

Cone Bottom Tanks

Installation, Operation &
Maintenance Manual



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Polymaster

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ABOUT THIS PRODUCT

Polymaster Cone Bottom Tanks are industrial-grade rotational moulded polyethylene tanks specifically designed to provide complete, fully draining storage of chemicals, liquids and other hazardous materials. The cone base geometry enables total product recovery at the outlet, eliminating residue and simplifying cleaning – making them ideal for processing, dosing, and applications where full drainage is operationally critical.

Australian made and certified to AS/NZS 4766, Cone Bottom Tanks are available in storage capacities up to 30,000 litres with SG 1.0 and SG 1.5 configurations.

By following the installation requirements in this manual, this product will give you many years of trouble-free service.

KEY FEATURES:

- Cone base design for complete, full-drain product recovery
- Storage capacity up to 30,000 litres
- SG 1.0 and SG 1.5 storage solutions available
- UV-stabilised polyethylene construction with minimum UV 12 antioxidant rating
- Designed for atmospheric pressure – tanks must not be pressurised
- Maximum continuous liquid temperature of 40°C
- Compatible with a wide range of chemicals and hazardous liquids
- Easy installation – plug and play configuration
- Above-ground installation only
- Australian made and independently tested and certified to AS/NZS 4766

MATERIALS USED IN CONSTRUCTION:

- PE – Polyethylene (tank body) – specially designed for rotational moulding of chemical and process tanks; exceeds all requirements of AS/NZS 4766
- Key mechanical properties: excellent impact resistance, strength and environmental crack resistance, with a high level of UV and antioxidant stabiliser designed for the harsh outdoor Australian environment, minimum UV 12 rating

AUSTRALIAN STANDARDS

Polymaster is certified to ISO9001 International Standards and undertakes regular audits from third-party auditors.

Our tanks are certified to the Polyethylene tank standard for water and chemicals, AS/NZS 4766:2006, for a range of chemical specific gravities. Every tank is independently tested and certified to SAI Global's AS/NZS 4766 standard and labelled to display manufacturing details and serial number for complete traceability.

Products in this Installation Guide have been manufactured to comply with the above standards.



AS/NZS 4766:2006
BMP 657671
AU/NZS Standards



**Quality
Certified
Company
ISO 9001**

GENERAL HEALTH & SAFETY

- Installation and use of this product should only be carried out by properly trained and approved personnel.
- This manual contains important information concerning the safe installation and use of this product. Read the manual carefully before installation and use, paying attention to all safety warnings.
- Users of this product are responsible for the safe and correct use of this product.
- Any changes to this product made without consulting the manufacturer will invalidate all warranties and guarantees.
- The manufacturer will not be responsible for any accidents or damages caused by incorrect installation or use of this product.
- Polymaster recommends that customers assess the suitability of chemicals being stored with the materials used in the construction of this product.
- The components must not be altered or tampered with due to potential risks to personnel.
- It is the responsibility of the end user/customer to ensure appropriate PPE, health and safety measures, and safe work practices are employed in conjunction with the use of this product.
- If present, control boards are not suited for use in areas where there may be a risk of explosion.
- Polymaster polyethylene tanks are heavy and require adequate equipment and properly trained personnel to unload and position them. Do not stand or work on top of the tank – the tank roof is not designed for live loading and doing so could result in serious injury or death.
- If tank entry is required, ensure proper confined space procedures are adhered to and adequate ventilation equipment is provided.

CHEMICAL RESISTANCE

A chemical resistance chart may be found on our website www.polymaster.com.au. It is recommended that you discuss your specific chemical storage requirements with a Polymaster consultant or study the comprehensive chemical chart to ensure compatibility. A more comprehensive list is also available on request.

POLYETHYLENE MATERIALS

Polymaster uses a variety of Polyethylene resins that have been specially designed for the rotational moulding process in the manufacturing of chemical and process tanks. These advanced materials exceed all requirements of AS/NZS 4766 Polyethylene Storage Tanks for Water and Chemicals. Key features include: excellent impact resistance, strength, and environmental crack resistance. These materials also carry a high level of UV and antioxidant stabiliser designed for the harsh outdoor Australian environment, minimum UV 12 rating.

TEMPERATURE & SG RATINGS

The temperature of the chemical/liquid stored has different effects on the polyethylene and can produce different effects within the same chemical range. Contact a Polymaster consultant if you are unsure about your application. A continuous liquid temperature above 40 degrees Celsius is not recommended for these tanks. Tanks are designed to a maximum Specific Gravity (SG) rating to suit the application and must not be exceeded.

