

INSTALLATION



A- Weld the tank pad

A.1. Weld the tank pad (1) onto the tank using TIG or MAG process.
Please make sure to respect a flatness of 0.15mm max.

B – Installation of the outlet valve control

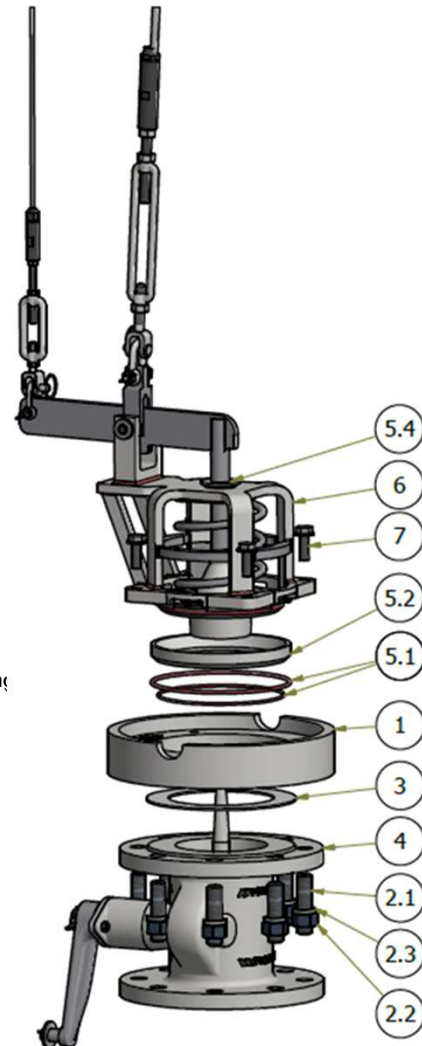
From the outside of the tank :

- B.1. Screw the M16 studs (2.1) onto the weld in flange (1).
- B.2. Fit the outlet valve control (4) onto the weld in flange (1) clamping gasket (3). Secure with washers and nuts (2.2 & 2.3).
The required tightening torque is **15 daN.m**
(do not exceed 19 daN.m)

C – Internal valve installation

From the inside of the tank :

- C.1. Make sure that no dirt or grit is present on the flange (1) & gasket (5.1).
Install the FEP/Silicone O'ring (5.1) inside the weld in flange (1).
 - C.2 Fit the removable seat (5.2) to clamp the O'ring (5.1) onto the weld in flange (1).
 - C.3 Fit the bottom discharge (6) onto the weld in flange (1).
Tight with the M10 screws using Nord-lock washers (7).
The required tightening torque is **3.3 daN.m**.
 - C.4 Remove part (5.4) from footvalve.
 - C.5 Check that poppet perfectly closes off.
- Installation details described on PWA1911260000 please ask this document if not available



Item	Description	Specification	Part n°
1	Weld in Flange	Weld In flange 304L / 1.4307	19 11 26 50 00
2	M16 Bolting Kit	8 x M16-50 Studs (2.1) + 8 x M16Nuts (2.2) + 8 x grower washers (2.3)	19 11 09 90 01
3	Gasket	PTFE Flat Gasket	19 90 05 30 01
4	Outlet Valve Control	4" Outlet Valve Control	19 11 09 20 00
5.1	O'ring	FEP/Sil encapsulated O'ring	19 11 26 00 00
5.2	Removable Seat	Removable Seat 316L	
5&6	Bottom Discharge	Rail Tank Car Bottom Discharge Carbon St Fep/Si seal	
7	M10 Screw Kit	4 x M10 screws + 4 Nordlock washers 304	
8	Wire Ø4	Cable,Rail tank Ø4 DMA Control	19 11 26 41 00
9	Wire Ø8	Cable,Rail tank Ø8 for rupture pin	19 11 2 642 00

Assembly is the same for Carbon Steel and Stainless steel version

Assembly for steam heated version is the same but requires steam heated weld-in flange