

ITEM	Part No.	DESCRIPTION	QTY	UNITS	Ref No.	Ref Qty.	ITEM	Part No.	DESCRIPTION	QTY	UNITS	Ref No.	Ref Qty.
1	NA	Ø 1.913" [48.6MM] THRU HOLE TANK DRAIN	1	ea	NA	0.00	60	NA	BLOCK OFF PLATE FOR 2 3/8" FRONT WATER FILL FLANGE	1	ea	NA	0.00
2	NA	2 3/8" FLANGE FOR 2" WATER FILL W/J-TUBE	2	ea	NA	0.00	65	824-1272	BOSS Rc 1/2	2	ea	824-1272	2.00
3	NA	2 3/8" FLANGE FOR 2" WATER SUPPLY W/J-TUBE	1	ea	NA	0.00	67	NA	PIPE, 4" SCH 80, T.D.E.	2	ea	140-1001-014	1.45
4	824-1273	BOSS Rc 3/8	3	ea	824-1273	3.00	68	200-0108	EYEBOLT - LAG THREAD	2	ea	200-0108	2.00
5	NA	3 1/2" FLANGE FOR 3" TANK SUCTION W/DIP TUBE	1	ea	NA	0.00	69	160-1041	2" 45° ELBOW, ENFIELD	1	ea	160-1041	1.00
6	NA	MANHOLE (SEE DETAIL)	1	ea	NA	0.00							
7	NA	WATER OVERFLOW DOME	1	ea	NA	0.00							
8	990-1148	4' VENT/OVERFLOW PIPE	2	ft	140-1001-004	9.06							
9	NA	FLANGE, 2 3/8" WATER FILL (SEE DETAIL) PT2	2	ea	NA	0.00							
10	NA	FLANGE, 3 1/2" WATER SUCTION (SEE DETAIL) PT2	1	ea	NA	0.00							
11	NA	FLANGE, 2 3/8" WATER FILL (SEE DETAIL) PT2	1	ea	NA	0.00							
12	NA	BLOCK OFF PLATE FOR 2 3/8" PS & DS WATER FILL FLANGE	2	ea	NA	0.00							
13	NA	BLOCK OFF PLATE FOR 3 1/2" SUCTION FLANGE	1	ea	NA	0.00							
14	NA	BLOCK OFF PLATE FOR 1 29/32" WATER SUMP DRAIN	1	ea	NA	0.00							
15	205-0012	GASKET-NEDPRENE-BLACK (CUT TO SHAPE)	4	sqft	205-0012-004	4.5							
16	200-0019-009	M10 X 1.5 BRASS INSERTS (FROM YARDLEY)	9	ea	200-0019-009	9.00							
17	824-1140	12mm X 12MM SQUARE O-RING	1	ea	824-1140	1.00							
18	200-0019-011	M12 X 25 mm LONG BRASS INSERTS (FROM THE INSERT CD)	16	ea	200-0019-011	16.00							
19	200-0019-012	M16 X 25 mm LONG BRASS INSERTS (FROM THE INSERT CD)	4	ea	200-0019-012	4.00							
20	200-0037-006	M10 X 30 mm WING HD THUMB SCREW, STAINLESS STEEL	9	ea	200-0037-006	9.00							
21	200-0003-027	M10 FLAT WASHER, STAINLESS STEEL	9	ea	200-0003-027	9.00							
22	824-1124	BOSS G 1-1/4	1	ea	824-1124	1.00							
23	824-1121	BOSS Rc 1/2 (BOTH ENDS)	1	ea	824-1121	1.00							
24	824-1122	BOSS Rc 3/4	1	ea	824-1122	1.00							
25	824-1123	BOSS Rc 3/4 (BOTH ENDS)	1	ea	824-1123	1.00							
26	160-1032	3" 90° ST ENFIELD ELBOW TRIMMED FLUSH W/ EXTERIOR OF BLOCK	1	ea	160-1032	1.00							
27	160-1002	2" 90° ENFIELD ELBOW	9	ea	160-1002	9.00							
29	160-1032	3" 90° ST ENFIELD ELBOW TRIMMED TO FLOOR, CENTERED OVER HOLE	1	ea	160-1032	1.00							
30	NA	ANTISWIRL PLATE INSTALLATION	1	ea	NA	0.00							
36	824-0166	LIFTING PEG	2	ea	824-0166-002	2.00							
41	824-0379-001	PEG, HOLD DOWN	2	ea	824-0379-001	2.00							
42	200-0037-005	SCREW, HEX CAP - M16 P2 X 30mm MEDIUM STRENGTH STEEL	4	ea	200-0037-005	4.00							
43	200-0003-032	M16 FLAT WASHER, ZINC-PLATED CLASS 4 STEEL	4	ea	200-0003-032	4.00							
44	200-0037-004	SCREW, HEX CAP M12 PL.75 X 30mm MEDIUM STRENGTH STEEL	16	ea	200-0037-004	16.00							
45	200-0003-031	M12 FLAT WASHER, ZINC-PLATED CLASS 4 STEEL	16	ea	200-0003-031	16.00							
48	160-1063	4" ADAPTER, ENFIELD	2	ea	160-1063	2.00							
49	NA	Ø8" ANTI-SURGE PIPE, 10" LONG	2	ea	140-1001-006	1.66							
52	NA	3/4" BSPT TAPPED THRU HOLE	1	ea	NA	0.00							
54	200-0002-042	ROUND FINISHING PLUGS FOR TUBING, 0.344"-0.444"	2	ea	200-0002-042	2.00							
56	824-1129	MOUNTING BLOCK, ASSY 6 HOLE	2	ea	824-1129	2.00							
57	160-1004	4" 90° ENFIELD ELBOW	4	ea	160-1004	4.00							

