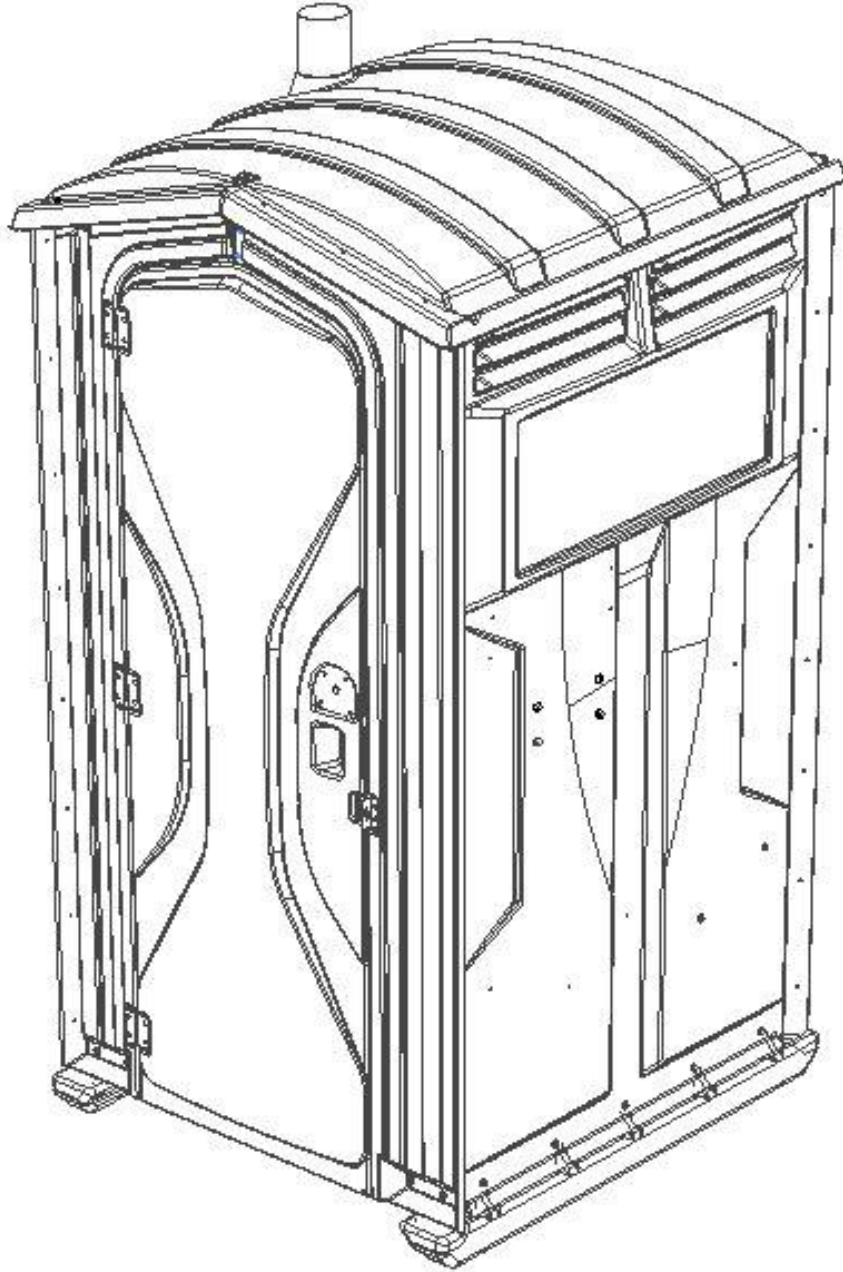


# TUFWAY®

## Portable Restroom Assembly 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)

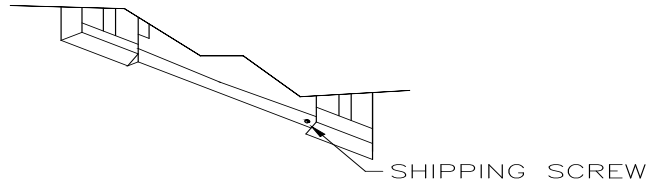
# INTRODUCTION

## Instructions for the Tufway portable restroom

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

The assembly procedures are written for assembly of single units. If assembling multiple units, considerable efficiency can be gained by working in assembly line fashion.

