

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

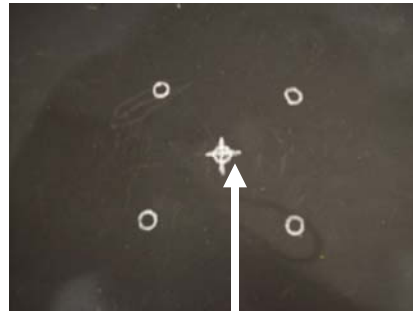
While the B.O.S.S.® fitting was designed for OR-1000™ systems, it also provides value on the non OR-1000™ systems as it eliminates 4 potential leak points when compared to other fittings.

Loose parts boxed for shipment



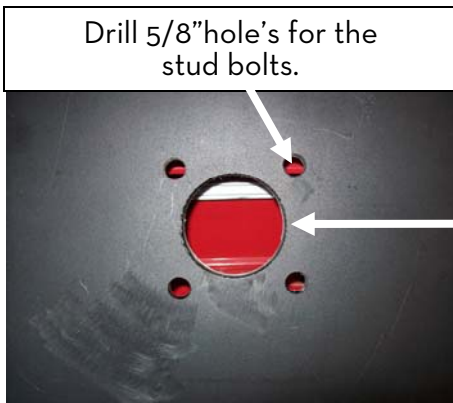
2 inch model shown with optional siphon leg

Drill layout on outside of tank



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

Once the tank is marked properly, drill the center hole and stud holes with a 1/4" pilot bit. Be precise with the layout and drilling of the tank as the fitting requires close tolerances.



Drill the center hole using the proper size hole saw. Do not drill this hole larger than needed to maintain adequate sealing surface. Clean and bevel all drilled and cut holes on the inside and outside of tank surfaces.

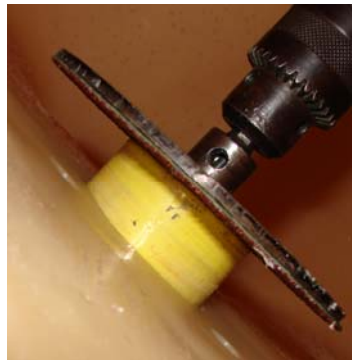
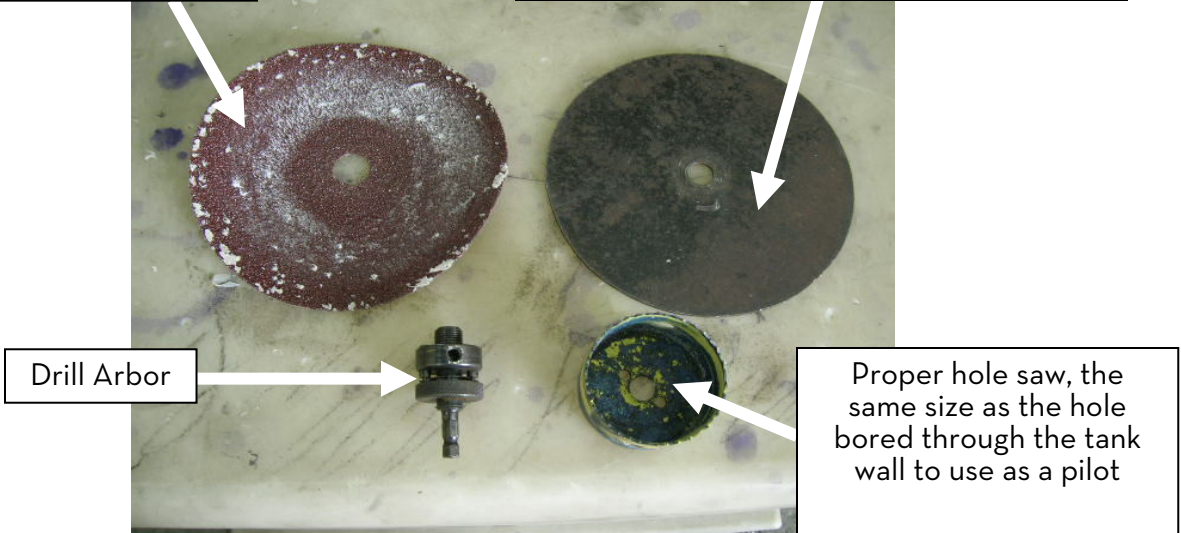


Inside of tank must be flat and smooth. If the inner surface is uneven or lumpy, the inner wall must be faced smooth using a drill with sandpaper attached to a steel plate. All surfacing must be done in a circular manner.

Surfacing Tools:

24 grit grinding disc, slightly larger in diameter than the flange face of the fitting.

