

# T4S-

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## Installation Instructions

### 4 Stud Penetration Fitting - Traditional Style - Single Sided



Diversified Products  
Manufacturing Inc.



Weaver Products

**Prepare all Surfaces:** All surfaces to be bonded should be prepared prior to completing the installation steps below.  
**Warning:** Failure to follow each step will void the warranty and may result in premature failure of the penetration fitting. Adhere to the following general instructions for each step of the installation.  
**Bonding to Poly & FRP surfaces:** Clean and sand (rough up) sump surfaces with CH-DBC II. Remove all gel coat on all fiberglass surfaces. Apply CH-DBB V to all surfaces to be bonded both the fitting and sump wall.  
**Cleaning:** Spray all surfaces to be bonded with CH-DBC II Cleaner and allow to air dry. Excess cleaner may be wiped off with a clean dry cloth.

#### Step 1

**Sump Preparation:** Where possible run pipe so as to penetrate the sump perpendicular to the sump surface. Drill the center hole according to the chart. Sand around the hole 2 1/2" on all sides to be bonded.

Hole Saw 2 1/4"

Minimum Spacing  
between Centers  
4.75"



#### Step 2

**Mark Sump for Drilling Stud Holes:** Center and clamp front plate to sump wall. Mark hole positions and drill with 5/16" drill. On round sumps make sure you drill perpendicular to the sump wall. **Warning make sure the correct fitting is on the outside of the sump.**



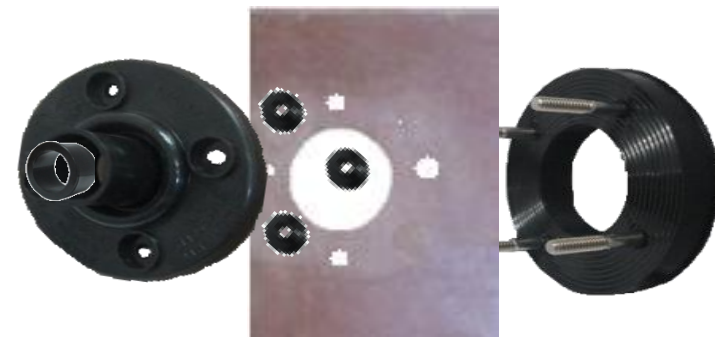
#### Step 3

**Dry fit the fittings:** Dry fit. If you have trouble fitting them together, recheck the holes. You may need to clean the holes with the drill. Studs must fit freely through the holes.



#### Step 4

**Clean & Bond:** Spray all surfaces to be bonded with CH-DBC II Cleaner. Wipe dry or air dry. Install Stud seals around studs prior to installing the boot. Apply CH-DBB V Bonder to the fitting surface that creates a seal with the sump wall. When installing there should be enough bonder so that a small bead escapes the perimeter of the fitting when the nuts are tightened to the fitting. If no bonder is present remove fitting and apply again.



#### Step 5

**Tighten Stud Nuts and Install Pipe and Tighten Band Clamps:** Tighten stud nuts to 75 in-lb. Allow fitting to cure for 1/2 hour then install pipe. Pipe should be run perpendicular to the sump wall. Do not exceed 15 deg off angle. Once the pipe is installed and connected, tighten the band clamp. Do not exceed 60 in-lb.



#### Tools Required

2 1/4" hole saw  
5/16 nut driver for band clamps  
7/16 deep socket for flange nuts  
CH-DAG III applicator gun for CH-DBB V bonder

#### Products Needed

CH-DBC II - Cleaner .1 Cans per penetration fitting  
CH-DBB V - Methylmethacrylate Bonder - 13 ml per fitting