**IMPORTANT:** *Do not remove shipping screw from door until instructed in the “Install the Front Assembly” step.*



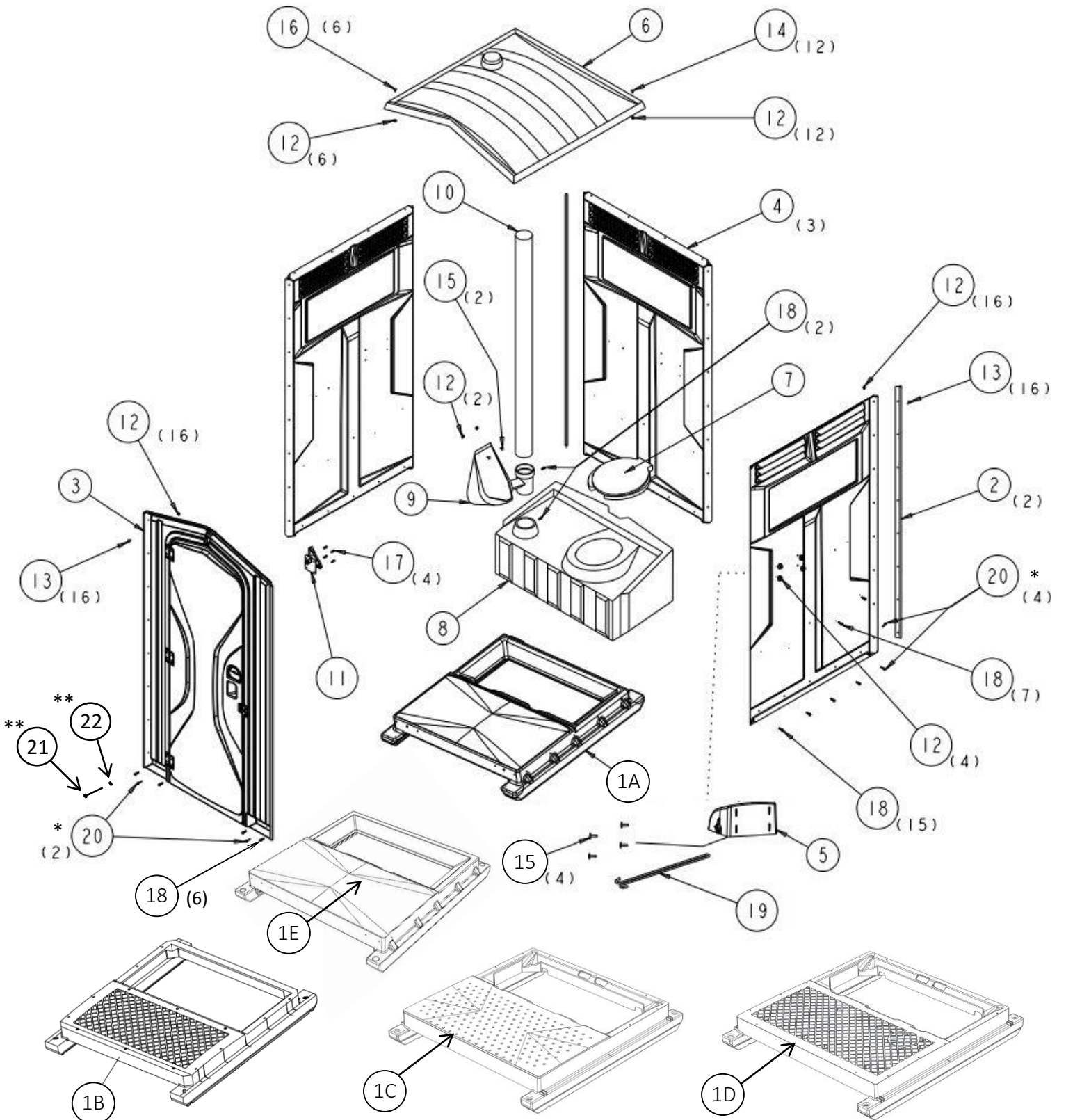
## TOOLS

1. C-CLAMP (SATELLITE PN 11593)
2. DRILL ELEC/CORDLESS
3. 3/8 NUT DRIVER BIT
4. 1/4 DRILL BIT
5. HAMMER
6. BLOCK OF WOOD 2X1-1/2 X 6
7. HAND RIVETING TOOL (SATELLITE PN 15814)
8. DEBURRING TOOL
9. #2 PHILLIPS SCREWDRIVER OR BIT
10. 5/16 DRILL BIT
11. APRONS (CARPENTERS)
12. 1/2 WRENCH OR SOCKET AND RACHET SET

## HELPFUL HINTS

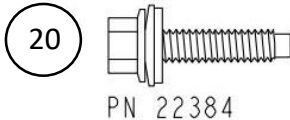
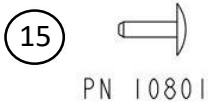
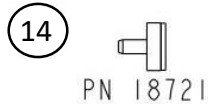
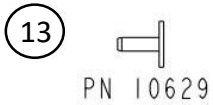
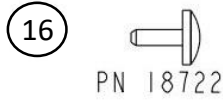
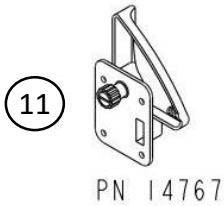
- Have an apron with at least two large pockets that allow the parts to be remove easily.
- Don't open up all your kit boxes. Open up only enough kit boxes to assemble the number of toilets you are currently working on. **KEEP PARTS ORGANIZED.**
- Use toilet paper holders for parts bins on multiple unit assembly
- The door latch can be put on at any time. It may be more efficient to have someone do this early on multiple unit assembly.

# EXPLODED UNIT ASSEMBLY



\* USED WITH BLOW MOLDED BASE ONLY

\*\* EUROPE ONLY



** EUROPE ONLY HARDWARE			
22	18191	1	NUT, 5/16" SERRATED FLANGE
21	13173	1	BOLT' 5/16 X 3-1/2 HWHD

HDWE, TUFWAY 3 ROLL 22332			
20	22384	6	BOLT- 1/4-20 X 1-1/4 DOG PNT WSH
19	22310	1	SPINDLE- PRGRD II 3 ROLL METAL
18	13860	30	SCREW, #14 X 1-1/2 W/WSH GOLD
17	10122	4	SCREW, #10 X 3/4 PN PH TAP
16	18722	6	RIVET, SOLID LONG DOME W/WSHR
15	10801	6	RIVET, SOLID LONG (DOME)
14	18721	12	RIVET, SOLID SHORT FLAT W/WSHR
13	10629	32	RIVET, SOLID SHORT (FLAT)
12	10047	56	PUSH CAP, 3/16 ID
11	14767	1	LATCH, RESTROOM PLASTIC

STANDARD TUFWAY			
10	14133	1	VENT PIPE. 4 X 62-1/2 GREY
9	14119	1	URINAL, STAND OVER DGRY
8	10553	1	TANK, TUFWAY DGRY
7	10570	1	SEAT, TOILET
6	16045	1	ROOF, TUFWAY DOME
5	22209	1	HOOD- PAPERGRD 3 ROLL DGRY
**	22332	1	HDWE, TUFWAY 3 ROLL
4	15450	3	DESIGN, TUFWAY PANEL
3	15562	1	DESIGN, TUFWAY FRONT ASSY (STD)
2	16050	2	CORNER MOLDING II BLACK PUNCH
1 E	19014	1	BASE, TUFWAY ROTO MOLD DGRY
1 D	10033	1	BASE ASSY- IMPACT GRID FLOOR
1 C	10034	1	BASE ASSY- IMPACT SOLID FLOOR
1 B	40014	1	BASE, GB DIRT BUSTER
1 A	22234	1	BASE- BLOWMOLDED
ITEM	PART#	QTY	DESCRIPTION

