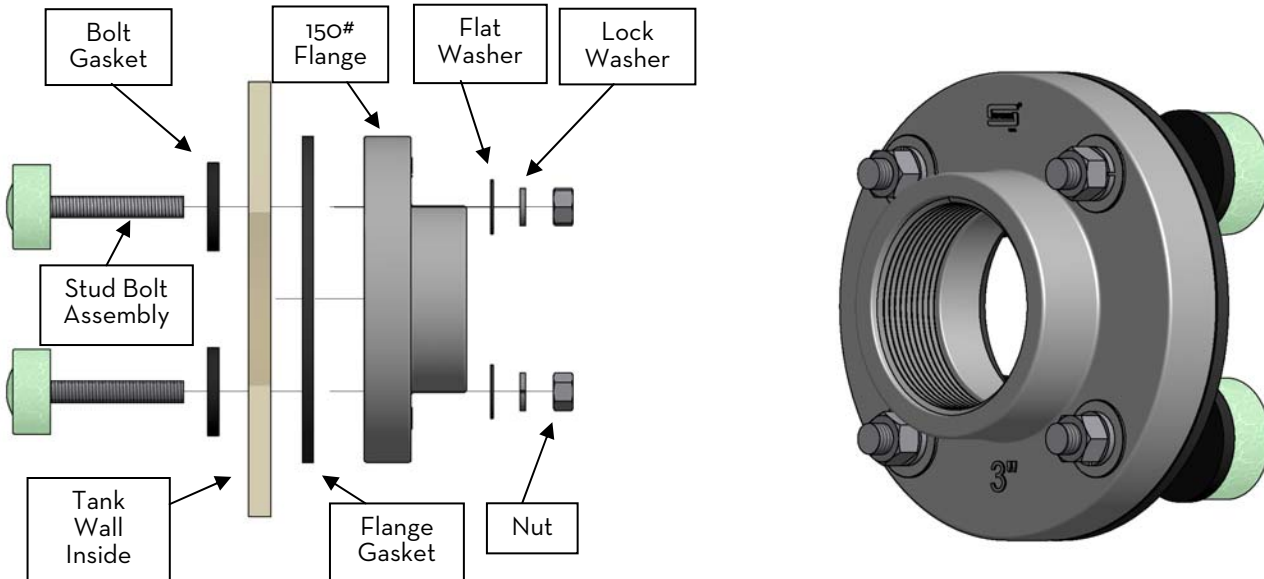


BOLTED FLANGE FITTINGS

1. Flanges for pipe sizes 4-in and larger should be curved to match the outside diameter of the tank.
2. Disassemble the fittings as shipped. If the holes are not drilled, place the flange against the tank in the desired location and use as a template for drilling the holes. Use a hole saw the same size as the fitting's port.
3. Clean and bevel all drilled and cut holes on the inside and outside of tank surfaces.
4. With the gaskets installed, place the stud bolts through the holes with the plastic head on the inside of the tank; threads on the outside.
5. Place the full face flange gasket over the bolts on the outside surface of the tank.
6. Place the flange over the gasket and stud threads with the hub of the flange facing out.
7. Put a washer and nut on each stud bolt. Be sure to lubricate the threads of the bolts with anti-seize compound.
8. Tighten the nuts in a crisscross pattern using a torque wrench. Tighten in 5 ft. lb increments to 20 ft. lb.
9. Inspect fitting. Gasket must be compressed and the outer flange drawn down evenly.
10. Piping such as a flange adapter should now be threaded into the fitting. Thread sealant should be applied to all pipe threads. Do not over tighten.
11. **Hydro test** the tank for at least 24 hours prior to loading with chemical.

Bolted Flange size	Hole saw size
1"	1 5/8"
1 1/2"	2"
2"	2 1/2"
3"	3 5/8"
4"	4 1/2"
6"	6"



CAUTION: Over torquing will damage the flange and gaskets.