

Assmann Corporation of America

TANK INSTALLATION AND USE GUIDELINES FOR BULK STORAGE TANKS

General Information

Assmann polyethylene storage tanks are manufactured to give you the toughest, most reliable and economical vessels offered for storing industrial strength chemicals such as sulfuric acid, sodium hydroxide, sodium hypochlorite and many other corrosives. Our unique process utilizing uniform walls and air-cooling gives us an advantage over any other polyethylene tank manufactured today. However, these vessels are not immune to damage. Precautions must be taken while off loading, handling, installing, and using to protect your investment.

These handling and installation instructions are only recommendations and do not relieve the purchaser of the responsibility to inspect the tank upon delivery and to properly handle and install the vessel. Any damage that is the result of improper handling or installation will be the sole responsibility of the purchaser. Failure to comply with handling and installation instructions will void all warranties, expressed or implied. Misuse or undocumented applications are the burden of the purchaser.

Preparing The Tank Site

Complete bottom support of all polyethylene tanks must always be maintained.

Assmann Corporation recommends that all tanks be placed on a concrete foundation capable of supporting the weight of the tank with accessories and its intended service (chemical). Vertical tanks over 6500 gallon capacity require a reinforced concrete foundation. Tanks from 6500 gallon and below that cannot be placed on a concrete foundation must be placed on an area that is compacted, level, smooth, and free of any foreign objects that may damage the vessel.

Assmann Corporation also recommends that at least six (6) layers of roof felt be placed between the tank and its intended foundation. This will allow the tank to move without restriction.

Assmann Corporation is not responsible for damage due to improper tank base preparation.

Receiving Your Polyethylene Tanks

At the time of delivery the purchaser shall be responsible for inspecting the tank and accessories for shipping damage before off loading. If damage has occurred, it must be noted on the driver's shipping papers/bill of lading prior to signing

for acceptance regardless of whether it is Assmann Corporation's truck or a contract carrier. Look inside the tank for fittings or accessories that may have been shipped loose.

Failure to document damage or incompleteness of the vessel becomes the responsibility of the purchaser.

Contact Assmann Corporation for information on which party is responsible for filing the claim for damaged equipment.

Off Loading Polyethylene Tanks

Assmann rotationally molded tanks are by far the toughest polyethylene tanks offered to the industrial market. However, the fittings and tanks are susceptible to damage if improperly handled. **DO NOT ALLOW THE TANK TO ROLL OVER INSTALLED FITTINGS. Whenever possible, use a crane or other suitable lifting devices to remove the tanks from the truck.** Because the stability of the tanks can be affected by wind, the party responsible for off loading the tank shall secure the tank to keep total control of the vessel while handling. See figure #1 and #2 for suggestions on how to handle the tanks when off loaded.

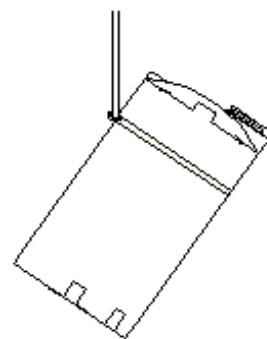
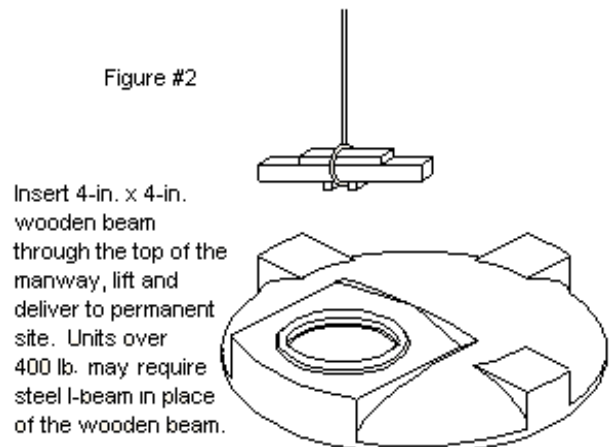


Figure #1

Using an overhead lifting device, make a choker collar and grasp top one-third of the tank while gently raising. Lower onto permanent site. Use caution to prevent the tank from slipping on the foundation.

Figure #2



Insert 4-in. x 4-in. wooden beam through the top of the manway, lift and deliver to permanent site. Units over 400 lb. may require steel I-beam in place of the wooden beam.

Do not use factory-installed fittings as lifting lugs.