VENTING

These tanks cannot be pressurised and are designed to operate at atmospheric pressure. Proper venting stops pressure or vacuum developing as the tank is filled or emptied. It is recommended that the vent should always exceed the size of the largest fill or discharge. Check that the chemical you are using is able to be vented to atmosphere without prior treatment.

REGULATIONS & SITE LOCATION

There may be local, state or national regulations that apply to your proposed tank installation. Check with the relevant authorities concerned to ensure all requirements are complied with. A thorough evaluation of the proposed site is recommended prior to any placement or installation works being carried out.

Service access and safe egress paths away and around the tank in line with Australian and local authority requirements to suit the specific chemical being stored is the responsibility of the installer and user of the tank. Do not block any service access or egress paths.

Position the tank to allow for ease of regular inspection and maintenance. It is recommended that tanks are not installed adjacent to equipment or buildings that will impact cost-effective removal and/or replacement of the tank in the future. Use guards and physical restraints to prevent tank fittings and piping from impact damage and protect personnel from potential chemical leakage.

GENERAL LOCATION

There are many aspects to consider when selecting the best location for your tank. Some points to consider:

- Excessive wind or seismic forces
- Area subject to flooding
- Safe distance from any source / equipment generating heat or flames

Generally accessible location to ensure safe operation, maintenance and distance from other chemicals in line with authority storage requirements.

For further advice, contact Polymaster on 1800 062 064.

TRANSPORT, HANDLING & STORAGE

These instructions should be read in their entirety before commencing installation of the tank.

- DO NOT TRANSPORT WITH LIQUID OR DRY MATTER INSIDE.
- The tank must be protected against mechanical damage during transport and storage.
- Loading and off-loading must be carried out using only professional equipment. For example, a crane or forklift with extended forks rated to the tank weight/load. Craneage at site is the responsibility of the customer/end user to suit the installation location. Fittings, covers, sockets or other protruding elements which are not designed for lifting or moving the tank must not be used to lift or move the tank.
- The tank must never be pushed, pulled, dragged, or rolled.
- Loading and transport areas must be smooth and free of sharp edges. During transportation, the tank must be secured to prevent movement.
- Storage time of the chemical being stored is to follow the handling requirements specific to that material and is the responsibility of the customer/end user. Consult with the chemical supplier for information.
- Tanks are not suitable for live loads – please discuss specific access requirements with Polymaster.
- For all tank installation and maintenance, please take into consideration Health & Safety and Local Building Regulations.

TANK LIFTING POINTS

In the event of tank relocation, the tank must be empty. Where fork channels are provided, a suitably equipped forklift may be used; otherwise the tank lift should be performed using the moulded lifting lugs. Do not lift the tank by using any of the installed fittings. The tank must be empty when lifted, taking care not to damage the tank walls, base, roof, pipework, and fittings. Please contact Polymaster for appropriate lifting plans for your tank type.

INSTALLATION

- A solid flat and level plinth suitable for the anchorage requirement of the tank is required. This plinth is to be engineered by the user and is to be compatible with the anchorage requirements detailed below. Engineering of any restraint or tethering system to suit specific local or chemical-specific storage requirements is the responsibility of the customer/end user. Foundation design is outside the scope of Polymaster specification.
- Prior to installing, inspect for damage. If damaged, do not install.
- In no cases should any modifications such as holes being drilled, or additional fittings installed into the tank wall in addition to those provided on the tank as supplied by Polymaster.
- The tanks must be adequately restrained to ensure stability whether full or empty.
- THE TANK IS TO BE INSTALLED ABOVE GROUND.
- After installation, ensure this manual is left with the end user for future reference.

ANCHORAGE

Cone Bottom Tanks are to be anchored using the provided restraints in accordance with the following model-specific specifications. Tanks are to be installed onto a 'suitable' foundation (foundation design is outside the scope of Polymaster specification).

Specification	SM5000 – SM12500	SM20000 – SM30000
Fasteners	4x M12	6x M20
Min. Embedment	120 mm	170 mm
Chemset	801 XTRSM	101 Plus (or equiv.)

TANK TESTING AND CHEMICAL COMPATIBILITY

Confirm compatibility of the tank and all associated fittings and gaskets with the chemical being stored. When installed, it is strongly recommended that tanks are hydrostatically tested for 24–48 hours before introduction of chemical. Remove all water used for testing in case of possible reaction with chemicals stored. Label tank with appropriate chemical warning label and do not remove any Polymaster Warning Labels. Ensure tanks are adequately vented to prevent pressure or vacuum, especially during filling and draw-down.

