

# OFF-LOADING INSTRUCTIONS

- Keep personnel clear of tank, rigging, and lift equipment! Improper and unsafe unloading can result in property damage, serious injury, or death.
- DO NOT STAND OR WORK ON TOP OF TANK. The tank surfaces are flexible and slippery, which could cause a dangerous fall. The tank dome is not load rated, as it is not required per ASTM D1998-06; therefore, it cannot be guaranteed that the top of the dome can support the weight of personnel.
- Whether unloading or moving, the tank must be fully drained before lifting.
- Use of Lifting Lugs:
  - Consult the tank drawing for the proper number of molded-in lifting lug sets to use during a lift. Two molded lugs constitute a set. See picture below.



- Position the boom of the crane directly over the centerline of the tank lying on its side near the dome (top). Use all lifting lug sets as the lift points (the holes in the lifting lugs have a 1-3/8-in diameter and are spaced 8-in from side to side). Thread a bolt through each eyelet that is large enough to take up as much of the hole as possible to improve lifting control. Ensure each bolt and cable have a lifting capacity of a minimum 3000 pounds. (INSULATED TANKS: Extreme care should be taken to ensure that during the attachment of the bolts and cables from the boom position to the lifting lugs, none come in contact with the tank, causing damage to the foam surface. To prevent this from happening, attach pieces of cardboard to the dome, near the lifting lug positions to protect the sensitive surface area from any contact during the lifting process. Once you have confirmed that all Lifting Lugs are properly attached and the slack in the cables have been removed, it is now an appropriate time to cut away the protective wrap and wooden cradle before starting the lifting process)
- Slowly begin to raise the tank into an upright position. Take extreme care in balancing the weight of the tank. (INSULATED TANKS: The bottom portion of the foam area of the tank base will be crushed if it is allowed to tilt and sit on its own weight)
- Once the tank is positioned in its upright position, lift it up and lower the tank back onto the bed of the trailer. This will remove the tension from the cables temporarily to provide the opportunity to reposition the clamps and cables and find the true balance point positions. (INSULATED TANKS: Remove protective wrap and wooden cradle and discard)
- Raise the boom slowly until all slack has been removed from all lifting cables and you are assured the weight of the tank is now balanced. Lift the tank high enough to clear the trailer. You are now positioned to transport the tank to its final position.
- IMPORTANT NOTE: If the tank has an IMFO, before it is allowed to sit flat on its own weight at any point during the off-loading process, a block (preferably a 12-in 4x4) must be set underneath the IMFO base to keep it off the ground. This is necessary to keep the IMFO from being damaged (by design, it sits lower than the flat bottom of the tank).

- Use of Manway: Poly Processing strongly recommends the use of lifting lugs or truck straps underneath the tank to lift the tank. If those are not available then the following applies.
  - Use a lifting device as shown below. The bar should be a minimum 3-in in diameter, have adequate strength for the load, and range in length from 42-in to 46-in.



- Use of Forklift:
  - Ensure the forklift tines are smooth and free from burrs.
  - Use extended tines if handling a large tank.
  - Tie the tank to the forklift mast to prevent rolling or sliding.
  - Insert the forklift tines into the long side of the tank (either from the dome or floor) to achieve a balance point (INSULATED TANKS: Use the center point of the wooden cradle). Lift the tank off the bed of the truck. Back away from the truck slowly, as the weight of the tank and the cradle are both very heavy. Be prepared to stop and adjust your load if need be.
  - Slowly set the tank onto the floor in an unobstructed, flat area that allows for the forklifts to move around as needed. (INSULATED TANKS: Do not remove the stretch wrap protecting the tank at this time. It aids in preventing damage, positioning and holding the cradle to the tank, as it is lifted into the upright position.)
  - Set (3) or (4) 4x4 blocks on the floor in a pattern of the outside radius of the tank. This will aid in temporarily allowing the tank to be elevated off the ground to allow the forks to get underneath for transporting the tank to its final position.
  - Station another forklift on the opposite side of the tank. This forklift is used so the tank will not tip forward or rock back and forth and is used as a safety measure to catch the tank as it is stood up. Using cardboard sleeves or other protective methods, wrap the ends of the forks to prevent the tank from being gouged in the event the forks touch the tank as it is being stood up. Raise and widen the fork spacing to straddle the outside radius of the tank.
  - From the dome (top) end of the tank, insert the forks near the center (balance point) of the tank. Slowly lift the cradle up and set the tank upright onto the 4x4 blocks. (INSULATED TANK: You may now safely remove the stretch wrap and cradle from the tank. CAUTION: As you remove the wrap, position the forks of one of the forklifts to catch the wooden cradle to keep it from falling on its own and preventing any injuries to anyone in the area. Once the wrap is removed, slowly lower the forks until the cradle gently lies back onto the ground. Discard cradle and wrap.)
  - Set tank upright over the blocks so the tank is positioned and the weight is equally distributed. Insert the forks of one of the lifts under the bottom of the tank and lift the tank slowly, just enough to clear the blocks, and transport the tank to the desired location, SLOWLY.