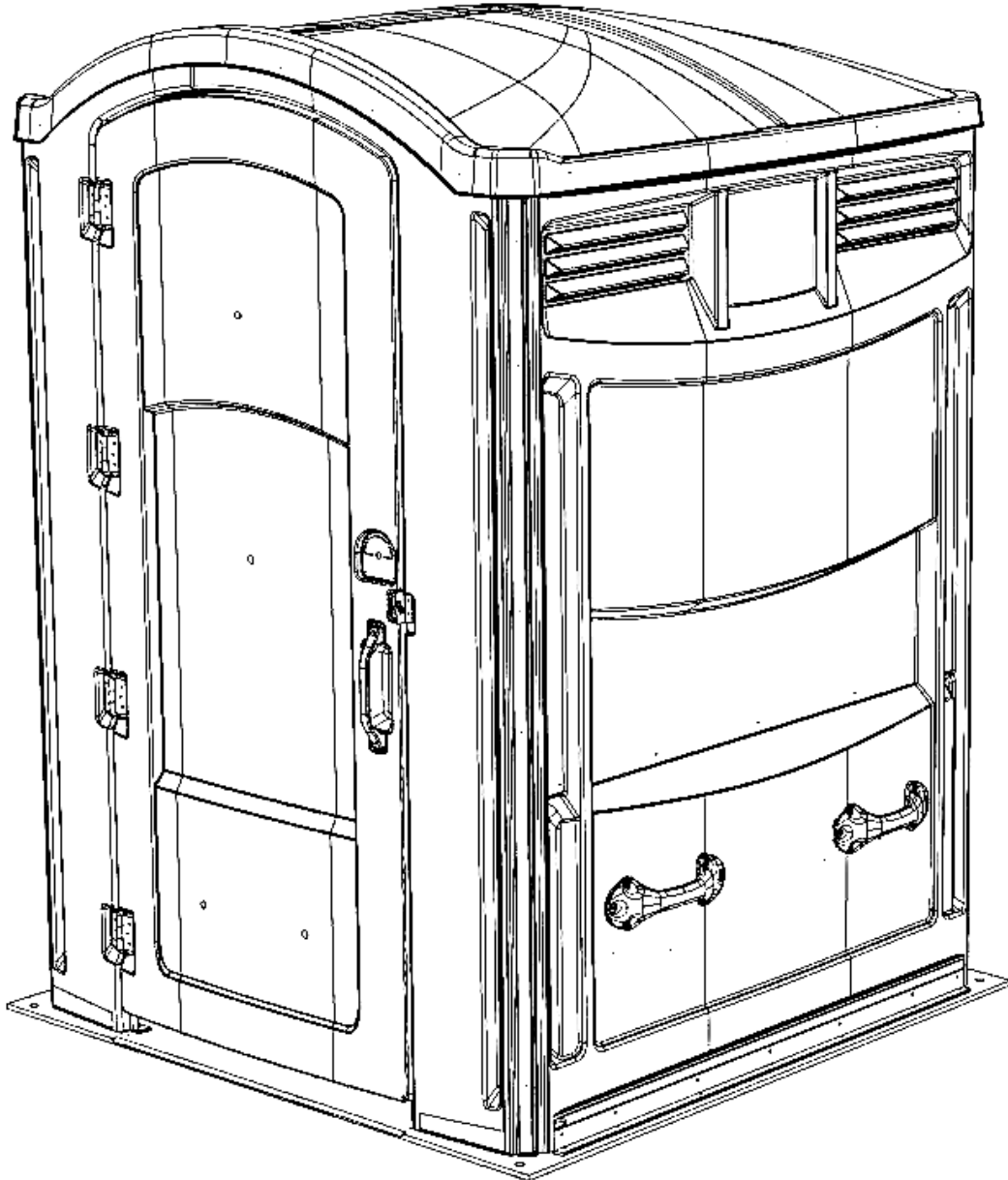


# *LIBERTY*

## *INSTRUCTIONS*



2530 Xenium Lane North, Minneapolis, MN 55441  
Telephone: 763-553-1900 Fax: 763-553-1905  
800-328-3332 / [www.satelliteindustries.com](http://www.satelliteindustries.com)

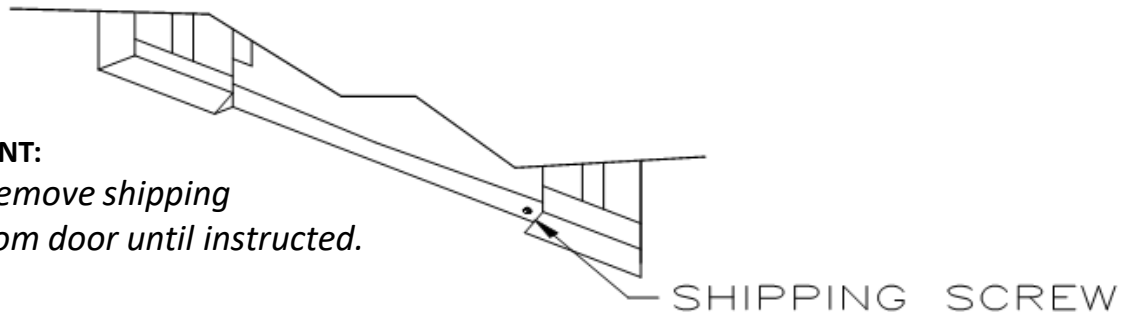
# INTRODUCTION

Satellite portable restrooms must be assembled according to approved assembly procedures. Avoid variations in assembly procedures which could adversely affect product life and warranty.

**PREASSEMBLY:** INSPECT ALL ITEMS FOR DAMAGE, VERIFY QUANTITIES ARE CORRECT (page 4)  
READ THROUGH ENTIRE INSTRUCTION BOOKLET

## IMPORTANT:

*Do not remove shipping screw from door until instructed.*

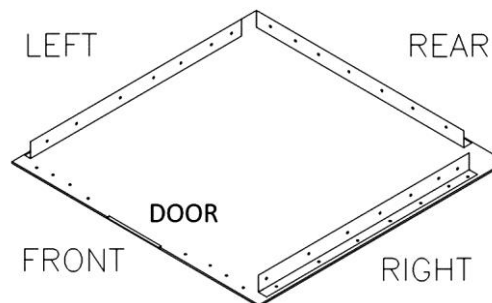


## TOOLS:

- CORDLESS DRILL
- 3/8" HEX DRIVER
- #10 ( 5mm ) DRILL BIT
- POP RIVET GUN
- #2 PHILLIPS SCREWDRIVER
- #4 PHILLIPS SCREWDRIVER