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED
	A	SEE ECN #C-7901	5/24/17	MM
	B	SEE ECN #C-7921	12/07/17	MAA
	C	SEE ECN #C-8119	12/21/17	MM
	D	SEE ECN #C-8377	8/22/18	MM
	E	SEE ECN #C-8830	10/17/2019	MAA
	F	SEE ECN #C-9103	05/21/2020	RCM
	G	SEE ECN #C-9113	08/12/2020	VS
	H	SEE ECN #C-9503	08/10/2021	RC
	I	SEE ECN #C-9552	08/13/2021	RC
	J	SEE ECN #C-9676	12/01/2021	RC

**MATERIAL SPECIFICATION:**  
COVERS - 3/4" BLACK TEXTURED  
SHELL - 1/2" BLACK TEXTURED  
TOWER - 1/2" BLACK TEXTURED  
MANWAY - SEE PAGE 4 FOR MATERIAL SPECIFICATION  
FLANGED BLOCKS - 1 1/2" BLACK SMOOTH COPOLYMER


\*\*\* WELD COVERS PER 980-1002 \*\*\*

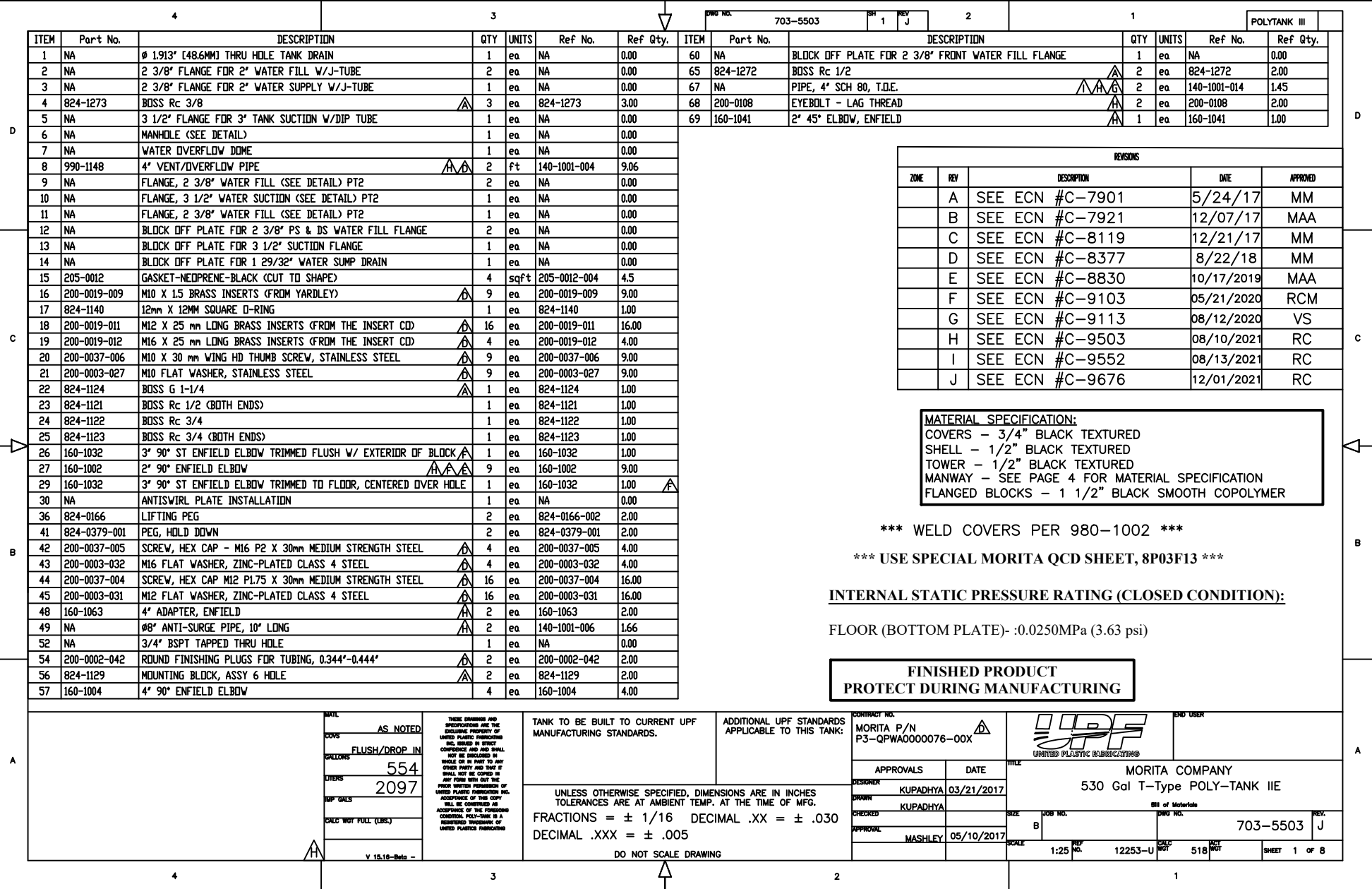
\*\*\* USE SPECIAL MORITA QCD SHEET, 8P03F13 \*\*\*

**INTERNAL STATIC PRESSURE RATING (CLOSED CONDITION):**

FLOOR (BOTTOM PLATE)- :0.025MPa (3.63 psi)