FILLING

THE TANK MUST NOT BE FILLED AT A RATE GREATER THAN 250 LITRES PER MINUTE (LPM) WHEN USING THE TOP FILL ASSEMBLY OPTION.

The maximum fill level must NOT be exceeded.

- Filling should be performed only under constant supervision of an authorised person.
- Tank filling is to occur only via the provided Camlock or tank-specific fill point connection.
- Do not overfill. Check level gauge during filling.
- Do not leave delivery hose connected to the coupling.
- Promptly clean up any drips or spills.
- The maximum tank fill/discharge rate is specific to each application's design and is based on fitting type and relief installed. Review your application to ensure the fill/discharge rate does not exceed the installed venting devices.

PIPING, VALVES & FLEXIBLE CONNECTIONS

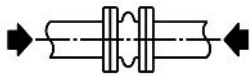
All hoses, piping and valves must be adequately supported independently of the tank. All hoses, piping and valves must be adequately supported independently of the tank. Flexible connections must be used when connecting to fittings installed on the tank, to ensure successful installation and tank warranty. All fittings, valves, and piping should be shielded to prevent possible physical impact and protect personnel from chemical spray or leakage.

WARNING: Failure to support and protect valves and piping and to provide engineered foundations for tank will void your warranty and could cause chemical release resulting in serious injury and/or property damage.

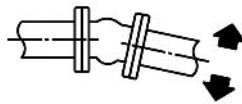
FLEXIBLE CONNECTIONS

INSTALL FLEXIBLE CONNECTION IN ACCORDANCE WITH THE SPECIFIC MANUFACTURER'S INSTALLATION GUIDELINES.

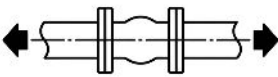
Flexible connections are required to protect the tank and fitting structure from the normal movements during its service use and life, and to isolate them from external loads and vibrations coming from the attached piping systems.



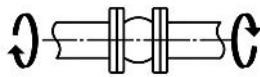
COMPRESSION



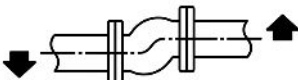
MOVEMENT



EXTENSION



TWISTING



DEFLECTION

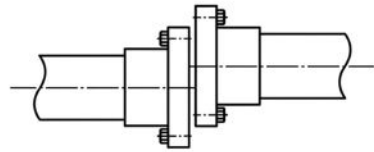


VIBRATION

- Flexible connections are not to be used for correcting piping misalignment. The flexible connection and mating flanges must be installed in a centred, aligned and mated position.

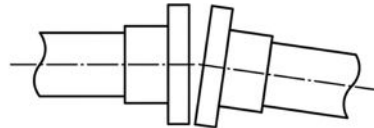
TYPES OF MISALIGNMENT

OFFSET



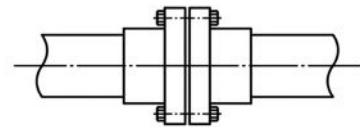
X

ANGULAR



X

CORRECT



✓

- Attach only FULL-FACE flanges to the flexible connection. They are not designed to attach directly to the tank wall.
- Ensure adequate clearance between bolt ends for full use of flexible connections.
- Provide pipe support adjacent to the flexible connection.

FLEXIBLE CONNECTION MINIMUM SPECIFICATIONS

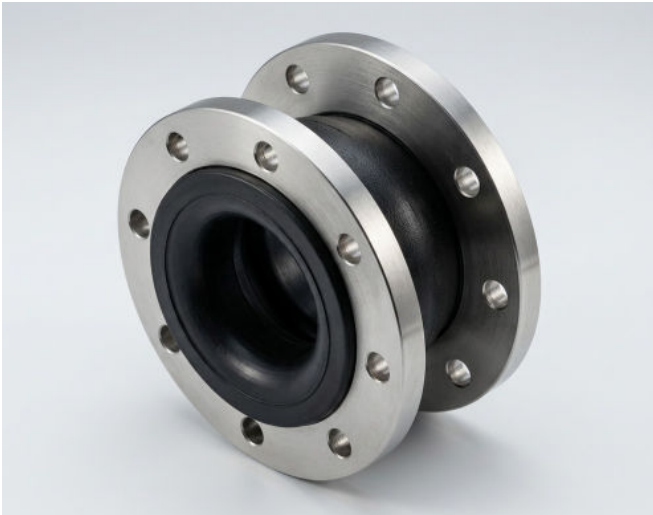
- Axial Compression $\geq 38\text{mm}$
- Axial Extension $\geq 15\text{mm}$
- Lateral Deflection $\geq 19\text{mm}$
- Angular Deflection $\geq 14^\circ$