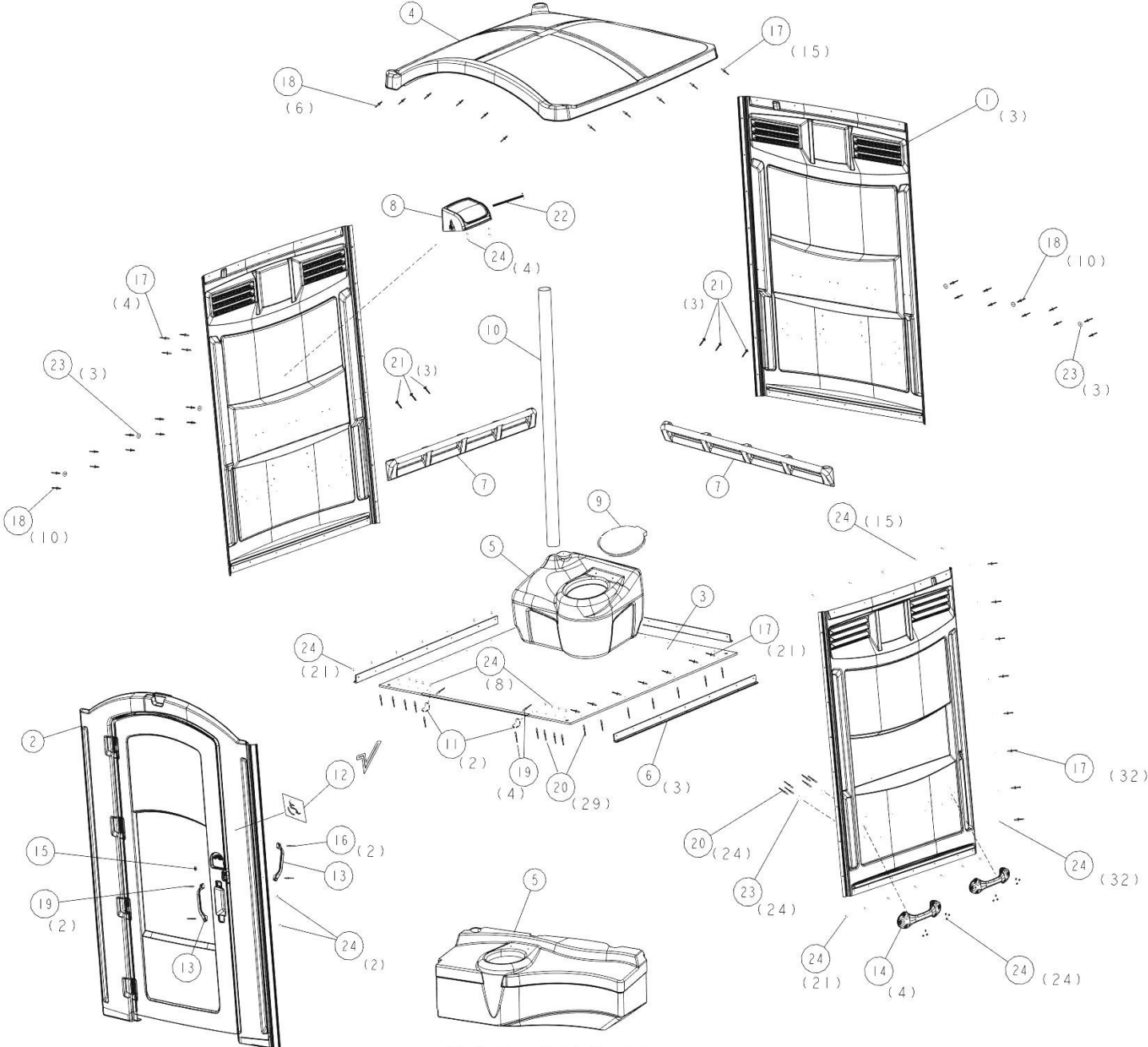
## HELPFUL HINTS:

- KEEP WORK AREA ORGANIZED.
- Do not open all kit boxes, open only enough to assemble the toilets you are currently working on.
- Use toilet paper holders for parts bins on multiple unit assembly
- The assembly procedure is written for assembly of a single unit. If assembling multiple units, considerable efficiency can be gained by having a crew work in assembly line fashion.
- An apron with large pockets is handy for holding parts and tools.



All references to left, right, front and rear correspond to this illustration.

# EXPLODED DRAWING



68 Gallon Tank Option

11



PN 16175

12



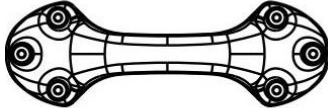
PN 14401

13



PN 16807

14



PN 22522

15



PN 10161

16



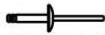
PN 17030

17



PN 11054

18



PN 22604

19



PN 11270

20



PN 14351

21



PN 13860

22



PN 22310

23



PN 11361

24



PN 11315

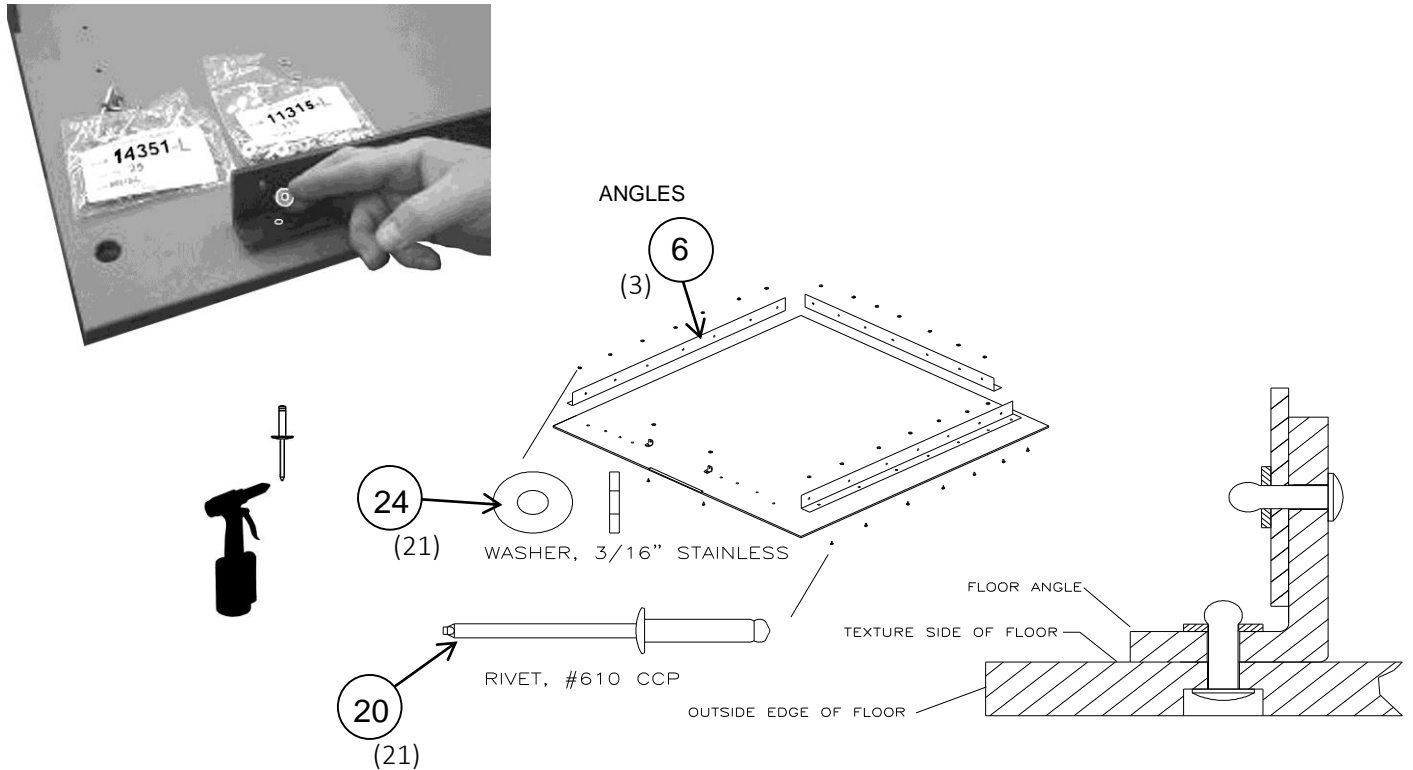
24	11315	127	WASHER 3/16 RIVET STNLS	HDWE, LIBERTY W/ 3ROLL PRGD ( 22340 )
23	11361	30	WASHER 3/16 ID FENDER	
22	22310	1	SPINDLE, PRGRD II 3 ROLL METAL	
21	13860	6	SCREW, #14 X 1-1/2 W/WSH GOLD	
20	14351	53	RIVET, #610 CCP	
19	11270	6	RIVET, #68 STNLS	
18	22604	26	RIVET- TRI-LOBE X 5/8 LF	
17	11054	72	RIVET, #68 AAL POP	
16	17030	2	RIVET, AVDEL BLACK	
15	10161	1	PLUG, 1/2 ROUND BLACK PLASTIC	
14	22522	4	HANDLE, PLASTIC LIFT DGRY	
13	16807	2	HANDLE, PLASTIC HOVER	
12	14401	1	DECAL, WHEELCHAIR ACCESSIBLE	
11	16175	2	BRACKET, L 1" STNLS	

