

## Ss Brewtech Infussion Mash Tun – Recirculation Bulkhead Installation Guide

This installation guide is designed to walk through the basic steps to add the recirculation bulkhead fitting to a 10 gallon Infussion Mash Tun. Always take all the necessary precautions when working with power tools and wear safety equipment such as gloves and eye protection.

### Tools Required:

Power Drill – Cordless or corded but preferably with a high speed setting

Razor Blade or Deburring Tool

22 mm Carbide Tipped Hole Saw

30 mm Carbide Tipped Hole Saw

5 mm Pilot Drill Bit

Adjustable Wrench

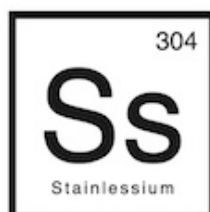


1. Begin by analyzing your current system to decide what orientation on the mash tun you would like the bulkhead located. Once you have decided, examine the width of the 30 mm bit and if needed trace the circumference onto your desired location. Take care to insure that the orientation isn't high enough on the side wall to remove any material from the top double wall seam. To be safe, there should be at least  $\frac{3}{4}$  inch from the outer circumference of the 30 mm bit location and the top of the double wall seam.
2. Mark the center point of the 30 mm bit location, then go ahead and chuck the 5 mm pilot bit in the power drill. Users not familiar with drilling into smooth metal surfaces may want to consider adding a starter punch with a nail or countersink punch, to avoid the drill bit walking along the surface of the stainless steel. Lastly, Drill the 5 mm pilot hole through both the INNER AND OUTER wall of the mash tun, making sure to keep the drill bit as straight as possible to better align the inner and outer holes. Cutting fluid can be used but is not required.
3. Next, chuck the 30 mm hole saw bit in the power drill, and insert the center starter bit into the existing pilot hole on the OUTSIDE of the mash



tun. Then go ahead and drill the outer hole, paying close attention to stop applying pressure once the outer hole is cut. Be sure to firmly grasp or secure the mash tun, and put your power drill on the highest speed setting for the cleanest cut.

4. Once the outer hole is cut, remove any foam obstructing the passageway. Next, chuck the 22 mm hole saw bit in the power drill, and insert the center starter bit into the existing pilot hole on the **INSIDE** of the mash tun. Then go ahead and drill the inner 22 mm hole, again making sure the mash tun is secure.
5. Finally, run a razor blade or deburring tool along the inside of the newly cut holes to remove any burrs that might remain. Slide the bulkhead through the outer 30 mm hole into the inner 22 mm hole, and thread the lock nut onto the inside of the bulkhead. Tighten the bulkhead lock nut with an adjustable wrench. Excess foam may need to be removed from the hole if the exterior rubber flange does not seat properly against the outer sidewall. Remember that although the bulkhead contains an o-ring to form a water tight seal, it's designed specifically to be located above the grist level and be utilized for accessories and recirculation.



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