**FINISHED PRODUCT  
PROTECT DURING MANUFACTURING**

MAIL AS NOTED COVS FLUSH/DROP IN GALLONS 554 LITERS 2097 IMP GALS OADR NOT FULL (CBS) V 15.16-Beta -	THESE DRAWINGS AND SPECIFICATIONS ARE THE EXCLUSIVE PROPERTY OF UNITED PLASTIC INDUSTRIES INC. ISSUES IN DIRECT CONFERENCE AND SHALL NOT BE REPRODUCED OR COPIED IN ANY FORM WITH OUT THE WRITTEN PERMISSION OF UNITED PLASTIC INDUSTRIES INC. ACCEPTANCE OF THIS COPY SHALL BE CONSIDERED AS A REGISTERED TRADEMARK OF UNITED PLASTIC INDUSTRIES	TANK TO BE BUILT TO CURRENT UPF MANUFACTURING STANDARDS.	ADDITIONAL UPF STANDARDS APPLICABLE TO THIS TANK:	CONTRACT NO. MORITA P/N P3-QPWA0000076-00X	 UNITED PLASTIC INDUSTRIES MORITA COMPANY 530 Gal T-Type POLY-TANK IIE	END USER
		UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES TOLERANCES ARE AT AMBIENT TEMP. AT THE TIME OF MFG. FRACTIONS = ± 1/16 DECIMAL .XX = ± .030 DECIMAL .XXX = ± .005 DO NOT SCALE DRAWING	APPROVALS DESIGNER KUPADHYA CHECKED KUPADHYA APPROVAL MASHLEY	DATE 03/21/2017		TITLE MORITA COMPANY 530 Gal T-Type POLY-TANK IIE
		CONTRACT NO. MORITA P/N P3-QPWA0000076-00X	SCALE B	JOB NO. Dwg No. 703-5503		REV. J
		SCALE 1:25	REF. No. 12253-U	QCD No. 518		SHEET 1 of 8



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DWG NO.

703-5503

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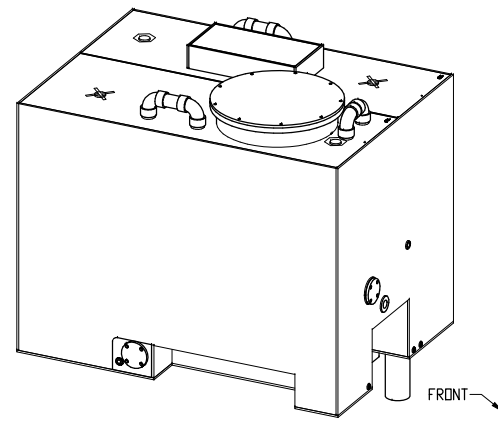
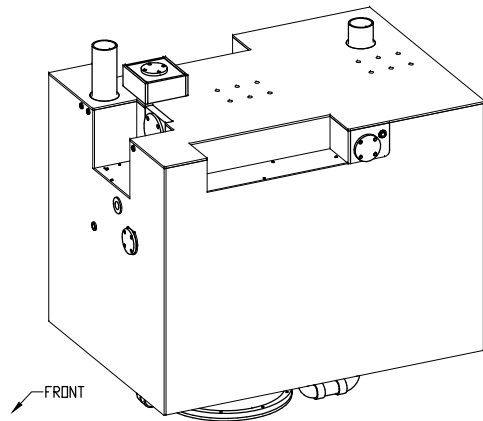
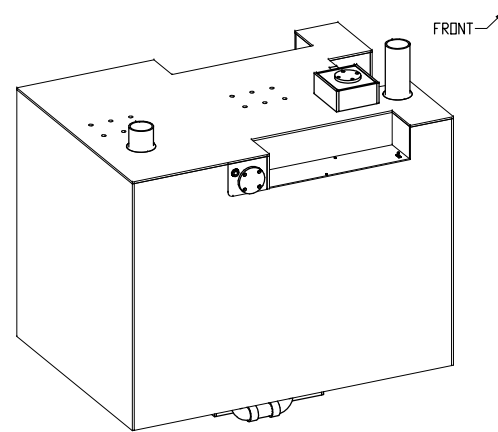
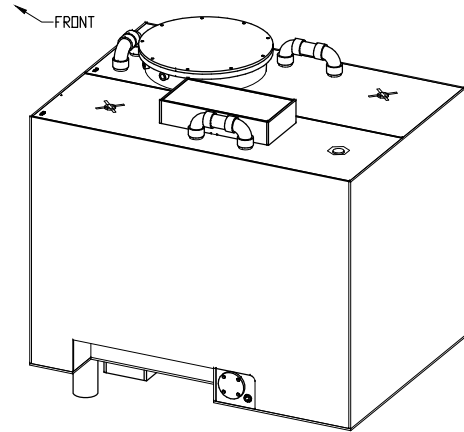
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POLYTANK III



