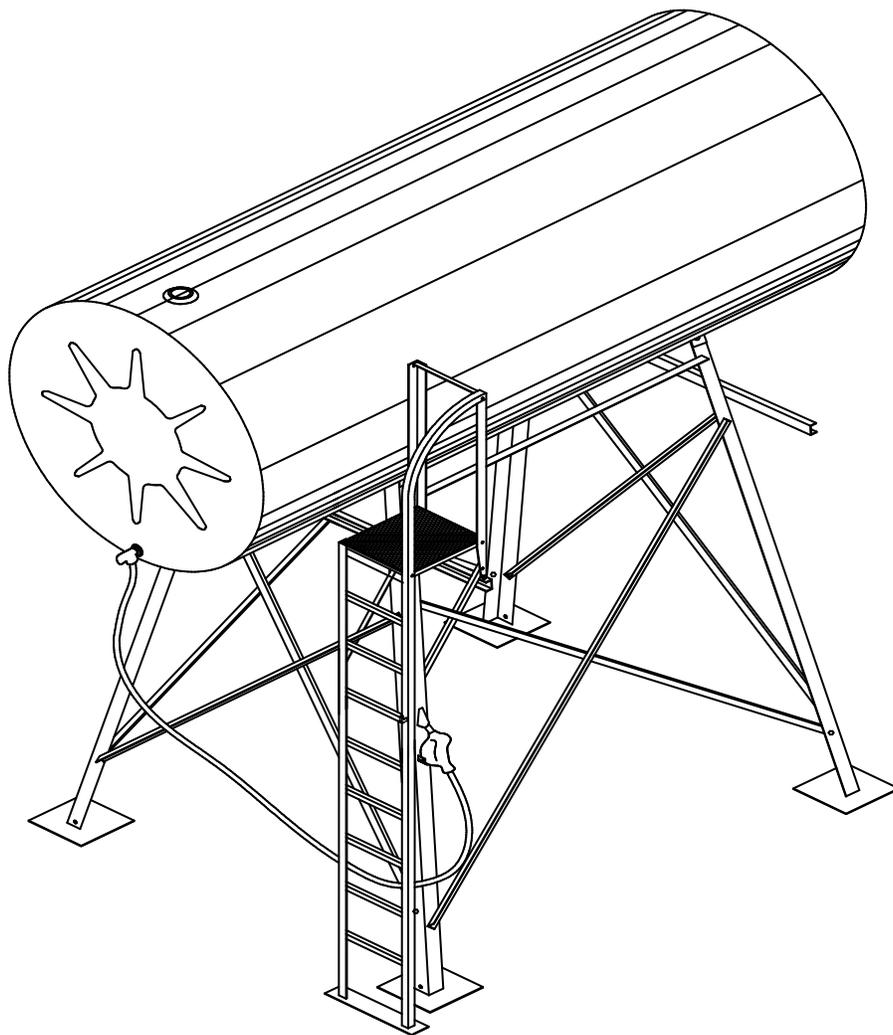


Tank Stand Assembly Instructions and Material List

For 1363L (300G), 2273L (500G) or 4546L (1000G) Cylindrical Tanks



Includes Assembly Instructions and Material List for Optional Safety Ladder

LIMITED WARRANTY

Westeel Division of Vicwest Corporation ("Westeel") warrants products that it has manufactured and/or that are branded with its name or that of Northern Steel Industries (the "goods") subject to the following terms and limitations, (the "warranty").

Note: The warranty does not apply to products manufactured by Westeel under license (the "licensed products"). The licensed products are solely subject to warranty terms as they may be set from time to time by the licensing body. The licensed products include but are not necessarily limited to: FLAME SHIELD, Fireguard, F921, stiP3, AquaSweep and Glasteel. For information on warranty terms applicable to the licensed products, or to determine whether a product is a licensed product, please consult the Westeel website at <http://www.westeel.com/> and/or contact Westeel by phone at 1-800-665-2099.

1. **Duration of Warranty.** The duration of the warranty is limited as follows.
 - i. External Corrosion – 2 years.
 - ii. Internal Corrosion – 2 years.
 - iii. Structural Defect – 5 years, except in the case of Mobile Tanks in which case it is 1 year.
 - iv. Tank Accessories – 1 year;
 - v. Loss of Vacuum – 2 years, except in the case of Underground Tanks in which case it is 30 days from date of delivery to the purchaser.

The duration of the warranty will run from the date of purchase from a dealer or distributor authorized by Westeel, unless otherwise stated (the "warranty period").

