

STEEL IBC TANK OUTLET INSTALLATION PROCEDURE

1. With the outlet nipple welded to the bottom of the tank, inspect the threads on all fitting prior to installation. The threads shall be free of burrs or galled threads prior to installation. (All pipe threads shall be fabricated in accordance to National Pipe Thread tolerance (N.P.T.) REF: ANSI/ASME B1.20.)
2. Install PTFE Teflon Tape (Heavy Duty High Density PTFE Tape Mil Spec T27730A) on outlet fitting. Tape should be started approximately 1/8" from the end of the fitting or approximately 2 threads from end of fitting. Install with clockwise motion as shown. (See Figure 1.0)
3. Install the Teflon Tape making 6-8 full rounds of tape on the fitting; evenly distributing the tape on the threads; the Teflon tape should be not gathered or assembled in one area of the fittings. NOTE: 1/2" tape shown, for 3/4" wide tape, use 4 full rounds. (See Figure 2.0)
4. After the Teflon Tape is installed, apply a single coating of Teflon Paste around the perimeter of the fitting for additional sealing protection. The Teflon paste should be applied in the same clockwise direction as the tape was installed. Do not use a generous amount of Teflon paste on the fittings. Wipe off and remove any excess paste or tape. (See Figure 3.0)



Figure 1.0



Figure 2.0



Figure 3.0

5. Install 90° Elbow Fitting on outlet nipple by hand until fitting becomes snug. Fitting should thread on easily without resistance, if not, remove fitting, check threads and repeat above procedures.

6. Using the recommended pipe wrench specified by pipe wrench manufactures. (**See Figure 4.0**) The table below references the proper pipe wrench to use when tightening various sizes of pipe that have standard tapered pipe threads. An average man using an 18"-24" pipe wrench will be able to complete the task and get a good seal. No cheater pipe is required. In fact, the use of a cheater pipe is NOT recommended. For a standard 2" bottom discharge on any model of Supertainer, an 18" pipe wrench is the tool of choice.

Suggested Pipe Wrench Size Reference	
Wrench	Pipe Dia.
6"	1/8" - 1/2"
8"	1/4" - 3/4"
10"	3/4" - 1"
12"	1 1/2" - 1 1/2"
14"	1 1/2" - 1 1/2"
18"	1" - 2"
24"	1 1/2" - 2 1/2"
36"	2" - 3 1/2"
48"	3" - 5"
60"	3" - 8"

Figure 4.0

7. When tightening the fittings above, the fittings should be tighten to the point where a fitting will not leak and minimize any movement of the valve assembly without the use of tools or wrenches: however, DO NOT over tighten the fittings or it may cause damage the threads on the fittings.

a. As a reference, you should be able to see approximately 1 to 2 threads showing on the inside 90° elbow fitting. (See Figure 5.0) and you should have approximately 8-9 threads exposed above the 90° elbow fittings.

b. The "maximum tightening" is not always possible. We want the valve stem orientation to be in the same location each time.



Figure 5.0

8. Inspect fitting assembly for Teflon tape and paste exposure on the inside of the fittings. The inside fittings should not have any Teflon tape or paste exposed on the interior of the fittings.

a. Remove any excess tape and paste if possible, if not, remove the fittings or assembly and repeat above Teflon tape and paste procedures.