## NOTES:

1. CL MEASURED FROM BASE OF TANK.
2. EXTRUSION WELD TANK INTERIOR, SUMP & EXTERIOR OF NOTCHES WHERE FEASIBLE. ALL OTHER EXTERIOR WELDS TO BE HAND WELDS.
3. ALL WELDS TO MEET CLASS B BOUNDARY WELD REQUIREMENTS.
4. WELD PARTITIONS PER 990-1152.
5. LABEL LOCATION, REF 990-1027.
6. BRAND LOCATION, REF 990-1028.
7. ALL PIPE TO BE SCHEDULE 40 UNLESS OTHERWISE NOTED.
8. SERIAL NUMBER TO BE ETCHED INSIDE TOWER.
9. NOTE ORIENTATION OF BOLT PATTERN FOR ALL FLANGES.
10. WELD A/S PLATE TO TANK SHELL AND TO LONGITUDINAL.
11. ALL PEGS EXTEND 1/4" ABOVE COVER.
12. REMOVE ALL WELD ROD TAILS.
13. REMOVE ALL FUSION COLLARS.
14. QUALITY PERSON TO INSPECT TANK WELDS PRIOR TO PARTITION INSTALLATION.
15. QUALITY PERSON TO INSPECT TANK INTERIOR PRIOR TO COVER INSTALLATION.
- ⚠ 16. TEST FILL PIPE FUSION JOINTS TO 3 PSI PRIOR TO INSTALLING COVERS SEE #975-0050.
17. ITEM #15 SHOULD NOT BE SHIPPED WITH THE TANK. IT'S ONLY TO BE USED AT TEST STAND AND DURING CHECK DESCRIBED IN NOTE #16.
18. RECORD THE AMBIENT TEMPERATURE OF THE TANK'S SURROUNDING AREA DURING ALL QC DIMENSIONAL CHECKS AND WHEN THE TANK IS FULL OF WATER ON THE TEST STAND.
19. A 400MM SPHERE MUST PASS COMPLETELY THRU THE TANK, 450MM SPHERE MUST PASS THRU MANWAY.
20. NO DEVIATION OF PIPE ROUTING OR SUPPORT PLACEMENT PERMITTED.
21. SHIP OVERFLOW EXTENSIONS LOOSE.
22. BLOCK OFF PLATES FOR FLANGED J-FILLS SHOULD BE REMOVED DURING TEST SO THAT IT CAN BE DETERMINED IF THERE IS A LEAK IN THE FILL PIPES/FLANGES.
23. PLACE ITEM #54 IN AN ENVELOPE AND PLACE ENVELOPE IN PACKING LIST ENVELOPE.
24. FOR J-FILLS, WELD ALL PIPING TO COVERS PRIOR TO WELDING TOWER & OVERFLOW DOME. AFTER TOWER AND OVERFLOW DOME WELDED, WELD FITTINGS TO FILLS.
25. FULL POINT IN WATER TANK IS AT TOP OF COVERS.
26. DO NOT USE POWER TOOLS ON ANY HARDWARE.
27. REMOVE ALL WATER FROM TANK PRIOR TO SHIPPING.
28. IF OVERFLOWS ARE PLUGGED FOR SHIPPING, CUT 1/2" HOLE IN PLUG TO HELP VENT TANK.
29. TANK TO BE TESTED ON TEST STAND PER UPF STANDARDS. PRESSURE TEST AND RE-TEST FOR LEAKS TO BE PERFORMED PRIOR TO SHIPPING. SEE TEST OUTLINE ON THIS DOCUMENT.
30. PREASSEMBLE NOTCHES PRIOR TO INSTALLING IN TANK.
31. ALL J FILL PLUMBING TO BE FREE OF LEAKS
32. CHAMFER FOR WELDING PRIOR TO INSTALLING IN TANK.
- ⚠ 33. WELD ALL (4) PARTITION JOINTS

MAX TORQUE SPECS FOR BRASS INSERTS:  
M10 = 8.75 FT-LB (105 IN-LB) (11.9 N-M)  
M12 = 10 FT-LB (120 IN-LB) (19 N-M)  
M16 = 16 FT-LB (192 IN-LB) (22 N-M)



END USER

MORITA COMPANY  
530 Gal T-Type POLY-TANK IIE

APPROVALS	DATE	TITLE	SIZE	JOB NO.	DWG NO.	REV.							
DESIGNER KUPADHYA	03/21/2017												
DRAWN KUPADHYA													
CHECKED MASHLEY	05/10/2017		B		703-5503	J							
APPROVAL													
		SCALE	1:25	REF NO.	12253-U	CALC WGT	518	ACT WGT		SHEET	2	OF	8

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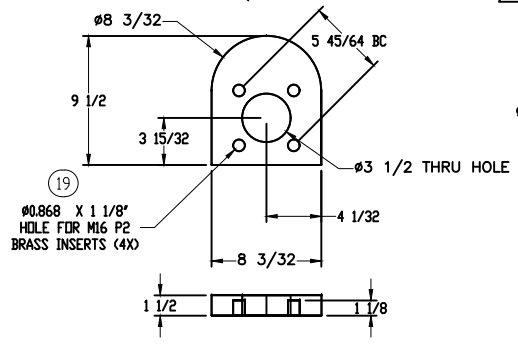
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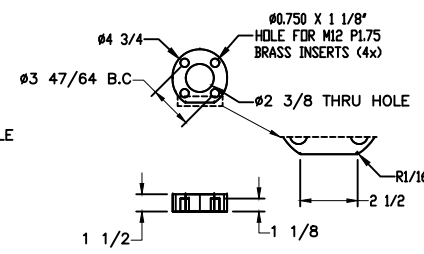
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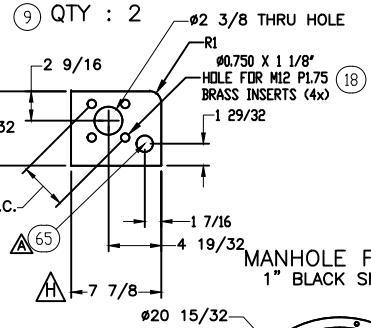
10 SUCTION FLANGE  
QTY : 1



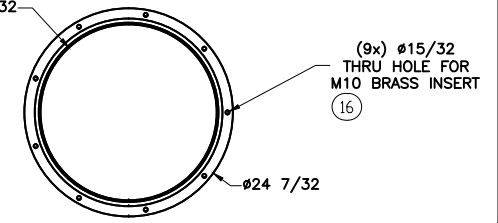
11 FRONT FILL FLANGE  
QTY : 1



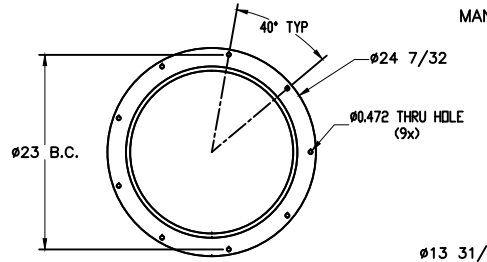
SIDE FILL FLANGE  
(DS SHOWN PS MIRRORED)



