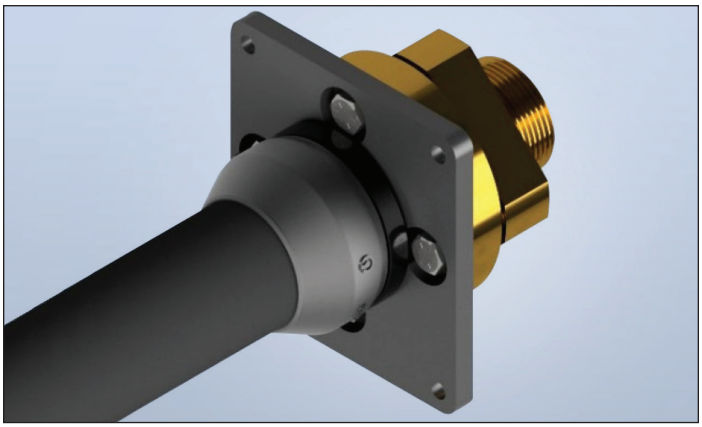


Figure: 1-8

11. Feed the Flange Assembly down through the clearance hole and mount the Rectangular Flange using appropriately sized screws to provide a firm mount (Figure 1-9).

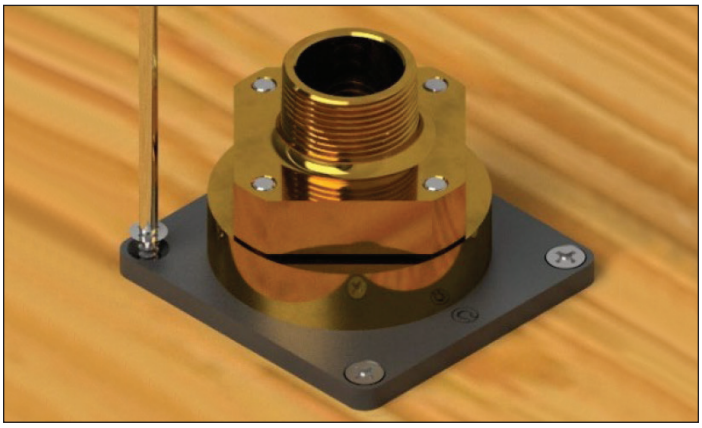


Figure: 1-9

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

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

OmegaFlex®
451 Creamery Way, Exton, PA 19341-2509
800-355-1039 • Fax: 610-524-6484
www.omegaflex.com
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FGP-771 06/26