

CABLE PRESSURE SYSTEM — PIPE SYSTEM

1. GENERAL

1.01 This appendix describes the A.M.P. - Fit plastic pipe fittings used to make connections in CA3131 (Air Pipe).

1.02 This appendix is being reissued to updated information.

1.03 These fittings provide permanent leak proof connections for pressurized air pipe systems. When installed they provide lightweight, corrosion resistant, highly reliable system that can be assembled more economically than the conventional methods.

1.03 An A.M.P. handtool #69992 is required to crimp the fittings to the pipe.

2. DESCRIPTION OF FITTINGS

2.01 The various types of fittings available for selection are shown in Figure 1. Each fitting consists of a plastic molding with a pre-assembled aluminum insert. The insert is serrated so that during crimping permanent electrical contact is

established between the insert and the aluminum inner lining of the CA3131 pipe.

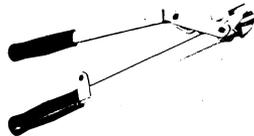
Stainless steel rings are provided with the fittings and are used to crimp the fittings to the pipe.

2.02 The Type K Fitting is equipped with a grounding post which is internally connected to the aluminum insert. Two hex nuts and flat washer and a lock washer are provided on the grounding post for use in grounding applications.

2.03 The coupling fittings and the type K fittings are used for the permanent joining of two sections of pipe. Electrical continuity of the aluminum pipe lining is maintained through the fitting by the serrated aluminum insert which also provides crimp support for the pipe. The type K fitting has a side entrance hole having a 1/8" NPT thread. This threaded opening will accommodate pressure testing valves, standard pipe plugs, or associated equipment fittings.

2.04 The pulling eye and Pipe Plug fitting has a 5/16" diameter pulling eye. The "pullout" force exceeds by approximately 50% the pulling stress of 150 pounds recommended for the air pipe.

Hand Tool
Part Number: 69992

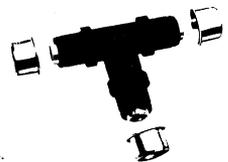


Pulling Eye and
Pipe Plug



Part Number: 561274-1

Tee



Part Number: 561515-1

Coupling



Part Number: 332843

Type K



Part Number: 332823

PIPE PLUG W/F VALVE



Part Number 561688-1

Figure 1

NOTICE

Not for use or disclosure outside Indiana Bell
except under written agreement.

2.05 The Tee fitting is used to join 3 air pipes. Electrical continuity of the aluminum pipe lining is maintained through the tee fitting by the serrated aluminum insert which also provides crimp support for the pipe. The tee fitting is not equipped with a threaded opening nor does it have a grounding post.

3. INSTALLATION & ASSEMBLY

3.01 Cut end of pipe squarely. Size the pipe using pipe shaper AT8631 Deburr inside edge of pipe and expose aluminum liner inside pipe by scraping adhesive film with knife.

3.02 Slide steel ring over end of pipe with flanged end of ring toward fitting. Slide fitting onto pipe to insertion depth of 1/2" minimum to 7/8" maximum. Slide steel ring forward until it butts against end of fitting. Assembly is now ready for crimping.

See Figure 2.

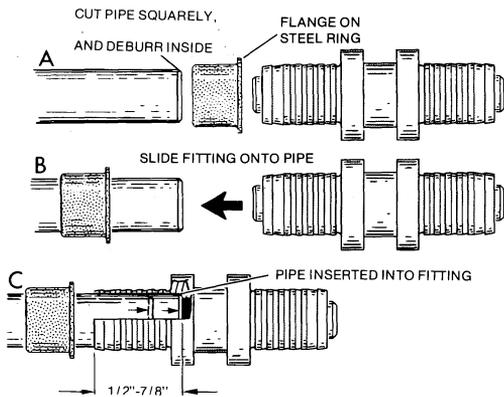


Figure 2

3.03 Open handles of handtool and place fitting in crimping jaws of tool with stationary jaw back of fitting shoulder and moving jaw back of ring flange. See Figure 3. Close handles until ring flange is resting against fitting. Then apply a steady, even pressure to tool handles until ring flange bottoms against fitting shoulder. (Do not "snap" tool closed.) See Figure 4.

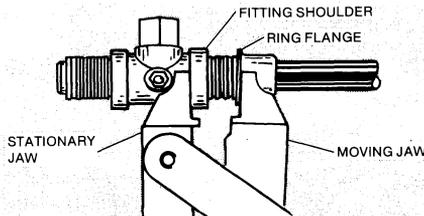


Figure 3

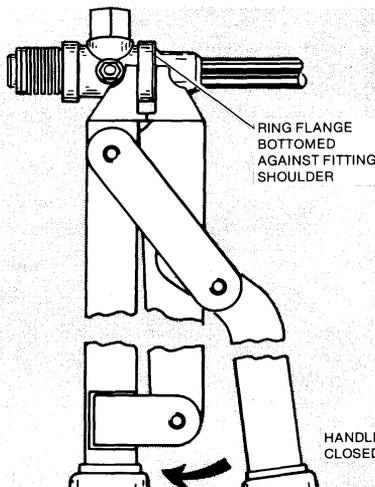


Figure 4

4. ASSEMBLY OF THREADED FITTINGS

4.01 When connecting pipe plugs or F valves or associated equipment fittings use the following procedure. Ensure the threads are clean apply pipe stick to the threads. Tighten the connection until it is hand tight and then use a wrench to tighten connection an additional 1-1/2 turn. Take care not to over tighten as the tapered pipe threads could crack the plastic fitting.

4.02 To complete grounding or electrical bonding of CA3131 pipe fittings proceed as follows.

Remove outer hex nut and lock washer from ground post. Ensure that the inner hex nut is tight on the fitting and the flat washer is in place on the ground post.

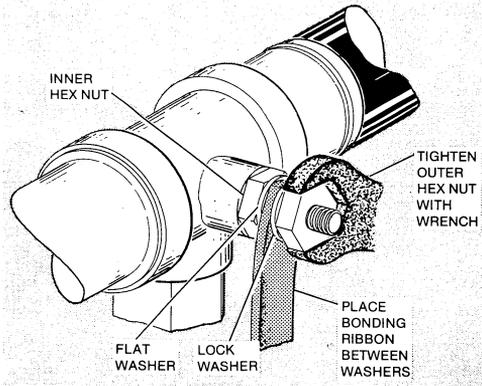


Figure 5

Attach the Bonding ribbon on the ground post by punching or drilling a 3/16" hole in the bonding ribbon. Assemble lock washer and outer hex nut with a wrench until teeth of lock washer firmly grip the bonding ribbon. Do not over-tighten. See Figure 5.

5. ORDERING INFORMATION

5.01 The A.M.P. - FIT fittings and crimping tool may be ordered from

AMP INCORPORATED
HARRISBURG PENNSYLVANIA 17105

PHONE 717-564-0100

When ordering use description and part number as shown in Figure 1.