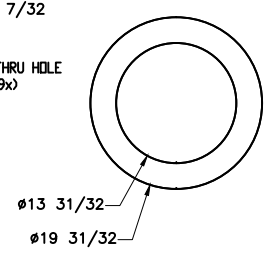
MANHOLE FLANGE  
1" BLACK SMOOTH



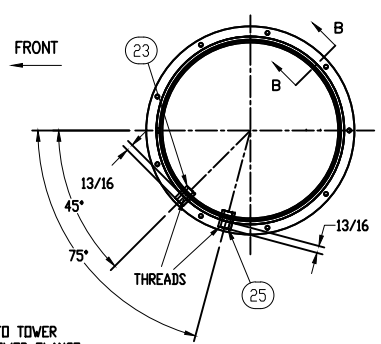
MANHOLE COVER  
1/2" BLACK TEXTURED  
\*\*\*SEE NOTE BELOW\*\*\*



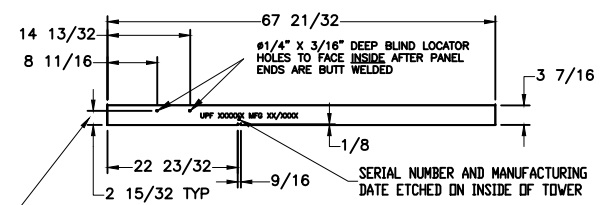
MANHOLE COVER STIFFENER  
1/2" BLACK SMOOTH



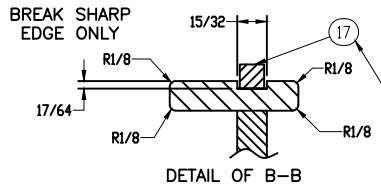
MANHOLE WITHOUT COVER



FLAT PATTERN OF MANHOLE ROUND TOWER  
3/8" BLACK TEXTURED

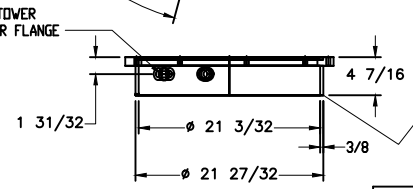


\*\*\*MANHOLE COVER INSPECTION NOTE\*\*\*  
QA TO INSPECT THE HOLE DIAMETERS IN THE MANHOLE COVER. IF ANY OF THE MEASURED DIAMETERS OF THE HOLES IS UNDERSIZED WHEN COMPARED TO THE PRINT SPECIFICATION, BY HAND, USE A 0.445" REAMER WITH A TAP WRENCH TO CORRECT THE HOLE DIAMETER.



INSTALL GASKET ITEM - 17 IN SUCH A MANNER SO AS TO NOT STRETCH THE FINISHED CIRCUMFERENCE OF 1704.94MM

MANHOLE FLANGE IS CENTERED ON TOWER



APPROVALS	DATE	TITLE
DESIGNER KUPADHYA	03/21/2017	MORITA COMPANY 530 Gal T-Type POLY-TANK IIE
DRAWN KUPADHYA		
CHECKED MASHLEY	05/10/2017	703-5503 J

APPROVALS		DATE	TITLE
DESIGNER KUPADHYA		03/21/2017	MORITA COMPANY 530 Gal T-Type POLY-TANK IIE
DRAWN KUPADHYA			
CHECKED MASHLEY		05/10/2017	703-5503 J
SCALE	1:25	REF. NO.	12253-U
DATE	05/10/2017	QTY	518
SHEET		4 OF 8	

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703-5503

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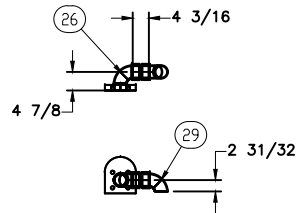
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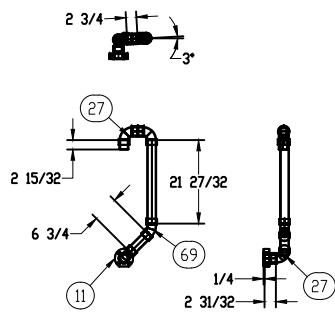
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POLYTANK III

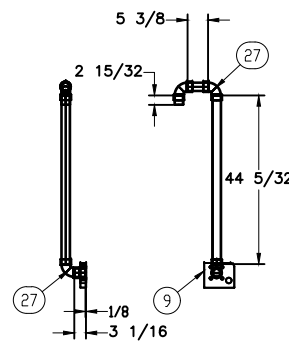
### ▲ SUCTION PIPE



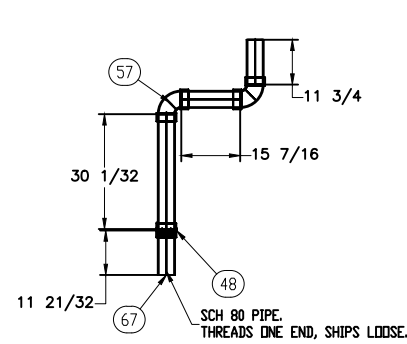
### ▲ FRONT FILL DETAIL



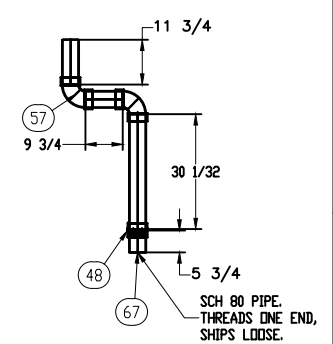
### ▲▲ P.S. & D.S. FILL DETAIL



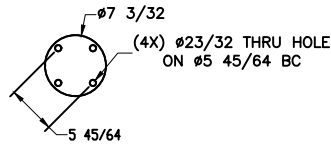
### FRONT VENT/OVERFLOW ▲▲▲



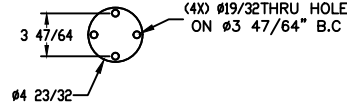
### ▲▲▲ REAR VENT/OVERFLOW ▲▲▲



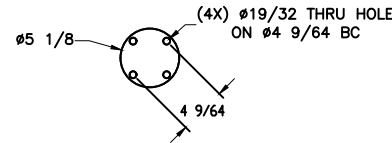
### SUCTION FLANGE BLOCK OFF PLATE (13) (1/2" THICK PT-2 MAT'L)



