

StreamTECH™ DS Installation Instructions 2 1/2" – 4"



1. Cut tube square using a tube cutter or fine tooth saw.



2. Deburr ID & OD of tube using a deburring tool or half round file.



3. Sand the tube OD using sand cloth, steel wire brush, or abrasive pad.



4. Clean tube OD and fitting ID with alcohol to remove any residue or shavings.



5. Mark tube to depth of insertion.



6. Apply a bead of StreamTECH ST-Weld Adhesive to the outer most lip seal, ensuring the bead is less than the height of the seal.



7. Insert fitting onto tube. Fitting should reach marked depth.



8. Place applicator nozzle against one of the ports of the fitting and pump the adhesive into the fitting by squeezing the applicator trigger. While pumping, monitor the opposing outlet.



9. Once adhesive emerges from opposing port, the space between the lip seals has been filled, and the joint is complete.



10. Allow joint to cure based on adhesive worklife /set times.

TUBE INSERTION MARKING DEPTH

Diameter	1/2"	3/4"	1"	1-1/4"	1-1/2"	2"	2-1/2"	3"	4"
Depth Mark	1-1/4"	1-3/8"	1-3/8"	1-1/2"	1-5/8"	1-7/8"	1-5/8"	2"	2-1/8"

WARNING !

Mueller StreamTECH Fittings are to be installed ONLY with StreamTECH ST-Weld Adhesives, equipment, and accessories. Failure to follow all instructions could affect joint/system integrity and may lead to property damage. Call the Mueller Industries Customer Service Department at 1-800-FITTING if you have any questions or need assistance.

Important

- When soldering nearby, stay at least three pipe diameters from a StreamTECH connector and use a wet rag or other heatsink.
- Soft tubing should slide into the fitting without excessive force and may need to be rounded
- Adhesive "Worklife" quantifies the time before bonding occurs during which installer can reposition a StreamTECH connection without compromising the ultimate integrity of the joint