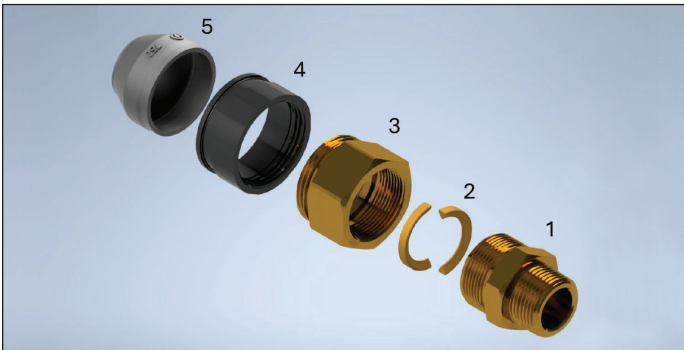


ASSEMBLY of TracPipe® System Threaded Fitting with Flip Sleeve Assembly

1. FGP-AF-S-SIZE (Straight Fitting Assembly) Components

- 1. Body
- 2. Split Rings
- 3. Nut
- 4. Sleeve Adapter } Flip Sleeve Assembly
- 5. 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.

2. 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.

3. STRIP JACKET & FINAL CUT

Using a sharp utility knife, strip back the jacket three inches. From the edge of the jacket, count out the required number of corrugations in Table 1. Make a final cut on the bare stainless in the valley between the corrugations. DO NOT overtighten roller which may flatten the first corrugation (Figure 1-1, Figure 1-2, Figure 1-3).

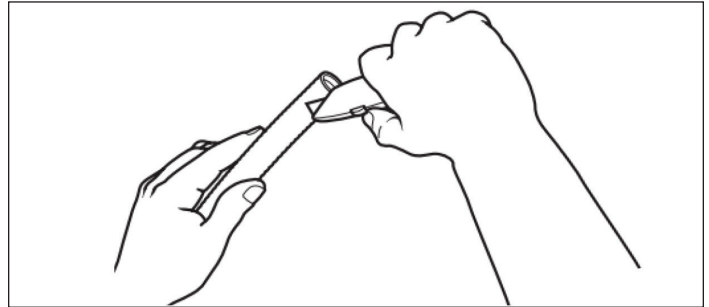


Figure: 1-1

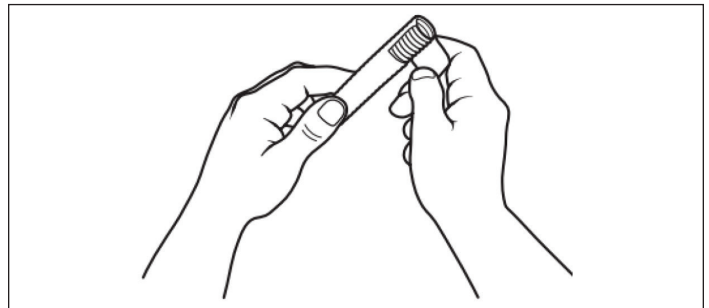


Figure: 1-2

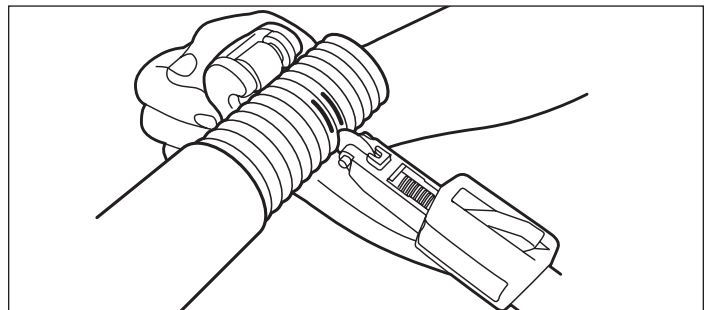


Figure: 1-3

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.

**Table 1
Final Cut Corrugation Count**

TracPipe System Pipe Size	Final Corrugation Count	Cut Between Corrugations
3/8"	9	9 & 10
1/2"	8	8 & 9
3/4"	8	8 & 9
1"	8	8 & 9

4. INSTALL FITTING

Separate the fitting Body from the Nut and Flip Sleeve Assembly and remove the two Split Rings. Ensure the Flip Sleeve is tucked into the Sleeve Adapter then slide the Nut with Flip Sleeve Assembly over the cut end until the Nut bottoms out against the jacket. Place two Split Rings into the first corrugation next to the tube cut (Figure 1-4).



