

Bonded Sump Entry Fitting - Termination Style

for Fuel Handling applications

Installation and Application Instructions

1. Determine entry hole location and cut entry hole in sump wall using appropriate "C" dimensions in Table 1.
2. Using 40-60 grit fresh emery cloth or sand paper, sand the sump wall surfaces, inside and outside, to the outside diameter of the alignment rings. All glazed surface must be removed. Once finished sanding, remove all dust from the sanded area with a clean, dry cloth or brush. Do not use compressed air or bare fingers.
3. Place two alignment rings on sump entry fitting and insert through sump wall from outside the sump. Locate the 1/4 inch threaded outlet to the desired angular location.

If this fitting is used in an Open (Drainage) System, locate the 1/4 inch threaded outlet in the 6 o'clock position.

Leave 1/4 inch plastic threaded outlet protector in place until 1/4 inch fitting installation.

4. Dry fit primary pipe and rotate the two rings until the desired angle is reached. Maximum allowable offset is 5°. Make alignment marks on the rings, the sump entry fitting, and the sump wall. Be sure to mark the rings so they can be placed in the same location and sequence during bonding.

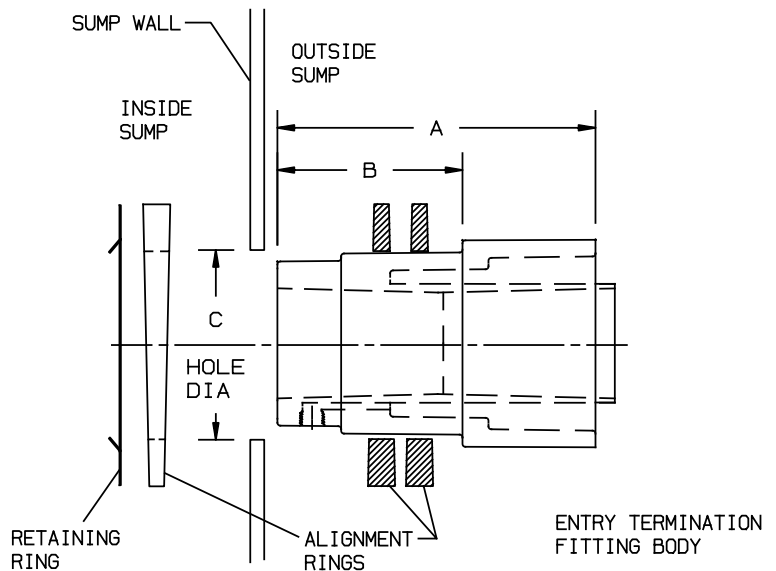


System	3x2 Part No.	4x3 Part No.
Red Thread IIA or Dualoy 3000/L	012030-626-0	012040-626-0
Dualoy 3000/LCX*	22856830	33856830

* Includes Closure Nipple

Size	A	B	C
Inch	Inch	Inch	Inch
3 x 2	6.88	4.00	4.00
4 x 3	6.88	4.00	5.00

NOTE: These fittings can only be bonded to flat walled, fiberglass sumps. **DO NOT** install on thermoplastic or round sumps.



5. Place the remaining ring over the sump entry fitting in the inside of the sump and rotate to the desired angle. Make alignment mark on both the sump wall and the ring when at the desired angle to make the "free" surface of the ring as close to perpendicular (square) to the axis of the fitting as possible.
6. Mix one 8 oz. PSX-34 or one 8069 adhesive for each fitting per the instructions in the adhesive kit. Filler should be used with 8069 to insure proper sealing of alignment rings.
7. Apply adhesive generously, approximately $\frac{1}{16}$ inch thick, to the inside and the outside of the sump walls where the alignment rings are located. Coat the edges of the hole cut in the sump wall. 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 holding the fitting in place from the outside of the sump.
9. Slide the metal retaining ring over the inside section of the sump entry fitting and against the inner alignment ring until all the rings are tight against both sides of the sump wall. (A short section of 4 inch 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 sump entry fitting against the outside sump wall while pressing the metal ring against the alignment ring on the inside. Clean excess adhesive from all bonding surfaces.
10. Do not disturb assembly until the adhesive is cured. This includes bonding of pipe to the sump entry fitting and installing the threaded outlet fitting. 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 $\frac{1}{4}$ inch plastic threaded outlet protector. **Apply adhesive only** to the $\frac{1}{4}$ inch fitting and screw into the $\frac{1}{4}$ inch threaded outlet. Tighten to 40 in.-lbs. or $1\frac{1}{2}$ -2 turns past hand tight.

