

Technical Bulletin TB2019-01

Assembly of XR3 Fitting (Rev 2) To FlashShield+™ CSST

Feb. 1, 2019

This Technical Bulletin provides the procedure for assembling the XR3 Fitting (Rev. 2) onto FlashShield+ CSST. This information is also located in the 2019 *Gastite/FlashShield Design and Installation Guides, Sec 4.2*, available through our distributors and at www.gastite.com.

XR3 FITTING (REV 2) TO FLASHSHIELD+™ CSST (SINGLE LAYER JACKET)

Step 1 Cut-to-Length (Fig. 4-2)

Cut tubing to desired length using tubing cutter. Cut should be centered in a corrugation valley. Use light roller pressure with extra rotations in one direction to leave tubing round and free of burrs on cut.

To ensure a quality flare, all cuts should be made on a straight section of tubing.

Note: Tubing ends are sharp, use care when handling.

Step 2 Strip Jacket (Fig. 4-3, Fig. 4-4)

Using a utility knife, cut jacket back to the second valley from tubing end.

Do not cut the jacket in such a way that the steel tubing end is scored.
(This could affect sealing)

Remove the short section of jacket which will expose one full corrugation-valley of the tubing.



(Optionally, for Step 2: Use side-1 of FlashShield™ stripping tool to strip jacket)

Step 3 Install Nut and Bushings (Fig. 4-5)

Thread fitting body (NPT thread) into valve or appliance connection.
Slide nut onto tubing and back a few inches.

Separate bushings and position on tubing as shown, locating large bump into the valley of the first corrugation leaving one corrugation-peak exposed between the end of the bushing and tubing.

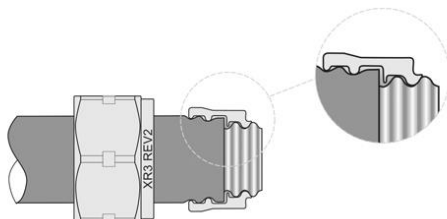


Fig. 4-2

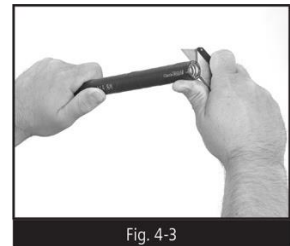


Fig. 4-3

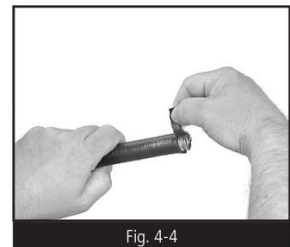


Fig. 4-4



Fig. 4-5

Step 4 Position Bushings (Fig. 4-6)

Insert bushings into fitting body. A small amount of resistance indicates the bushings are being compressed to further capture the jacket.

Note: Pipe dope or sealant is not to be used inside the fitting.

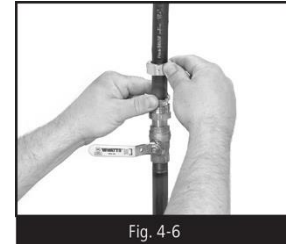
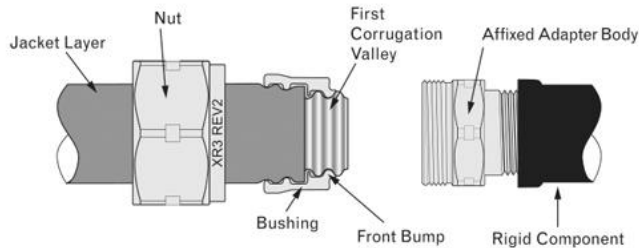


Fig. 4-6

Step 5 Wrench Fitting (Fig. 4-7)

Slide nut over bushings and thread onto fitting body. Some resistance will be experienced as the nut begins to compress the tubing and create the double-wall flare. Continue to wrench the nut until the resistance increases greatly and the double-wall flare is tightly seated.

Note: Rotate the nut only during the tightening process. Do not rotate the fitting body.

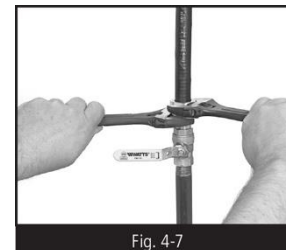


Fig. 4-7

TABLE 4-2		
RECOMMENDED TORQUE VALUES		
SIZE	EHD	*TORQUE
3/8"	13	25 ft.-lbs.
1/2"	19	35 ft.-lbs.
3/4"	23	45 ft.-lbs.
1"	31	65 ft.-lbs.
1-1/4"	37	95 ft.-lbs.
1-1/2"	48	120 ft.-lbs.
2"	60	150 ft.-lbs.
Fitting is factory lubricated to reduce field torque requirements.		
* Minimum torque values supplied for reference. Field installation requirements: system must pass pressure/leak test (See Section 6).		