

Red Thread™ IIA Riser Pipe Assembly Instructions

For Red Thread™ IIA Riser Pipe



General

Installing our Red Thread IIA Riser Pipe assembly follows the same guidelines as our standard pipe (INS1280 - Fuel Handling Installation Manual) with important considerations which have been detailed below.

Special Considerations

Adjust the 4" Mandrel on Box Tool

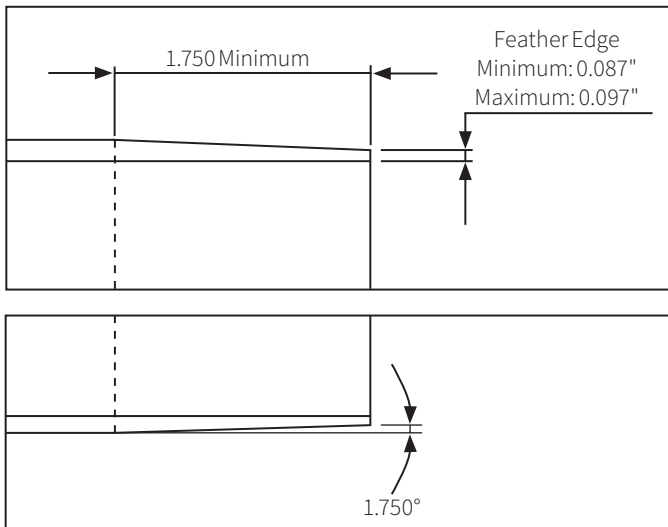
- Rotate the mandrel reference mark away from the cross mark at the center of the tool.
- Re-tighten the Allen head bolt.

The minimum feather edge thickness is 0.087" with a maximum allowed feather edge thickness of 0.097". Err on the side of tapering less so that you can readjust and taper more until you get to the desired feather edge.

Once tapered you can dry fit the tapered pipe into the adapter and check insertion to verify that the taper has been made properly. See Average Taper Dry-Insertion Length table for more information,



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Dry Fit Complete Assembly

Once tapers have been applied and checked for proper insertion depth, dry fit the entire assembly and thread onto tank top fitting to measure the overall height of the assembly.

Check the Adapter ID After Bonding

Immediately check ID after adhesive joints are made up to make sure adhesive overflow does not obstruct the ID clearance. In the event of overflow wipe away excess adhesive. This must be done before the adhesive cures and before installation on the tank top.

Average Taper Dry-Insertion Length

| Pipe Size | | Average Taper Dry-Insertion Length | |
|-----------|-----|------------------------------------|-------|
| in | mm | in | mm |
| 4 | 100 | 2" - 2 3/4" | 50-70 |

Adhesive Kits

| Kit No. | Label Color | Mixed Qty. (oz) | # of Bonds per Kit |
|---------|-------------|-----------------|--------------------|
| 8014 | Green | 6.5 | 7 |
| 8024 | Yellow | 2.7 | 3 |
| 8069 | Orange | 9.8 | 11 |
| PSX-20 | Red | 3.0 | 3 |
| PSX-20 | Purple | 5.0 | 5 |
| PSX-20 | Yellow | 8.0 | 9 |
| PSX-34 | Red | 3.0 | 3 |
| PSX-34 | Purple | 5.0 | 5 |
| PSX-34 | Yellow | 8.0 | 9 |

IMPORTANT: If your Spill Container has a Gravel Guard you will need to insert the tapered end of the Riser Pipe through the Gravel Guard before making up the adhesive joint on the Adapter that threads into the Spill Container. If the Riser Pipe does not fit through the Gravel Guard we recommend excluding the Gravel Guard from the installation or using an appropriate tool to increase the ID of the Gravel Guard to fit. Do not lubricate the OD of the Red Thread IIA Riser Pipe to fit through Gravel Guard.

Order of operations for installing Riser Pipe assembly

1. Adjust mandrel on Taper Tool.
2. Taper Riser pipe.
3. Verify taper and re-taper if necessary (see Average Taper Dry-Insertion Length table).
4. Verify overall length of assembly by dry-fitting on tank top.
5. Prep joint surfaces.
6. Mix adhesive.
7. Apply thin layer of adhesive (see Adhesive Kits table).
8. Check ID of joint for adhesive overflow, wipe away excess.
9. Apply thread dope to adapter threads.
10. Thread Riser Pipe assembly into tank top fitting.

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