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Window Kit Installation Instructions

Supply List of Items Provided

- Polycarbonate window
- 2 rolls of gray butyl window tape
- 60 bolts with neoprene washers and finishing washers
- 60 flat washers
- 60 nylon locking nuts

Supply List of Items NOT Provided

- Silicone caulking
- Phillips head screw driver
- 5/32" drill bit and drill
- Vice grips
- Grinder or file
- Circular saw (only needed if window has not previously been cut)

If your tank does not already have a window, follow these instructions first:

Position of the Hole

- 36" from the inside plastic step toward front of tank to the left side of the window
- 7" up from the bottom of the tank

Size of Hole Needed in Tank

- 44" wide by 32" tall
- Using a precut pattern makes this easier—draw it out on paper or cardboard and trace on the tank

Preparation of the Tank

Lay the tank down on its side (drainage plug on top) to measure, mark and cut the hole. To cut the hole in the tank, use a circular saw, being careful not to cut the hole too large. File off any sharp edges.

If you are replacing an existing window in your tank, begin with these instructions:

Remove Old Window

Back out old window bolts.



This is a two person job (one person on the inside and one outside). The person on the outside pushes the window inward, while the inside person carefully cuts through the old grey butyl tape with a utility knife.



Window Tape

If the old butyl rubber is relatively clean, free of debris, and still pliable, it can be smoothed down and reused. Simply add more butyl rubber to fill any gaps. Otherwise, using the rolls of gray butyl tape provided, apply one strip approximately $\frac{1}{4}$ " from the hole all the way around the window. Then apply a second strip immediately to the outside of the first strip.



Positioning the Window

After the gray butyl tape is in place, from the inside of the tank, carefully position the window, making sure that the window is straight and even before allowing it to touch the butyl rubber, and press firmly onto the tape.



Installation

This is a two person job. One person sits on the outside of the tank; one person sits inside the tank. Using a 5/32" drill bit, the person on the outside of the tank drills a hole through the tank and the window at the top center point, while the person on the inside holds the window securely in place.



From the inside, insert the bolt with neoprene washer and finishing washer (provided) through the hole and hold it in place with a Phillips head screw driver. From the outside of the tank, place the flat washer next to the tank, and then tighten the nylon locking nut (provided).



NOTE: Be sure to tighten the nylon nuts snugly, but not so tight that the bolt breaks. Space each bolt approximately 3" apart, all the way around the window. After the bolts are installed, go back around and re-tighten each bolt so they are all snug and tight.

Finishing

Using a pair of vice grips, break each bolt off. Check for any sharp edges and grind or file these sharp edges off. Using white silicone caulk, seal the edge of the window and tank edge on the outside of the window cut out (optional).

