

Bonded Double-Wall Sump Entry/Termination Fitting



TABLE 1 - Fitting Dimensions

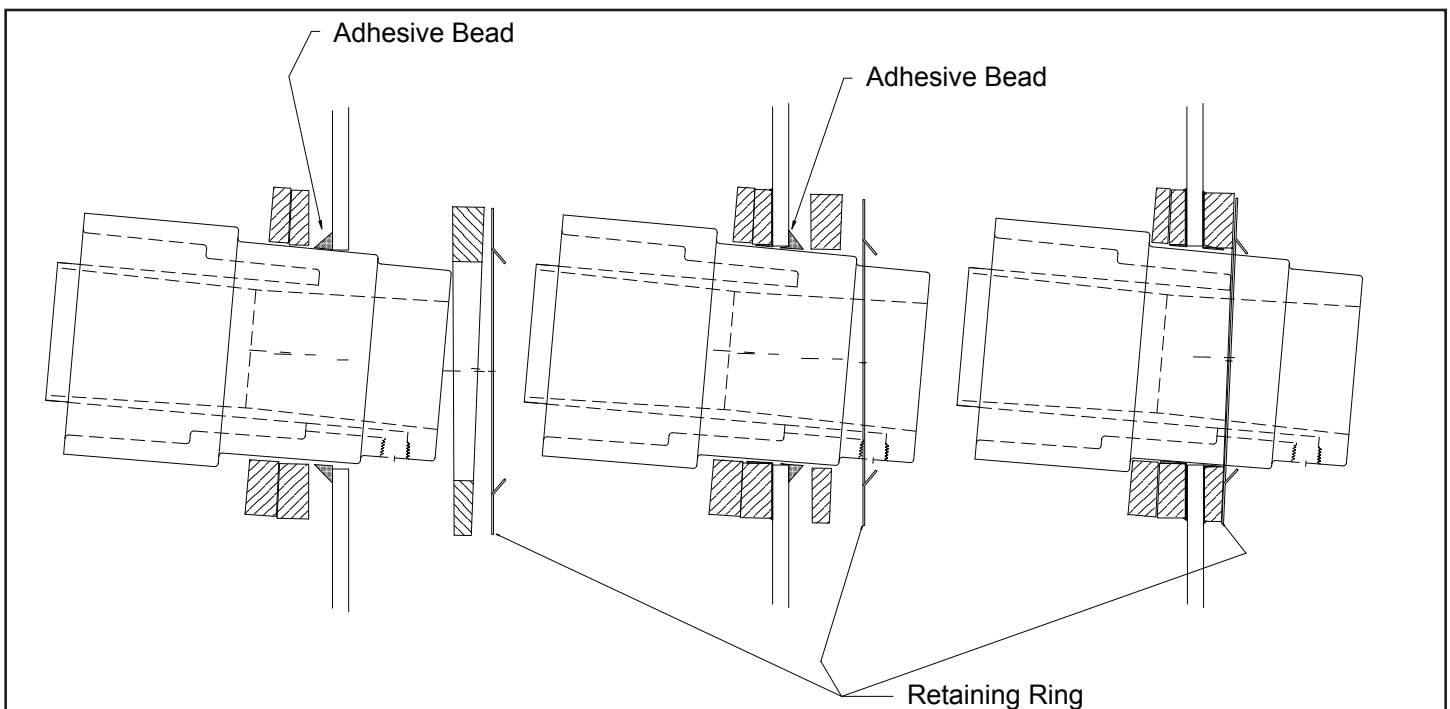
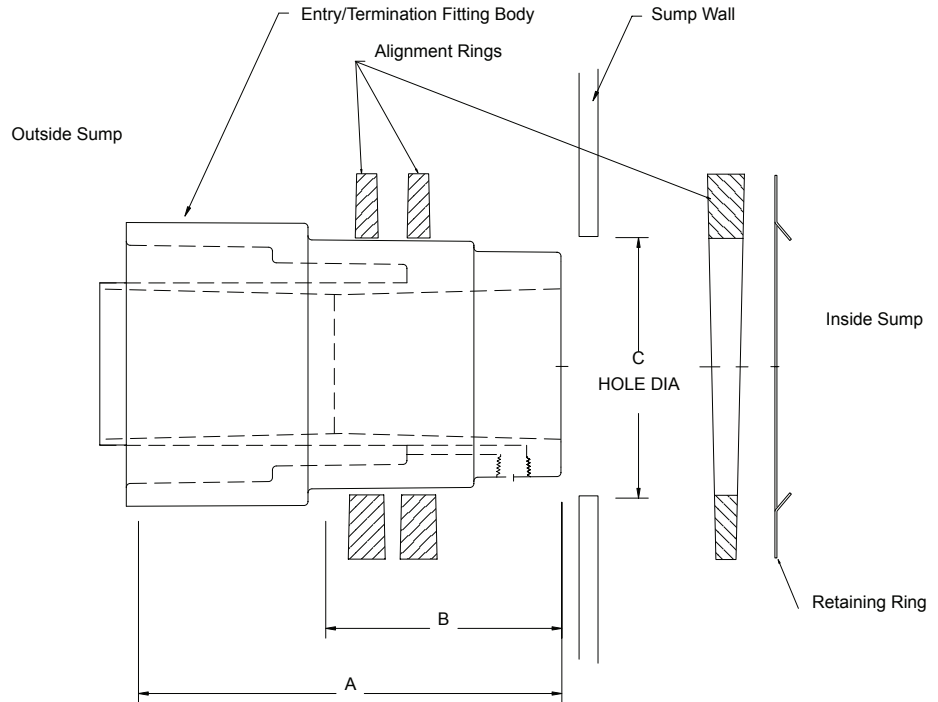
Size	A	B	C
In.	In.	In.	In.
3" x 2"	6.88	4.00	4.00
4" x 3"	6.88	4.00	5.00

