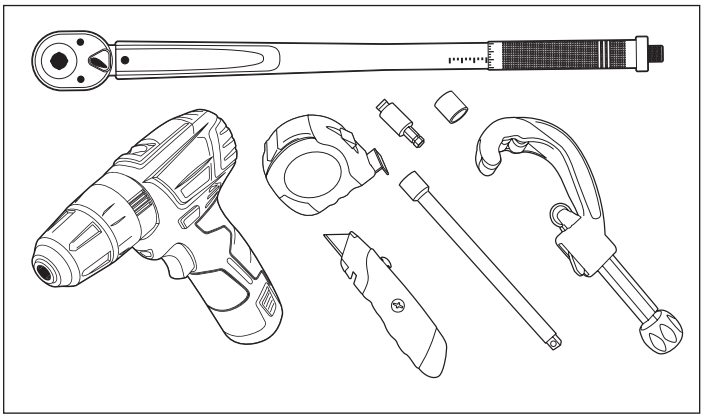
ASSEMBLY of TracPipe® PS-II 4-Bolt Fitting

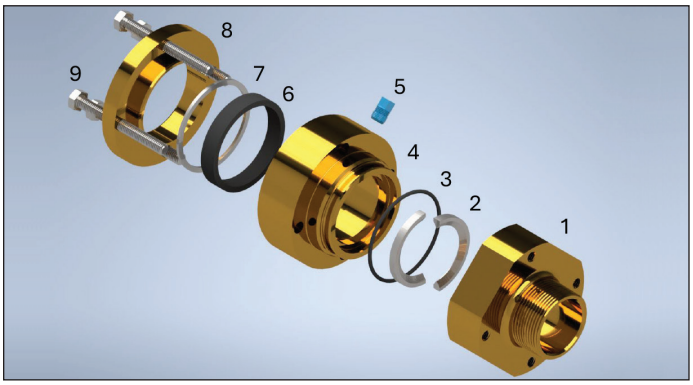
1. Tools Required for Assembly

- Impact Driver (recommended) or Ratchet
- Tape Measure
- Utility Knife w/ Sharp Blade
- Tilt Socket Adapter
- 6-8″ Socket Extension
- 1/2″ Socket
- RIDGID 152 Tubing Cutter w/ FGP-E-5272 cutting wheel
- Torque Wrench



2. FGP-UGF2-SIZE Components

1. Front Pipe Flange
2. Split Rings
3. Front Pipe O-Ring
4. Flange Body
5. Vent Plug (1/8-27 NPT)
6. Rear Seal
7. Spiral Retaining Ring
8. Rear Flange
9. Hex Bolts (4) 5/16-18 x 3″ lg. 18-8 SS



⚠ 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.

3. 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.

4. STRIP JACKET

To determine the jacket strip length measure back 3” from the end (Figure 1-1).

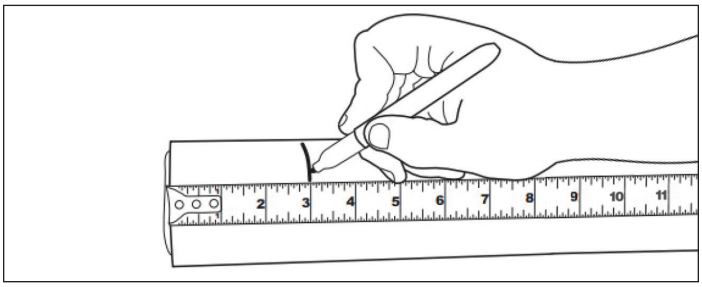


Figure: 1-1

5. Using the appropriate tubing cutter with **TracPipe** cutting wheel, score the black jacket approximately three quarters of the way through. Use extreme care NOT to cut or score the stainless-steel corrugated tubing! (Figure 1-2)