10	13796	1	VENT PIPE, 3 X 65-1/2 BLACK	LIBERTY STANDARD PARTS
9	10570	1	SEAT TOILET	
8	22209	1	HOOD, PAPERGRD 3 ROLL DGRY	
	22340	1	HDWE, LIBERTY W/ 3ROLL PRGRD	
7	22519	2	GRAB BAR, LIB/ FRDM4 PLASTIC	
6	18039	3	ANGLE, PLSTC LIBERTY	
5	16538	1	TANK- FRE/LIB LARGE DGRY	
	22608	1	TANK- FRE/LIB 35 GAL BLOWMOLD	
4	18036	1	ROOF LIBERTY	
3	18037	1	FLOOR LIBERTY	
2	18011	1	DESIGN, LIBERTY FRONT ASSY	
1	22517	3	DESIGN, LIBERTY/FR4 SIDE PANEL	
ITEM	PART#	QTY	DESCRIPTION	

# INSTALL ANGLES

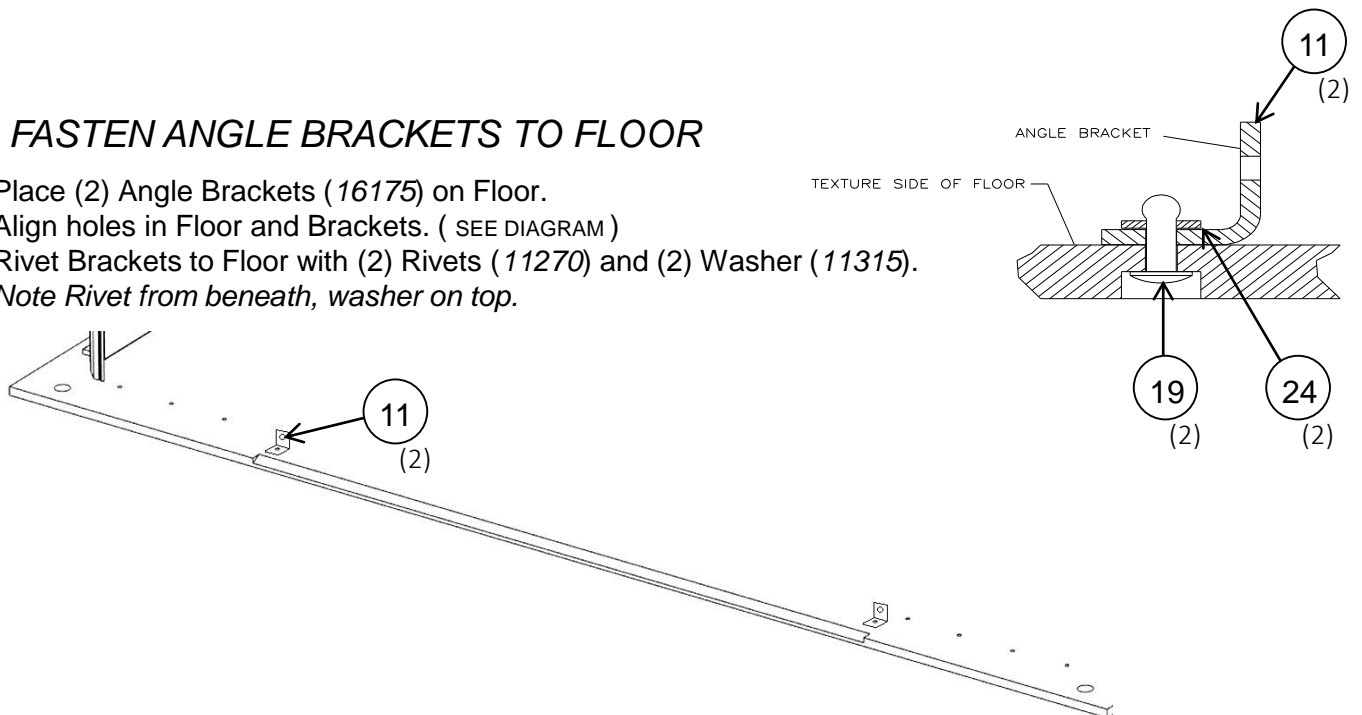
## 1. FASTEN ANGLES TO FLOOR

- Use a raised work surface such as a large work bench or stacked pallets.
- Place Plastic Angles (18039), short flange down, on Floor (18037). *Note Floor texture must be up.*
- Align holes in Floor and Angles. (SEE DIAGRAMS)
- Rivet Angles to Floor with Rivet (14351) and Washer (11315). *Note Rivet from beneath, washer on top.*



## 2. FASTEN ANGLE BRACKETS TO FLOOR

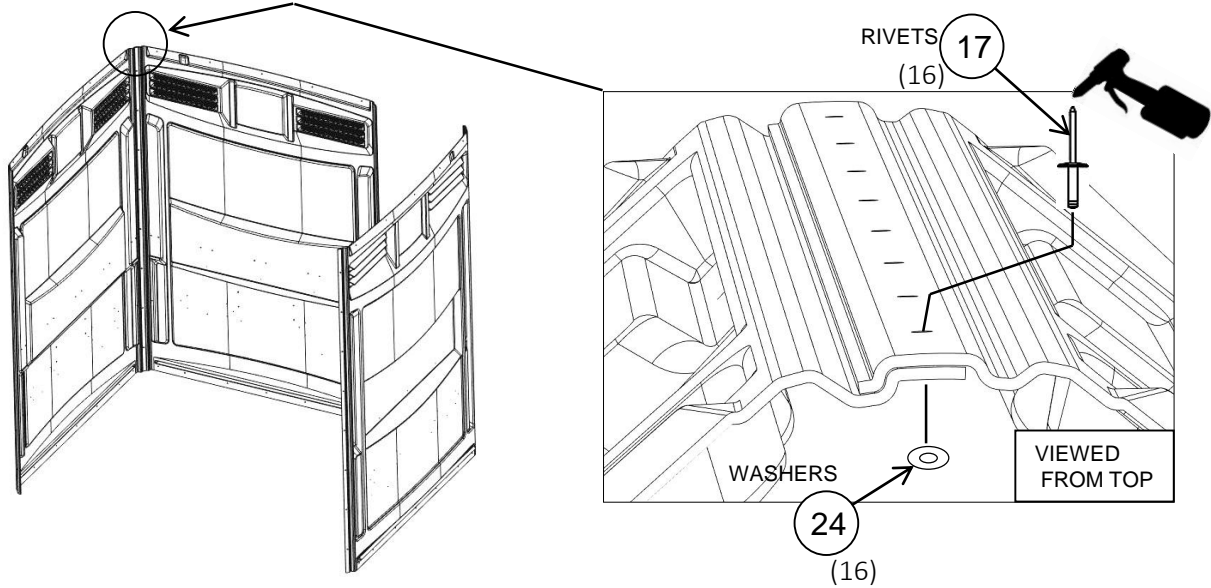
- Place (2) Angle Brackets (16175) on Floor.
- Align holes in Floor and Brackets. (SEE DIAGRAM)
- Rivet Brackets to Floor with (2) Rivets (11270) and (2) Washer (11315).
- *Note Rivet from beneath, washer on top.*



