

# Red Thread™ IIA Riser Pipe Assembly Instructions

For Red Thread™ IIA Riser Pipe



## General

Installing the UL-971 Listed Red Thread IIA Riser Pipe assembly follows the same guidelines as standard pipe (INS1280 - Fuel Handling Installation Manual) with important considerations detailed below.

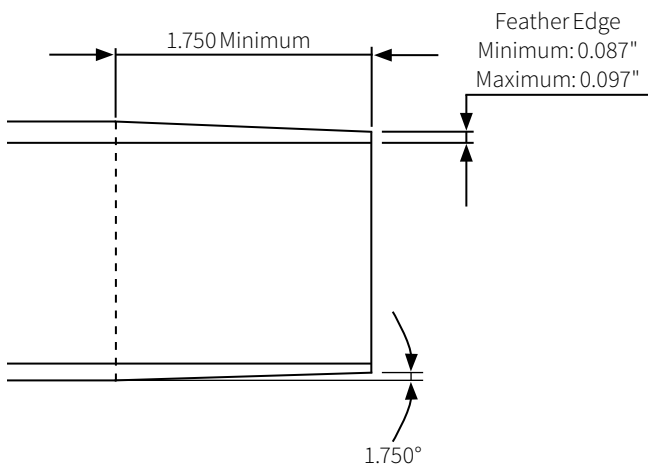
### Special Considerations

#### Adjust the 4" Mandrel on the 2102 Box Tool

- Rotate the mandrel reference mark away from the cross mark at the center of the tool. Refer to TLS2000 Series Power Tools instructions.
- Re-tighten the Allen head bolt.

The minimum feather edge thickness is 0.087" with a maximum allowed feather edge thickness of 0.097". It is recommended tapering less, readjusting and taper more until desired feather edge.

Once tapered, dry fit the tapered pipe into the adapter and check insertion to verify that the taper has been made properly. See Average Taper Dry-Insertion Length table for more information.



### Average Taper Dry-Insertion Length

Pipe Size		Average Taper Dry-Insertion Length	
in	mm	in	mm
4	100	2" - 2 3/4"	50-70



Red Thread IIA Riser Pipe Assembly

### Dry Fit Complete Assembly

Once tapers have been applied and checked for proper insertion depth, dry fit the entire assembly and thread onto tank top fitting to measure the overall height of the assembly.

### Check the Adapter ID After Bonding

Immediately check ID after adhesive joints are made up to make sure adhesive overflow does not obstruct the ID clearance. In the event of overflow wipe away excess adhesive. This must be done before the adhesive cures and before installation on the tank top.

### Minimum Torque

Minimum torque is 1.5 turns past hand tight (approximately 100 ft.-lbs).

### Maximum Torque

Maximum torque of 500 ft.-lbs. when installing Red Thread IIA Riser Pipe.

### Adhesive Kits

Kit No.	Label Color	Mixed Qty. (oz)	# of Bonds per Kit
8014	Green	6.5	7
8024	Yellow	2.7	3
PSX-20	Red	3.0	3
PSX-20	Purple	5.0	5
PSX-20	Yellow	8.0	9

**IMPORTANT:** If the Spill Container has a Gravel Guard, insert the tapered end of the Riser Pipe through the Gravel Guard before making up the adhesive joint on the Adapter that threads into the Spill Container. If the Riser Pipe does not fit through the Gravel Guard, exclude the Gravel Guard from the installation or use an appropriate tool to increase the ID of the Gravel Guard to fit. Do not lubricate the OD of the Red Thread IIA Riser Pipe to fit through Gravel Guard.

#### Order of operations for installing Riser Pipe assembly



1. Adjust mandrel on Taper Tool.



2. Taper riser pipe. Verify taper and re-taper if necessary (see Average Taper Dry-Insertion Length table).



3. Verify overall length of assembly by dry-fitting on tank top. Prep joint surfaces.



4. Mix adhesive.



5. Apply thin layer of adhesive (see Adhesive Kits table).



6. Check ID of joint for adhesive overflow, wipe away excess.



7. Apply thread dope to adapter threads.



8. Thread Riser Pipe assembly into tank top fitting.

National Oilwell Varco has produced this brochure for general information only, and it is not intended for design purposes. Although every effort has been made to maintain the accuracy and reliability of its contents, National Oilwell Varco in no way assumes responsibility for liability for any loss, damage or injury resulting from the use of information and data herein nor is any warranty expressed or implied. Always cross-reference the bulletin date with the most current version listed at the web site noted in this literature.

#### Fiber Glass Systems

17115 San Pedro Avenue, Ste 200  
San Antonio, Texas 78232 USA  
Phone: 210 477 7500  
Fax: 210 477 7560



© 2019 National Oilwell Varco All Rights Reserved  
INS1287ENG June 2019