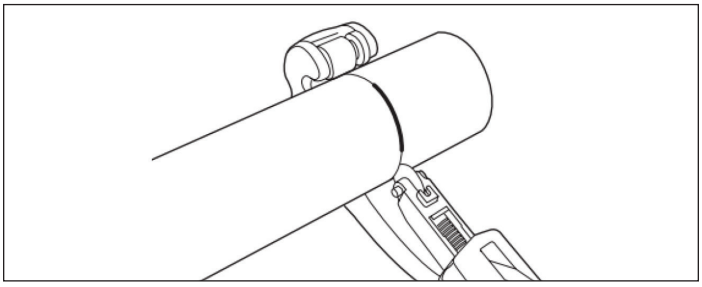


Figure: 1-2

6. Finish cutting through the jacket down to the stainless-steel corrugated tubing using a sharp utility knife (Figure 1-3).

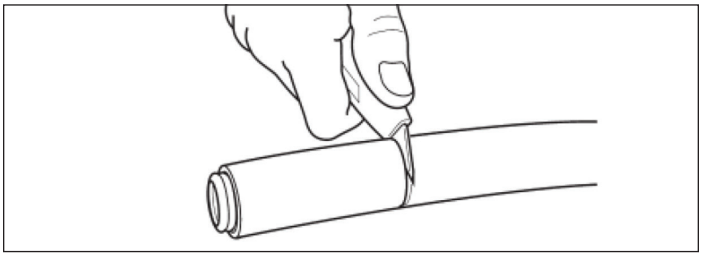


Figure: 1-3

7. Carefully cut the jacket longitudinally with a sharp utility knife for ease of removal. Do not score the **TracPipe** System tubing (Figure 1-4).

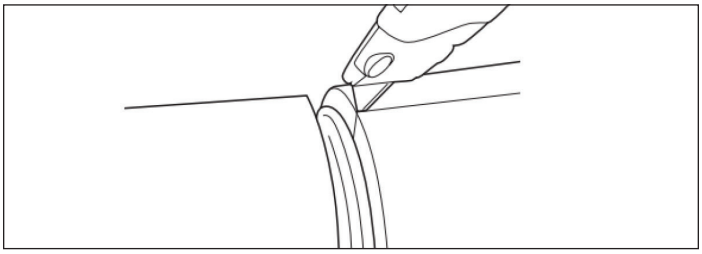


Figure: 1-4

8. Remove cut portion of the sleeve (Figure 1-5).

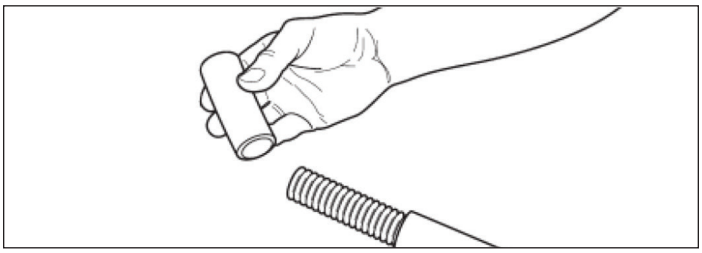


Figure: 1-5

9. FINAL CUT

Starting from the edge of the jacket, count out FOUR full corrugations, and make a final cut on the bare stainless in the valley between the fourth and fifth corrugations. DO NOT overtighten roller which may flatten tube (Figure 1-6).

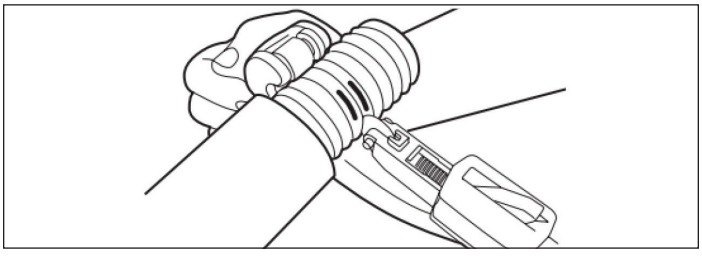


Figure: 1-6

⚠ 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.