# INSTALL PANELS

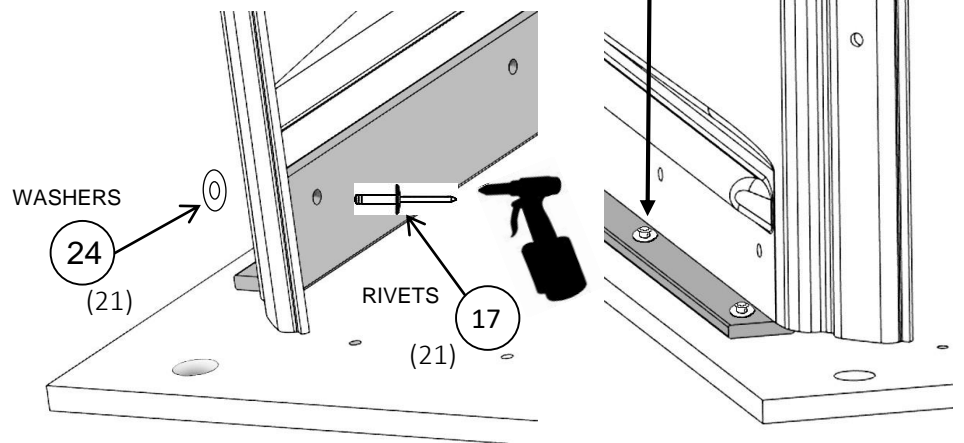
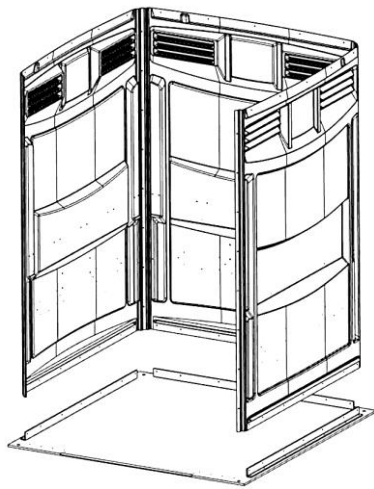
## 3. FASTEN PANELS TOGETHER

- Place Rear Panel edge over Left Panel edge, panels standing. ( SEE DIAGRAM )
- Align holes in Panels.
- Install Rivets ( 11054 ) and Washer ( 11315 ). *Note Rivet from outside, washer inside.*
- Repeat process by placing Right Panel edge over Rear Panel edge, align holes & rivet.



## 4. FASTEN PANELS TO ANGLES

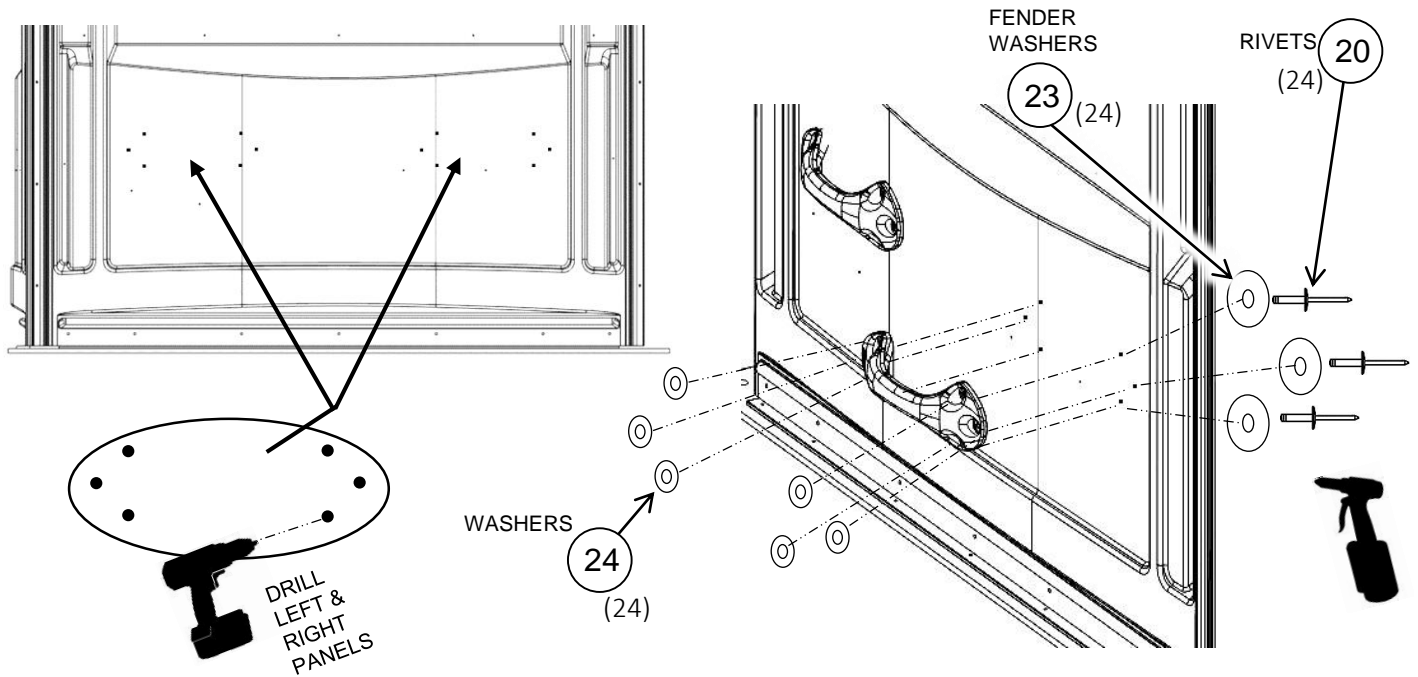
- Place Panels on outer surface of Angles. ( SEE DIAGRAMS )
- Align holes in Panels with holes in Angles.
- Install Rivets ( 11054 ) and Washer ( 11315 ). *Note Rivet from inside, washer outside.*
- Repeat for remaining Panels.



# INSTALL LIFT HANDLES

## 5. DRILL LEFT & RIGHT HANDLES

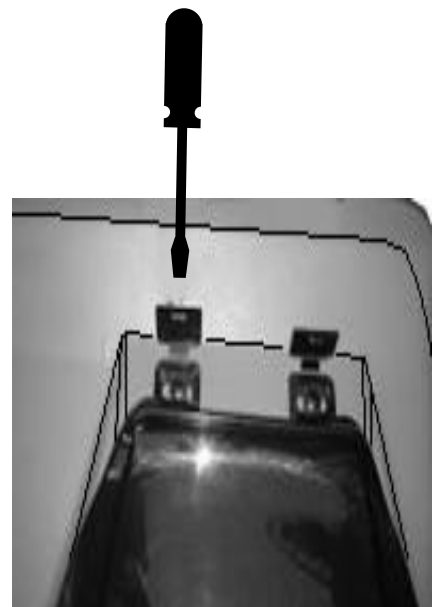
- Using a #10 drill bit, Drill 12 dimple locations on the lower half of the Left & Right Panels. ( SEE DIAGRAM )
- Align drilled holes with holes in Handles (22522).
- Insert Rivets (14351) with Fender Washers (11361) under the head through holes. ( SEE DIAGRAM ).
- Place Washer (11315) in Handle recess, rivet in place. *Note Rivet from INSIDE, washer OUTSIDE.*



# INSTALL TOILET SEAT

## 6. FASTEN TOILET SEAT ( 10570 )

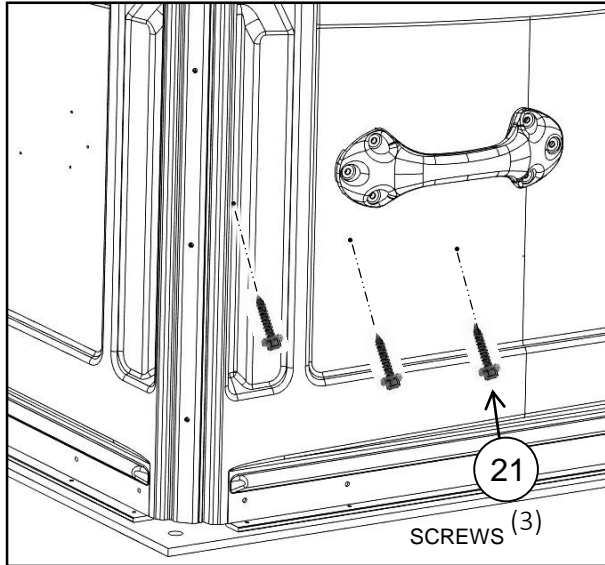
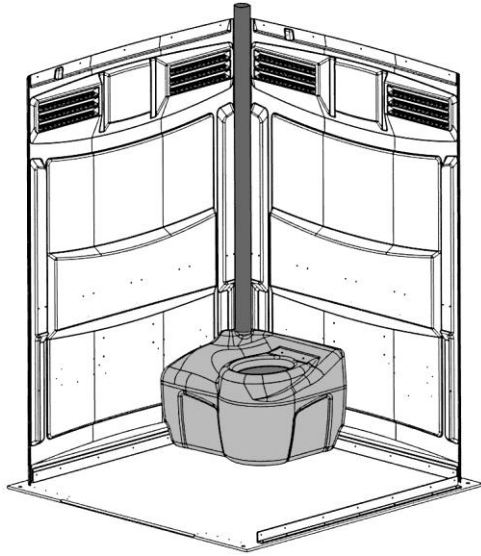
- Place Seat on Tank and align holes.( SEE DIAGRAM )
- Insert plastic Bolts through hinge into tank.
- Install plastic Nuts and tighten. *DO NOT OVER TIGHTEN*
- Be sure to close cap over bolt heads.