**\*\* For use with Roto Base Europe only**

22  
PN 18191

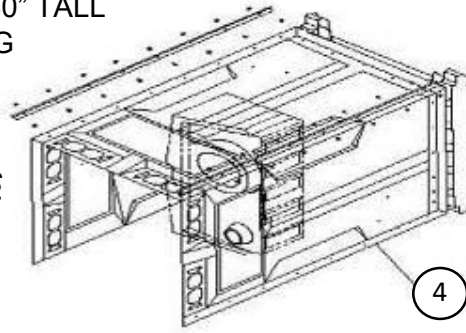
21  
PN 13173

\* USED WITH BLOW MOLDED BASE ONLY

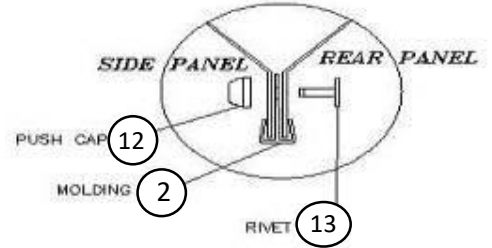
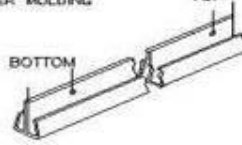
# DIRECTIONS

## 1. JOIN PANELS TOGETHER WITH CORNER MOLDING

- SET REAR PANEL ON A BOX AT LEAST 40" TALL BUT NOT WIDER THAN 41". IF ASSEMBLING SINGLE UNITS, THE WASTE TANK WILL DO. ASSEMBLE ALL PUSH CAPS TO RIVETS BY HAND, THEN CLAMP USING THE C-CLAMP TOOL; **ALL RIVETS & PUSH CAPS MUST BE CLAMPED TIGHT.**



DISTANCE FROM RIVET HOLE TO END OF MOLDING IS NOTICEABLY SHORTER AT TOP OF CORNER MOLDING



## 2. ATTACH BASE TO PANELS

TIP BASE UP AND POSITION INSIDE PANELS. USING THE DRILL AND 3/8" HEX DRIVER BIT. FASTEN PANELS TO BASE WITH LAG SCREWS (PN 13860 OR BOLTS PN 22384).

**BLOWMOLDED BASE:** LOCATE DIMPLES & INSERTS ON BASE (see below). FASTEN PANELS TO BASE WITH SCREWS & BOLTS. INSTALL REMAINING SCREWS IN HOLES.

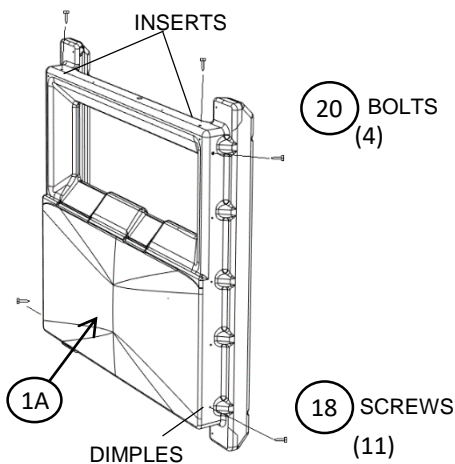
**DIRT BUSTER BASE:** FASTEN REAR PANEL FIRST. PANEL NEEDS TO BE FLUSH WITH TOP OF RUNNER. USE CENTER SCRIBE LINE ON BASE TO ALIGN PANEL, INSTALL SCREWS. REPEAT PROCESS ON SIDE PANELS USING SCRIBE LINES TO CENTER (see below)

**NOTE: PANEL MUST BE FLUSH WITH BASE BEFORE FASTENING PANEL TO BASE.**

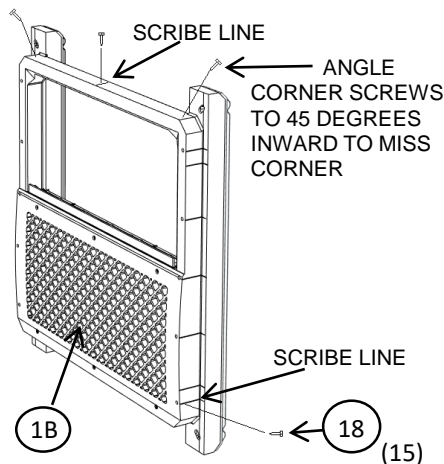
**IMPACT BASES:** FASTEN REAR PANEL FIRST. USE THE CENTERING BUMP ON THE BASE TO CENTER THE PANEL THEN FASTEN THE REAR PANEL WITH LAG SCREWS. \*\* REPEAT PROCESS ON SIDE PANELS, USE THE CENTERING BUMPS TO CENTER PANELS AND INSTALL REMAINING SCREWS (see below).