Figure: 1-4

5. Slide the Nut with Flip Sleeve Assembly forward to trap the Split Rings. This will untuck the Flip Sleeve onto the outer jacket (Figure 1-5). With the Flip Sleeve Assembly installed, there will be no exposed stainless steel.



Figure: 1-5

6. Apply pipe dope or thread sealant to the NPT threads of the fitting Body as needed. Tighten the NPT threads of the TracPipe System fitting Body into the NPT threads of the mating pipe component. Sealants are to be used on the NPT connection only (Figure 1-6)!

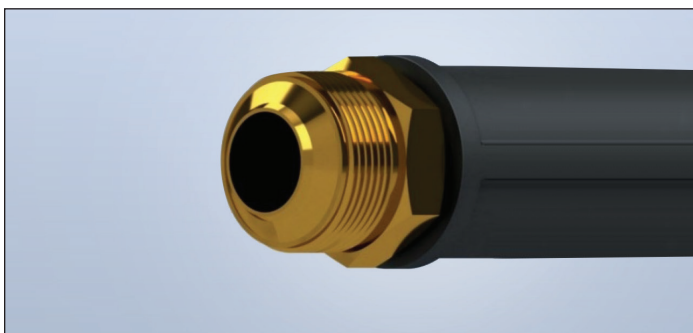


Figure: 1-6

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.

7. Thread the Nut onto the Body to engage the threads. Using appropriate wrenches, tighten the fitting to the torque values listed in Table 2. Note that TracPipe System fitting is designed to form a leak tight seal on the stainless-steel tubing as the fitting is tightened (Figure 1-7). When fully tightened, there should be no threads visible between the Nut and Body.

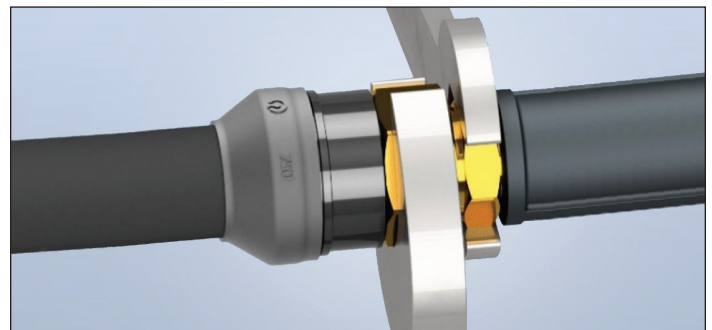


Figure: 1-7

Table 2
TracPipe System Torque Values

TracPipe System Pipe Size	Nut Wrench Flat Size	Torque Range
3/8"	1-1/8"	35-50 FT-LBS
1/2"	1-1/4"	42-70 FT-LBS
3/4"	1-1/2"	45-110 FT-LBS
1"	1-3/4"	110-150 FT-LBS

8. Pressure test TracPipe System pipe and fitting in accordance with state & local codes and Section 6 of the TracPipe System Flexible Gas Piping Design Guide & Installation Instructions.

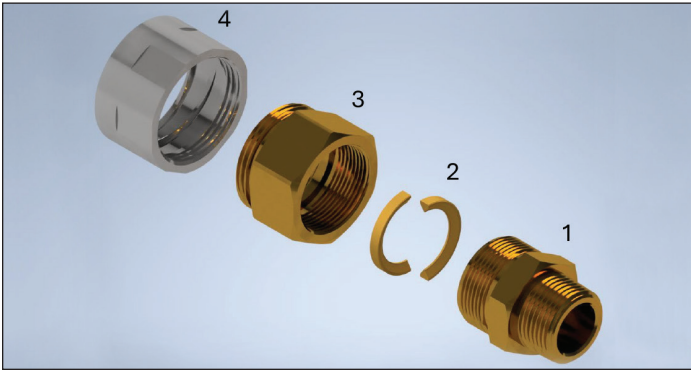
NOTICE:

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

ASSEMBLY of TracPipe System Threaded Fitting with Floppy Conduit Adapter

1. Components

- 1. Body
- 2. Split Rings
- 3. Nut
- 4. Floppy Conduit Adapter



2. Standard FGP-AF-S-SIZE fittings come with the Flip Sleeve Assembly. If fitting installation requires 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. **BEFORE** installing the fitting, unthread and remove the Flip Sleeve Assembly, and thread the Floppy Conduit Adapter onto the Nut (Figure 1-8, Figure 1-9).

