

# Bulk Plant Inspection

<b>Facility:</b> _____						
<b>Facility ID:</b> _____	<b>Code</b>	<b>Type</b>	<b>Trainer</b>	<b>Date</b>	<b>Supervisor</b>	<b>Date</b>

## A. Tank Registration

1) All tanks on site are registered	ATCP 93.140	tank				
a. Registered to current owner.						
b. Tank type and size is correct.						

## B. Records

1) Maintenance, repair, testing & inspection records are to be on site or available electronically during inspection.	ATCP 93.400(11)	facility				
2) Bulk Plants with underground piping need to maintain records:						
a. Annual corrosion protection test or rectifier logs (impressed systems)	ATCP 93.400(2)					
b. Monthly leak detection	ATCP 93.400(4)					

## C. Visual Inspection

1) Tanks/Piping						
a. Tanks must be "UL Listed" aboveground or approved "Field Erected" tanks constructed for aboveground use.	ATCP 93.250					
b. All tanks and piping shall be identified as to product inside according to API 1637.	ATCP 93.340.2.A-C					
c. Tanks and piping must be painted or have acceptable corrosion protection.	ATCP 93.400.2 or ATCP 93.615.H.2					
d. Tanks need NFPA 704 signage visible to oncoming emergency personnel and Class I liquid tanks need to be labeled "Flammable - Keep Fire Away"	ATCP 93.400.7					
e. Tanks must be double wall with interstitial monitoring or be in a compliant dike.	ATCP 93.420					
f. Piping shall be supported against impact, vibration and expansion/contraction.	ATCP 93.615.H.3					
g. Check valves shall be installed in the piping at the unloading connection points.	ATCP 93.615(5)(J)					
h. All fill pipes shall be locked, labeled and color coded as specified in ATCP 93.230(12)	ATCP 93.615(5)(k)3					
i. Fire & Block (e.g., gate, ball or butterfly) valves shall be installed in any piping that	PEI 800.8.3.1					

product can flow by gravity.					
j. Tank vents & emergency vents must be the correct type, in the correct location and be operational.	PEI 800.9.4.1-2				
k. Piping systems shall be maintained tight. (i.e., valves, fittings/connections & pumps)	NFPA 30.22.11.4.6				
l. Spacing between adjacent tanks shall not be less than 3 feet.*	NFPA 30.22.11.4.6				
2) Dike/Secondary Containment					
a. Tank yards and dike areas shall be kept free from debris and kept clean and orderly.	ATCP 93.340(3)				
b. Containment must hold 125% of largest tank, 100% if not open to weather exposure.*	ATCP 93.420(2)(b)				
c. Containment must be liquid tight.	ATCP 93.420(2)(d)				
d. Containment must have a manually controlled drainage system for the removal of leaks, spills or precipitation.	ATCP 93.420(2)(m)				
e. Tanks shall have at least 5 feet of separation from the dike toe.*	NFPA 30.22.11.2.5.3				
f. Drain shall be controlled to prevent liquids from entering natural water course, public sewers & drains.	NFPA 30.22.11.2.7				
g. Drain must be accessible under fire conditions from outside the dike.	NFPA 30.22.11.2.7.1 or 30.22.11.3.5.1				
h. Storage of other materials shall not be permitted in the dike area.	NFPA 30.22.11.2.8 or 30.22.11.3.6				
3) Collision Protection					
a. Collision protection shall be provided for any new or existing tank or component that could result in a release of product when damaged, in any area where a vehicle could impact due to speed, turning or backing.	ATCP 93.430(1), ATCP 93.615(5)(g) & (h)				
b. At least 24 inches of clearance shall be provided between the impact barrier and the system component.*	ATCP 93.430(2)				
4) Loading/Unloading					
a. Loading/Unloading area with tanks <i>larger</i> than 5000 gallons capacity shall have a catch basin or treatment facility large enough to contain the capacity of the largest tank car or tank vehicle loaded or unloaded.	ATCP 93.340(5) or 93.420(5)				
b. Tanks <i>smaller</i> than 5000 gallons require a catch basin with a minimum 5 gallon capacity at the fill point if the fill point is located outside of a diked area.	ATCP 93.410(6)				
c. Spill and overfill equipment must work as designed.	ATCP 93.410(4)				

d. Tanks without a dike that use a remote fill point must have 90% Visual/Audible signal & 95% shut-off if using a latch-open or tight-connect device. (Only needs 90% Visual/Audible if filled with a manual-shutoff nozzle.)	ATCP 93.410(8) & (9)					
e. A clearly identified and easily accessible Emergency Shut-Off switch must be no less than 20 feet and no more than 100 feet from point of fueling.	PEI 200.13.4					
f. Electrical-Bonding equipment must be provided and used in loading and unloading areas.	PEI 800.14.3					
g. Loading arms shall equipped with a deadman control device. (Non-latching)	PEI 800.14.4 & NFPA 30.28.11.1.6					
h. 80 B:C fire extinguisher is maintained, inspected & installed no more than 100 feet from point of fueling.	NFPA 30A 9.2.5.2					

**D. Trainer/Supervisor Comments**

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