NOTE: This fitting can be bonded to a flat fiberglass surface only. **DO NOT** install on thermoplastic or round sumps.

1. Determine entry hole location and cut entry hole in sump wall using dimensions in Table 1. (Maximum allowable offset is 5°.)
2. Using 40-60 grit sanding surface, sand the area around the hole where the alignment rings will bond to the sump. Lightly sand the rings. Remove dust and wipe with solvent (optional).
3. Place two alignment rings on sump entry/termination fitting and insert through sump wall with the rings on the outside of the wall. Locate the 1/4"

threaded outlet to the desired location. **If this fitting is used in an Open (Drainage) System, locate the 1/4" threaded outlet in the "South" position.** Leave 1/4" plastic threaded outlet protector in place until 1/4" fitting installation.

4. Dry fit primary pipe and rotate the two rings until the desired angle is reached. Make alignment marks on the rings, the fitting, and the sump wall. Be sure to mark the rings so they can be placed in the same location and sequence during bonding.



Bonded Double-Wall Sump Entry/Termination Fitting

5. Place one ring over the sump fitting in the inside of the sump and rotate to the desired angle. Make alignment mark on both the sump wall and the ring.

6. Mix one 7069 or 8069 adhesive for each fitting per the instructions in the adhesive kit. Mix in filler to thicken adhesive (fiberglass alignment rings will not seal properly without filler).

7. Apply adhesive generously, approximately $\frac{1}{16}$ " thick to the inside and the outside of the sump walls where the alignment rings are located. Coat cut edges of the entry hole. Apply a thin coating of adhesive to the bonding surfaces of the alignment rings.

8. Line up rings with alignment marks and press together firmly.

9. Slide the metal retaining ring over inside section of sump fitting against the alignment rings until they are tight against sump wall. (A short section of 4" pipe may be used to drive the metal retaining ring over the fitting.) Be sure there is an adhesive bead visible between the rings and the sump wall. The metal ring must hold the assembly in position while the adhesive cures. If the assembly is not tight against the sump wall, firmly press the entry fitting against the outside sump wall while pressing the metal ring against the alignment ring on the inside.

