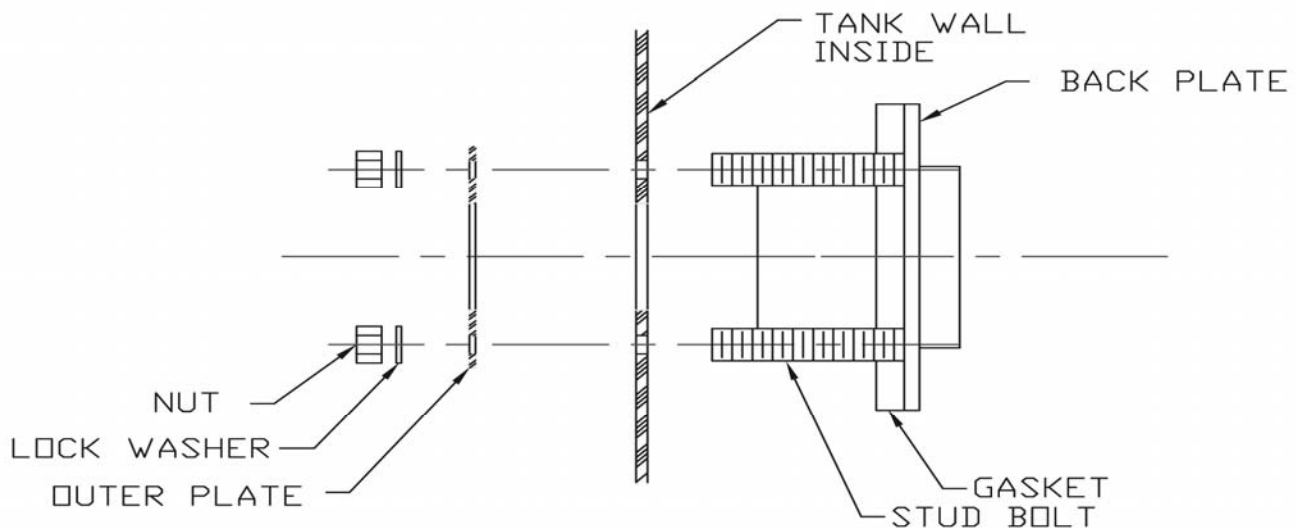


# STAINLESS STEEL FITTINGS

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 bolt holes on the outside of the tank.
3. Find the center of the large "pipe fitting" hole by drawing an "X" through the center of the bolt holes.
4. Drill out the pipe fitting hole using a hole saw. Please note that the hole to be drilled into the tank may be smaller than the hole in the outer plate that was used as a template. The hole drilled should be only slightly larger than the outside diameter of the pipe fitting.
5. Next drill out the stud bolt holes using a 9/16" drill bit for the 1/2" diameter studs.
6. Clean and bevel all drilled and cut holes on the inside and outside of tank surfaces.
7. Install the fitting and gasket from the inside of the tank.
8. Slide the outer plate onto the stud bolts that are protruding on the outside of the tank.
9. Replace the washers and nuts on the stud bolts. Tighten the nuts in a crisscross pattern using a torque wrench. Tighten until the gasket is fully compressed (approximately 30 ft. lbs. on a torque wrench).
10. Inspect the fitting. The gasket should be compressed and the outer stainless steel plate should conform to the wall of the tank.
11. **Hydro test** the tank for at least 24 hours prior to loading with chemical.



ILLUSTRATION