



TECHNICAL INSTRUCTIONS

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50 Gallon Fuel Tank Installation (18" Diameter)

Models: X4 7700

Purpose: The intent of this technical instruction is to provide guidelines for installing 50-gallon 18" diameter sumpless fuel tank with lift pump located inside the TRU.

Required Parts

Quantity	Part Number	Part Description
1	65-01104-05	Tank, Fuel
1	76-00988-10	Kit, Installation
1	79-00916-08	Kit, Tank Strap
1	Loctite 577	Sealant, Thread

Required Tools

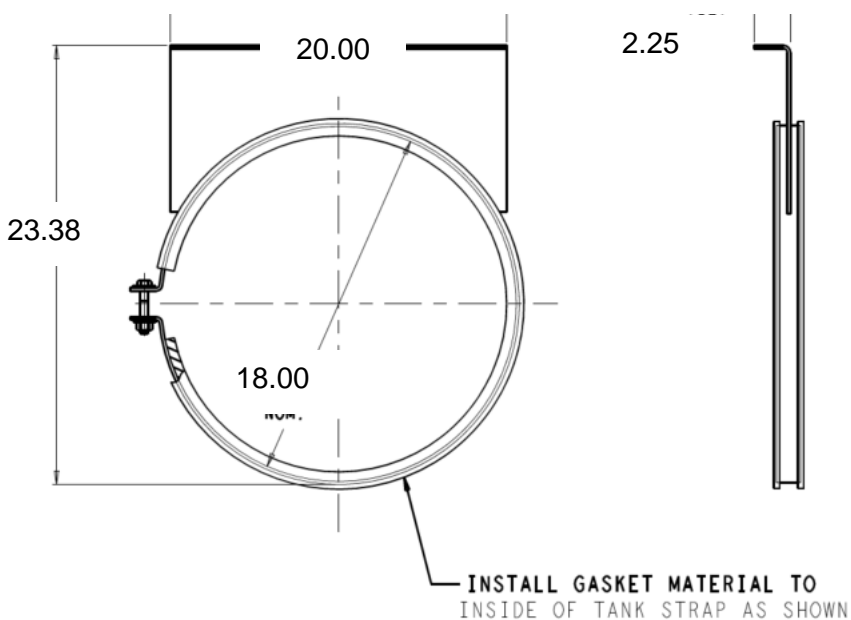
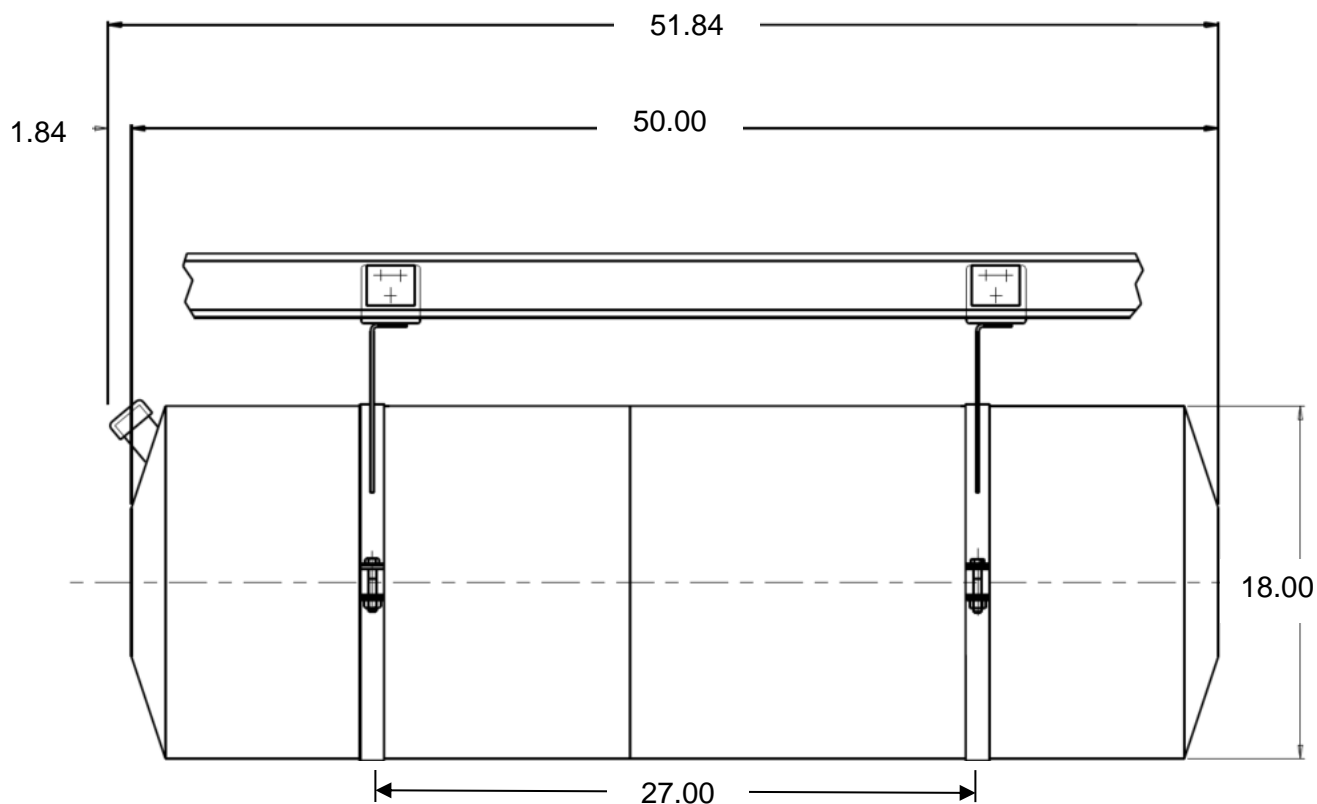
Part Number	Tool Description
Customer Supplied	Drill
Customer Supplied	Bit, Drill 9/16" and 13/32"
Customer Supplied	Cutter, Hose
Customer Supplied	Wrench, Torque (9-60 ft-lb)

