

## INSTALLATION INSTRUCTIONS

<u>Model No.</u>	<u>Description</u>
495370	Primary Replacement Kit for A1005-518GP, 5 gal, stainless steel primary

### Emco Supplied Parts

Stainless steel bucket  
O-ring  
(2) split flanges  
(10) stainless steel bolts  
(8)  $\frac{3}{8}$ " x 1" long bolts  
(2) Rim gaskets  
(4)  $\frac{3}{8}$ " studs

### Required Tools

9/16" socket  
12" extension and ratchet  
Chain wrench or strap wrench  
Adapter wrench  
Plumbers putty or heavy grease  
3/8" socket

### Purchased Separately from Emco

Emco 494833 Test Cover  
Emco A1004-210TEST



**Step 1:** Remove lid, cap, adapter and gauge. Set aside. Remove and discard bolts from the primary rim. Remove rim and set aside. Remove and discard rim gasket.



**Step 2:** Remove the 10 flange bolts, the 2 split flanges and o-ring from the bucket; discard all.



**Step 3:** Remove and discard primary unit. Remove and discard secondary rim gasket.



**Step 4:** Insert (4)  $\frac{3}{8}$ " studs (included) into every other bolt hole a minimum of  $\frac{1}{4}$ " as shown. Position a new rim gasket on secondary bellows, using studs to assist with alignment.



**Step 5:** Install new primary bucket over nipple, using studs to assist with alignment.

Note: Outer lip of primary unit should rest against rim seal underneath.



**Step 6:** Install the remaining new rim gasket over outer lip of primary bucket, using studs to assist with alignment.



**Step 7:** Place primary rim over studs.



**Step 8:** Loosely install 4 of the new  $\frac{3}{8}$ " x 1" bolts into open holes in rim.



**Step 9:** Remove studs and replace with the 4 remaining  $\frac{3}{8}$ " x 1" bolts. Tighten all 8 bolts to 20 ft. lbs.



**Step 10:** Install new o-ring over the nipple, seating it completely in the groove in the stainless steel flange.



**Step 11:** Install the two split flanges using the ten supplied stainless steel bolts. Hand tighten all ten bolts, ensuring that the bucket is completely down and flat on the rim.



**Step 12:** Using a  $\frac{9}{16}$ " socket, tighten each of the ten bolts to 15 ft. lbs.



**Step 13:** Install adapter and cap per instructions included with each.

**Step 14: Testing**

Perform one of the following test procedures as specified by customer:

**Integrity Test** - perform per following procedure, with customer specified cap and adapter.

**Hydrostatic Test** - perform if specified per customer or local regulations. Perform per local guidelines.

## Integrity Test Procedure

### **Equipment** (not supplied)

Emco A1004-210TEST Vacuum Apparatus w/test adapter 494343

Emco 494833 Test Cover

Timer

Air supply

### **Procedure**

1. Line top surface of stainless steel bucket with plumbers putty as shown. (Heavy grease may be used, but may not work properly on rough surfaces.)
2. Place test cover over plumbers putty or heavy grease.
3. Insert brass plug from test unit into opening in test cover (A).
4. Attach air pressure source to air pressure regulator on vacuum apparatus.
5. Slowly apply vacuum of 30" water column (2.2" mercury) to the interstitial space, by moving the toggle switch. Wait 30 seconds. Reapply 30" water column.
6. Ensure switch is in off (center) position, start timer and record remaining vacuum after 1 minute.
7. If the remaining vacuum after 1 minute is 26" water column (1.9" mercury) or greater, the containment is tight.
8. If the test fails, determine if leak point is at test cover seal, cap or adapter, or base flange o-ring by spraying a soap solution to each area and watching for bubbles. Repair as required and retest.
9. Replace components.



## Follow-Up Testing

If follow-up or annual retesting is required by local/state regulation, use the above procedure.

### **Tank Operator Responsibilities**

1. Tank operator must ensure that all Federal, Provincial and local codes are being met during the filling of the tank.
2. All operators must be familiar with proper filling procedures.
3. The operator responsible for transferring product to an above ground storage tank must take all reasonable steps to prevent spillage.
4. The delivery hose from the tank's fill pipe must not be disconnected before the hose has been drained completely.
5. When tank vehicles are being unloaded, the vehicle operators must remain (a) in constant view of the transfer nozzle and fill pipe; and (b) in constant attendance at the discharge control valve.