



READ COMPLETELY BEFORE ATTEMPTING INSTALLATION*

THESE INSTRUCTIONS ARE APPLICABLE WHEN 8900 SERIES ZINC OR BRASS HEAD FLOAT GAUGES ARE INSTALLED IN FORGED STEEL, THREADED WELD ADAPTERS. THESE FLOAT GAUGES ARE INTENDED FOR USE WITH 1"-11 ½ NPTF ADAPTERS OR 1"-11 ½ NPT ADAPTERS.

BOTH ZINC AND BRASS HEADS FOR 8900 SERIES FLOAT GAUGE ARE SUPPLIED WITH 1"-11 ½ NPTF THREADS. THE THREADS ARE MADE WITH SPECIAL PITCH DIAMETER TOLERANCE OF "FLUSH TO ½ TURN LARGE OR ½ TURN SMALL".

IF NOT COATED WITH THREAD COMPOUND, THE THREAD PITCH DIAMETER ON FLOAT GAUGE HEAD MAY BE GAGED WITH EITHER 1"-11 ½ NPTF L1 RING GAGE OR 1"-11 ½ NPT L1 RING GAGE.

1. INSPECT ADAPTER THREAD PITCH DIAMETER WITH 1"-11 ½ NPTF L1 BASIC NOTCH PLUG GAGE OR 1"-11 ½ NPT BASIC NOTCH PLUG GAGE. TYPICAL COMMERCIAL TOLERANCE IS "FLUSH WITH NOTCH TO ONE TURN LARGE OR ONE TURN SMALL".

2. IF ADAPTER THREADS ARE CORRECT, THEY MAY BE WELDED INTO THE TANK. HOWEVER, STEPS SHOULD BE TAKEN TO MINIMIZE THREAD DISTORTION DUE TO HEAT AND TO SHIELD THREADS FROM WELD SPATTER.

3. AFTER WELDING, REINSPECT ADAPTERS AS DESCRIBED IN STEP ONE. IF THREADS ARE CORRECT AFTER WELDING, PROCEED TO STEP SIX. IF THREADS ARE NO LONGER CORRECT, GO TO STEP FOUR.

4. UNDERSIZE, DISTORTED OR WELD SPATTERED ADAPTER THREADS MUST BE RE-TAPPED WITH 1"-11 ½ NPTF OR 1"-11 ½ NPT TAP USING THREAD CUTTING OIL. BE CAREFUL NOT TO TAP THREADS TOO DEEP. AFTER TAPPING, CLEAN ADAPTER THREADS OF METAL CHIPS AND EXCESS OIL.

5. REINSPECT ADAPTER THREADS AS DESCRIBED IN STEP ONE. IF THREADS ARE CORRECT, GO TO STEP SIX. IF THREADS ARE STILL UNDERSIZE, GO BACK TO STEP FOUR.

6. IF NOT ALREADY COATED WITH EVERSEAL, APPLY THREAD COMPOUND AND OR LUBRICANT TO THREADS OF FLOAT GAUGE HEAD. IT IS PERMISSIBLE TO APPLY VEGETABLE OIL OVER EVERSEAL.

7. INSTALL FLOAT GAUGE THROUGH ADAPTER AND SCREW IN AT LOW ROTATIONAL SPEED TO PREVENT FLOAT ARM DAMAGE. TORQUE GAUGE HEAD TO 100 FOOT-POUNDS. IF SPECIAL DIAL ORIENTATION IS NECESSARY, TORQUE HEAD TO 100 FOOT-POUND AND THEN CONTINUE TO ROTATE HEAD UNTIL THE DESIRED DIAL ORIENTATION IS OBTAINED.

THREAD ENGAGEMENT ON FLOAT GAUGE HEAD SHOULD BE BETWEEN FIVE AND SEVEN TURNS WITH ONE TO FOUR THREADS VISIBLE AFTER INSTALLATION.

SEE MS-516 FOR ADDITIONAL INFORMATION

* Materials and specifications are subject to change without notice.
Pressure ratings subject to change due to temperature and other environmental considerations.