**\*\* NOTE: SIDE PANELS MUST BE FLUSH WITH SPACING RIBS AT EACH CORNER.**

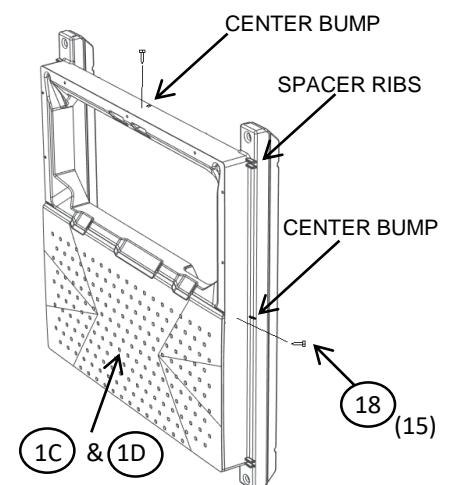
### BLOWMOLDED



### DIRT BUSTER BASE



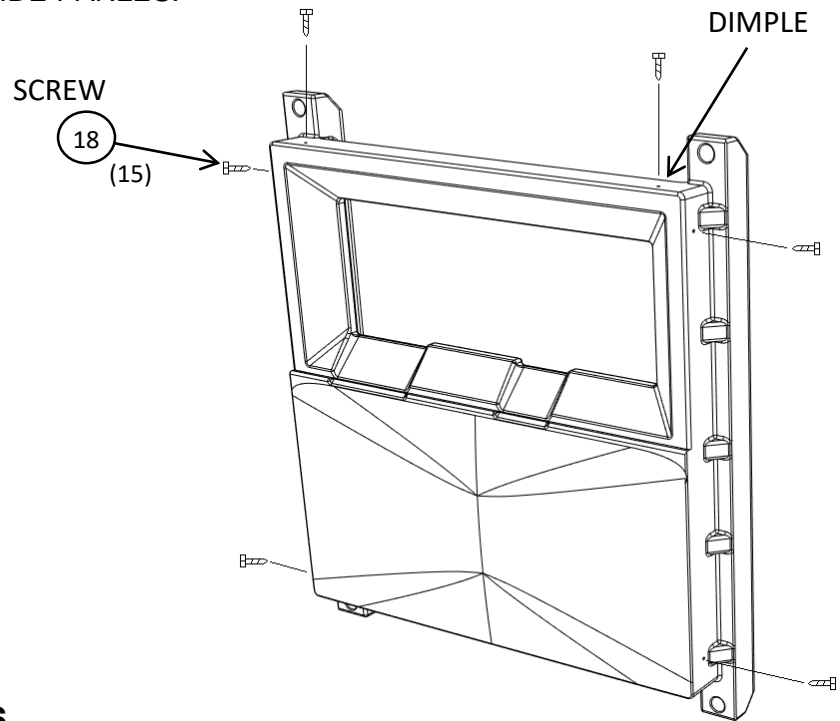
### IMPACT BASES





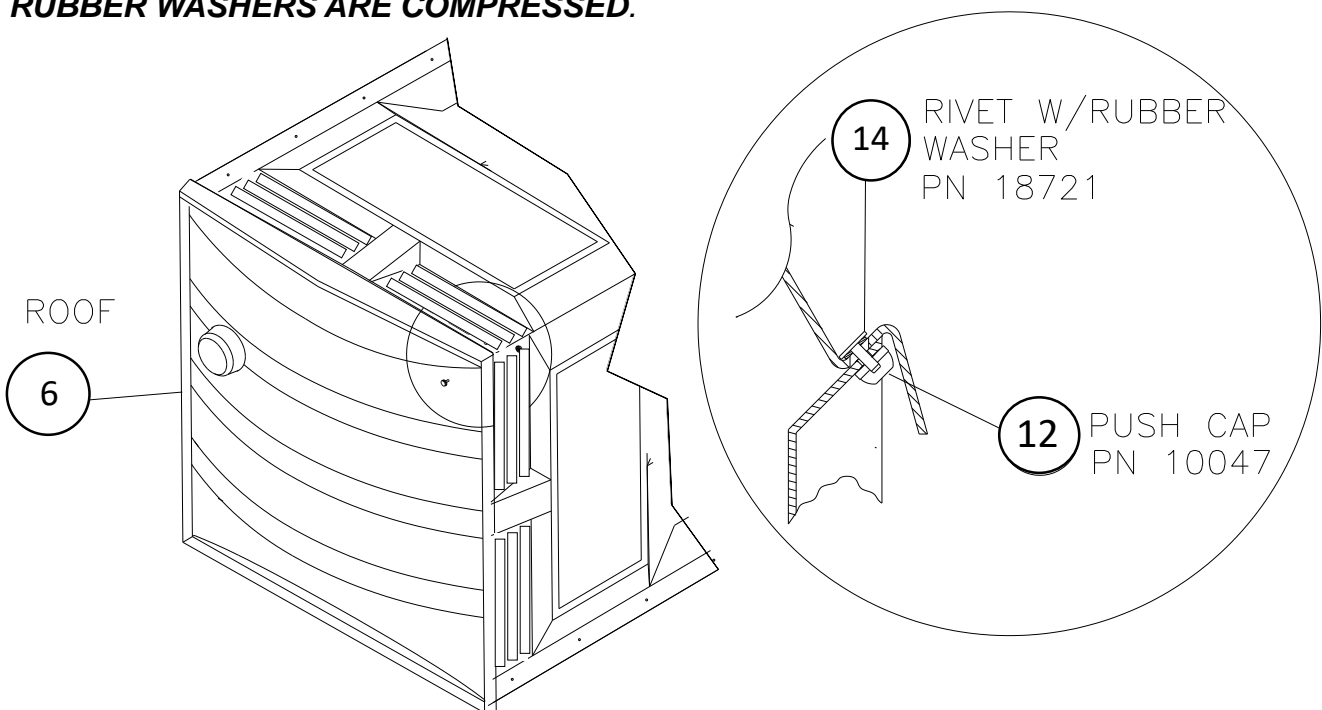
### ROTO BASE:

- STARTING WITH REAR PANEL LOCATE DIMPLES ON BASE (see below).
- ALIGN OUTER PANEL HOLES WITH DIMPLES.
- USING THE DRILL AND 3/8" HEX DRIVER BIT INSTALL SCREWS (PN 13860).
- INSTALL REMAINING SCREWS IN HOLES.
- REPEAT PROCESS FOR SIDE PANLES.



### 3. ATTACH ROOF TO PANELS

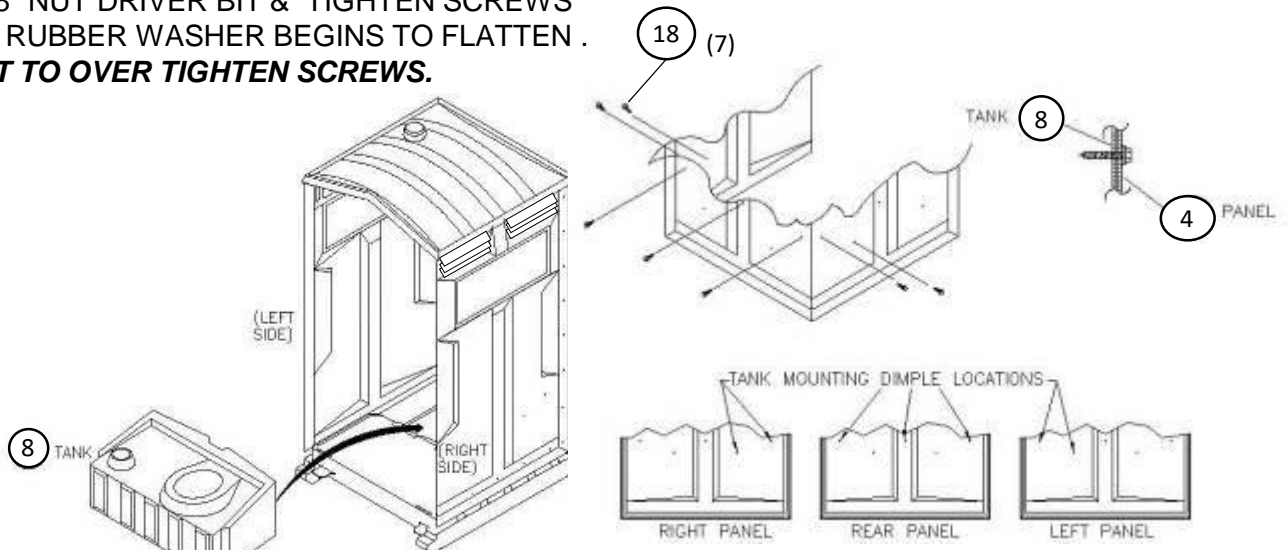
- TILT ROOF UP AND POSITION OVER PANELS.
  - INSTALL ALL RIVETS & PUSH CAPS BY HAND USING THE C-CLAMP TOOL.
- ALL CAPS & RIVETS MUST BE CLAMPED TIGHT UNTIL RUBBER WASHERS ARE COMPRESSED.**