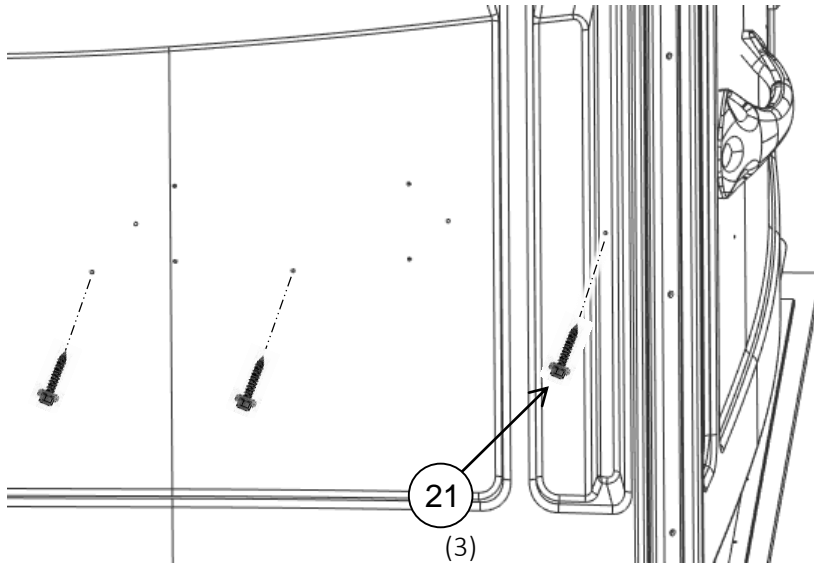
# INSTALL TANK & VENT PIPE *Note Requires (2) people.*

## 7. 35 GALLON TANK OPTION ( 22608 )

- Place Tank into left rear corner.
- Firmly hold Tank into corner.
- Install (3) Lag Screws ( 13860 ) through dimples on left panel, Use 3/8 driver. ( SEE DIAGRAM )
- Insert Vent Pipe ( 13796 ) into Tank until Pipe contacts screw.



- Drive Screw ( 13860 ) through dimple on rear panel and into Vent Pipe ( SEE DIAGRAM ).
- Continue to hold tank in place firmly.
- Install Remaining (2) Screws through indicated dimples on rear panel.
- *Note screws must securely fasten tank. DO NOT OVER TIGHTEN*

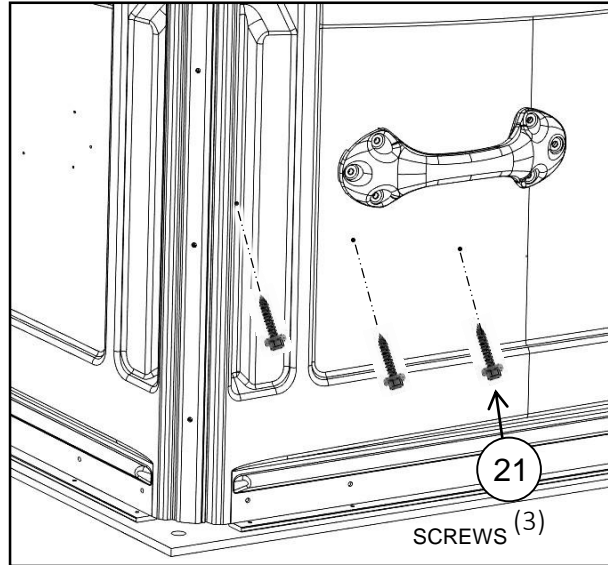
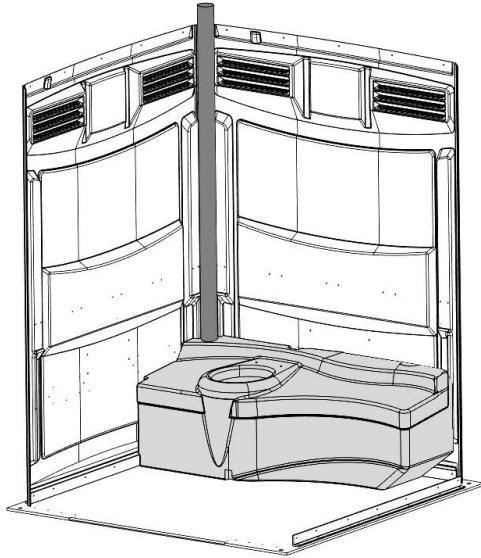




# INSTALL TANK & VENT PIPE *Note Requires (2) people.*

## 7. LARGE TANK OPTION ( 16538 )

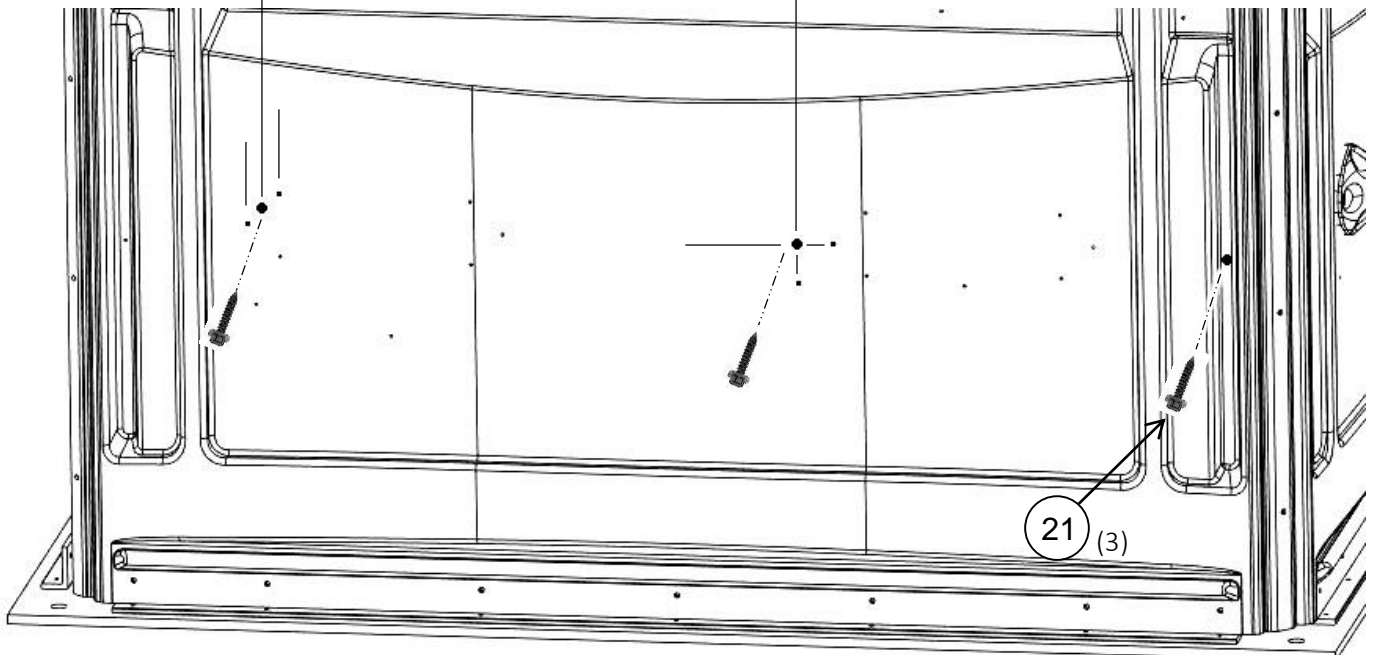
- Place Tank into left rear corner.
- Firmly hold Tank into corner.
- Install (3) Lag Screws ( 13860 ) through dimples on left panel, Use 3/8 driver. ( SEE DIAGRAM )
- Insert Vent Pipe ( 13796 ) into Tank until Pipe contacts screw.