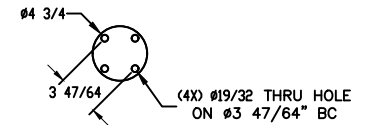
### SUMP DRAIN FLANGE BLOCK OFF PLATE (14) (1/2" THICK PT-2 MAT'L)



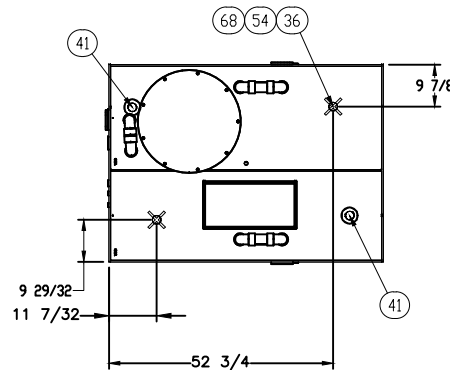
### PS & DS FILL FLANGE BLOCK OFF PLATES (12) (1/2" THICK PT-2 MAT'L)



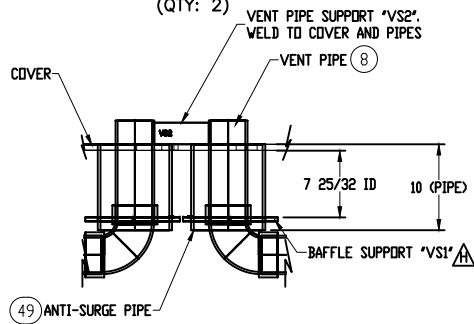
### FRONT FILL FLANGE BLOCK OFF PLATES (60) (1/2" THICK PT-2 MAT'L)



### LIFTING DETAIL



### VENT BAFFLE SUPPORT WELDMENT (QTY: 2)



APPROVALS	DATE	TITLE
DESIGNER KUPADHYA	03/21/2017	MORITA COMPANY 530 Gal T-Type POLY-TANK IIE Details Print
DRAWN KUPADHYA		
CHECKED MASHLEY	05/10/2017	
APPROVAL		

UNIVERSAL PLASTIC FABRICATING		END USER	
SCALE	JOB NO.	DWG NO.	REV.
1:25	B	703-5503	J
REF. NO.	CALC. NO.	DATE	SHEET
12253-U	518		5 of 8

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DWG NO. 703-5503

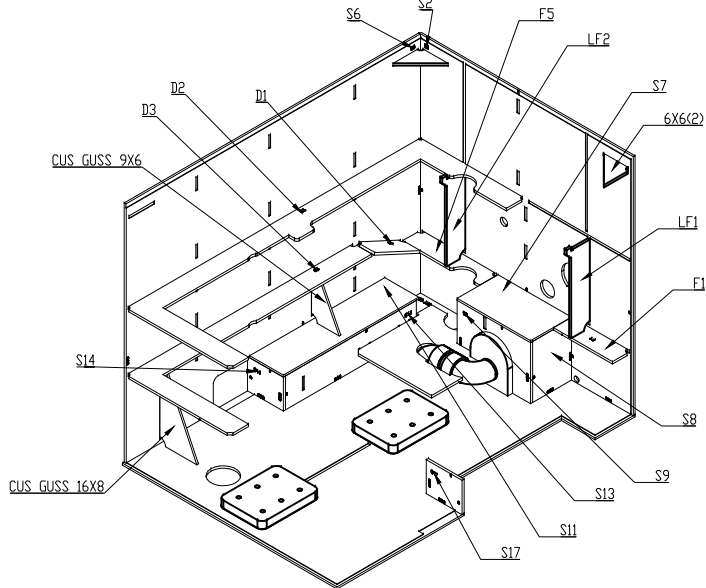
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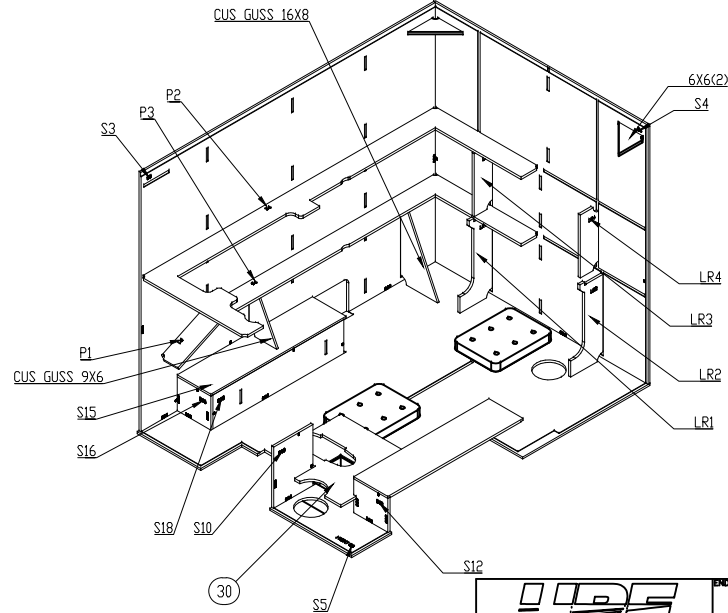
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POLYTANK III