**STAND UNIT UP ON BASE FOR THE NEXT ASSEMBLY STEPS**

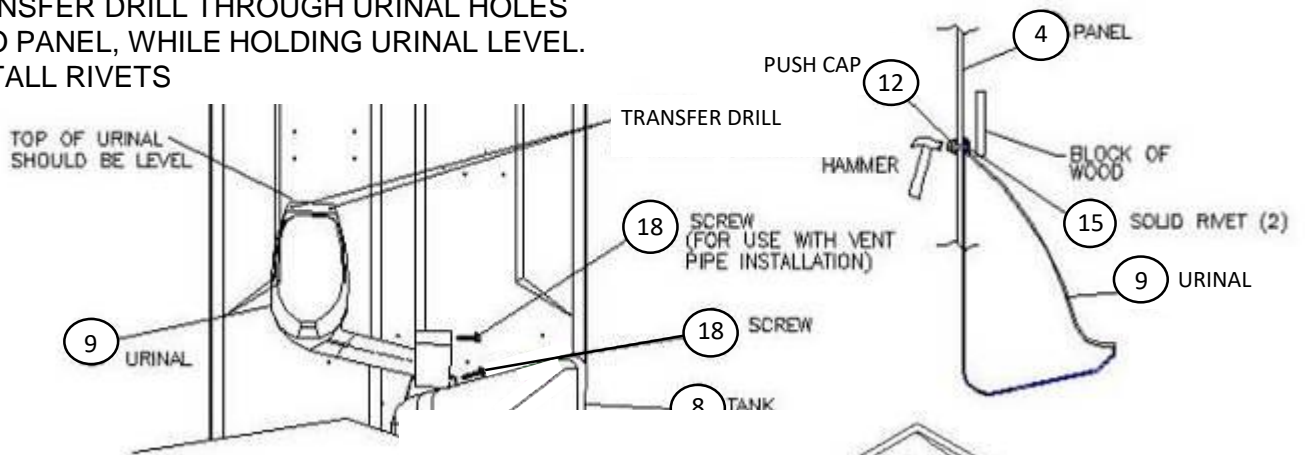
#### 4. PLACE TANK IN UNIT

- THE TANK MUST BE SEATED PROPERLY WHILE ATTACHING THE SIDE PANELS, HAVE A PERSON STAND IN TANK WHILE LAGGING PANELS TO TANK.
- USE 3/8" NUT DRIVER BIT & TIGHTEN SCREWS UNTIL RUBBER WASHER BEGINS TO FLATTEN. **DO NOT TO OVER TIGHTEN SCREWS.**



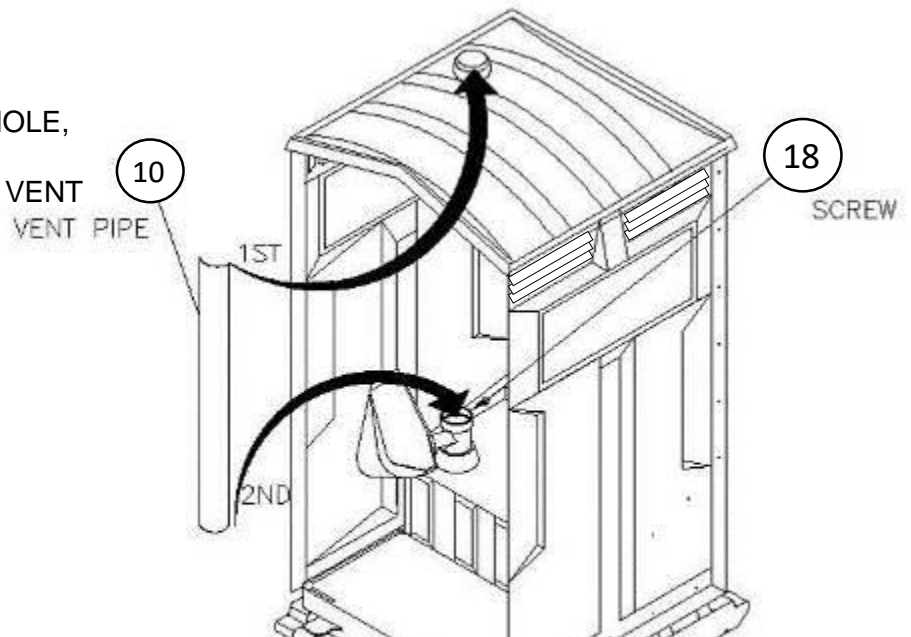
#### 5. INSTALL URINAL

- INSERT URINAL VENT PIPE INTO TANK VENT.
- LEVEL TOP EDGE OF URINAL.
- TRANSFER DRILL THROUGH URINAL HOLES INTO PANEL, WHILE HOLDING URINAL LEVEL.
- INSTALL RIVETS