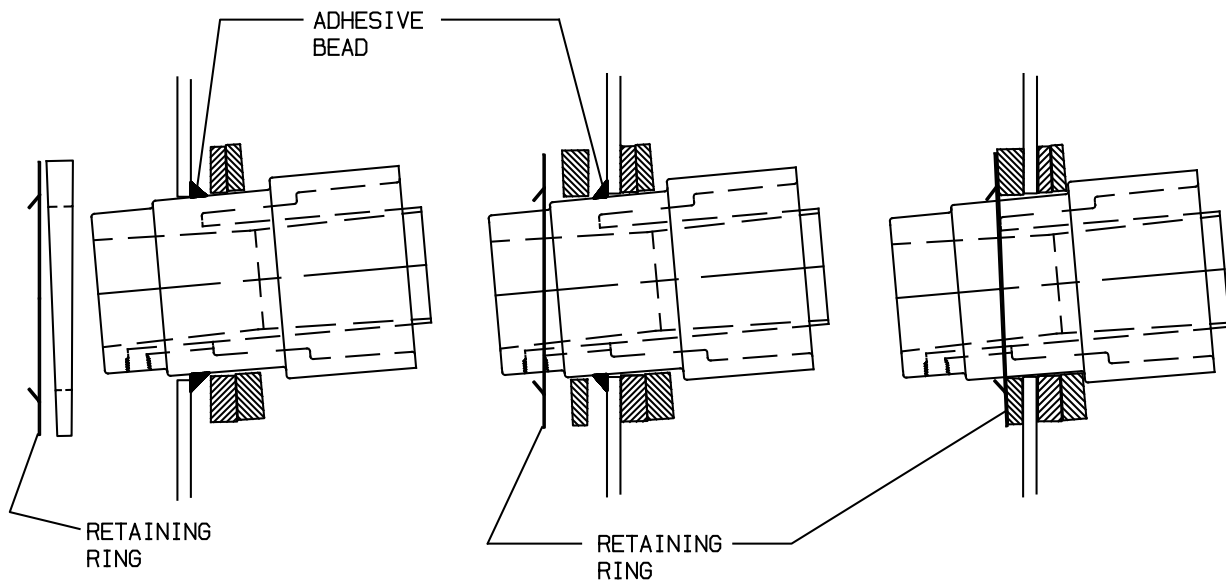
NOTE: *Over-tightening the tapered threads of the fitting may damage the fitting body. DO NOT OVER-TIGHTEN.*

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.

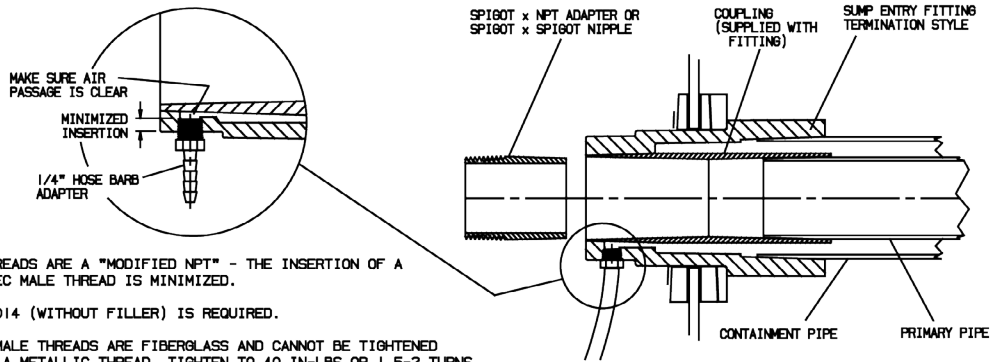
NOTE: *Verify with testing company or monitoring manufacturer if a larger thread is needed for their equipment. After the port fitting is installed, do not remove.*
13. Connect only flexible tubing or hoses to the port fitting.