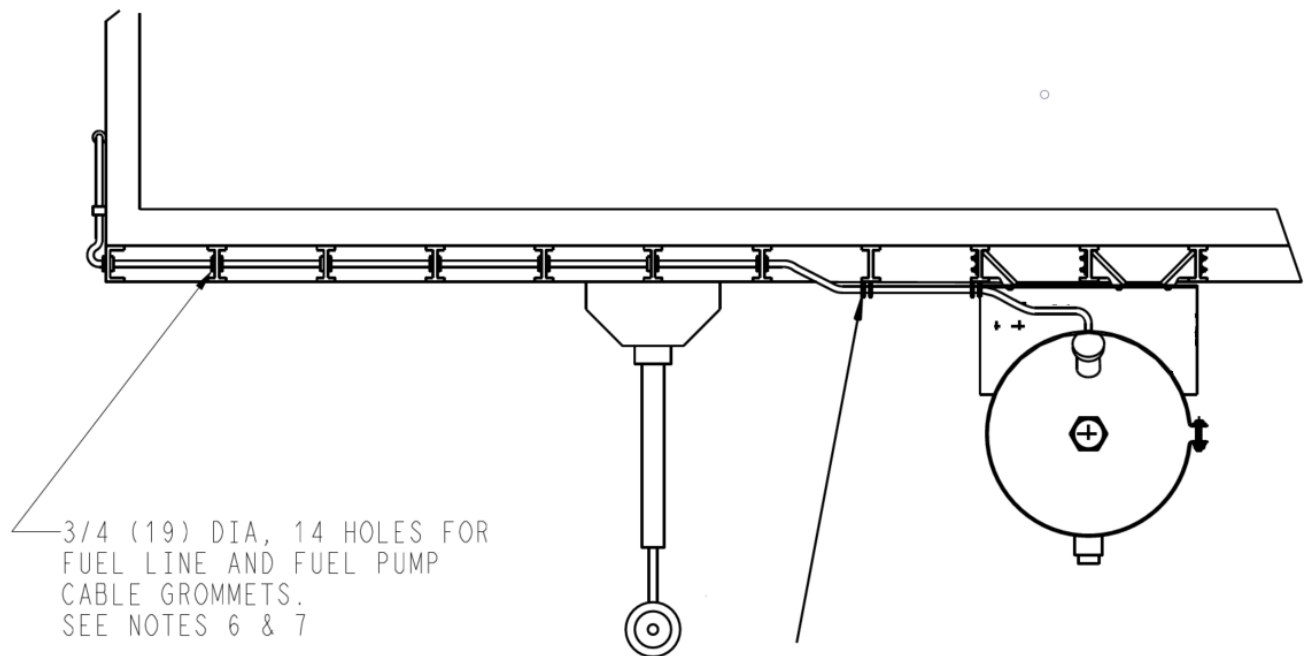
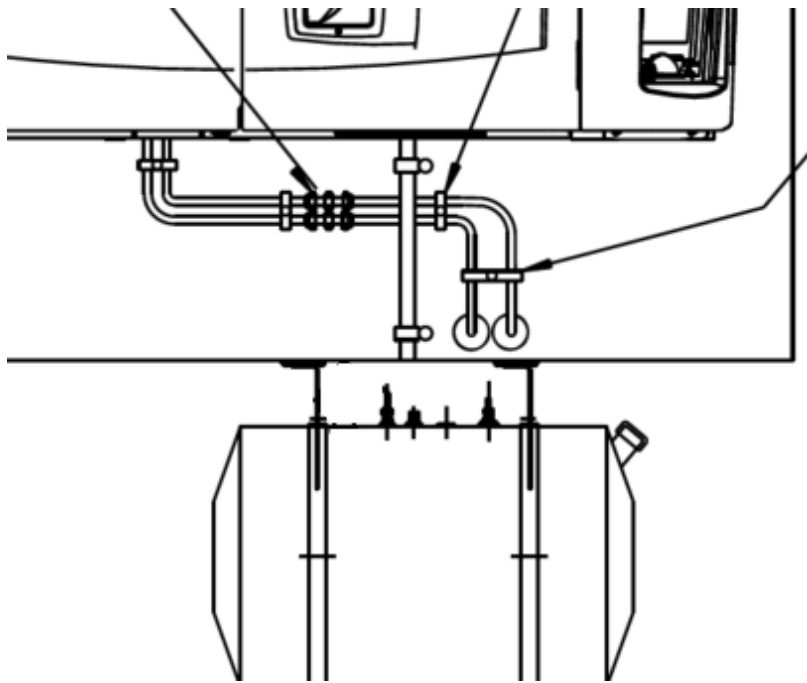
Installation Requirements