- Drive Screw ( 13860 ) through dimple on rear panel and into Vent Pipe ( SEE DIAGRAM ).
- Continue to hold tank in place firmly.
- Install Remaining (2) Screws in locations indicated below, on rear panel.
- *Note screws must securely fasten tank. DO NOT OVER TIGHTEN*

PLACE SCREW CENTERED  
BETWEEN DIMPLES

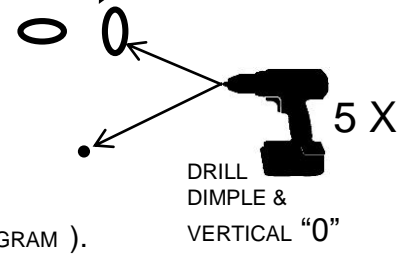
ALIGN SCREW TO  
DIMPLE BELOW & RIGHT



# INSTALL GRAB BARS

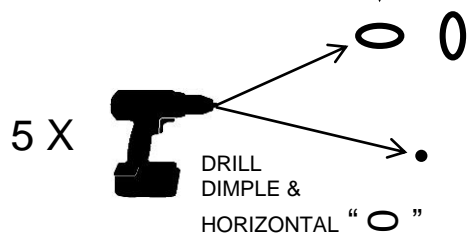
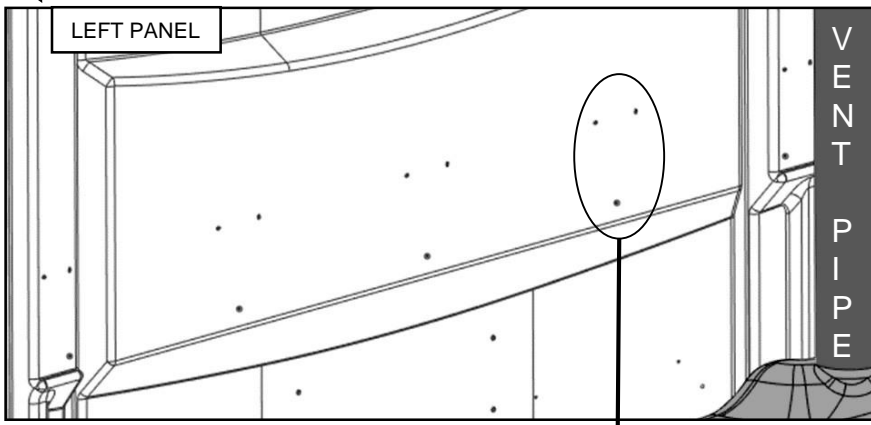
## 8. DRILL REAR PANEL

- Locate & drill (5) dimples for Rear Panel using #10 drill bit( SEE DIAGRAM ).
- Locate & drill (5) Vertical "0" for Rear Panel using #10 drill bit( SEE DIAGRAM ).



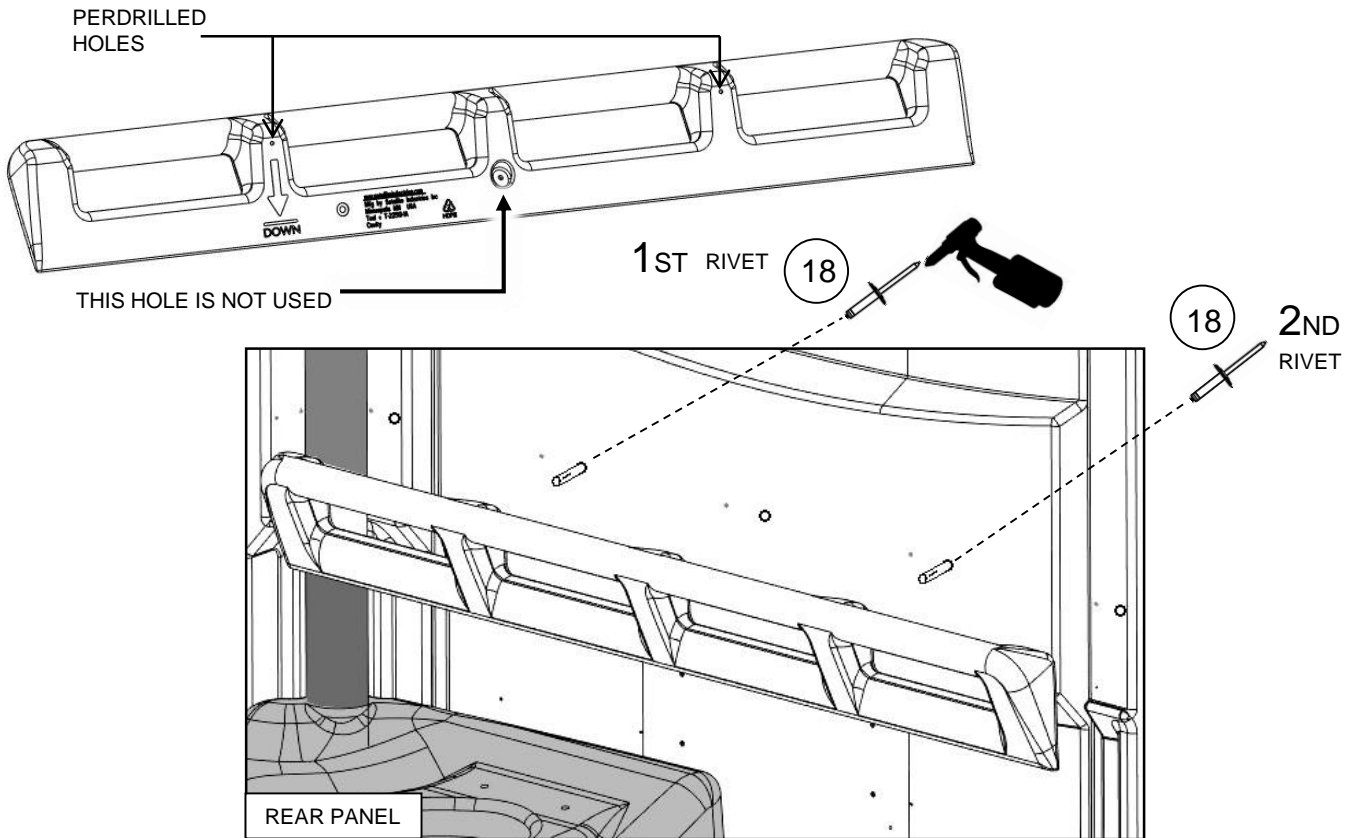
## 9. DRILL LEFT PANEL


- Locate & drill (5) dimples for Left Panel using #10 drill bit( SEE DIAGRAM ).
- Locate & drill (5) Horizontal "0" for Left Panel using #10 drill bit( SEE DIAGRAM ).

