

Bonded Sump Entry Fitting



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

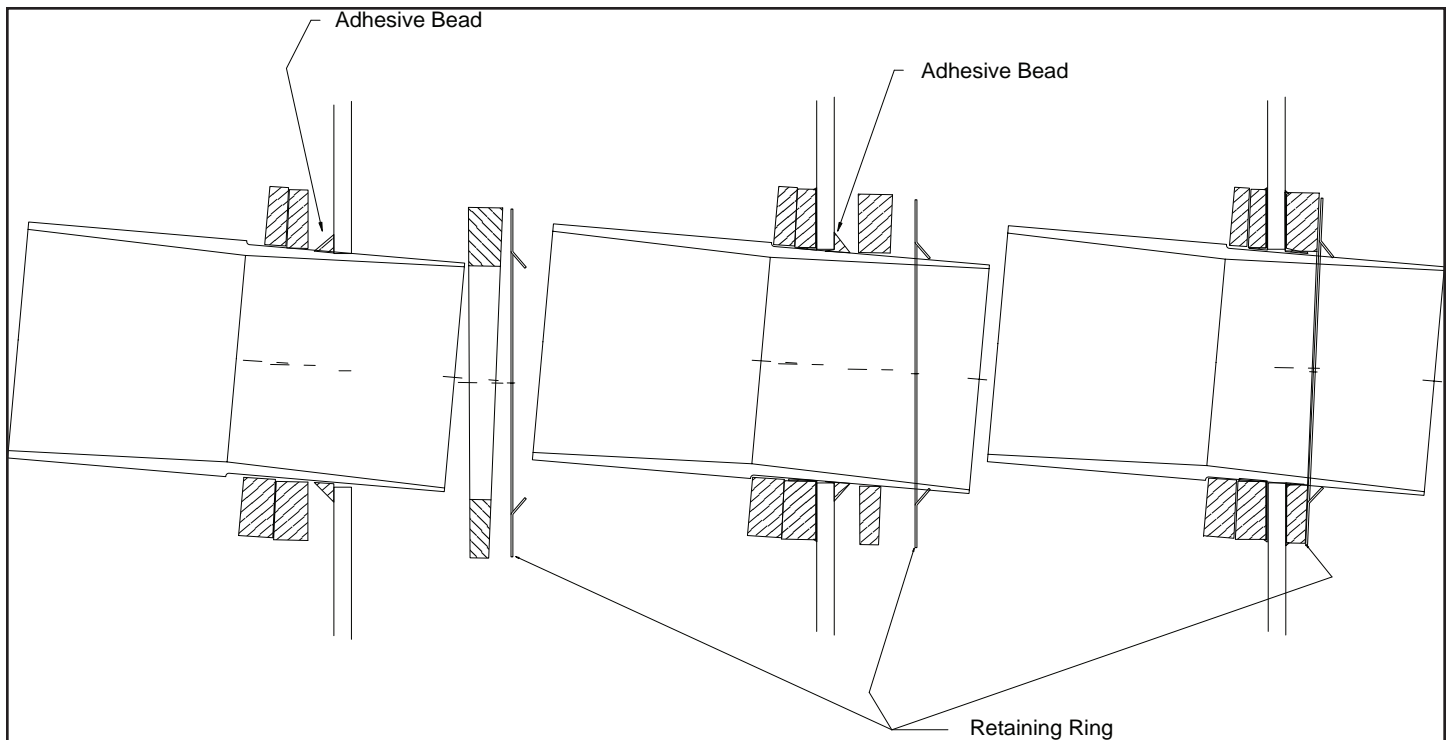
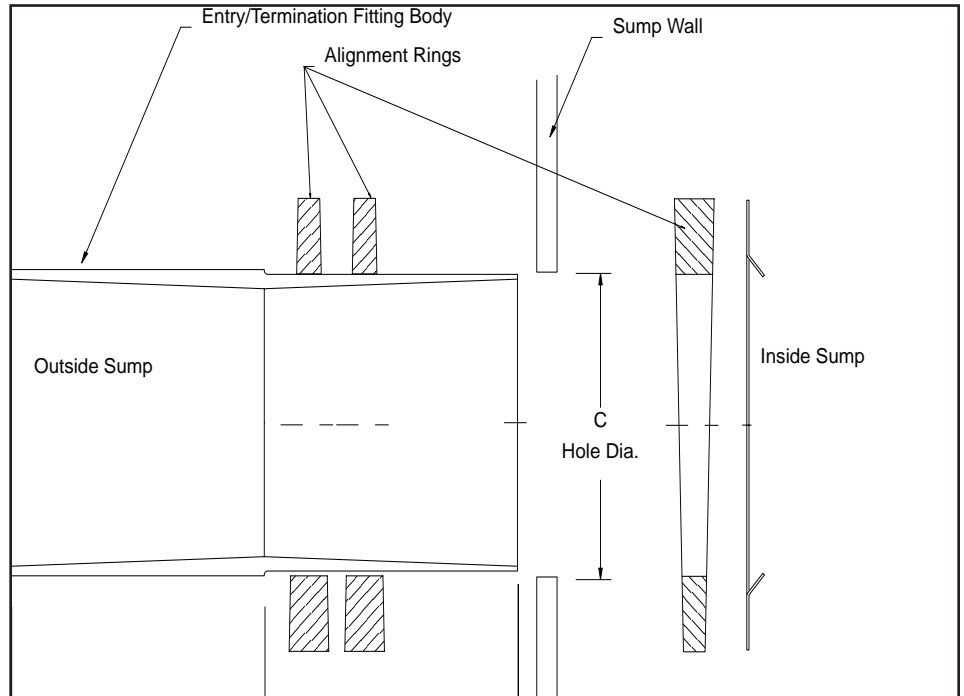
1. Determine entry hole location and cut entry hole in sump wall using dimensions in Table 1. (Maximum allowable offset is 5° - shown in "Adhesive Bead" drawing below.)

TABLE 1 - Fitting Dimensions			
Size	A	B	C
In.	In.	In.	In.
2"	6	3	2 9/16
3"	6	3	3 3/4
4"	6	3	4 3/4
*6"	6	3	6 7/8

*Adjustable hole cutter required for 6" fitting.

- 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 and remove dust.
- Place two alignment rings on sump entry/termination fitting and insert through sump wall with the rings on the outside of the wall.

- Dry fit 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.



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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 kit for each fitting per the instructions in the adhesive kit. Mix in filler to thicken adhesive (fiberglass alignment ring 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 all three 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 ring until tight against sump wall. A short section of pipe (3" pipe for 2" fitting, 4" pipe for 3" fitting; contact manufacturer for 4" and 6" fitting) 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. 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.

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