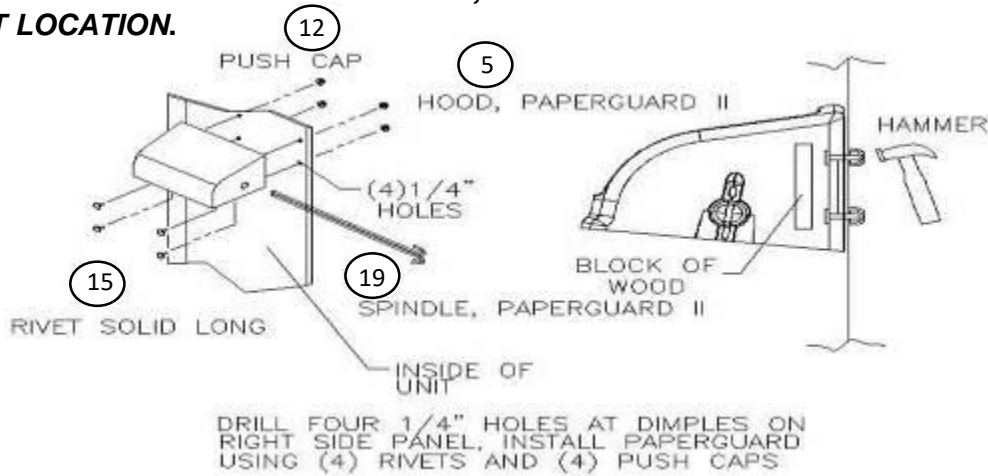
#### 6. INSTALL VENT PIPE

- INSERT VENT PIPE INTO ROOF HOLE, TWISTING PIPE MAY HELP.
- INSERT VENT PIPE INTO URINAL VENT
- INSTALL SCREW.



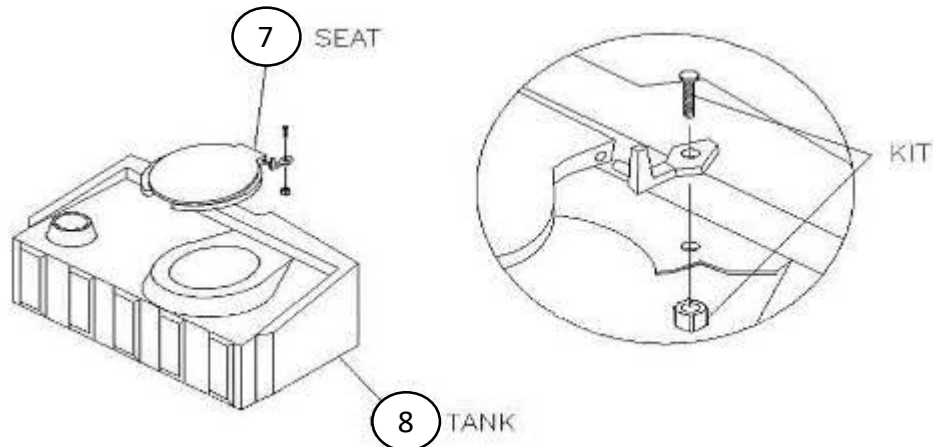
## 7. INSTALL PAPERGUARD

- DRILL (4) 1/4" HOLES AT DIMPLES ON RIGHT SIDE PANEL.
- INSTALL PAPERGUARD USING (4) RIVETS & (4) PUSH CAPS. **NOTE: IF INSTALLING OTHER ACCESSORIES SUCH AS A SLIMMATE SINK, THE PAPERGUARD MUST BE PLACED IN A DIFFERENT LOCATION.**



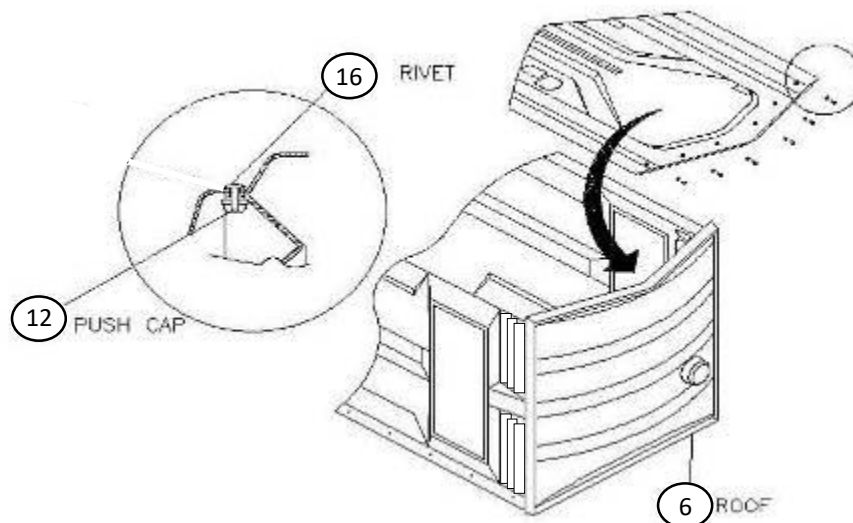
## 8. ATTACH TOILET SEAT

- USE A SCREWDIVER. (TIGHTEN SEAT HINGE NUT SECURELY)



## 9. ATTACH FRONT ASSEMBLY TO ROOF ( FOR THIS PROCESS LAY THE UNIT ON ITS BACK.

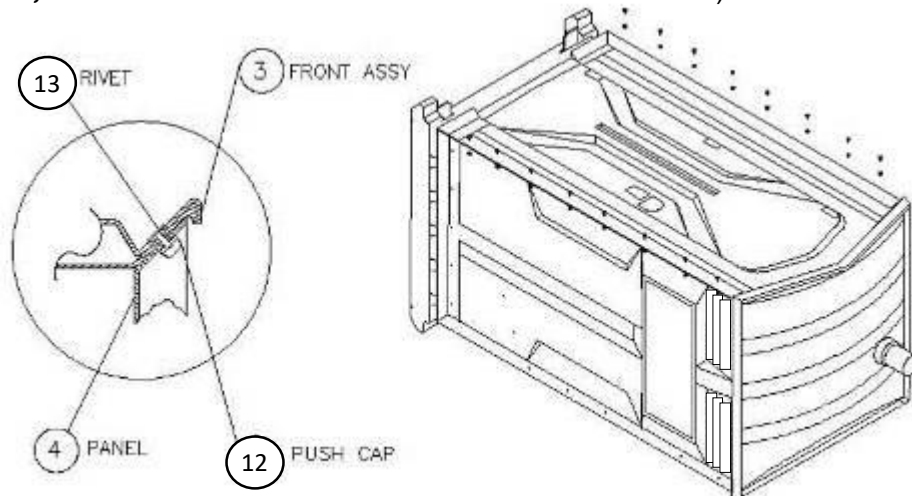
- INSTALL RIVETS AND PUSH CAPS WITH THE C-CLAMP TOOL (**CAPS & RIVETS MUST BE CLAMPED TIGHTLY, UNTIL RUBBER WASHERS ARE COMPRESSED**).