Tank Piping

All pipes, valves and other accessories must be independently supported. **Do not support piping, valves or other accessories with tank connections.**

Note: Flexible expansion joints must be used on all sidewall fittings to allow the tank to expand and contract while filling or draining. Not using the expansion joints may result in premature failure of the vessel.

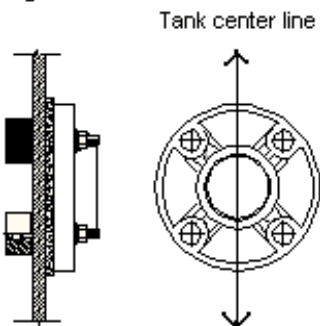
Assmann recommends that a hydro-test be performed after the installation is complete to ensure all piping has been installed properly.

Installation Of Fittings And Accessories

Flange Fitting Assembly

1. Locate on the tank where you want to place the fitting and mark the tank.
2. Place the flange on the tank and trace the center hole and the bolt holes on the flange. **Note: The bolt holes must straddle the centerline of the tank.** See figure #3

Figure #3



3. Drill pilot holes in the center of each hole traced using a 1/4" drill.
4. For the center hole you will need a hole saw the same size as the flange. **Example:** A two-inch flange will require a two-inch hole saw.
5. Carefully drill out the center hole with the hole saw.
6. Use a 1/2" drill to finish the bolt holes. The bolts should fit snug when placed through the holes.
7. Trim all burrs inside and out that may have been caused by drilling.
8. Place the bolts through the tank wall so the threads are outside and the gasket head is on the inside.

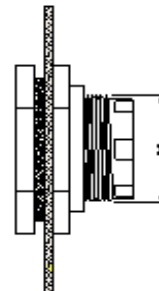
9. Slip the flange gasket over the threads on the bolts. Push the gasket flush against the tank wall.
10. Slip the flange over the bolts.
11. Coat the threads of the bolts with anti-seize to keep the threads from gulfing.
12. Place the flat washer, lock washer, and nut on the bolt threads and torque to 11-ft. lbs.
13. Hydro-test before introducing chemical.

Installation of Bulkhead and Self-Aligning Dome Fittings

Note: Do not install self-aligning dome fittings in the sidewall of the tank. **Self-aligning fittings are for top use only.**

1. Locate on the tank where you want to place the fitting and mark the tank. **Do not locate sidewall fittings too close to the bottom radius on tank.**
2. Drill a pilot hole using a 1/4" drill.
3. Measure the body of the bulkhead fitting you intend to install. See figure #4

Figure #4

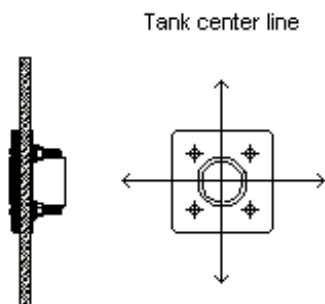


4. Using a hole saw that is slightly larger than the body of the bulkhead fitting, carefully drill the access hole.
5. Trim all burrs inside and out that may have been caused by drilling.
6. Place the body of the bulkhead fitting with the gasket through the hole from the inside.
7. Thread the nut of the bulkhead on hand tight. Hold the body of the bulkhead fitting steady and tighten the nut another 1/4 to 1/2 turn.
8. Hydro-test before introducing chemical.

Installation of Stainless Steel Bulkhead Fitting

1. Locate on the tank where you want to place the fitting and mark the tank.
2. Place the backer plate on the tank wall and trace the center hole and the bolt holes. **Note: The bolt holes must straddle the centerline of the tank.** See figure #5

Figure #5



3. Drill pilot holes in the center of each hole traced using a 1/4" drill.
4. For the center hole you will need a hole saw slightly larger than the outside diameter of the pipe nipple (male fitting) or coupler (female fitting).
5. Carefully drill out the center hole with the hole saw.
6. Use a 3/8" drill to finish the bolt holes. The bolts should fit fairly snug when placed through the holes.
7. Trim all burrs inside and out that may have been caused by drilling.
8. Install the body of the bulkhead with the gasket through the inside of the tank.
9. Slip the backer plate over the threads and the pipe connection. Push the plate flush against the tank.
10. Coat the threads of the bolts with anti-seize to keep the threads from galling.
11. Place the lock washer and nut on the threads and torque to 11-ft. lbs.
12. Hydro-test before introducing chemical.

Installation of U-vent Assembly

All u-vents must be located on the top dome of the tank.