Component	Requirement
Fuel Tank Support Straps and Brackets	Must attach to three steel crossmembers.
	Interface with three crossmembers for 12.00" center.
	Structural steel channel required to span between crossmembers if 15.00" center.
	Mylar spacer required between fuel tank hanger bracket and I-beam and between I-beam and backing plate.
	Mylar washers required between nuts and bolts where they contact fuel tank hanger brackets and backing plates.
Threaded Fittings	Apply Loctite 577 to all male NPT threads.
	Use backing wrench when tightening fittings.

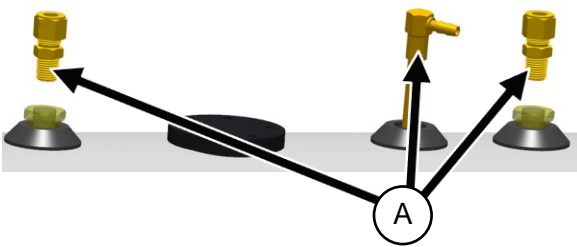
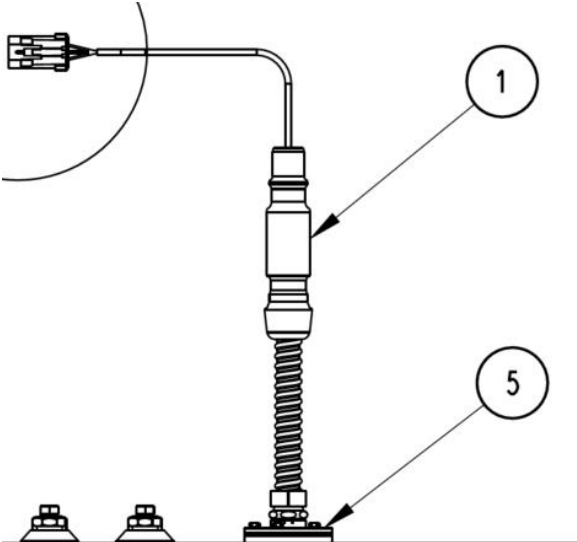
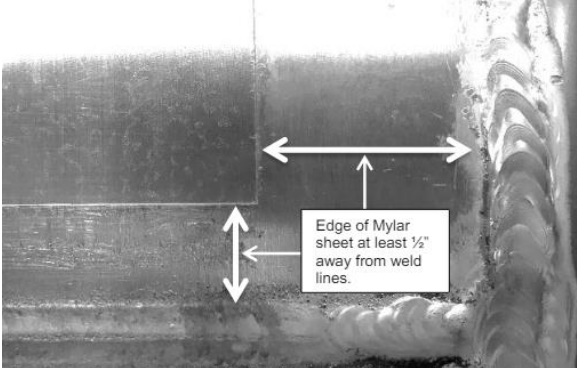
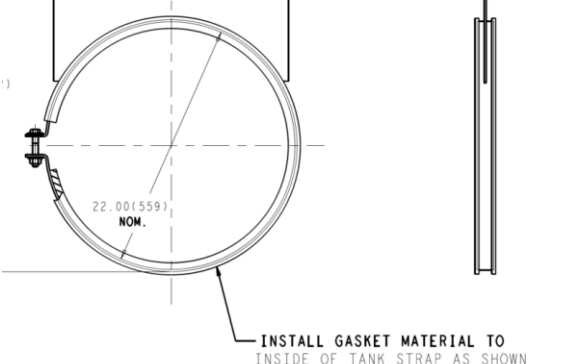
Component	Requirement
Fuel Lines	Routed through grommets when passing through holes in trailer
	¾" conduit may be used for fuel line routing in place of grommets
	Separate supply and return lines from each other where possible
	Apply pipe sealant to all pipe connections.
	Cut fuel lines with fuel line cutter. Cuts must be perpendicular.
	Supply/return lines 1.00" from bottom of tank.
	Avoid sharp bends in the line or rubbing on the trailer frame or tank/brackets.

