

2. Boiler Block Assembly

All B10 Series Boilers are shipped from the factory in assembled boiler blocks. If, however, 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 sanding the port very lightly. Wipe the push nipples and nipple ports with a clean cloth. Apply a film of nipple compound to both the nipple and port. Install the nipple in the port and then seal by tapping with a hammer cushioned with a block of wood. Apply section sealant to grooves in one section only and slide sections together. Install the four draw rods and draw the sections together evenly (measure with yardstick). 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

NOTE: When cutting off excess length of draw rods, allow enough length to install boiler jacket on the draw rods.

Boiler Components & Parts

B 10 Series

Boiler Block Assembly:

- 1 Front Section
- 2 Rear Section
- 3 Intermediate Section
- 4 Steel Push Nipples
- 5 Tie Rod
- 6 Tie Rod Nut
- 7 Tie Rod Washer
- 8 3/4" X 1 1/4" Bushing
- 9 Bushing gasket
- 10 1/2" X 1 1/4" Bushing
- 11 Boiler Swing Door
- 12 Upper Cleanout Plate Insulation
- 13 Upper Cleanout Plate Gasket
- 14 Upper Cleanout Plate Backing
- 15 Burner Door Insulation
- 16 Door/Cleanout Stud (Qty 7)
- 17 Burner Door Gasket
- 18 3/4" Plug (Sight Hole)
- 19 Boiler Door Hinge (4 pieces)
- 20 Hinge Pin (Qty 6)
- 21 Boiler Body Hinge Bolts (Qty 2)
- 22 Door Hinge Mounting Bolts (Qty 2)
- 23 6" Boiler Breeching
- 24 Upper Cleanout Plate

