

7. FIELD INSTALLATION OF FITTINGS

7.1 BULKHEAD FITTINGS

1. Remove the large fitting nut from the fitting body. Note that the gasket is located immediately below this nut. The gasket and remainder of the fitting should be set aside for later use.
2. Using the nut as a template, locate the desired position of the fitting. Trace the nut inside and out. Draw a line through the center of the traced outline from each of the points of the nut (see illustration 7.1). This will locate the center of the fitting. **Fittings must be installed at an elevation that will prevent interference with tank's inside bottom knuckle radius.**
3. Before drilling, the hole saw should match the Outside Diameter (O.D.) portion of the fitting that must go through the hole in the tank. Drill the tank with a hole saw. Remove any flashing with a pocket knife and brush away any shavings around the hole.
4. Working from the inside of the tank, slide the fitting body through the hole in the tank. The gasket should be between the back of the shoulder of the fitting and the inside wall of the tank.
5. Install the large fitting nut on the outside of the tank. Tighten the nut securely, hand tight plus one half turn to three quarter turn. Care should be taken to prevent the fitting body from turning during this process to prevent the gasket from creeping from between the fitting and the tank wall.
6. Inspect the gasket to make sure it has not crept from the shoulder of the fitting. If so, loosen the nut on the outside of the tank and the gasket will return to its original position. Retighten the nut carefully.
7. 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.
8. **HYDROTEST THE TANK WITH STANDING WATER FOR AT LEAST 24 HOURS BEFORE PUTTING INTO SERVICE.**

NOTE: Some bulkhead fittings have left hand threads for the large fitting nut.