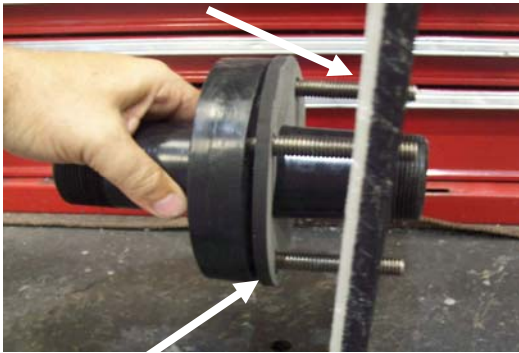
Steel backing plate for sanding disc to ensure even pressure.	
Fitting size	Plate size
1"	4 1/2"
2"	6"
3"	7 1/2"



Make sure drill is flat against the tank wall while surfacing.

Once all drilling and surfacing is complete, install the fitting from the inside of the tank as shown in the photo's below.

Inside of tank

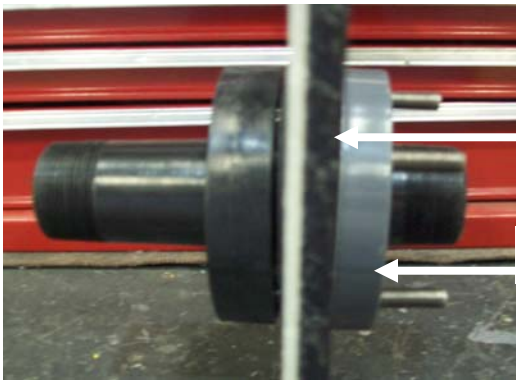


Gasket

B.O.S.S.® fitting placed in tank, sealing surface on the inside of tank



Place plastic ring over the studs on the outside of the tank.



Outside of tank

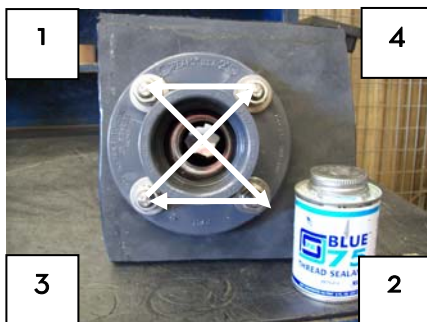
Plastic ring

Add flat and lock washers, apply a small amount of anti-seize compound, and screw the nuts onto the studs



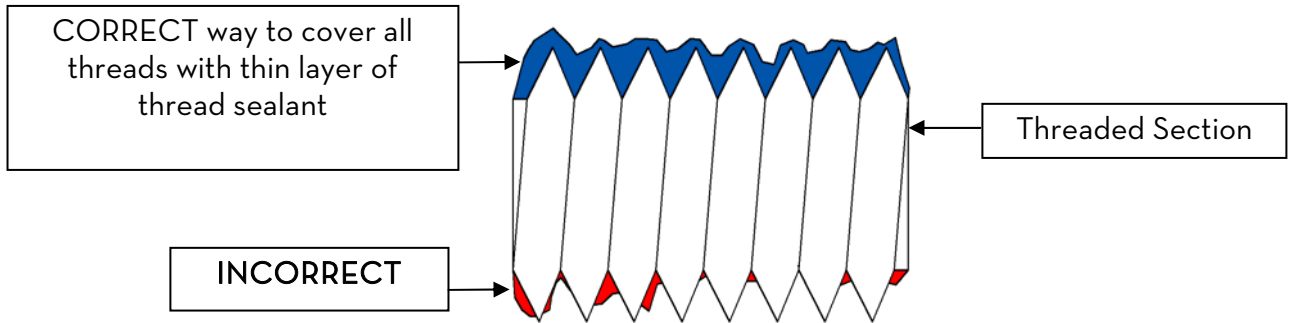
With nuts installed, begin tightening in a crisscross pattern. Tighten in 5 ft. lbs. increments to 20 ft. lbs.

Apply thread sealant applicable for application, (Spears Blue 75 recommended) to the outside nipple of the B.O.S.S.® fitting and install the female adaptor or coupler.



Tighten threaded plastic fittings only 1/2 turn beyond hand tight using a strap wrench.

Method for applying thread sealant to threaded fittings:

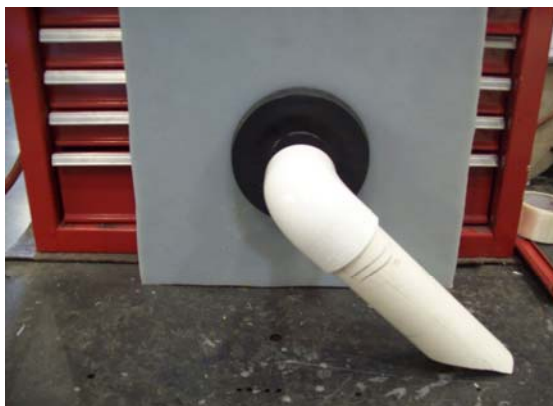


Adding the optional siphon leg

If the B.O.S.S.® fitting requires a siphon leg, apply thread sealant to the fitting's nipple, and screw on a PVC 90 degree elbow.



After the elbow is in place, measure and cut the appropriate length of PVC pipe and glue it in place.



HANDLING NOTE: Once a tank is fitted and ready to be moved, great care must be taken to prevent damage to the fitting. When hydro testing this unit, use inflatable test plugs to block off the fitting.