

APPENDIX RA-10

SIGHT GAGES - CLOSED CIRCUIT

SGC SERIES INSTALLATION INSTRUCTIONS

Access to inside of reservoir is required

Existing Reservoir Applications

1. When modifications to the reservoir walls are required, a complete draining of the reservoir is recommended to facilitate removal of possible debris within the tank after modifications are made. At a minimum, draining to a fluid level below the lower mounting hole of the sight gage is required for installation of the SGC sight gage.

New or Existing Reservoir Applications

2. When the reservoir wall thickness is thin, drill two .66 inch (16.8 mm) diameter holes through the reservoir wall corresponding to the centerline of the sight gage -OR- when reservoir wall thickness permits, drill and tap reservoir wall to mate with 5/8-27UNS thread (studs) and centerline of gage. The acceptable tolerance between drilled mounting holes is [$\pm .03$ inch (± 0.8 mm)]
3. Remove burrs from holes to provide good sealing surfaces.
4. Remove bulkhead adapters from sight gage.
5. Remove locknuts from bulkhead adapters and insert bulkhead adapters through mounting holes with flat gasket contacting exterior wall of reservoir. Secure each adapter with a locknut [torque to 80 in-lb (9.04 N-m)]. Prevent bulkhead adapters from rotating while the locknuts are being tightened by holding the head of the adapter with a wrench.
6. Verify o-rings are set properly in recess provided on backside of the sight gage body and under the head of the mounting bolts.
7. Install gage by first tightening the mounting bolts by hand until secure.
8. Then using a torque wrench, uniformly tighten mounting bolts to 60 in-lbs (6.78 N-m).

NOTE: The tank seal is designed to space the gage body away from the heads of the adapters leaving the o-rings visible after assembly. Excessive assembly torque may cause the tank seal to fail prematurely.