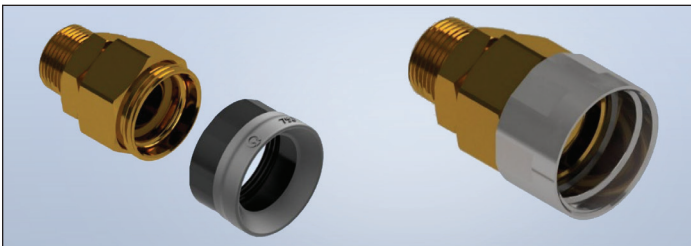


Figure: 1-8

Figure: 1-9

4. Follow **TracPipe** System Threaded Fitting Installation Steps 2 & 3 for standard jacket stripping and final cut procedures.

5. Slide the floppy conduit over the tubing (Figure 1-10).

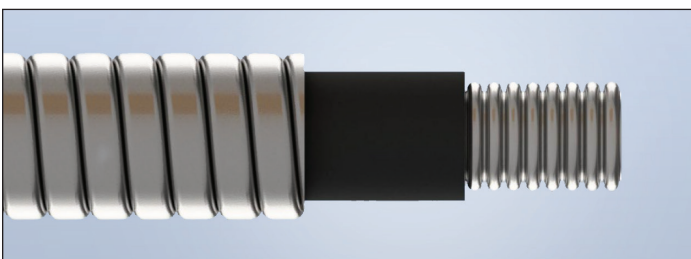


Figure: 1-10

6. INSTALL FITTING

Slide the Nut with Floppy Conduit Adapter over the cut end until it bottoms out against the jacket. Place two Split Rings into the first corrugation next to the tube cut, then slide the Nut forward to trap the Split Rings (Figure 1-11).

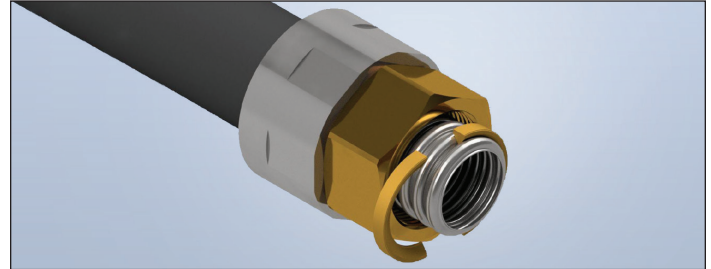


Figure: 1-11

7. Follow the **TracPipe** System Threaded Fitting Installation Steps 6 & 7, using the final torque values listed in Table 2.

8. Thread floppy conduit into the Floppy Conduit Adapter until it stops. This will secure the floppy conduit to the fitting (Figure 1-12). **NO additional fastening or adhesives required!**

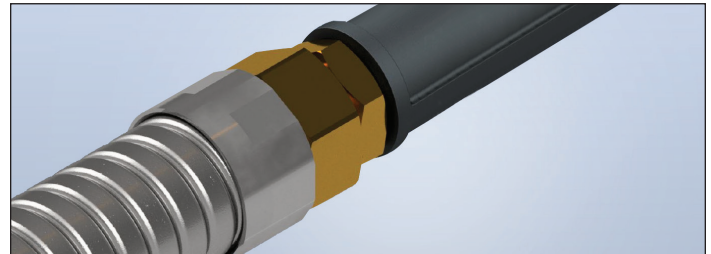


Figure: 1-12

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

NOTICE:

The same instructions apply when installing the following:
 FGP-AF-R-SIZE-SIZE (Reducing Fitting Assy)
 FGP-AF-F-SIZE (Female Fitting Assy)
 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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