10. DISASSEMBLE FITTING

Loosen and remove all Hex Bolts, separate the Front Pipe Flange from the Flange Body, the Flange Body from the Rear Flange, and remove the Split Rings (Figure 1-7 & 1-8).

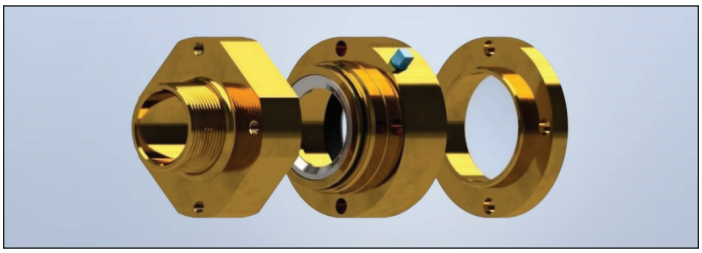


Figure: 1-7

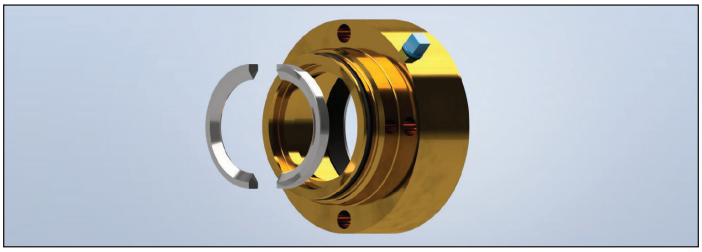


Figure: 1-8

11. INSTALL FITTING

Slide the Rear Flange and Flange Body over the piping until the Flange Body bottoms out against the jacket. Insert Split Rings into the valley of the first exposed corrugation next to the tube cut (Figure 1-9).

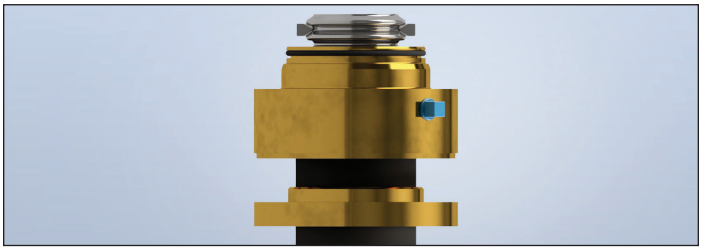


Figure: 1-9

12. Slide the Rear Flange and Flange Body forward to trap the Split Rings. While applying forward pressure to the Rear Flange and Flange Body, slide the Front Pipe Flange onto the Flange Body Ledge. Insert and align Hex Bolts, then partially tighten to allow the fitting to swivel (Figure 1-10).

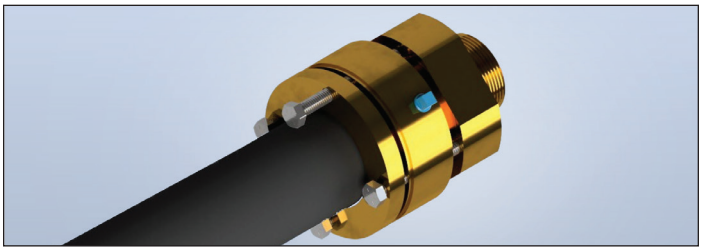


Figure: 1-10

⚠ CAUTION

If forward pressure is not maintained, the split rings may dislodge from the Flange Body pocket, causing an improper seal.

13. Apply pipe dope or thread sealant to the NPT threads of the Front Pipe Flange as needed. Tighten the NPT threads of the Front Pipe Flange into the NPT threads of the mating pipe component. Sealants are to be used on the NPT connection only (Figure 1-11)!