Fuel Tank and Hanger Strap Reference Dimensions

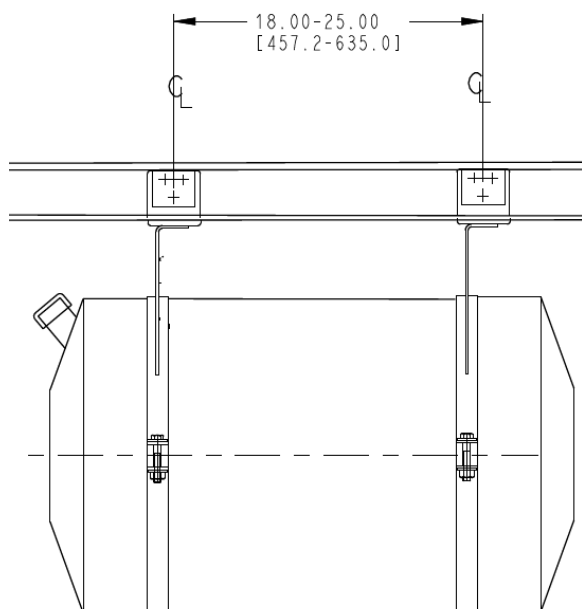




Tank Preparation and Strap Installation

1		<p>Apply thread sealant (A) (Loctite 577) to male threads of fuel line adapters and tank vent fitting.</p> <p>Screw fittings into tank until finger tight and then 1-1/2 to 3 turns with wrench.</p> <p>Align vent fitting so that barb will face rear of trailer when tank is installed.</p>
2		<p>Install fuel level sensor FLS (1) into sensor port on the tank (5).</p> <p>Refer to 98-02678-00 for FLS installation instructions.</p>
3		<p>Clean any dirt and oil from exterior surface of fuel tank.</p> <p>Apply Mylar sheets to fuel tank where tank strap gasket will contact the surface of the tank.</p> <p>Position sheet ends at least 0.5" away from weld seams.</p> <p>Note: Use of decal squeegee is recommended to avoid trapping air pockets during installation.</p> <p>Trim as required ensuring smooth cut edge.</p>
4		<p>Install gaskets to inside of both tank straps.</p> <p>Align ends of gasket with end of tank straps.</p>

5



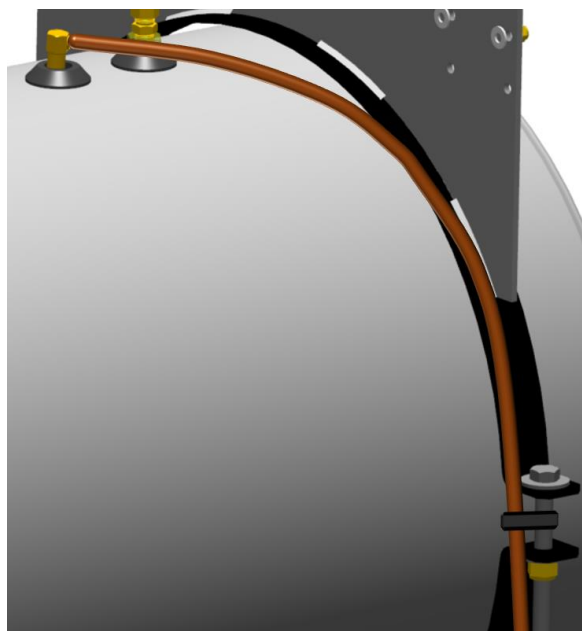
Install the tank brackets on the tank.

Adjust the position of the brackets so that the centerline distance is 18.00-25.00" and the brackets are equally spaced from the ends of the tank.

Rotate brackets so that the mounting flanges are coplanar and the filler neck is vertical when installed on the trailer.

Tighten hardware to 25 ft-lb.

