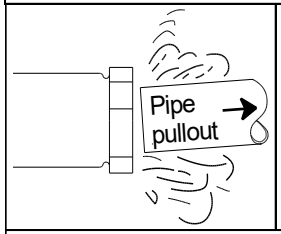
Installation Instructions
Risers with Lock Rings

Use NORMAC FLEX-Risers to connect ASTM D2513 polyethylene pipe to above ground metallic piping. This joint and these instructions have been design-qualified to ASTM D2513 Category 1. Flex-Riser meets performance criteria of ASTM F2509 Category 1 with maximum pressure rating of 125psig.

⚠ WARNING

Improper installation or application can result in pipe pullout, escaping gas, explosion, property damage, serious injury or death.

Advertencia: La instalación o aplicación incorrecta puede resultar en el desprendimiento del tubo, escape de gas, explosión, daños a la propiedad, graves lesiones o la muerte.



- Do not alter or add to this product.
- Adhere to all applicable codes, standards and regulations
- Use **ONLY** on ASTM D2513 polyethylene pipe of size and wall thickness shown on gasket and stiffener.

▼ Follow step by step instructions below

1. Remove body, stiffener, lock ring, gasket, and retainer from nut. Read markings on pipe, stiffener and gasket. Pipe must be marked ASTM D2513. Make sure size and wall thickness markings on stiffener and gasket match those on pipe. DO NOT proceed until sizes of gasket and stiffener match pipe size and wall thickness.

⚠ • Improperly matched materials may result in a leak or pullout.

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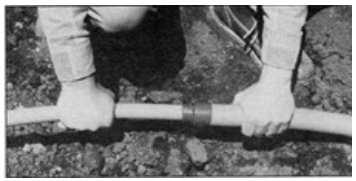
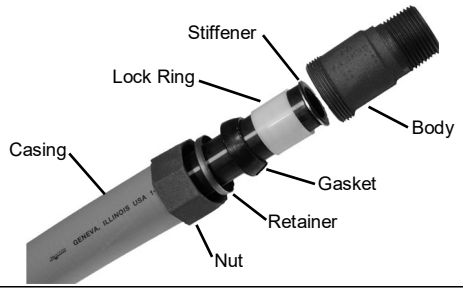
2. Inspect pipe for scratches or other defects that may impair gasket seal. Cut pipe squarely to remove defects.

3. Insert pipe through moisture seal, casing and nut.



4. Slide retainer, gasket, then lock ring over pipe. See photograph for correct assembly.

⚠ • DO NOT put gasket over lock ring. This may cause a leak or pullout.



5. Insert stiffener until flange hits pipe.

6. Insert pipe with components into body. Slide riser casing forward and thread nut onto body.

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7. Tighten assembly by holding body with one wrench and turning nut with another. Tighten according to chart below.

⚠ • Insufficient tightening may cause a leak or pullout.

			Wrench Size				
			10”	12”	14”	18”	24”
This chart shows minimum pounds of force to put on ends of pipe wrenches.	PIPE SIZE	1/2" IPS			95	75	
		3/4" IPS			100	80	
		1"IPS				80	60
		2"IPS					90
		5/8" OD	50	40	35	30	
		7/8" OD		100	85	65	
		1 1/8" OD			100	80	60
		1 3/8" OD				85	65

8. Complete piping so nut and body will be above ground after final grade. Pressure test per local requirements.