### REAR PASSENGER



### FRONT DRIVER



END USER

MORITA COMPANY  
530 Gal T-Type POLY-TANK IIE

APPROVALS	DATE
DESIGNER KUPADHYA	03/21/2017
DRAWN KUPADHYA	
CHECKED KUPADHYA	
APPROVAL MASHLEY	05/10/2017

SIZE B	JOB NO.	DWG NO. 703-5503	REV. J
SCALE 1:25	REF. NO. 12253-U	COPY NO. 518	SHEET 6 OF 8

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DRW NO. 703-5503

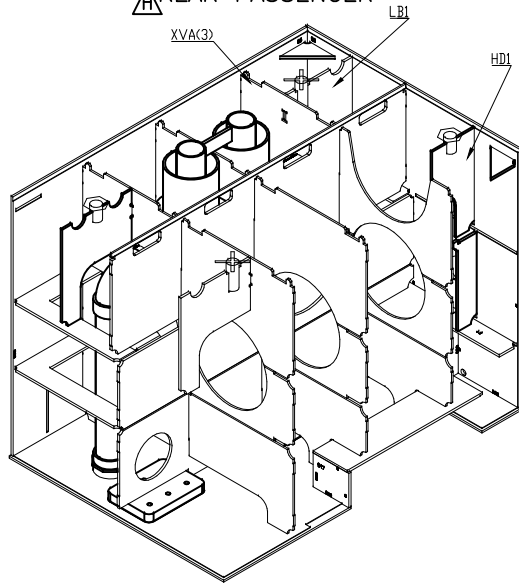
REV 7 J

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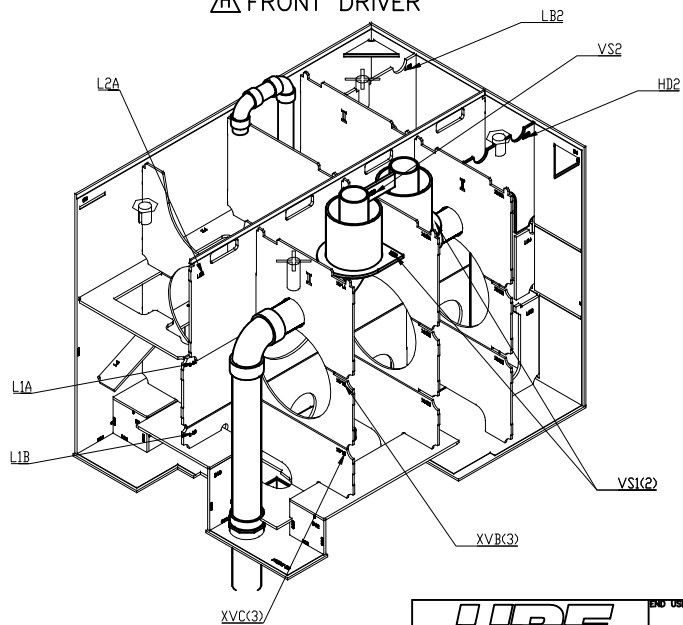
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POLYTANK III

### REAR PASSENGER



### FRONT DRIVER



WELD ALL (4) PARTITION JOINTS



END USER

MORITA COMPANY  
530 Gal T-Type POLY-TANK IIE

APPROVALS	DATE
DESIGNER KUPADHYA	03/21/2017
DRAWN KUPADHYA	
CHECKED KUPADHYA	
APPROVAL MASHLEY	05/10/2017

SIZE	JOB NO.	DRW NO.	REV.
B		703-5503	J

SCALE	REV. NO.	DATE	BY	CHKD	DATE	SHEET	OF
1:25		12253-U	518			7	8

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- TEST PROCEDURE ON TEST STAND  
 - NO FIRST ARTICLE FLOW TEST IS REQUIRED ON THIS TANK