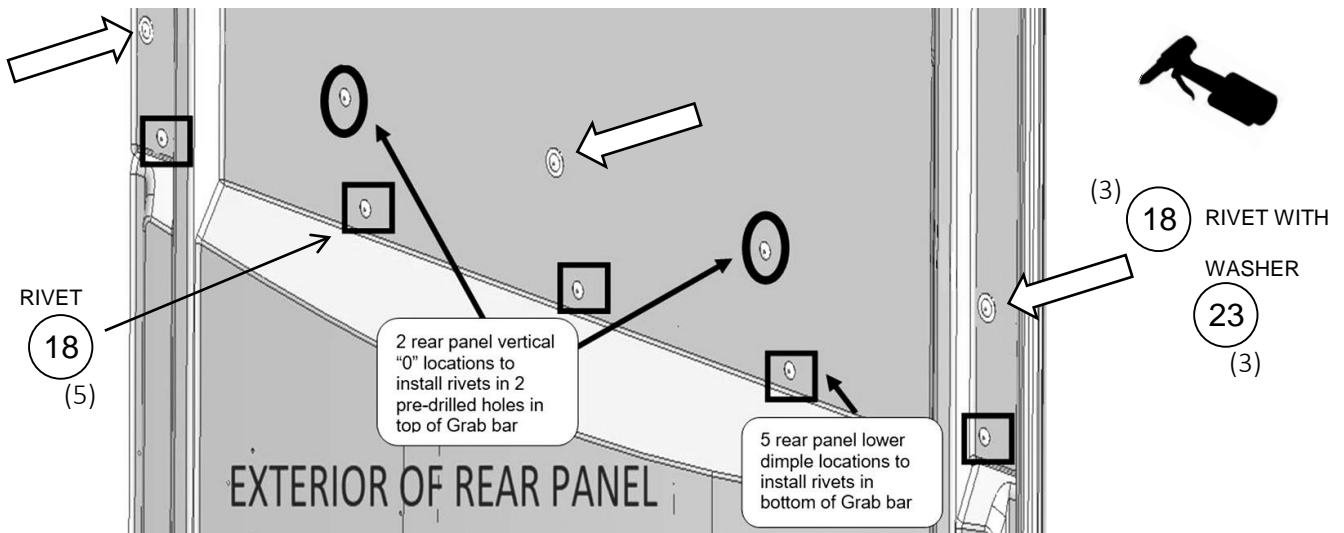


10. RIVET REAR GRAB BAR *Note Requires (2) people.* 

- Insert Rivet (22604) through hole indicated below. *Note Rivet from outside.*
- Place Grab Bar (22519) onto Rivet using predrilled hole then rivet.
- *Note push Grab Bar firmly against Panel.*
- Insert second Rivet (22604) through Panel and into Grab Bar , use hole indicated below.( SEE DIAGRAM )



- Hold Grab Bar firmly against Panel . *Note requires (2) people.* 
- Transfer drill through (8) remaining panel holes into Grab Bar from outside with #10 drill Bit.
- Do Not Drill through both Grab Bar walls.
- Rivet bottom (5) holes using Rivet (22604) . ( SEE DIAGRAM )
- Using Rivet (22604) with Washer (11361) under its head, rivet center and end locations (3)



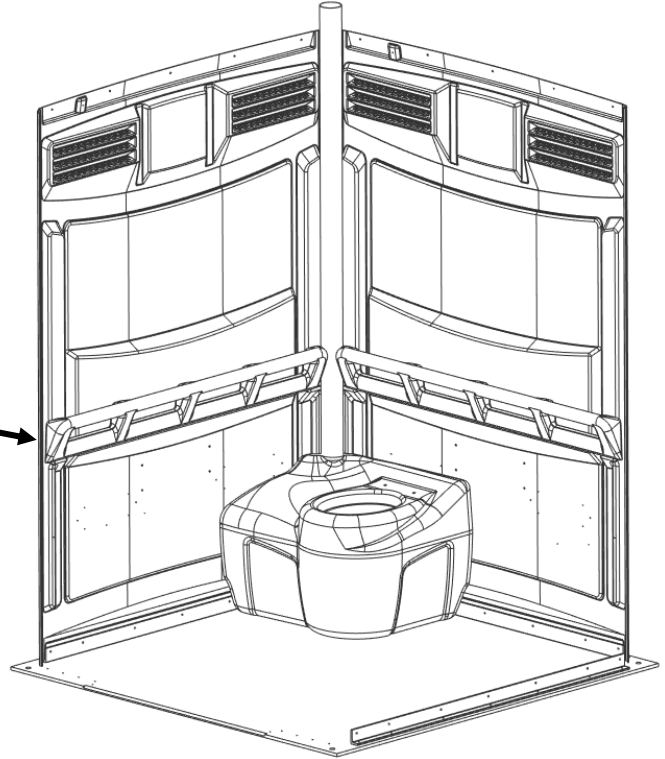
## 11. RIVET LEFT GRAB BAR *Note Requires (2) people.*



- Repeat process for Left Grab Bar ( 25519 ) as outlined on previous page, installing Rear Grab Bar.
- *Note Rivet from outside.*
- *Note push Grab Bar firmly against Panel.*
- Fender Washer ( 11361 ) is used under the head of the Top center and Top end Rivets ( 22604 ).



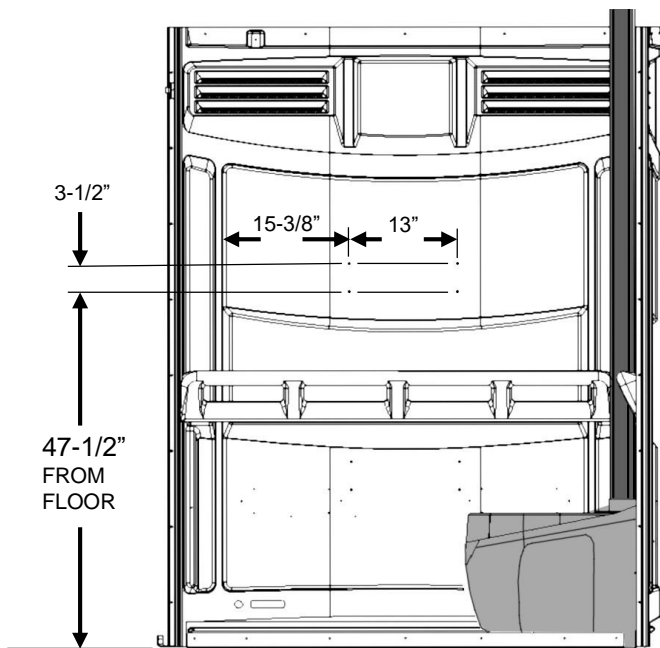
INSPECT GRAB BAR INSTALLATION,  
GRAB BARS MUST BE SECURE AND  
ALL RIVETS PROPERLY ENGAGED



## INSTALL PAPER GUARD

### 12. DRILL & FASTEN PAPER GUARD

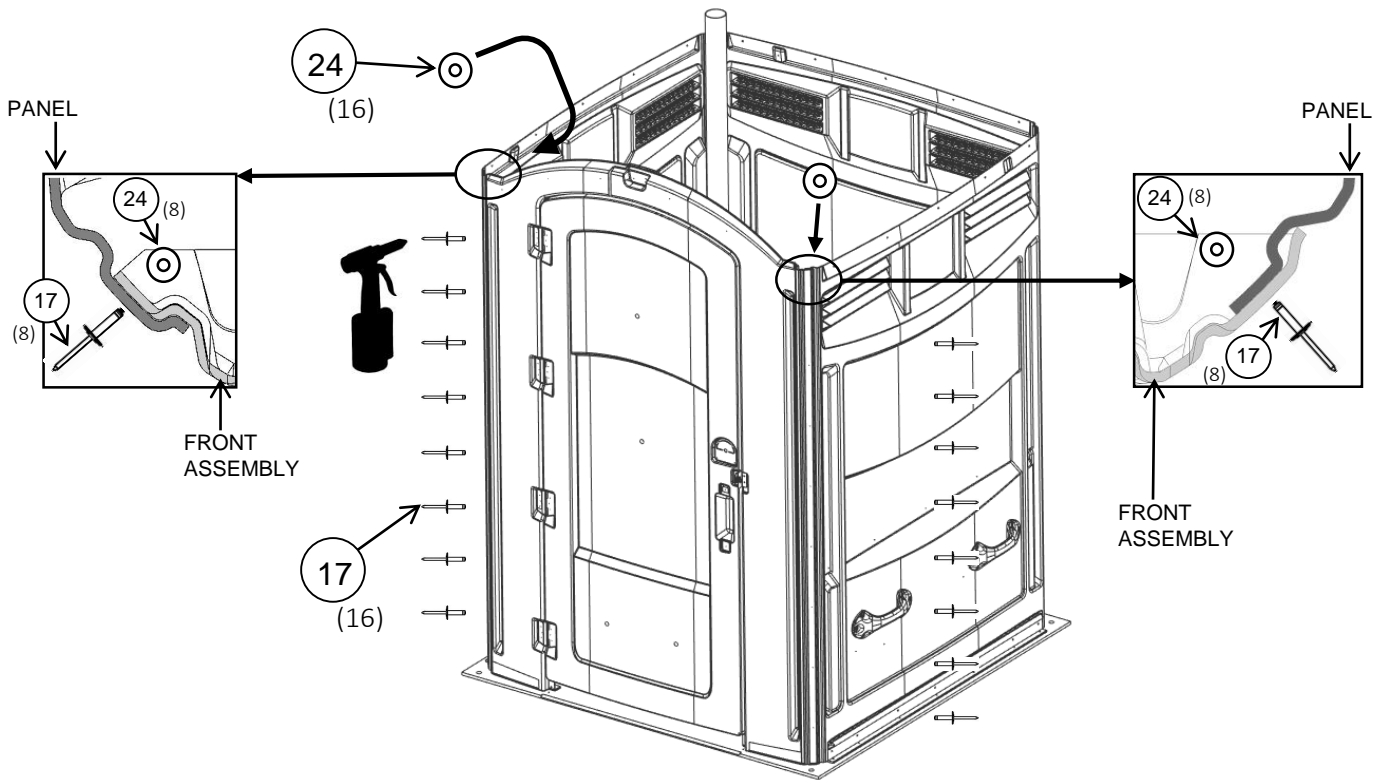
- Mark (4) holes as shown below.
- Drill holes using #10 drill bit.
- Align holes in Paper Guard with holes in Left side Panel. ( SEE DIAGRAMS )
- Fasten with Rivet ( 11054 ) and Washer ( 11315 ). *Note Rivet from outside, washer on inside.*



