

# **BELLOWS TRANSITION FITTING**

## **Introduction and Warning**

These instructions are intended to make your transition fitting installation and maintenance trouble free. Read them carefully and identify all parts before starting your installation. Follow all general safety practices and your company specific safety practices.

## **Inner and Outer Tank Alignment**

The design of the alignment sleeve is to ensure that your tank arrives without any alignment issues. In the event that a misalignment does occur during shipment or set up, please contact the manufacturer for instructions.



**WARNING:** The SAFE-Tank® system is designed to provide a minimum of 110% secondary containment. Once the transition fitting is installed, a leak in the inner tank will result in product collection between the inner and outer tank. If this product is not drained off prior to breaking the seals of the transition fitting, serious property damage, injury or death may occur. Great care must be taken to protect people and property when working with a transition fitting.

## Filling and Testing Inner Tank

1. Attach flexible connection assembly to inner tank fitting. (Do not install bellows at this time.) If the connection is a solvent weld, allow adequate dry time.
2. Cap or plug all inner tank sidewall fittings and fill the inner tank with water to top knuckle. Make sure you provide support to the flexible connection during the hydro test. Allow the tank to remain full for 12 to 24 hours. This allows:
  - The inner tank to fully seat itself in the outer tank.
  - The inner tank to fully expand without stressing the inner tank flange and recently installed flexible connection assembly.
  - Detection of any leaks in the inner tank created during shipping and handling.
  - Detection of any leaks between the inner tank flange and recently installed nipple.
3. Determine if any leaks are occurring by using the outer tank access hole to look for water collecting in the space between the inner and outer tank. Correct any problems. Leaks cannot always be visually detected once the transition fitting is installed!

## Assembly of the Transition Fitting

Loose parts boxed for shipment



Remove nuts and alignment sleeve before beginning



Confirm proper alignment



Glue PVC pipe/flexible connection assembly to inner tank fitting



Install gasket for bellows



Install bellows and SS Back Rings



Glue BHF



Install Outer Face Plate and SS Back Ring



Tighten nut on BHF (left hand threads)



Finished Assembly



## Tightening/torque criteria:

- Steel bolts/stud bolts: progressively tighten in crisscross pattern to 20 ft lbs max.
- PVC BHF Nut: Hand tighten plus 1/4 turn with a wrench.