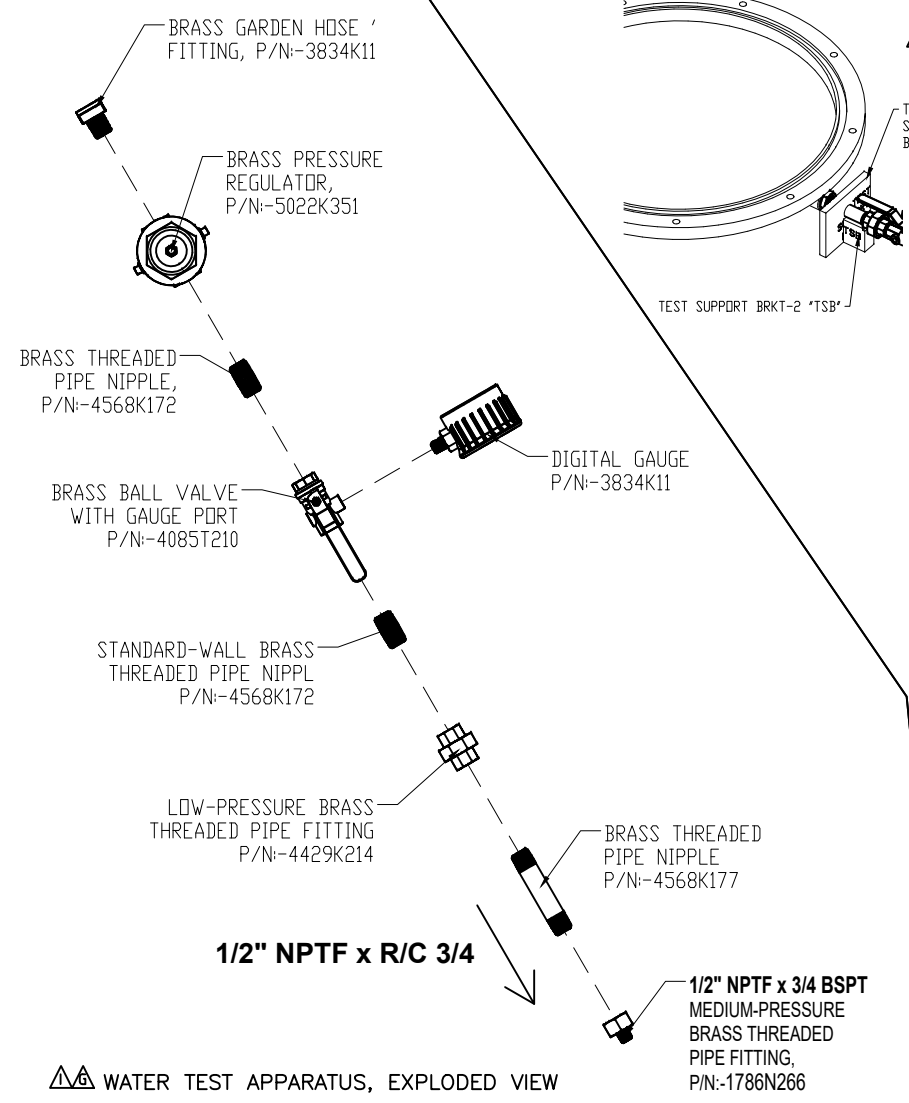
**WATER TEST PROCEDURE**

**USE THESE INSTRUCTIONS EXACTLY. DO NOT ALTER TEST METHOD IN ANYWAY.**

1. PERFORM THE FOLLOWING WITH THE MANWAY LID OFF.
2. BLOCK OFF ALL FLANGED PORTS WITH PROVIDED PLATES.
3. PLUG ALL THREADED PORTS. EXCEPT ONE RC 3/4 IN THE FILL TOWER.
4. ATTACH THE FILL TEST APPARATUS TO THE FILL TOWER OPEN RC 3/4 PORT.
5. CLOSE THE TANK FILL VALVE.
6. CLOSE THE PRESSURE REGULATOR PORT BY TURNING IT CLOCKWISE.
7. INSTALL THE GAUGE IN THE PRESSURE REGULATOR TO CALIBRATE.
8. RESET THE GAUGE TO ZERO.
9. TURN ON THE WATER SUPPLY FULLY WITH THE TANK FILL VALVE CLOSED.
10. SLOWLY TURN THE REGULATOR CCW UNTIL THE GAUGE READS 1.78 PSI.
11. TURN OFF THE WATER SUPPLY.
12. OPEN THE TANK FILL VALVE TO BLEED OF PRESSURE.
13. REMOVE THE GAUGE AND PLUG THE PORT.
14. CLOSE THE TANK FILL VALVE.
15. INSTALL THE GAUGE IN THE TANK FILL VALVE.
16. WITH THE TEST MANWAY LID OFF, FILL THE TANK TO THE TOP OF THE FILL TOWER FLANGE.
17. ATTACH THE MANWAY LID.

**DO NOT LEAVE THE TANK UNATTENDED DURING THESE NEXT STEPS.**

18. FULLY OPEN THE WATER SUPPLY.
19. OPEN THE FILL VALVE TO THE TANK ALLOWING THE TANK TO PRESSURIZE.
20. CONTINUOUSLY WATCH THE PRESSURE READING ON THE GAUGE. IT SHOULD NEVER REACH MORE THAN **1.78 PSI**.
21. IF THE TANK IS NOT PRESSURIZED TO 1.78 PSI, SLOWLY TURN THE PRESSURE REGULATOR VALVE CCW UNTIL THE GAUGE READS 1.78 PSI.
22. TURN OFF THE WATER SUPPLY LINE.
23. RECORD THE MAXIMUM COVER DEFLECTION.
24. RECORD THE MAXIMUM PRESSURE.
25. **IF COVERS DEFLECT MORE THAN A .25", OR YOU SUSPECT A WELD HAS BROKEN, STOP AND CALL FOR FURTHER INSTRUCTIONS.**
26. HOLD FOR THIRTY MINUTES AND THEN CHECK FOR LEAKS. DO NOT CHANGE SPARK TEST INTENSITY ABOVE SOP.
27. IF LEAKS ARE FOUND, LOWER WATER AS REQUIRED TO REPAIR AND REPEAT STEPS 15-25. TEST MUST BE PERFORMED AT THE REQUIRED PRESSURE INDICATED REGARDLESS OF THE NUMBER OF REPAIRS MADE. REMOVE THE FILL APPARATUS AND INSTALL THE 3/4 RC PLUG.
28. BLEED OFF PRESSURE IN TANK BY OPENING THE TEST PORT ON THE PRESSURE REGULATOR OR LOOSEN THE UNION



**WATER TEST APPARATUS, EXPLODED VIEW**

APPROVALS		DATE	TITLE		DWG USER	
DESIGNER	KUPADHYA	03/21/2017	MORITA COMPANY		530 Gal T-Type POLY-TANK IIE	
DRAWN	KUPADHYA		Support Print			
CHECKED			SIZE	JOB NO.	DWG NO.	REV.
APPROVAL	MASHLEY	05/10/2017	B		703-5503	J
SCALE		1:25	REF. NO.	12253-U	COPY NO.	518
			POST		POST	
			SHEET		8 OF 8	