6

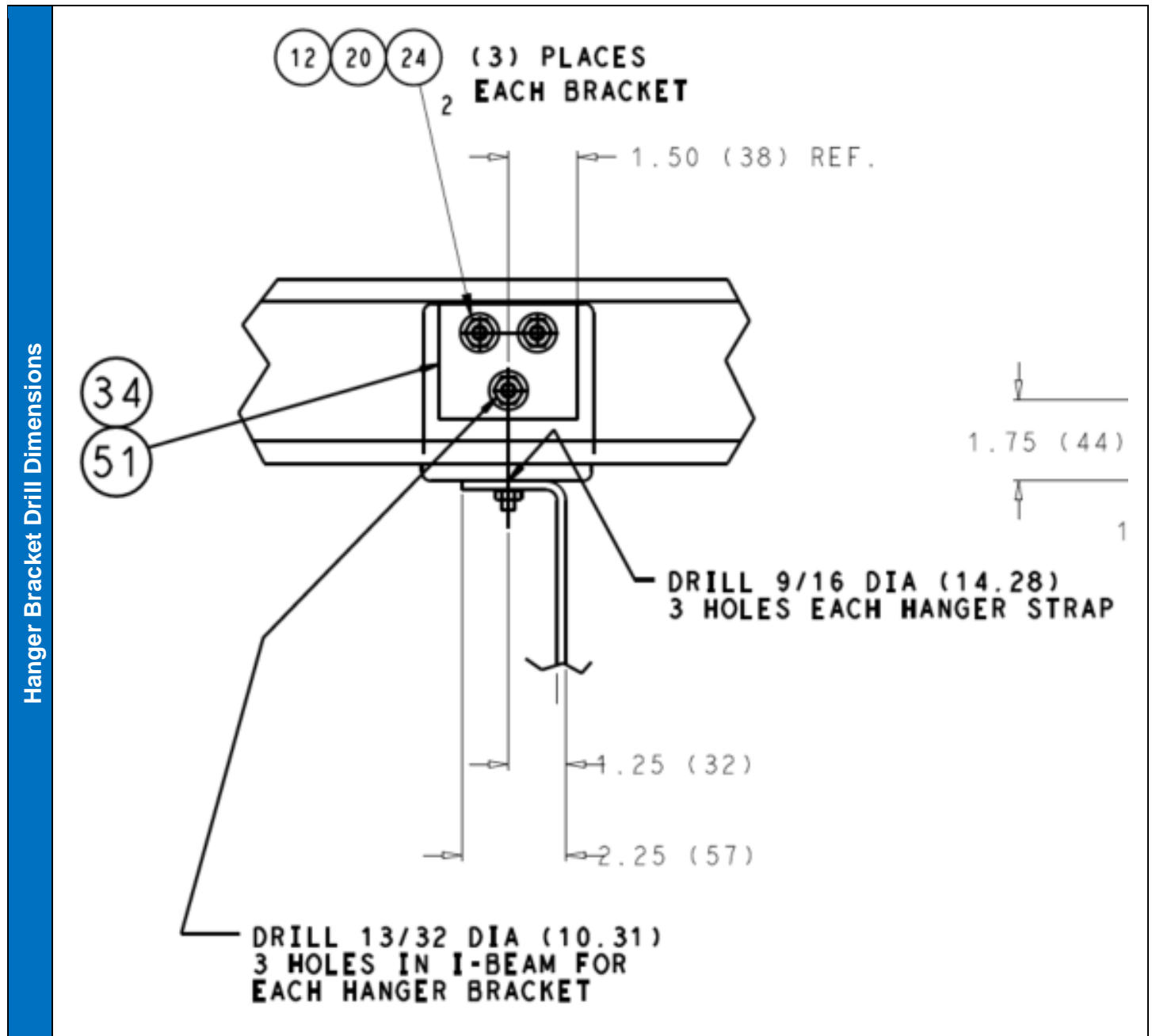


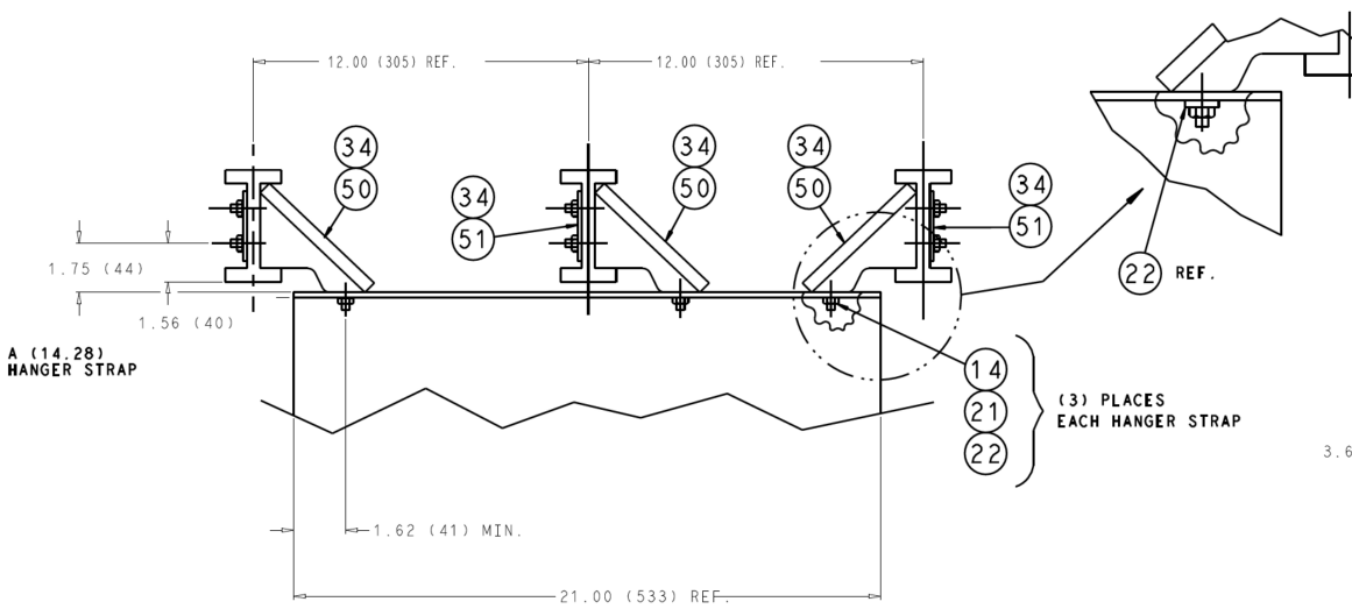
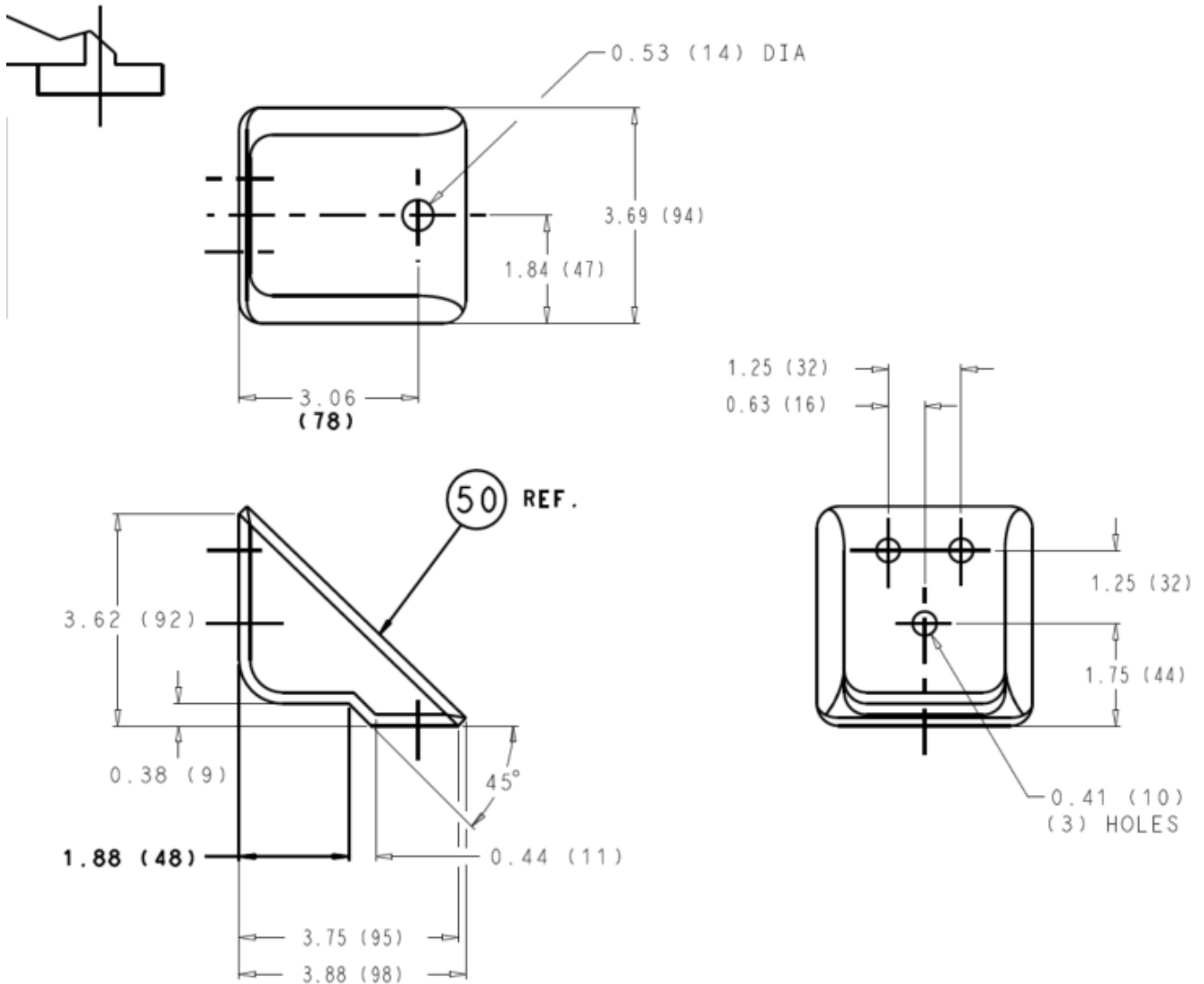
Connect piece of brown fuel line to to tank vent barb.

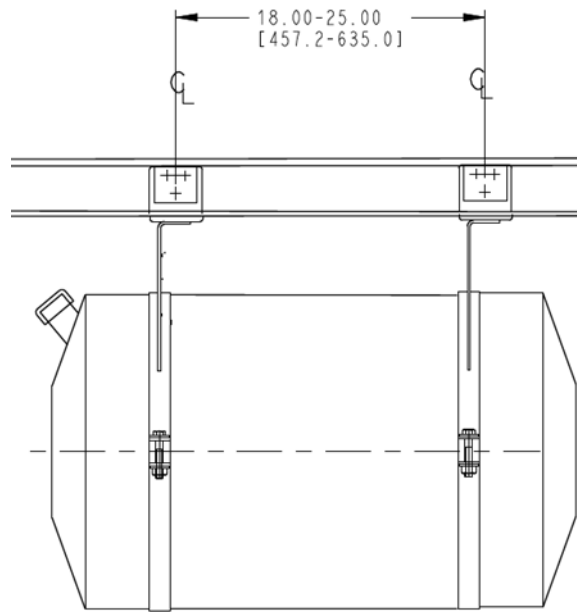
Route hose along tank bracket.

