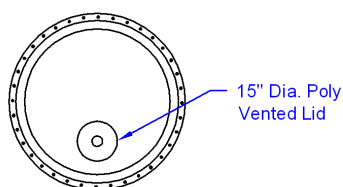


ASSEMBLY INSTRUCTIONS ABOVE GROUND STORAGE TANKS

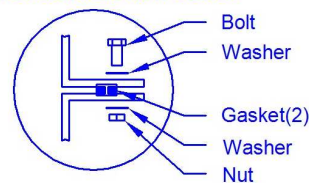
1. Prepare bed for tank to sit upon. The bed must extend at least 12" beyond tank floor in all directions.
2. Bed material can either be a concrete pad, engineered to withstand the forces of the tank and its contents, or stone or gravel crushings, not smaller than 1/8" or larger than 1/2" in diameter.
3. Bedding material should not contain more than 30% fines.
4. Finished bed should be an evenly tamped, level surface.
5. If overall tank height is greater than 15 feet, consult a Professional Engineer with expertise in soil science analysis to ensure proper site preparation.
6. For water storage tanks, install the female bulkhead fitting that is provided with the tank, in bottom section, where hole is cut.
7. Plug bulkhead and test for leakage. Elevate and block the side of tank opposite the fitting and submerge the fitting with water. Leave for minimum 1 hour and then check for leaks. Repair and recheck if necessary.
8. Make sure surface of flanges are clean and dry.
9. Apply gaskets to bottom section of tank between bolt holes and inside rim of tank. (See diagram). Remove paper backing.
10. Lower next section (or top depending on model) onto spacer blocks at the 3, 6, 9, 12 o'clock positions. Line up holes, using a tapered punch or a screw driver as a guide. Be sure to match the locations of the two (2) little holes on the lowered section and the section you are lowering it onto. As the gasket is very adhesive, only a minimal amount of play is allowed once the section is on.
11. Put one bolt and washer in every hole to make sure all holes are aligned before putting the remaining hardware on. Snug up the bolts at the 3, 6, 9, and 12 o'clock positions first, and then snug up the remaining bolts in an alternating pattern. Ensure that the components are assembled when they are at or above standard room temperature.
12. Use approximately 15 pounds of torque at 70 degrees Fahrenheit (20 degrees Celsius). This should be done gradually to ensure the gasket is properly seated on the flange(s). (Double check bolt torque approximately one hour after assembly.)

CAUTION: When using your tank, ALWAYS have vent open.

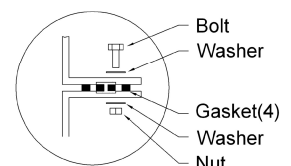
TOP VIEW



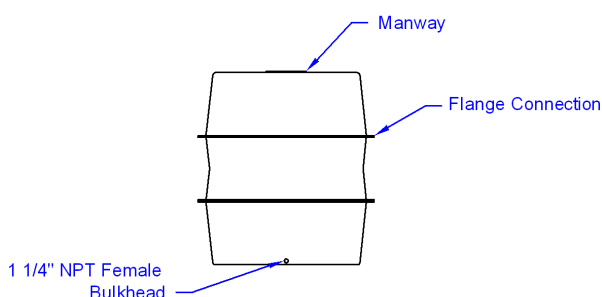
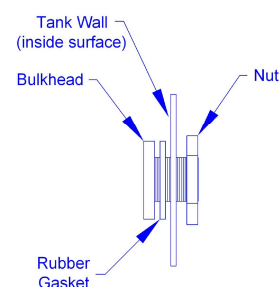
FLANGE CONNECTION DETAIL



FLANGE CONNECTION DETAIL
(12' Dia. Tanks Only)



BULKHEAD INSTALLATION



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