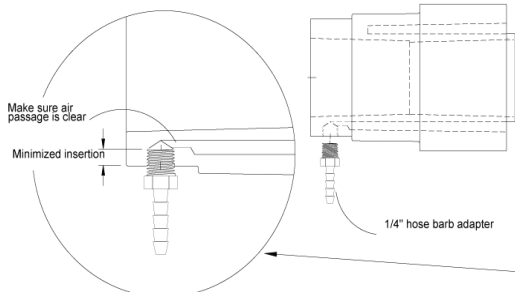
10. Do not disturb assembly until the adhesive is cured. This includes bonding of pipe to the entry fitting and installing the threaded outlet fitting. Clean excess adhesive from all bonding surfaces. See adhesive kit instructions for cure times.

11. The use of an industrial hot air gun may speed up the curing process. Do not overheat.

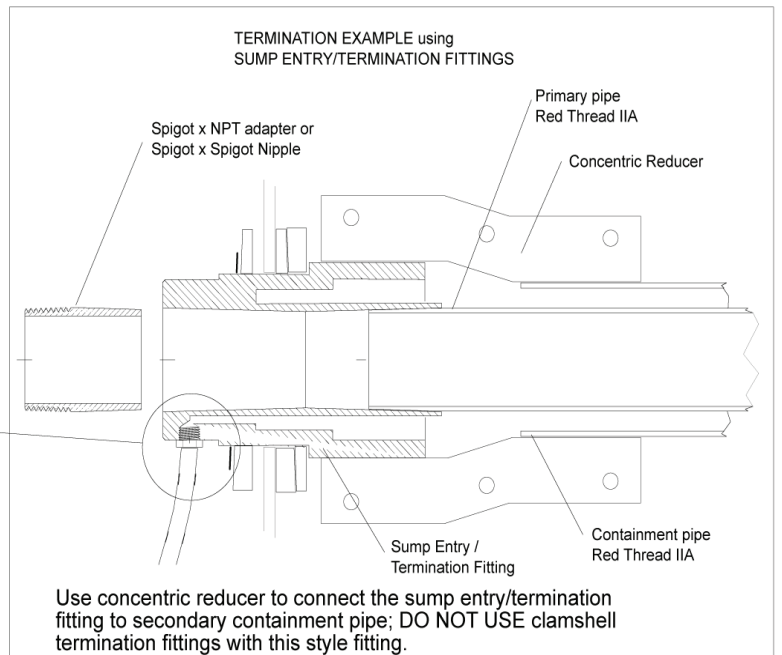
12. Remove $\frac{1}{4}$ " plastic threaded outlet protector. **Apply adhesive only** to the $\frac{1}{4}$ " fitting and screw into the $\frac{1}{4}$ " threaded outlet. Tighten to 40 in.-lbs. or $1\frac{1}{2}$ -2 turns past hand tight. After installing the fitting, be sure the interstitial space is free from excess adhesive. Install a short hose and blow excess adhesive through the air passage. **NOTE:** Verify with testing company or monitoring manufacturer if a larger thread is needed for their equipment. After the port fitting is installed, do not remove.

13. **Connect only flexible tubing or hoses to the port fitting.**

NOTE: Tubing or hoses must be rated to full vacuum.



- The 1/4" threads are a "modified NPT" - the insertion of a standard spec make thread is minimized.
- 7014 or 8014 adhesive (without filler) is **required**.
- The 1/4" female threads are plastic and cannot be tightened the same as a metallic thread. Tighten to 40 in.-lbs or 1.5-2 turns.
- After installing a 1/4" NPT fitting, the passageway to the piping interstitial space should be cleared with air pressure to insure that it is free of thread sealant and/or adhesive.



National Oilwell Varco has produced this brochure for general information only, and it is not intended for design purposes. Although every effort has been made to maintain the accuracy and reliability of its contents, National Oilwell Varco in no way assumes responsibility for liability for any loss, damage or injury resulting from the use of information and data herein nor is any warranty expressed or implied. Always cross-reference the bulletin date with the most current version listed at the web site noted in this literature.



www.fgsipipe.com

2700 West 65th Street
Little Rock, Arkansas 72209
Phone: 1 (501) 618-2256

25 S. Main Street
Sand Springs, Oklahoma 74063
1 (918) 245-6651

NOV Fiber Glass Systems

® Trademark of NATIONAL OILWELL VARCO
© 2009, NATIONAL OILWELL VARCO
B2108 - June 2009