# INSTALL FRONT ASSEMBLY

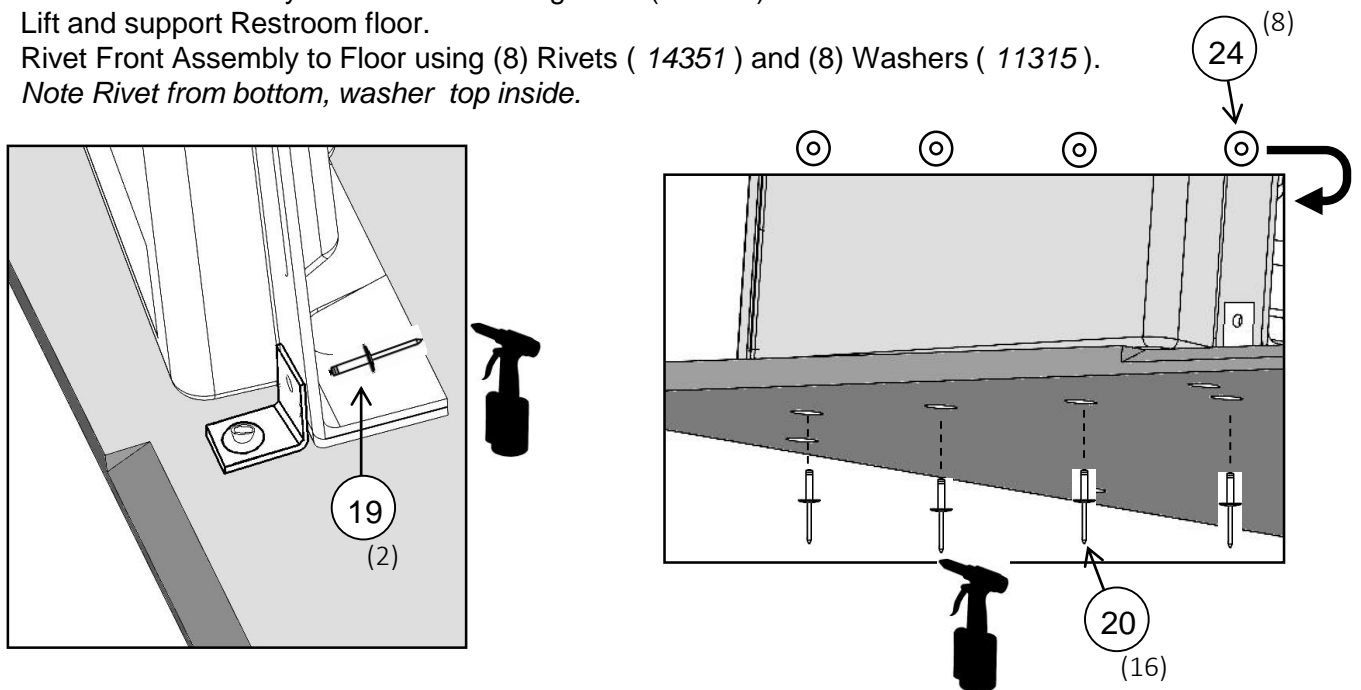
## 13. ATTACH FRONT ASSEMBLY TO PANELS

- Place Front Assembly on Restroom with Front Assembly over right Panel and behind Left Panel.
- Fasten with (16) Rivets (11054) and (16) Washers (11315). *Note Rivet from outside, washer inside.*
- Front Assembly must be behind two small L- Brackets at front of floor.



## 14. ATTACH FRONT ASSEMBLY TO FLOOR

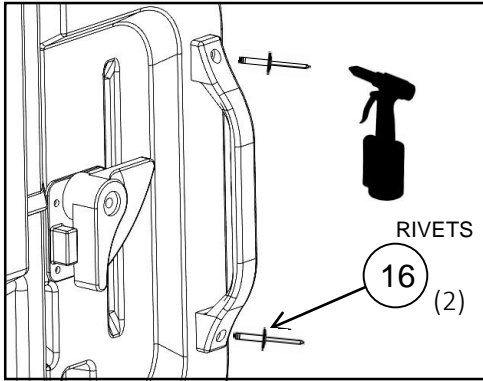
- Rivet Front Assembly to L- Brackets using Rivet ( 11270 ).
- Lift and support Restroom floor.
- Rivet Front Assembly to Floor using (8) Rivets ( 14351 ) and (8) Washers ( 11315 ).
- *Note Rivet from bottom, washer top inside.*



# INSTALL DOOR HANDLES

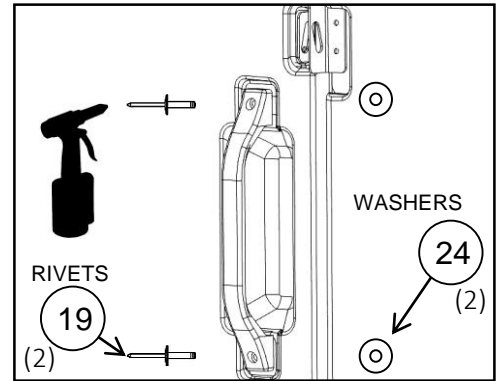
## 15. INTERIOR HANDLE ( 16807 )

- Align Handle with holes in door.
- Fasten with (2) black Rivets ( 17030 ).



## 16. EXTERIOR HANDLE ( 16807 )

- Align Handle with holes in door.
- Fasten with (2) Rivets ( 11270 ) & (2) Washers ( 11315 ).
- *Note Rivet from outside, washer inside*



# INSTALL DECAL

## 17. INSTALL DECAL TO FACING

- Align Decal with rivet, about 60" above floor.
- Center on right Facing.
- Remove backing and apply to Facing.



# INSTALL ROOF *Note Requires (2) people*

## 18. FASTEN ROOF TO PANELS AND FRONT

- Place Roof ( 18036 ) on top of restroom and slide pipe hole down over Vent Pipe .
- Align holes in Roof and Panels. ( SEE DIAGRAMS )
- Fasten roof to panels with Rivet ( 11054 ) and Washer ( 11315 ). *Note Rivet from outside, washer on inside.*
- Rivet Roof to Front Assembly using Rivets ( 22604 ).

