

## INSTALLATION INSTRUCTIONS

### Emco Supplied Parts

- (1) large cross section o-ring
- (1) small cross section o-ring

### Required Tools

- Adapter wrench
- 9/16" socket
- 12" extension and ratchet
- Snap ring pliers
- Plumbers putty or heavy grease

### Purchased Separately from Emco

- Emco 494833 Test Cover
- Emco A1004-210TEST

The 494845 O-ring Kit is for A1005-517, -518 and A1005-505 series spill containment with or without an eccentric ring. Remove lid, cap and adapter. Determine if the spill containment has an eccentric ring by identifying the number of flanges. Buckets with eccentric rings have 3 flanges. Buckets without eccentric rings have 2 flanges.

### Buckets without Eccentric Rings:



**Step 1:** Use a 9/16" socket to loosen and remove the ten bolts. Set bolts aside.



**Step 2:** Remove the two split flanges and set aside.



**Step 3:** Remove and discard o-ring. Make certain o-ring groove is clean and free of debris.



**Step 4:** Install new large cross section o-ring over the nipple, seating it completely in the groove in the stainless steel flange.



**Step 5:** Reinstall the two split flanges using the bolts removed from Step 1. Hand tighten all ten bolts.



**Step 6:** Using a 9/16" socket, tighten each of the ten bolts to 15 ft. lbs. Pressure may need to be applied to ensure the liner does not shift while tightening bolts.

Proceed to Step 12 of Eccentric Ring Instructions

**Buckets with Eccentric Rings:**



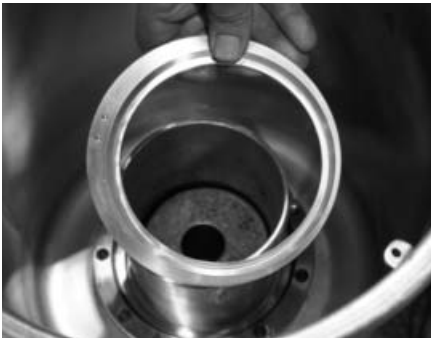
**Step 1:** Use a 9/16" socket to loosen and remove the nine bolts and washers. Set aside.



**Step 2:** Remove the three flanges and set aside.



**Step 3:** Remove and discard the large cross section o-ring.



**Step 4:** Remove eccentric ring and set aside. Snap ring pliers may be used in two small holes to assist in removal. Make certain o-ring groove is clean and free of debris.



**Step 5:** Remove and discard the small cross section o-ring. Make certain o-ring groove is clean and free of debris.



**Step 6:** Install new small cross section o-ring in the groove of the lower flange.

Large section of offset ring  
O-ring groove facing up



**Step 7:** Reinstall eccentric ring, with o-ring groove facing up. Align the large section of the ring with largest open area around the nipple as shown.



**Step 8:** Install new large cross section o-ring on top of eccentric ring.



**Step 9:** Reinstall the three flanges using the nine bolts and washers from Step 1. Ensure that the flanges are tight against the nipple.



**Step 10:** Hand tighten all nine bolts.



**Step 11:** Using a 9/16" socket, tighten each of the nine bolts to 15 ft. lbs. Pressure may need to be applied to ensure the liner does not shift while tightening bolts.



**Step 12:** Install adapter and cap per instructions included with each.

**Step 13: 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

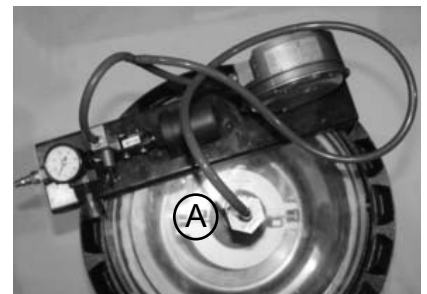
Emco 494833 Test Cover

Timer

Air supply

**Procedure**

1. Line top surface of stainless steel bucket with plumbers putty. (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.