

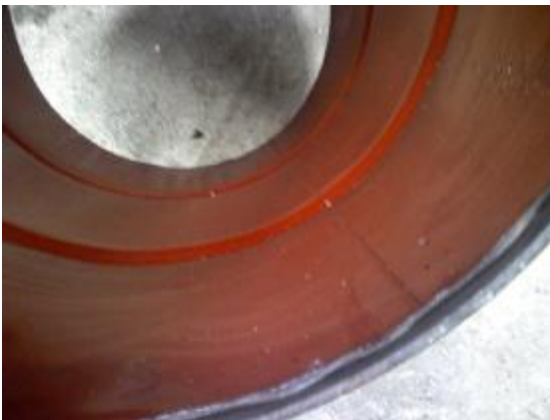
## Biodiesel Cone Bottom Tank Instructions

These instructions are for you to use with the Boss Buck biodiesel funnel. The funnel can be used to make a cone bottom tank out of 15, 30, and 55 gal. steel drums. Below is step by step instructions of things that need to be done in the process of attaching the funnel to any drum.

1. Verify the drum is empty, and free of all explosive residues.  
(I'm not going to specify how you do this, but do it safely)
2. Invert your drum.
3. Remove the bottom of your drum, leaving the rolled edge attached.



4. Flatten the remaining edge with a hammer. Use lacquer thinner or some other cleaning agent to remove any residue from the bottom rolled edge. In the welding process, if any oil or other substance gets mixed in the weld bead it will cause pinholes and leakage when the drum is full.



5. Remove the paint from the outside of the rolled edge, with a sanding disk or some other method at your disposal.

It's best to create a temporary stand to hold the funnel and drum while connecting them. I use a 14" diameter section of pipe with legs attached.

6. Set the funnel in your stand and level it all directions.



7. Place the drum with your prepared edge down on top of the funnel.



8. Depending on your drums outside diameter you will have from zero to several inches extra material on the funnel.



9. Use a Plasma Cutter (preferably), torch, grinder or cut off wheel to remove excess funnel material.

10. When you are satisfied with the fit, tack the drum and funnel together.



11. You can now complete the welding of the funnel.

12. Pressure check your weld by sealing the drum up and adding 4-5 PSI of compressed air. Then take a little soapy water and a small paint brush and check for leaks or pinholes. If you find some, mark where they are, then grind and re-weld the area.

13. Continue checking the weld until all leaks are sealed up.

14. For the legs in the pictures, 2 x 2 x 1/8 angle iron was used. You can use whatever scrap you have lying around.

15. Cut 3 pieces and grind a notch so they will fit over the lip of the drum.

16. Weld the legs on, being very careful not to burn through the skin of the drum. To be safe you should pressure test for leaks with soapy water once again.

17. If you will be using the tank outside on an unpaved surface you might want to add base plates to the legs.

18. Clean and pain up your new cone bottom tank.

