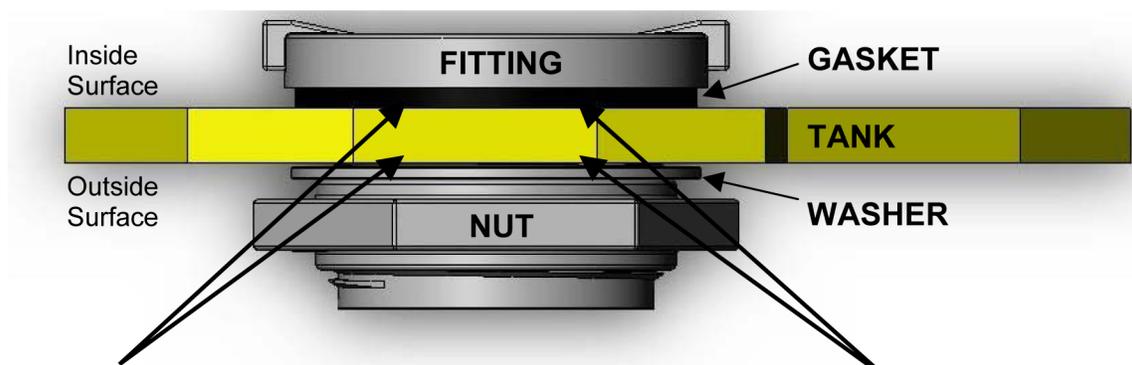


Fitting Installation Guidelines



- Drill hole as straight as possible through tank at fitting location— recommend using hole saw at smallest diameter possible. Be careful not to drill hole too close to edge of sump or tank bottom. Wall thickness variation must not exceed .050” at the sealing surface of the fitting gasket.
- Deburr edge of hole on both sides to allow smooth sealing surface
- One gasket between fitting and tank, one washer between nut and tank
- Tighten nut to hand-tight plus ½ turn



- Must remove burr and any shavings on tank surface to allow gasket to seal properly
- Do NOT deburr too much material around opening – only remove lip from saw cut, do not carve extra material out

NOTES:

- Edge of drilled holes for fittings must be at least 1” from adjacent surface or radius to allow sufficient space for gasket and washer to seal.
- Washer is not provided with all fittings.

Fitting Installation:

Be careful not to over tighten poly fittings. If over tightened, these fittings can be damaged and leak. In such cases, always replace the fittings. If thread sealant is used, be certain that it is rated for use with the fittings and chemical to be contained. Never subject fittings to loads or weight that may cause cracking. Avoid rigid plumbing from tank fitting. Fitting installations to and from tank must consider the effects of expansion and contraction stresses due to temperature as well as filling and emptying of the tank. (See page 14 for general fitting installation guidelines)

- **Dry Fittings** – Fittings that are not exposed to chemicals and have no low temperature limit providing the plumbing loads that the fittings are subjected to are within the Application Guidelines recommendations.
- **Wet Fittings** – Fittings that are exposed to chemicals will have a low temperature rating equivalent to the freezing limits of the chemical the fitting is exposed to. In the case of water that would be 32° F (0° C) ambient. Chemicals or solutions such as calcium chloride are generally rated for -20° F (-29° C) depending upon the salt concentration. Note that heaters, heat bands or chemical inhibitors that prevent chemical freeze up will allow the fittings to be exposed to ambient temperatures below the published freeze point of the chemical. Again, the low temperature rating of all fittings must be above the point at which the chemicals freeze or solidify.