

Technical Bulletin #TB2015-03

Handling Tips for 2" CSST

April 8, 2015

This Technical Bulletin provides handling and cutting tips for size 2" Gastite® and FlashShield™ Flexible Gas Piping.

Handling

- 2" CSST reels are very heavy, 150-ft coil is over 100 lbs. Care is required when lifting.
- Care is required when handling or working near sharp CSST cut ends.
- 2" CSST pressure test should be limited to 40 PSI, to keep CSST from moving and/or arching between tubing supports at test pressures beyond 40 PSI.

Cutting 2" CSST

- Utilize tubing cutter with blade specified for cutting stainless steel, and with flat rollers (not copper flared tubing/grooved rollers). Gastite P/n: GTCUTTER-LG2
- Cut the tubing on a straight section.
- Apply light cutting wheel contact and utilize several rotations and advancement to locate the valley of the corrugation. Rotate cutter in one direction.
- Continue the rotations with light cutting wheel advance per rotation. The light cutting pressure will help the cutting wheel to be centered in the valley, and also to reduce wrinkling of the outer jacket.
- ***While rotating the tubing cutter, 'pull' the cutter away from the CSST to maintain consistent contact of the cutter's rollers, to the CSST.***
- As many as 20 to 25 rotations are typical.
- Assure that the cut ends are straight and free of burrs.

2" FlashShield CSST

- Cut FS-32 CSST with GTCUTTER-LG2 cutter, which has a 30mm cutting wheel, needed to penetrate the thicker multi-layered CSST jacket.
- If a second cut is required, re-cut the FS-32 three to four inches from end of the CSST to reduce outer jacket movement on the free end, which can affect the cut quality.
- Utilize STRP3-32 jacket stripper for the best means to achieve the CSST end-prep required for attaching the XR3-32 fitting.