Assembly of Split Cast Iron Block
for use with Part No. 7821 010
for Vitorond 100 and 200 boilers

Safety and Installation Requirements

Please ensure that these instructions are read and understood before commencing installation. Failure to comply with the instructions listed below can cause product/property damage, severe personal injury, and/or loss of life.

Working on the equipment
The installation, adjustment, service, and maintenance of this product must be done by a licensed professional heating contractor who is qualified and experienced in the installation, service, and maintenance of hot water boilers. There are no user serviceable parts on the boiler, burner, or control.

Ensure main power supply to equipment, the heating system, and all external controls has been deactivated. Close main oil supply valve. Take precautions in both instances to avoid accidental activation of power during service work.

Ensure that the installation literature of other applicable components is referenced.

Split Cast Iron Block Assembly

Splitting boiler block for easy transportation into boiler room (only if boiler is supplied as block)

1. Drive wedges between cast iron sections to split boiler block.

Only drive wedges in at the appropriate positions (where the boiler body is thicker), not near the hubs.

2. Remove existing push nipples using a metal rod and discard.
1. Carefully clean all sealing grooves, nipple ports and push nipples with solvent.

2. Using a narrow putty knife, carefully trowel sealing compound into the sealing grooves.

**IMPORTANT**

Ensure that the groove system on each cast iron block is completely filled with the sealing compound. Failure to fully seal each cast iron block section will result in flue gas leaks.

3. Apply field supplied lubricant (linseed oil or glyptal paint) onto cleaned push nipples. Gently and evenly tap push nipples into nipple ports using a rubber mallet.

**IMPORTANT**

Only use new nipples during assembly.

4. Insert three draw tool rods and attach pressure flanges, locking plates.

**CAUTION**

Do not use tie rods as a draw tool.

5. Attach pressure nuts and align both sections parallel to each other (same thread depth) by utilizing the ratchet tool. Ensure that all sections are aligned parallel to each other before applying pressure. Start to tighten evenly. Once the push nipple ports touch, do not apply further pressure. Do not use excessive force if push nipple ports do not touch.

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Installation

Split Cast Iron Block Assembly (continued)

6. Attach tie rods to cast iron block as shown. **Do not overtighten.**

7. Using a putty knife, clean off excess sealant from combustion chamber interior.

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**IMPORTANT**

Do not remove draw tools until tie rods have been properly attached to the cast iron block.

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Assembly with sections in vertical position

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1. Carefully clean all sealing grooves, nipple ports and push nipples with solvent.

2. Using a narrow putty knife, carefully trowel sealing compound A into the sealing grooves.

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**IMPORTANT**

Ensure that the groove system on each cast iron block is completely filled with the sealing compound. Failure to fully seal each cast iron block section will result in flue gas leaks.

3. Apply field supplied lubricant (linseed oil or glyptal paint) onto cleaned push nipples.

4. Gently and evenly tap push nipples into nipple ports using a rubber mallet.

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**IMPORTANT**

Only use new nipples during assembly.
5. Insert three draw tool rods and attach pressure flanges, locking plates.

6. Attach pressure nuts and align both sections parallel to each other (same thread depth) by utilizing the ratchet tool. Ensure that all sections are aligned parallel to each other before applying pressure. Start to tighten evenly. Once the push nipple ports touch, do not apply further pressure. **Do not use excessive force if push nipple ports do not touch.**

7. Attach 3 tie rods to cast iron block as shown. **Do not overtighten.**

8. Using a putty knife, clean off excess sealant from combustion chamber interior.

**IMPORTANT**

Do not remove draw tools until tie rods have been properly attached to the cast iron block.