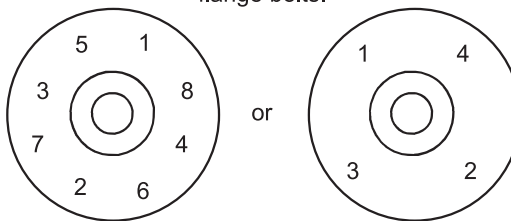


7.2 BOLTED-FLANGE FITTINGS

1. Disassemble the fittings as shipped. If the holes are not drilled, place the flange against the tank in the desired location and use as a template for drilling the holes. Use either a hole saw the same size as the fitting's size or up to a 1/2" size larger.
2. With the gaskets installed, place the stud bolts through the holes with the plastic head on the inside of the tank, threads on the outside.
3. Place the full face flange gasket over the bolts on the outside surface of the tank.
4. Place the flange over the gasket and stud threads with the hub of the flange facing out.
5. Put a washer and nut on each stud bolt. Be sure to lubricate the threads of the bolts with anti-seize lubricant.
6. Tighten the nuts by pulling down the nuts diametrically opposite each other using a torque wrench. Tighten bolts according to sequence shown in illustration 7.2. Complete tightening should be accomplished in stages. Tighten until the gasket is fully compressed (Approximately 15/20 ft. lbs.)
7. Inspect fitting. Gasket must be compressed and the outer flange drawn down evenly.
8. Piping such as a flange adapter should now be threaded into the fitting. Teflon sealant tape or other thread sealant should be applied to all pipe threads. Do not over tighten.
9. Flanges for pipe sizes 4" and larger should be curved to match the outside diameter of the tank.
- 10. HYDROTEST THE TANK WITH STANDING WATER FOR AT LEAST 24 HOURS BEFORE PUTTING INTO SERVICE.**

The following tightening sequence is suggested for the flange bolts.

ILLUSTRATION 7.2



CAUTION: OVERTORQUING WILL DAMAGE THE FLANGE AND GASKETS.

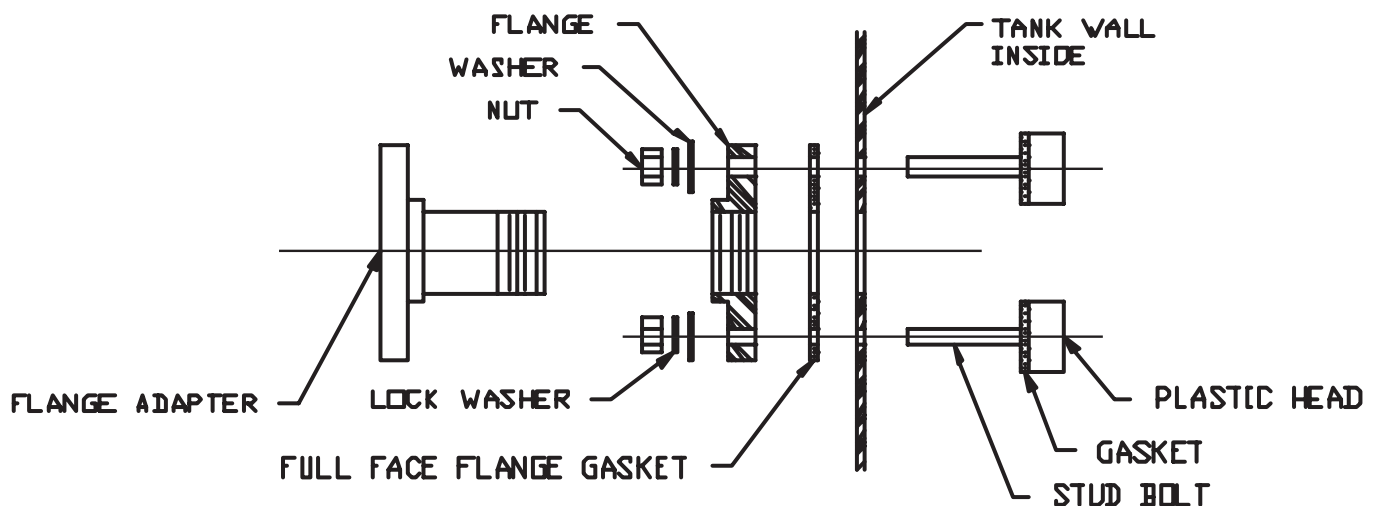


ILLUSTRATION
(F:\DWG\FITTING\ASHZFLG)