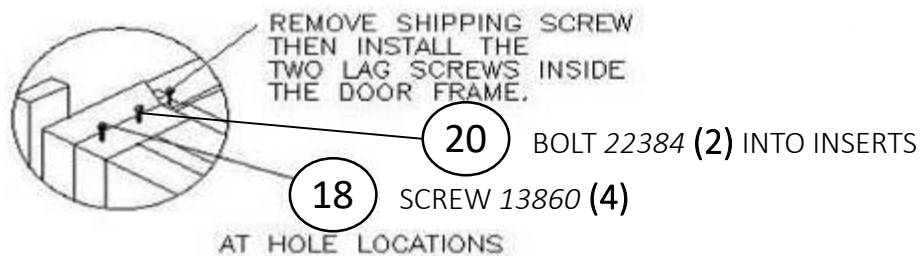
## 10. ATTACH FRONT ASSEMBLY TO SIDE PANELS

- INSTALL RIVETS AND PUSH CAPS WITH THE C-CLAMP TOOL (**CAPS & RIVETS MUST BE CLAMPED TIGHTLY, UNTIL RUBBER WASHERS ARE COMPRESSED**).

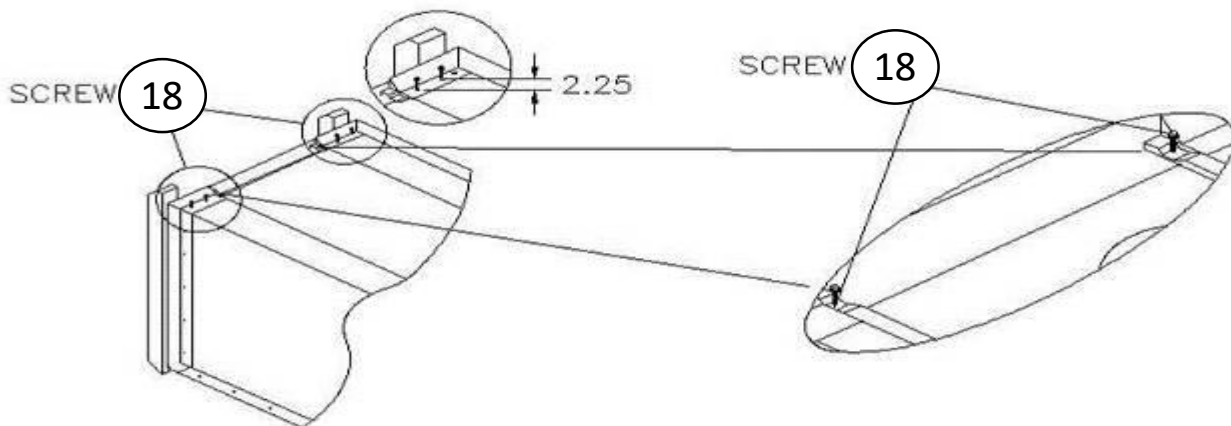


## 11. ATTACH FRONT ASSEMBLY TO BASE

- A. BLOWMOLDED BASE: SCREW / BOLT FRONT ASSEMBLY TO BASE**  
TIGHTEN LAG SCREW UNTIL RUBBER WASHER BEGINS TO FLATTEN – **DO NOT OVER TIGHTEN.**

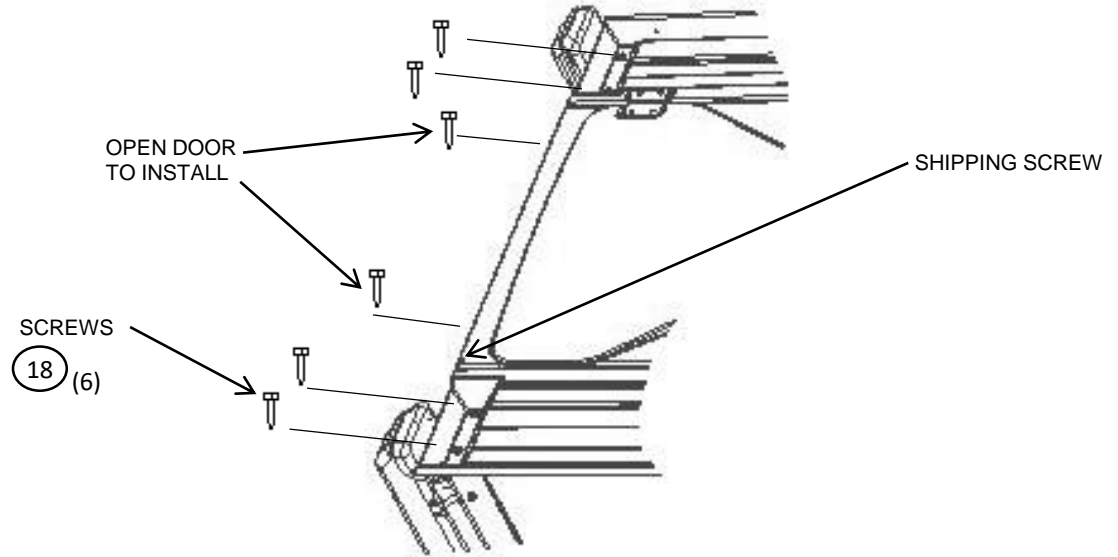


- B. DIRT BUSTER BASE: INSTALL SCREWS 13860 USING A 3/8 NUT DRIVER BIT. DRIVE SCREWS IN HOLES CLOSEST TO DOOR. MEASURE 2-1/4 FROM THAT SCREW AND FASTEN SECOND SCREWS IN NEW LOCATION. **SEE DIAGRAM.** REMOVE SHIPPING SCREW. OPEN DOOR AND INSTALL THE (2) SCREWS THROUGH DIMPLES ON INSIDE OF FACING FRAME. TIGHTEN SCREW UNTIL RUBBER WASHER BEGINS TO FLATTEN - **DO NOT OVER TIGHEN.****



