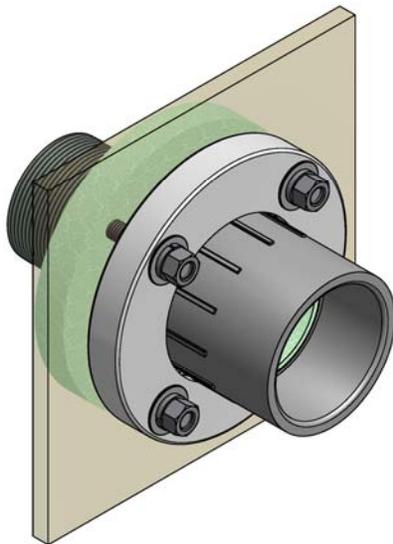


# **B.O.S.S.® (Bolted One-Piece Sure Seal) FITTING ASSEMBLY**

1. Using the gasket as a template, mark the bolt holes on the outside of the tank.
2. Drill the center hole and stud holes with a 1/4-in pilot bit. Be precise with the layout and drilling of the tank as the fitting requires close tolerances.
3. Drill out the pipe fitting hole using a hole saw. Please note that the hole to be drilled into the tank may be smaller than the hole in the outer plate that was used as a template. The hole drilled should be only slightly larger than the outside diameter of the pipe fitting.
4. Next drill out the stud bolt holes using a 9/16-in drill bit for the 1/2-in diameter studs.
5. Clean and bevel all drilled and cut holes on the inside and outside of tank surfaces.
6. Install the fitting and gasket from the inside of the tank. Inside of tank must be flat and smooth. If the inner surface is uneven or lumpy, the inner wall must be faced smooth using a drill with sandpaper attached to a steel plate. All surfacing must be done in a circular manner.
7. Slide the flange onto the stud bolts that are protruding on the outside of the tank.
8. Place the washers and nuts on the stud bolts. Tighten the nuts in a crisscross pattern using a torque wrench. Tighten until the gasket is fully compressed (approximately 15-20 ft. lbs. on a torque wrench).
9. Inspect the fitting. The gasket should be compressed and the flange should conform to the wall of the tank.
10. **Hydro test** the tank for at least 24 hours prior to loading with chemical.



Fitting size	Hole saw size
1"	1 1/2"
2"	2 5/8"
3"	3 5/8"

