

7.3 STAINLESS STEEL FITTINGS

1. Disassemble the stainless steel fitting by removing the nuts from the stud bolts. Remove the 1/8" thick stainless steel outer plate. Set the remainder of the fitting aside along with the nuts and washers.
2. Using the outer plate as a template, mark the hole patterns on the outside of the tank.
3. Find the center of the large "tank fitting" hole by drawing an "X" through the center of the bolt holes (see illustration).
4. With the drill motor and hole saw, drill out the pipe fitting hole. Please note that the hole to be drilled in the tank may be much smaller than the hole in the outer plate that was used as a template. The hole saw should match the Outside Diameter (O.D.) of the portion of the fitting that must go through the hole in the tank.
5. Next drill out the stud bolt holes using the 9/16" drill bit for fittings with 1/2" diameter studs or a 3/8" drill bit for fittings with 5/16" diameter studs.
6. Trim any flashing from the holes with a pocket knife and brush away any shavings around the hole.
7. You are now ready to install the tank fitting. With the gasket on the studs against the back plate of the fitting, install the fitting from the inside of the tank. Slide the outer plate onto the stud bolts that are protruding from the tank wall.
8. Replace the washers and nuts on the stud bolts. 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 on page 7. Complete tightening should be accomplished in stages. Tighten until the gasket is fully compressed (Approximately 15/20 ft. lbs. on a torque wrench). **1/2" nuts should be torqued to 30 ft. lbs., 5/16" nuts to 12 ft. lbs. Be sure to lubricate the threads of the bolts prior to tightening.**
9. Inspect the fitting. The gasket should be compressed and the outer stainless steel plate should conform to the wall of the tank.
10. **HYDROTEST THE TANK WITH STANDING WATER FOR AT LEAST 24 HOURS BEFORE PLACING INTO SERVICE.**

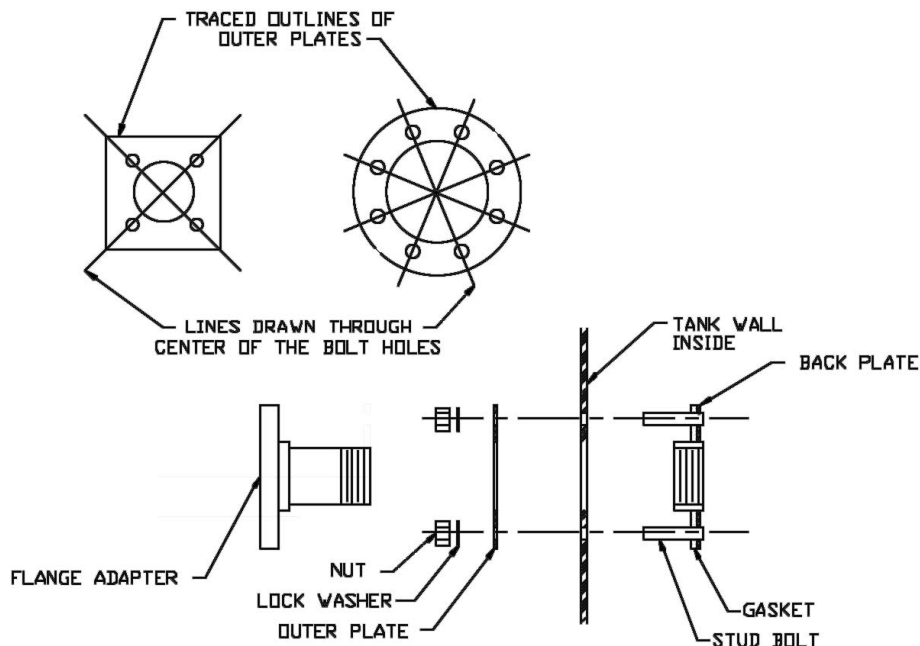


ILLUSTRATION
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