

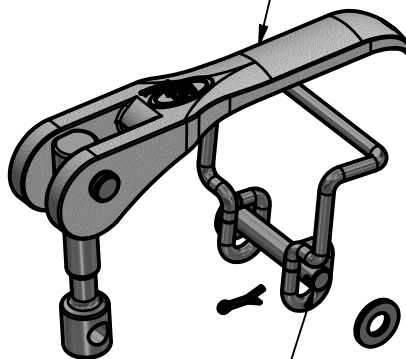
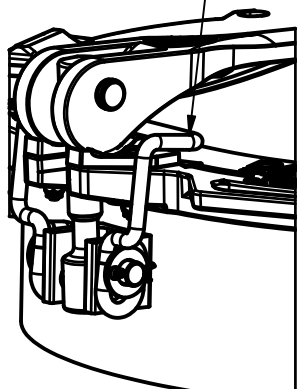
2



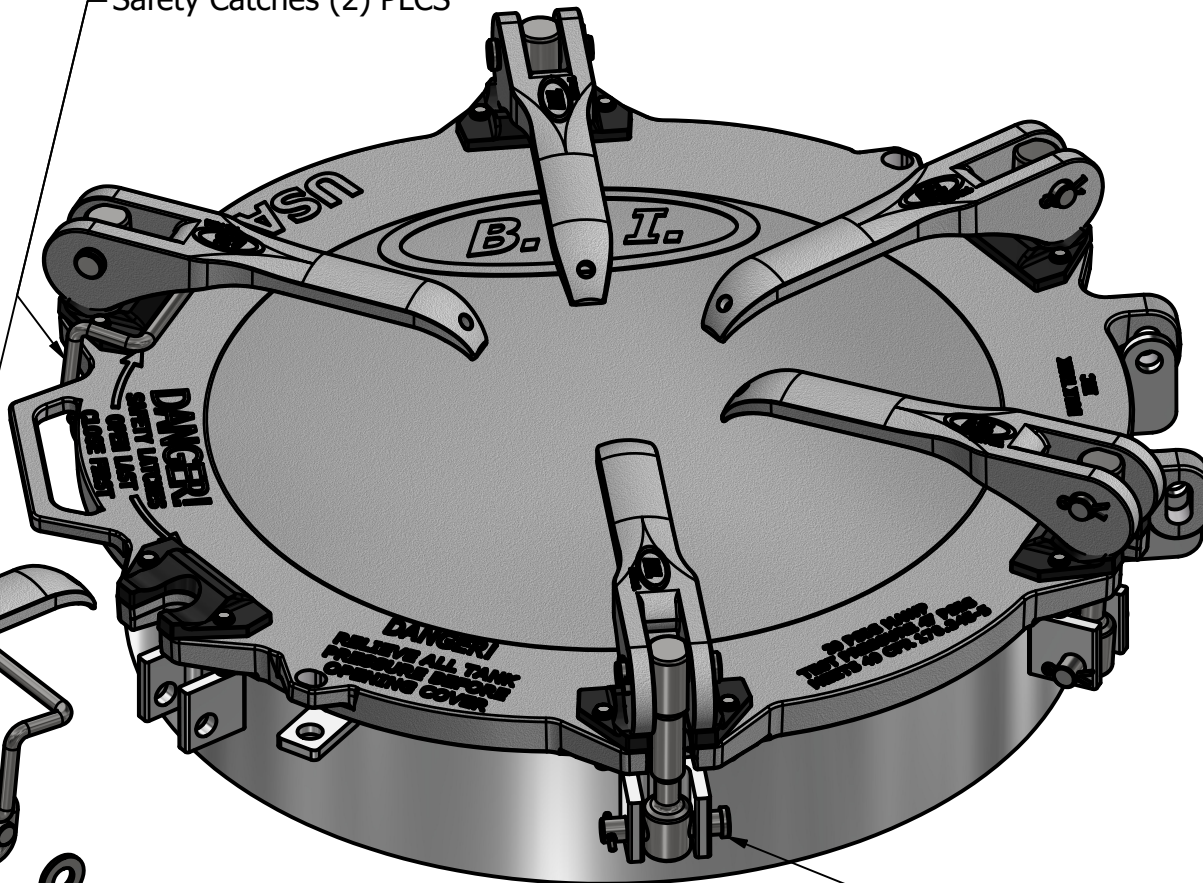
1

Safety Catch
In Front of
Cam Latch

Safety Catches (2) PLCS



3" Clevis Pin (2)



2" Clevis Pin (4)

DANGER!
DO NOT
OPERATE
UNTIL
SAFE

DANGER!
RELIEVE ALL TANK
PRESSURE BEFORE
OPENING COVER

DANGER!
DO NOT WALK
ON COVER UNTIL
IT IS OPEN

USA
B. T. I.

SEE REVERSE FOR WELDING INSTRUCTIONS

CONFIDENTIAL
PROPERTY OF BULK TANK INC.
400 PARKWAY DRIVE
PARK HILLS, MO 63601

ALL DIMENSIONS ARE
IN INCHES UNLESS
OTHERWISE NOTED
TOLERANCES
.XXX± .010
ANGLE± 2°
DIMENSIONING PER
ASME Y14.5M-1994

BULK TANK, INC.
400 PARKWAY DRIVE
PARK HILLS, MO 63601



DESCRIPTION
Manhole Assembly Instructions

PART NO. N/A	MATL.
DRAWN BY T. Kinneman ENGINEER P. Kemp	SCALE SHEET 1 of 2 DATE 7/7/2020

2



1

B

B

A

A



BULK TANK, INC.



BTI Never Seize Manhole Assembly Weld Ring Installation

1. Place the weld ring in the hole in the tank shell. Ensure the hole in the tank shell has been cleaned and deburred. Position the manhole in a manner that will allow for proper function taking note of the desired orientation and height. Tack weld the ring in place with 4 to 6 welds spaced equally around the ring.
2. Intermittent weld segments should be utilized as not to overheat and warp the weld ring. 6 to 8 segments moving from one side of the ring directly across to the opposite side is recommended to reduce heat buildup. Grinding stops and starts is recommended.
3. Allow the ring to fully cool before welding additional segments
4. Continue with the intermittent weld segments as stated in step #2 for the remaining surfaces. Staggering weld segments from one side of the ring to the other and allowing sufficient time for the ring to cool between segments is critical. Grinding stops and starts is recommended.

THE WELD RING MUST BE FLAT WITHIN 1/16" AND ROUNDNESS MAINTAINED WITHIN +/- 1/16". FAILURE TO MAINTAIN THIS TOLERANCE MAY AFFECT THE PERFORMANCE AND PRESSURE RATING OF THE MANHOLE ASSEMBLY.

DOC-BTI-8.5-131
NEW DATE: 3/9/21