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

Drawings below show the assembly of the fitting and associated pipe when using either size-over-size containment systems or coaxial pipe.

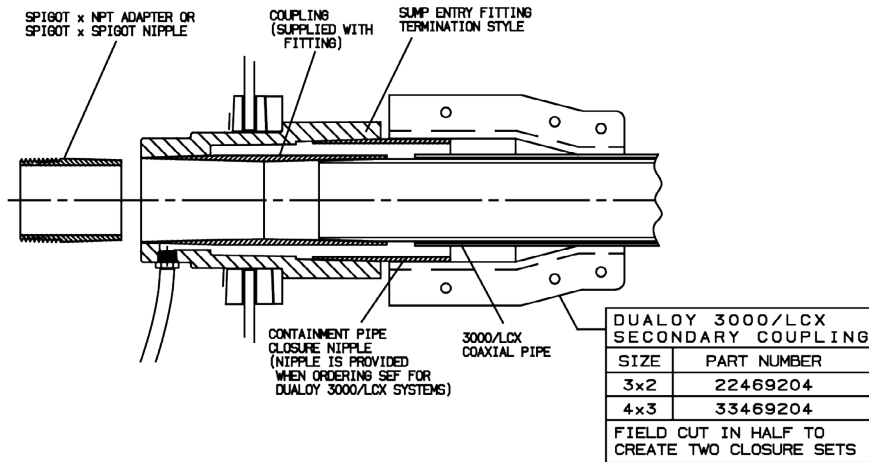


**SUMP ENTRY FITTING - TERMINATION STYLE
EXAMPLE FOR PIPE OVER PIPE, RTIIA OR DUALOY 3000/L**



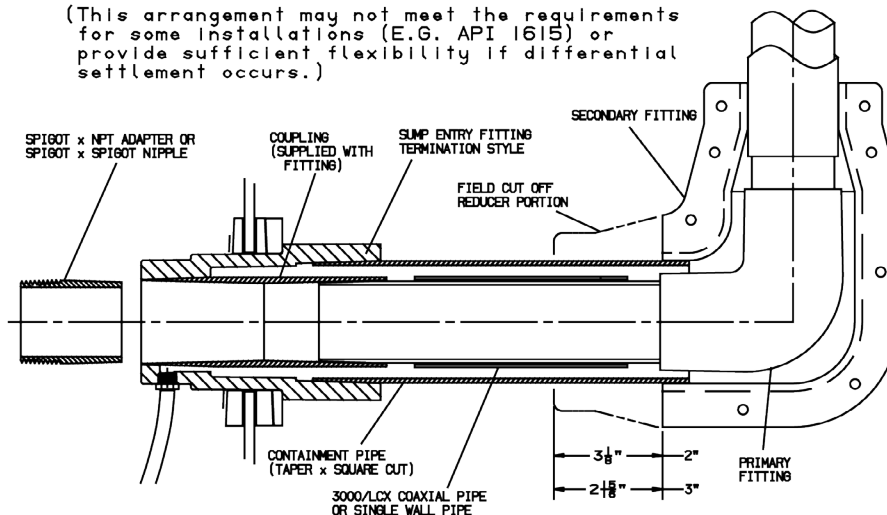
- THE 1/4" THREADS ARE A "MODIFIED NPT" - THE INSERTION OF A STANDARD SPEC MALE THREAD IS MINIMIZED.
- PSX-20 OR 8014 (WITHOUT FILLER) IS REQUIRED.
- THE 1/4" FEMALE THREADS ARE FIBERGLASS AND CANNOT BE TIGHTENED THE SAME AS A METALLIC THREAD. TIGHTEN TO 40 IN-LBS OR 1.5-2 TURNS
- AFTER INSTALLING A 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.

**SUMP ENTRY FITTING - TERMINATION STYLE
EXAMPLE FOR DUALOY 3000/LCX COAXIAL PIPE**



**SUMP ENTRY FITTING - TERMINATION STYLE
EXAMPLE FOR CLOSE PROXIMITY FITTING**

(This arrangement may not meet the requirements for some installations (E.G. API 1615) or provide sufficient flexibility if differential settlement occurs.)





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