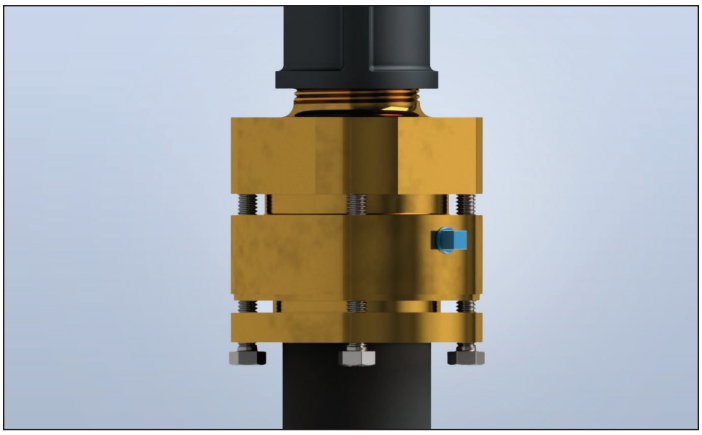


Figure: 1-11

⚠ 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.

14. Tighten all hex bolts in an alternating pattern to the torque value listed in Table 1 (Figure 1-12). Note that the **TracPipe** PS-II fitting is designed to form a leak tight seal on the stainless-steel tubing as the fitting is tightened. **DO NOT overtighten bolts**. When fully tightened, there should be a small and uniform gap around the circumference of the fitting between the Front Pipe Flange and the Flange Body.

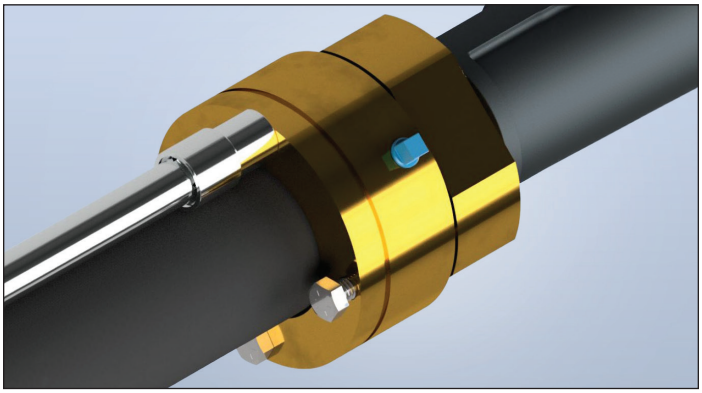


Figure: 1-12

Table 1
TracPipe PS-II 4-Bolt Fitting Torque Values

TracPipe PS-II Pipe Size	Torque Settings
1-1/4″	25 FT-LBS
1-1/2″	25 FT-LBS
2″	25 FT-LBS

15. Pressure test **TracPipe** PS-II primary piping and fittings in accordance with state & local codes and Section 6 of the **TracPipe** System Flexible Gas Piping Design & Installation Instructions.

NOTICE:

When pressure testing **TracPipe** PS-II primary piping, it is necessary to remove both Vent Plugs to ensure proper test results on the stainless steel tubing.

16. If local jurisdictions require the secondary to be tested, a gauge can be threaded into the secondary port of one end fitting and air can be introduced into the secondary port of the other end fitting. Do not exceed the pressure of the pipe **(25 PSI maximum)**.

NOTICE:

Vent Plugs are 1/8-27 NPT.

17. Remove Vent Plugs for venting when required by code. If the Vent Plugs are removed, the installer must ensure that water, insects, or contaminants CANNOT enter the vent port.

NOTICE:

When installing coupling FGP-UGC2-SIZE the same instructions apply. When couplings, adapters, or other metallic fittings are installed underground, all metallic parts of the fitting must be wrapped in a code approved manner (e.g. mastic used for wrapping metallic pipe).

Refer to the following QR code to access assembly videos and instructions for other products.

OmegaFlex®

451 Creamery Way, Exton, PA 19341-2509
800-355-1039 • Fax: 610-524-6484
www.omegaflex.com

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