INSTALLATION OF FLEXIBLE HOSE CONNECTIONS

- Check flexible hose is compatible with the chemical being stored and is of sufficient size.
- Support the flexible hose in such a manner that horizontal and vertical movement is not impeded. It is the responsibility of the tank installer/purchaser to install the appropriate flexible connections between the tank and pipework. Failure to comply with this will void Polymaster's warranty.

PIPING, VALVES & FLEXIBLE CONNECTIONS (cont.)

TANK WARRANTY – FLEXIBLE CONNECTIONS



All fittings, including outlets and inlets on the tank, must have a flexible joint connection between the tank and the plumbing or rigid pipework. This is vital to absorb movement and stress, isolate pump vibration, accommodate pipe misalignment, and minimise surge pressures. It is the responsibility of the tank purchaser to install the appropriate flexible connections between the tank and plumbing. The Polymaster warranty is only valid if the installation has appropriate flexible connections.

For applications with mild chemicals, rubber flexible joints are available from Polymaster.

CARE & MAINTENANCE

Regular routine visual inspections of your polyethylene tanks are important to ensure safety of personnel and preservation of stored chemical. (Refer to Recommended Care Instructions table.) Any sign of stress cracking, UV degradation and/or other signs of tank failure should be immediately reported and a full inspection carried out by authorised Polymaster personnel.

- Plan and initiate a maintenance regime for the tank system. Aim to keep all system equipment in good working condition.
- Spare parts must comply with the requirements of the manufacturer and be of like for like type.
- Any faults or alarms should be reported to the users station manager/site manager or equivalent immediately.
- Protect against unauthorised access.
- Carry out a daily visual check of the tank and ancillary equipment. Any leaks are to be promptly recorded, reported and repaired by a qualified service engineer or technician. If liquid is detected by alarm or observed around the tank, promptly record, report and arrange for corrective action. Corrective action may include locating the source of the liquid, possibly caused by an overflow event or leak. If the liquid source is not the result of an overflow event, contact Polymaster for additional advice. Further action may include emptying and isolating the tank.
- Ensure that contamination not intended to be in the tank is prevented from entering at any time either by design or a managed maintenance regime. If the stored liquid or fumes are allowed to escape outside the tank, ensure you check local EPA, Australian Standard and local Authority guidelines and requirements for compliance.
- Metal items and control panels that could be affected by the fumes must be protected from corrosion by using good engineering practice. Additional corrosion protection to suit the chemical being stored is the responsibility of the customer/end user.

INTERNAL INSPECTION

It is recommended that an internal inspection is undertaken over regular intervals. Polymaster recommends this is done yearly. Empty the tank and neutralise any chemical remaining. All chemical handling must be safely performed in line with Australian Standards, EPA and local authority requirements for the specific chemical being stored. Where a confined space entry is possible, thoroughly clean the inside of the tank – a dirty tank will potentially mask faults. Examine the tank surface for any cracking or surface degradation. Pay particular attention around fittings and the base in the radius where the cone meets the wall.

If a confined space entry is not possible, clean inside as well as possible from the inspection cover and use a light to inspect the internals.

WARNING: Do not enter a tank without confined space entry training and relevant personnel and permits. Use adequate approved ventilation equipment when inspecting the internals of a tank as fumes and vapours may be present. Use necessary fall protection equipment to prevent against accidental falls relating to entry method or slippery conditions. Failure to comply with these warnings could result in injury or death.

EXTERNAL INSPECTION

Thoroughly clean the outside of the tank and examine for any cracking or excessive surface degradation. Pay particular attention around all fittings, level indication tubing, flexible couplings, connection hoses and gaskets for any leakage or signs of corrosion. Inspect the vents for “free flow” to ensure adequate entry for pressure and vacuum. Check all pipe support brackets to make sure fittings, valves, piping etc. are adequately supported and protected.