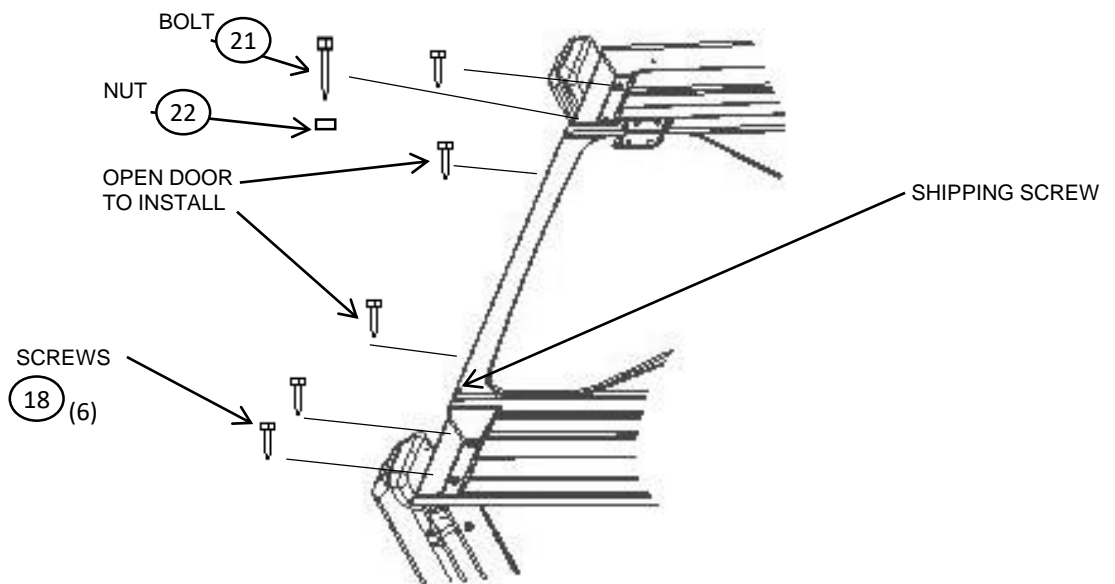
**C & D. IMPACT BASES:**

- INSTALL SCREWS 13860 (4) USING A 3/8 NUT DRIVER BIT.
- REMOVE SHIPPING SCREW.
- OPEN DOOR AND INSTALL THE (2) SCREWS THROUGH DIMPLES ON INSIDE OF FACING FRAME. TIGHTEN SCREW UNTIL RUBBER WASHER BEGINS TO FLATTEN - **DO NOT OVERTIGHTEN**.



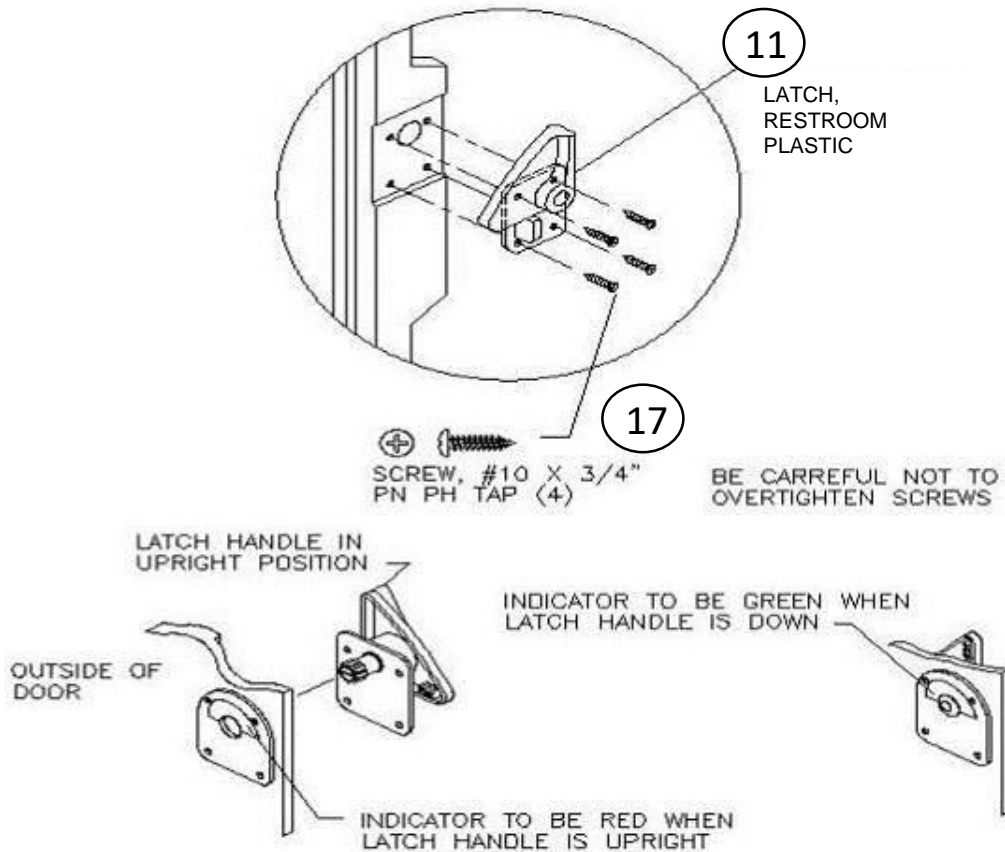
**E. ROTO MOLDED BASE: ( EUROPE ONLY )**

- INSTALL SCREWS 13860 (3) USING A 3/8 NUT DRIVER BIT.
- DRILL HOLE FOR BOLT USING 13/32 [ 10mm]
- INSTALL BOLT 13173 AND NUT 18191.
- REMOVE SHIPPING SCREW.
- OPEN DOOR AND INSTALL THE (2) SCREWS THROUGH DIMPLES ON INSIDE OF FACING FRAME. TIGHTEN SCREW UNTIL RUBBER WASHER BEGINS TO FLATTEN - **DO NOT OVERTIGHTEN**.



## 12. INSTALL DOOR LATCH

- USE PHILLIPS SCREWDRIVER TO INSTALL (4) #10 SCREWS THROUGH LATCH IN DOOR ASSY.



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