Secure hose to tank strap with cable tie.

Hanger Bracket Installation



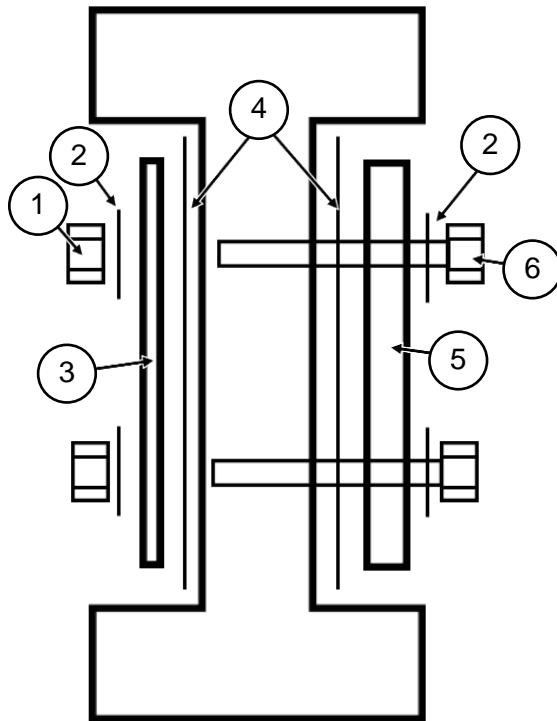




1

Drill holes in I-beam for each hanger bracket. Three brackets are required for each hanger strap.
Refer to hanger bracket details above for drill dimension and spacing.

2



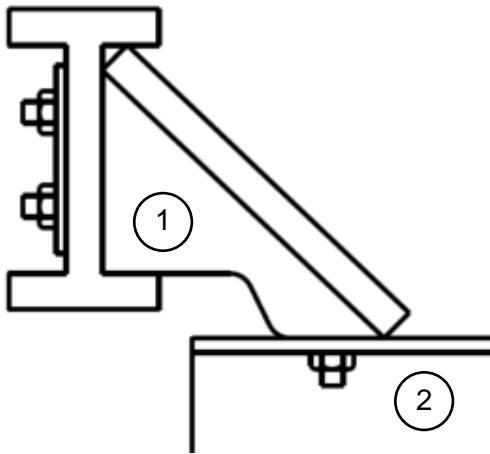
Secure hanger bracket to I-beam with hardware as shown.

1. Nut
2. Mylar washer
3. Backing plate
4. Mylar sheet
5. Hanger bracket
6. Bolt

Note: Hanger bracket partially hidden for clarity.

Tighten hardware to 30 ft-lb.

3



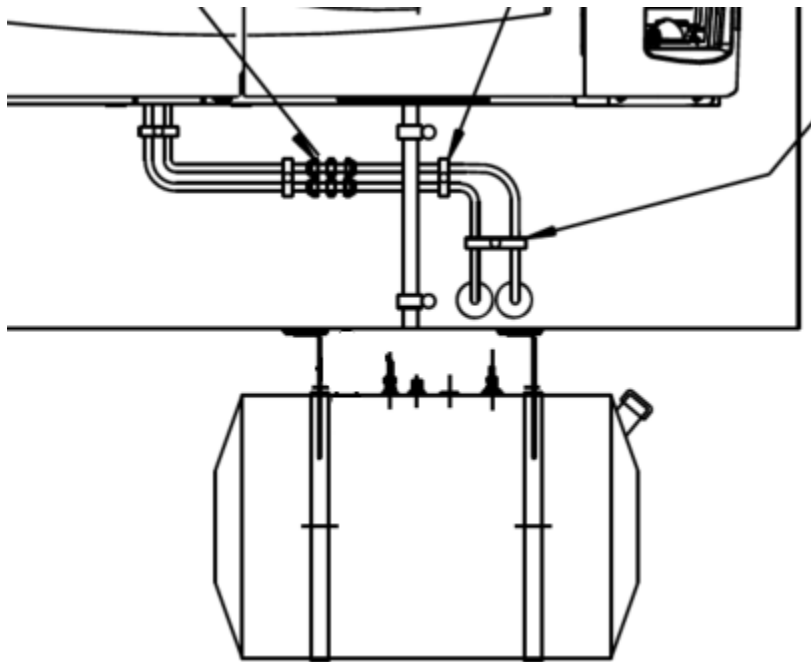
Lift fuel tank/hanger strap assembly into place with appropriate lifting device.

Secure hanger brackets (1) to hanger straps (2).

