

## 2. Boiler Block Assembly

All SG series boilers are shipped from the factory in assembled boiler blocks. If the block needs to be split into sections for ease of delivery, please read the following:

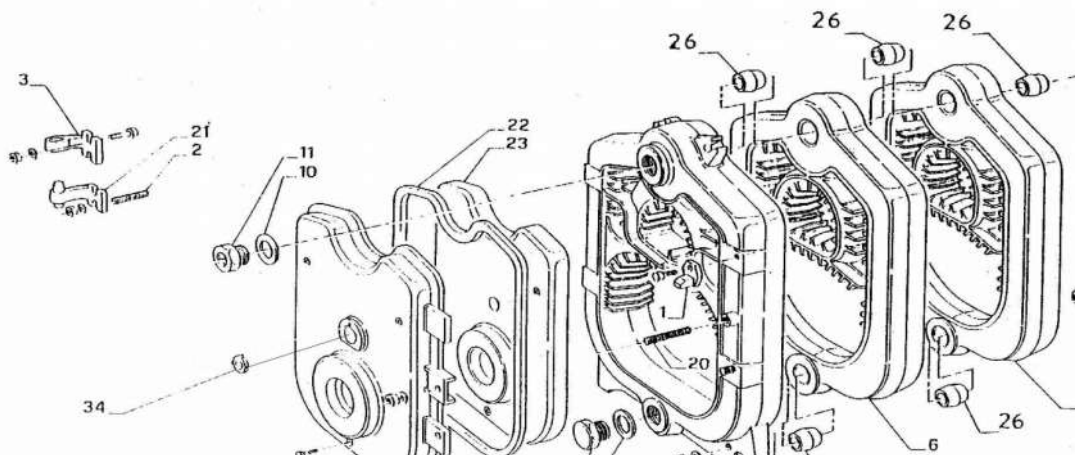
To assemble split blocks, move sections into parallel and facing each other. Sections may be slid along boards placed underneath the sections. Inspect nipple ports for damage or burrs. Remove any burrs by scraping the port very lightly. Wipe the push nipples and nipple ports with a clean cloth. Apply a film of sealing compound to both the nipple and port. Install the nipple in the port and then seat it by hitting with a hammer cushioned with a block of wood. Apply boiler mastic to one section only and slide sections together. Install the four draw rods and draw the sections together evenly (measure with ruler or tape measure). Draw the sections together until sections make iron-to-iron contact at a point around the top and bottom ports of each section.

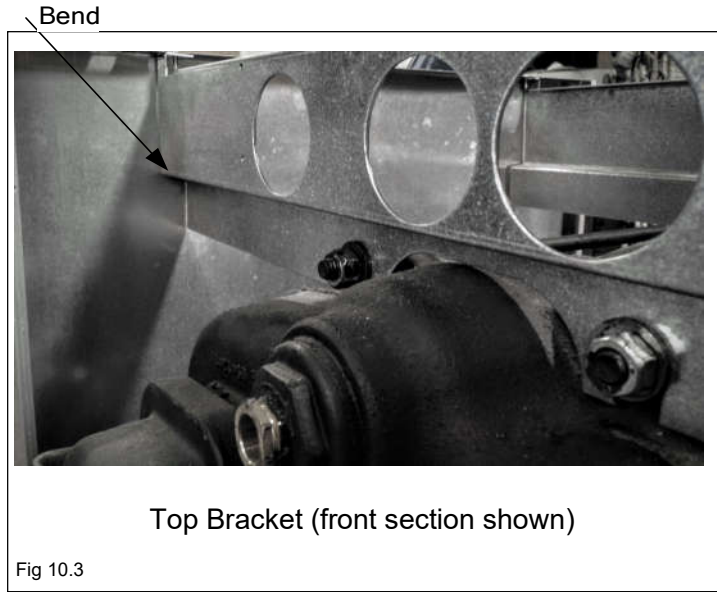
### DO NOT OVER TIGHTEN DRAW RODS

After assembly of boiler block, seal all joints with boiler gasket and remove boards. NOTE: When cutting off excess length of draw rods, allow enough length to install boiler jacket on the draw rods.

### BIASI SG-Series Components & Parts

2) Door Alignment Pin	9) Lower Front Bushing
21) Hinge Stud, Nut and Washer	10) Front Tapping Gasket
3) Upper Hinge Element	11) Upper Front Bushing
19) SG Front Block Section	12) Lower Rear Bushing
5) SG Rear Block Section	13) Draw Rod
6) SG Intermediate Block Section	19) SG Door





**Biasi SG — Series Components & Parts**

Boiler Jacket Assembly:

- |                                  |   |
|----------------------------------|---|
| 1) Boiler Body                   | 8) Top Jacket Panel                     |
| 2) Insulation Surrounding Boiler | 9) Top Rear Jacket Panel                |
| 3) Lower Mounting Bracket        | 10) Bottom Rear Jacket Panel            |
| 4) Upper Mounting Bracket        | 11) Front Jacket Panel*                 |
| 5) M10 Nut (mounted on tie rod)  | 12) Control Panel                       |
| 6) RH Side Jacket Panel          | 13) Self-tapping screw (min. 3/4" long) |
| 7) LH Side Jacket Panel          | 14) Self-tapping screw (min. 1/2" long) |
- \* Supplied with attached insulation

