



Installation Guidelines for 9' Water Tank

The plug for the water tank should be installed on site once the tank has been placed in the exact location that it will be used. It is not recommended to install the plug and then move the tank. This could break the seal between the plug and tank and create leaks.

Materials

Windshield Urethane Adhesive, Methyl Hydrate, Adhesive Primer, Medium sandpaper/sander, $\frac{3}{4}$ " Gravel, (12) $\frac{3}{8}$ " x $1\frac{1}{2}$ " Lag bolts, drill



Step 1. TANK PLACEMENT

Set the water tank in the desired location. Fill the inner hole of the water tank with $\frac{3}{4}$ " gravel up to 3" below the top of the inner hole. DO NOT OVERFILL THE HOLE OR PACK THE GRAVEL.



Step 2. DRILL the HOLES.

Set the plug inside the 9' water tank, keeping in centered in the hole. Measure and mark the locations for the holes to be drilled. Holes should about 15" apart and 2" from the inside edge of tank. Before you start to drill, mark both tank and plug to make it easy to remove and replace the plug to the exact same position. Use a ¼" bit to drill for the lag bolts through the polyethylene plug and into the centre bead of the tank.

Step 3. CLEAN AND PREP SURFACES



Wipe down the surface of the inner bead on the tank with Methyl Hydrate twice to make it as clean as possible. Sand the underside of the plug where it will meet the tank and the urethane adhesive. After sanding, wipe the plug clean then apply a 2" strip of the adhesive primer all around the plug in the area where it will sit on the adhesive. Apply 2 coats of primer about 20 minutes apart. Allow 20 minutes to dry apply final coat.

Step 4. SCREW LAG BOLTS INTO PLUG

With the plug standing on its edge, screw the lag bolts into each pre-drilled hole just far enough so that they protrude on the underside of the plug about ¼". Keep the primed underside of the plug as clean as possible.



Step 5. APPLY THE URETHANE ADHESIVE TO THE TANK

Apply a single continuous bead of the adhesive to the tank, **between the pre-drilled holes and the inner bead of the tank.... about 1" from the inner bead.** Make sure to cut the nozzle on the adhesive tube into a "V" to ensure best results. (Note: preheat the tube(s) of adhesive for 6 – 8 minutes by setting them on your vehicle dashboard and run the defrost on high. The adhesive will be easier to apply)

Step 6. SET THE PLUG IN PLACE

Using two people, carefully lift and set the plug into position on the tank inner bead. Use the marks you made on the tank and plug to ensure the holes in the plug line up perfectly with the holes in tank inner bead.

Step 7. TIGHTEN THE LAGS BOLTS

Using the same tightening method as for a wheel on your vehicle, tighten all of the lag bolts down into the inner bead of the tire.

Step 8. FILL THE TANK

Immediately after the plug has been installed, **fill only the plug portion** of the tank first and let it sit for several hours. The weight of the water in the plug will help create the best seal possible. After several hours, the rest of the tank may be filled.



For questions about installation of the plugs into National Tire Water Tanks contact;

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