Normally, the bulkhead fitting for the u-vent will be factory installed. If not, follow instructions on how to install bulkhead fittings. **U-vent assemblies are normally shipped inside the tanks to avoid damage in transit.**

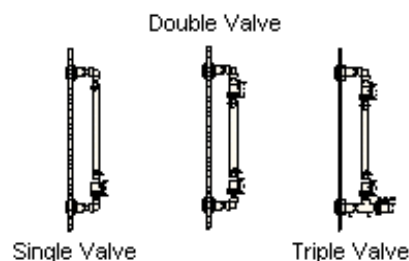
1. Thread or glue the u-vent assembly to the appropriate fitting.

Installation of Sight-glass Assembly

Normally, the bulkhead fittings for the sight-glass assembly will be factory installed. If not, follow instructions on how to install bulkhead fittings. **Sight-glass assemblies are normally shipped inside the tanks to avoid damage in transit.**

Assmann Corporation offers three styles of sight-glass assemblies. See figure #6 for the style you received.

Figure #6



1. Coat the threads of the bottom assembly with pipe joint compound and thread into the bottom bulkhead fitting. **Do not over tighten.** Align the hose barb in the vertical position so the barb is pointing straight up.
2. Follow the same steps for the top assembly. This time the hose barb will point down.
3. Cut the flexible PVC tubing to the necessary length. Slip the hose clamps over the tubing and slide the tubing over the hose barbs.
4. Tighten the hose clamps snug over the tubing and barbs.
5. Hydro-test before introducing chemical.

Installation of Fill Line Assembly

1. Remove the ball valve from the fill line assembly.
2. Slip the threaded end of the fill line through the bracket on the sidewall of the tank.
3. The fill line will have a half union with o-ring. Carefully remove the tape that holds the o-ring in place while shipping. Place the o-ring in the groove cut into the union and thread the two halves back together.
4. Use pipe joint compound on the pipe threads at the bottom of the fill line assembly and reinstall the ball valve.
5. Hydro-test the assembly before introducing chemical.

Installation of Tie Down Assembly

1. Place the straps of the tie down assembly around the bottom of the tank.
2. Bolt the straps loosely together so you will be able to slide the straps up into place.
3. Slip the carriage bolts through the precut holes in the center of each strap.
4. Slide the strap up the tank so that the legs can be fastened to the carriage bolts.
5. Mark the holes in the legs where the anchors will be installed and rotate the assembly slightly for drilling.
6. Drill and install the anchors. Rotate the assembly back to its original location.
7. Carefully snug the straps around the tank. **CAUTION: Do not over tighten the straps around the tank.**
8. Tighten the legs to the pad using anchors.

Installation of Bolted and Gasketed Cover

1. Place the flat plate on the top of the tank and mark out the hole pattern.
2. Drill 1/4" pilot holes in the center of each hole marked on the tank.
3. Drill each pilot hole with a 15/32" drill.
4. Thread the holes with a 1/2-13 tap.
5. Set the gasket on the tank top and line up the holes.

6. Place the flat plate on the gasket and carefully thread one of the PVC bolts into the tank. **Do not over tighten.**
7. Check each existing hole for alignment and continue installing the remainder of the bolts.

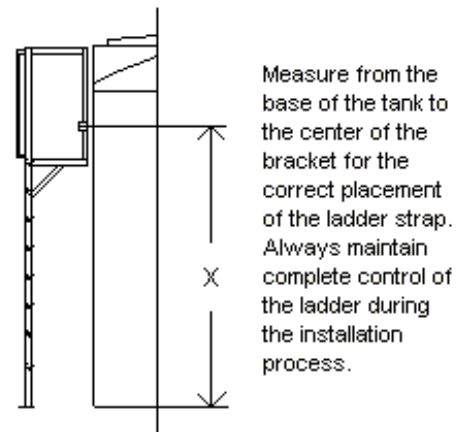
If you have any questions concerning installation call:

Assmann Corporation of America (219) 357-3181

Installation of Ladder Assembly

1. Carefully place the ladder at the desired location. Mark the bottom legs for the anchors, and mark the centerline height of the two holes located near the platform. See figure #7

Figure #7



2. Carefully set the ladder on its side away from the tank.
3. Drill the holes for the base of the ladder and install anchors.
4. Place the straps around the bottom of the tank.
5. Bolt the straps loosely together so you will be able to slide the straps into place. Locate the studs on the straps at the height established when you marked the tank.
6. Set the ladder in place so that the bracket slips over the studs. You may have to adjust the strap height.
7. Fasten the ladder to the tank with the hardware supplied with the ladder.
8. Fasten the base of the ladder to the anchors you previously drilled.

