

# Liquid Fertiliser Self Draining Tanks

Installation, Operation &  
Maintenance Manual



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Polymaster

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## APPLICATION NOTES

- Tanks are suitable for the storage of liquids up to and including 1.5 SG.
- Compatibility with fittings must be checked by user prior to filling tank.
- Stability notes to be considered (see anchorage section).
- Drawings are available and may contain information relating to freight and handling.
- Note: A specific lifting guide exists as a separate document. Please refer to this as part of planning your lift, or contact Polymaster for a copy.

## ABOUT THIS PRODUCT

Polymaster Liquid Fertiliser Self Draining Tanks provide purpose-built bulk storage for on-farm liquid fertiliser, engineered to drain completely between blend changeovers. A sump-and-gradual-slope base directs the tank to a single low point, eliminating sludge accumulation and protecting spray equipment from residue carryover.

Available in capacities from 23,000L to 33,000L and rated to 1.5 SG – suited to common broadacre liquid fertilisers such as UAN, Easy-N and Flexi-N, which run around 1.32–1.34 times the density of water. Tanks are Australian made and manufactured to AS/NZS 4766:2006.

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

### KEY FEATURES:

- Sump-and-gradual-slope base for 100% drainage – no dead zones or residue carryover between blends
- Rated to 1.5 SG for concentrated nitrogen and potassium fertiliser solutions
- 2" top fill camlock and ball valve for closed-system filling
- 2" outlet, ball valve and camlock at the sump for complete drainage
- Clear sight tube level indicator with independent ball valve for at-a-glance inventory
- 600mm vented screw lid for safe above-ground inspection access
- 90mm overflow/breather with mesh screen to manage fill/draw-down pressure and prevent insect ingress
- Chemical resistant fittings throughout – no reactive metals in contact with fertiliser
- Available in three colours: Beige, Monument and Mist Green
- Manufactured to AS/NZS 4766:2006

## MATERIALS USED IN CONSTRUCTION:

- PE – Polyethylene, engineered and rated to 1.5 SG for concentrated liquid fertiliser loads
- Made from premium polyethylene resin that meets the material requirements of AS/NZS 4766, UV-stabilised for Australian conditions
- Tanks are designed using engineering methods including finite element analysis (FEA) to ensure structural integrity under load
- Chemical resistant fittings – no reactive metals in contact with the stored fertiliser

## AUSTRALIAN STANDARDS

Polymaster is certified to ISO 9001:2015 International Standards and undertakes regular audits from third-party auditors.

Polymaster Liquid Fertiliser Self Draining Tanks are manufactured to AS/NZS 4766:2006 – BSI Benchmark certified (Licence BMP 657671).

Every tank is labelled with full manufacturing details, including a serial number, for complete traceability.



PRODUCT CERTIFICATION



BSI Certified Product

**AS/NZS 4766:2006 Lic:BMP No 657671**  
**Australian/New Zealand Standards**

## 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.

## CHEMICAL RESISTANCE

A chemical resistance chart may be found on our website [www.polymaster.com.au](http://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 the Australian standard AS/NZS 4766 Polyethylene Storage Tanks for Water and Chemicals. Key features of the mechanical properties 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 topped 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 and agitator 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 and agitator system 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 and agitator system 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 rated to the tank weight. 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

Note: Specific lift plans exist as a separate document. Please refer to this as part of planning your lift, or contact Polymaster for a copy of the document.

In the event of tank relocation, the tank must be empty. 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. Care must be taken to ensure the wire-rope assemblies are only bearing the weight of the base. Please contact Polymaster for appropriate lifting plans for your tank type.

## INSTALLATION

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

- 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.
- 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.
- Immediately upon discovery of any defect in the tank, the tank must be safely drained immediately and taken out of service in line with that chemical's safe handling procedures. We recommend contacting the chemical supplier as part of this process.
- After installation, ensure this manual is left with the end user for future reference.

## ANCHORAGE

It is imperative to maintain stability of the tank in high wind load conditions when the tank is near empty. The minimum fill levels from the invert of the tank (under the outlet) are identified in the table below. The only exception is when the chemical tank is being emptied – the maximum time span for an empty chemical tank is recommended to be 48 hours as weather permits. If this length of time needs to be exceeded, appropriately designed temporary tethers shall be installed from the lifting lugs at the top of the chemical tank down to the supporting reinforced concrete slab.

require adequate equipment and properly trained personnel to unload and position them. Do not stand or work on top of the tank as the surfaces are slippery and flexible, which could result in serious injury or death. If the tank needs to be entered, ensure proper confined space procedures are adhered to and adequate ventilation equipment is provided.

| SG of Contents | Min Fill Level (mm) |
|----------------|---------------------|
| 1.0            | 778                 |
| 1.5            | 588                 |

## PIPING, VALVES & FLEXIBLE CONNECTIONS

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 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.

- 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.
- 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.

## CARE & MAINTENANCE

All fittings, including outlets and inlets on the Regular routine visual inspections of your tank and agitator system are important to ensure safety of personnel and preservation of stored chemical. 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 and agitator 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 overfill event or leak. If the liquid source is not the result of an overfill 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.**

# RECOMMENDED CARE INSTRUCTIONS

| ITEM/AREA OF INTEREST                         | ACTION RECOMMENDED                                                                                                                                                                                                                                                                                      | FREQUENCY           |
|-----------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------|
| <b>Visual Inspection</b>                      | Visually inspect the entire unit for any changes in condition.                                                                                                                                                                                                                                          | 1 Month             |
| <b>Cleaning</b>                               | Clean the unit regularly with soapy water and a cloth to remove any buildup of dust/dirt/chemical spillage.                                                                                                                                                                                             | 3 Months            |
| <b>Location</b>                               | 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 |
| <b>Tank Condition</b>                         | 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  |
| <b>Chemical Degradation and Compatibility</b> | 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 |
| <b>Valves</b>                                 | During normal operation, check the action of installed ball valve handles and/or Slide Gate.                                                                                                                                                                                                            | As Used / 3 Months  |
| <b>Vent</b>                                   | 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            |
| <b>Seals</b>                                  | 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           |
| <b>Gaskets</b>                                | 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  |
| <b>Screw Lids</b>                             | Check that the screw lids are still tightly secured.                                                                                                                                                                                                                                                    | As Used /           |
| <b>12 months</b>                              | Check that the screw lids (internal and external) are still tightly secured.                                                                                                                                                                                                                            | As Used/12 months   |
| <b>Weld on Fittings</b>                       | 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 /           |
| <b>12 months</b>                              | 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  |
| <b>Flexible Connections</b>                   | 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  |

## RECOMMENDED CARE INSTRUCTIONS

|                             |                                                                                                                                                                               |                    |
|-----------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------|
| <b>Electrical / Sensors</b> | 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           |
| <b>Foundation/Base</b>      | 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           |
| <b>Moving</b>               | Refer to Installation Handling section for information on moving the tank.                                                                                                    |                    |
| <b>Tank Restraints</b>      | 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 person.
- 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.
- 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](https://polymaster.com.au/warranty).



## Questions? Contact Polymaster

1800 062 064  
[polymaster.com.au](https://polymaster.com.au)  
[sales@polymaster.com.au](mailto:sales@polymaster.com.au)