RECOMMENDED CARE INSTRUCTIONS

ITEM/AREA OF INTEREST	ACTION RECOMMENDED	FREQUENCY
Visual Inspection	Visually inspect the entire unit for any changes in condition.	1 Month
Cleaning	Clean the unit regularly with soapy water and a cloth to remove any buildup of dust/dirt/chemical spillage.	3 Months
Location	Confirm that the installation environment matches that of the original installation. Review changes for any influence to the safe use of the tank such as wind or distance to people and traffic.	As Used / 12 Months
Tank Condition	Temperature & SG Ratings of the product. Review the product being stored in the tank and confirm that they match those intended for original tank use. Inspect abrasions or cuts on the tank. Assess tank for excessive weathering. Assess tank for any swelling, bulging or deformation of tank walls.	As Used / 3 Months
Chemical Degradation and Compatibility	Confirm the chemicals currently used are compliant with the original installation. Review any change with Polymaster and the Polymaster Chemical Compatibility Chart.	As Used / 12 Months
Valves	During normal operation, check the action of installed ball valve handles and/or Slide Gate.	As Used / 3 Months
Vent	Check and clean around the vent regularly to remove any buildup of dust/dirt. Check that there is nothing impeding the operation of the vent.	3 Months
Seals	When the unit is completely empty, undo and remove the PVC-U ball valves. Check the condition of the seals within the ball valve. Replace if the seals have deteriorated.	12 months
Gaskets	Visually inspect the condition of the flanges and connected fitting regularly for any changes or leaks. If any change is noted, completely drain the tank until empty then inspect and service the unit and replace gaskets as needed.	As Used / 3 Months
Screw Lids	Check that the screw lids are still tightly secured.	As Used / 12 Months
Weld on Fittings	Investigate any degradation of weld and/or excessive stress marks. Check for any leakage or surface cracks developing. Check fitting distortion including vertical/horizontal alignment.	As Used / 12 Months
Flexible Connections	Check positioning and alignment of flexible connections. Assess compatibility of connector to user's systems. Review for excessive axial or lateral compression.	As Used / 3 Months
Electrical / Sensors	Visually inspect the condition of the power box and associated components. Clean the power box with a damp cloth to remove any buildup of dust/dirt/chemical spillage.	3 Months
Foundation/Base	Check the condition of the tank foundation for any erosion, cracking or subsidence. Repair as required. Ensure any repair materials meet the Installation Guide requirements.	3 Months
Moving	Refer to Installation Handling section for information on moving the tank.	

RECOMMENDED CARE INSTRUCTIONS

ITEM/AREA OF INTEREST	ACTION RECOMMENDED	FREQUENCY
Foundation/Base	Check the condition of the tank foundation for any erosion, cracking or subsidence. Repair as required. Ensure any repair materials meet the Installation Guide requirements.	3 Months
Moving	Refer to Installation Handling section for information on moving the tank.	
Tank Restraints	Review all restraints, tie down lugs and associated fasteners to ensure they are secure, meet "As Installed" condition and performance and are in good condition.	As Used / 3 Months

WARRANTY

Polymaster products are guaranteed against material or manufacturing defect. Warranty periods commence from the date of invoice:

Item	Warranty
Polyethylene tanks	5 years
Accessories / components	12 months
Hoses, nozzles, and sensors	3 months

WARRANTY CONDITIONS:

- Equipment is installed and commissioned in accordance with this manual.
- Equipment is installed and commissioned by a suitably qualified engineer.
- Equipment has not been subject to misuse, careless handling, faulty installation, or repairs by unauthorised personnel.
- Equipment has been purchased by the end user and is not for hire purposes.
- The tank is installed above ground.
- The tank is inspected every 3 months or to a total volume dispensed as required for that chemical or as specified by the dispensing/dosing system, whichever occurs first. This inspection is to be performed by a suitably qualified service engineer or technician.
- All fittings have appropriate flexible connections between the tank and plumbing or rigid pipework.
- The tank has not been filled at a rate exceeding 250 litres per minute (when using the top fill assembly option).
- Immediately upon discovery of any defect in the tank, the tank must be safely drained and taken out of service. Contact Polymaster and allow a representative to inspect before any attempts are made to repair or move the tank.

WARRANTY EXCLUSIONS:

- Mechanical damage caused by the user, dealer, or improper maintenance.
- Faults, damage, or premature wear caused by improper use.
- Damage caused by third parties.
- Repairs carried out by unauthorised service personnel.
- Ancillary fittings such as contents measuring gauges or mechanical pumps (refer to respective manuals).

To make a warranty claim, you will need your serial number, proof of purchase, and a photo of the product clearly showing the issue.

Submit a claim at polymaster.com.au/warranty.



**Questions?
Contact Polymaster**



1800 062 064
polymaster.com.au
sales@polymaster.com.au