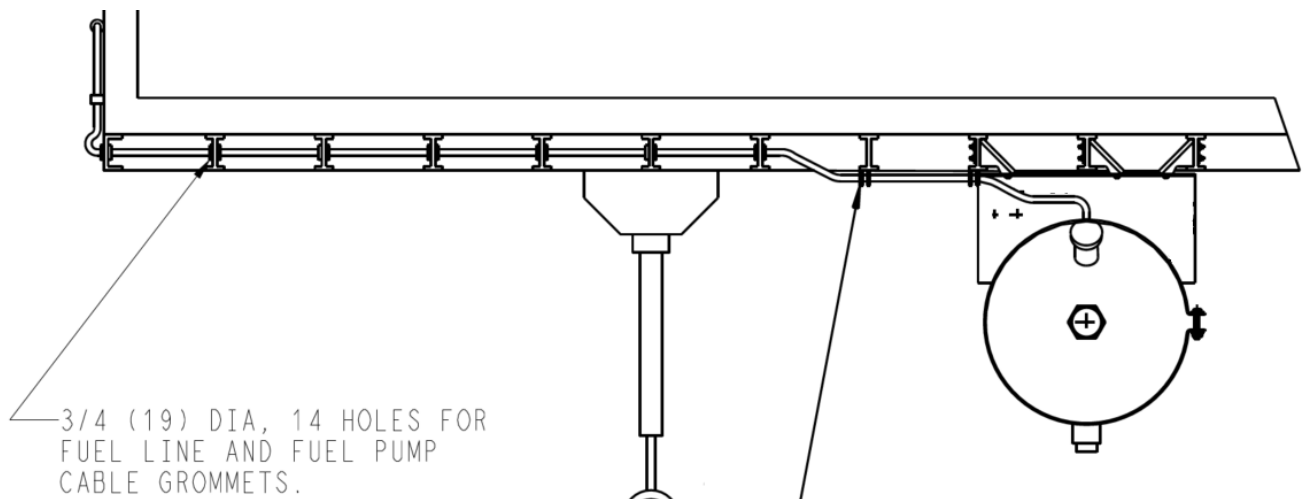
Tighten hardware to 60 ft-lb.

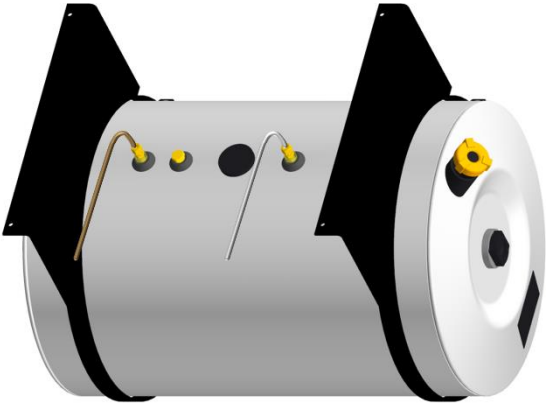
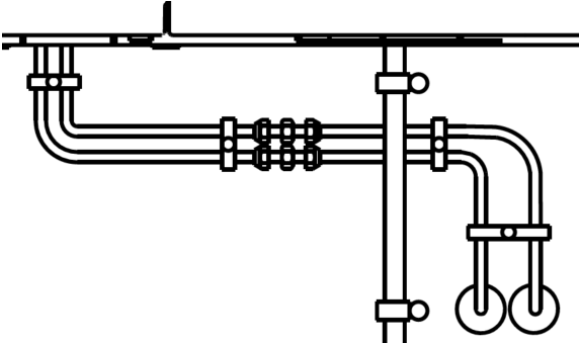
Fuel Line Installation

Fuel Line Routing Detail



Fuel Line Routing Detail



1		<p>Insert grey fuel line into the fuel line fitting closest to the fill port.</p> <p>Insert the brown fuel line into the fuel line fitting closest to the vent fitting.</p> <p>Continue inserting the fuel lines into the tank until the line contacts the bottom of the tank. Pull the fuel line back out of the tank 1.00"</p> <p>Tighten the compression nut 1-1/4 turns past finger tight.</p>
2	<p>Route the brown fuel line (tank) and gray line (tank) to the front of the trailer.</p> <p>Fuel line routing must follow installation requirements.</p>	
3		<p>Route the fuel lines from the front of the trailer to the bottom of the TRU.</p> <p>Extend the fuel lines from the TRU and through the bottom panel.</p> <p>Connect the fuel lines from the tank to the TRU fuel lines with fuel line unions.</p> <ul style="list-style-type: none"> • Brown to Brown (Supply) • Gray to Grey (Return) <p>Tighten compression nuts on unions 1-1/4 turns past finger tight. Use backing wrench.</p> <p>Individually clamp fuel lines across front of the trailer at the following locations:</p> <ul style="list-style-type: none"> • Fuel lines exit TRU. • Fuel line union • Start/end of fuel line bends. • Every 12.00" of fuel line length (As required)