2. **Limitation of Remedies Replacement.** Within the warranty period, Westeel will replace the goods and/or original manufactured components thereof which are found, to Westeel's satisfaction, to be defective. Westeel is not responsible for direct, indirect, special, consequential, or any other damages of any kind, including personal injury to any individual, howsoever caused, including caused by transportation of the goods for repair or replacement.

3. **Procedure for Obtaining Service.** In the event of a warranty claim, the purchaser must complete any and all information required by Westeel in order to properly assess or investigate the claim. Westeel will not be responsible for the removal of any of the goods found to be defective, or transportation charges to and from Westeel's authorized dealer or distributor, or for installation of any replacement goods and/or parts furnished under the warranty.

4. **Limitations as to Scope of Warranty.** The warranty does not extend to defects or damage caused, in whole or in part, by:
 - i. use of a kind and/or to a degree not reasonably expected to be made of the goods;
 - ii. improper storage of the goods both prior to and after purchase;
 - iii. damage caused by, or in the course of, installation or assembly;
 - iv. any use of the goods which is not an intended use as specified in Westeel's published product literature, or otherwise specified by Westeel in writing;
 - v. any equipment attached to or used in conjunction with the goods;
 - vi. any field modifications or substitutions to original bin components;
 - vii. inadequate ventilation or any other circumstance not in keeping with proper maintenance and/or use of the goods;
 - viii. acts of God, accident, neglect or abuse of the goods by the purchaser and/or any other individual or entity; or
 - ix. Any use or installation inconsistent with Westeel's Standard Disclaimers.

5. **Limitations as to Manufacturer.** The warranty does not cover products sold by Westeel that are not manufactured and/or that are not branded with its name or that of Northern Steel Industries. In those circumstances, the purchaser is referred to the manufacturer of those products.

6. **Limitation of Implied Warranties and Other Remedies.** To the extent allowed by law, neither Westeel nor its dealers, nor any company affiliated with Westeel makes any warranties, representations, or promises as to the quality, performance, or freedom from defect of any Product covered by this Warranty.

WESTEEL HEREBY DISCLAIMS, TO THE EXTENT APPLICABLE, ANY AND ALL IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. A PURCHASER'S ONLY REMEDIES IN CONNECTION WITH THIS WARRANTY ARE THOSE SET FORTH IN THIS WARRANTY. IN NO EVENT WILL WESTEEL, ITS DEALERS, OR ANY COMPANY AFFILIATED WITH WESTEEL BE LIABLE FOR INCIDENTAL, CONSEQUENTIAL OR PUNITIVE DAMAGES.

Some jurisdictions do not allow waivers of certain warranties, so the above waivers may not apply to you. In that event, any implied warranties are limited in duration to ninety (90) days from delivery of the products. You may also have other rights which vary from jurisdiction to jurisdiction.

7. **Exclusive Warranty.** This warranty is the only warranty provided by Westeel and all other warranties and/or commitments whether express or implied and no matter by whom made, statutory or otherwise, are subsumed and replaced by it and are of no legal effect. If any provision of the warranty is held by a court of competent jurisdiction to be void or unenforceable, in whole or in part, such provision shall be deemed severable and will not affect or impair the legal validity of any other provision of the warranty.

Note: An extended warranty may be available for purchase in respect of certain of the goods (the "Guardian Warranty and Environmental Protection Program"). The terms of the Guardian Warranty and Environmental Protection Program apply only if and when it is purchased. Please contact a Westeel representative should you wish further information on terms and pricing of the Guardian Warranty and Environmental Protection Program.

DISCLAIMERS

External Corrosion

The warranty does not apply if:

- I. Foreign materials have contacted painted surfaces or stainless steel surfaces causing damage and/or allowing for corrosion and/or rust.
- II. The goods have been primed and/or painted by someone other than Westeel.
- III. Threaded material has been scraped or scratched in a manner causing damage and/or allowing for corrosion and/or rust (eg. pipe caps or pumps).

Internal Corrosion

The warranty does not apply if:

- I. The goods are not used solely for the containment of petroleum products, unless otherwise stated in writing and signed off by an authorized representative of Westeel.
- II. All maintenance procedures are not strictly followed. This includes but is not limited to a regular inspection for internal moisture and debris, dents, punctures, leaks and loose or damaged fittings a minimum of once every twelve (12) months.

Loss of Vacuum

The warranty does not apply if:

- I. The purchaser fails to contact Westeel immediately for instructions when vacuum appears to have been lost.
- II. The vacuum has not been checked immediately after transporting to installation site.
- III. The Installation Checklist is not strictly followed and completed, signed and returned to Westeel within fourteen (14) calendar days of the date of delivery.

Underground Tanks

The warranty does not apply if:

- I. The Installation Checklist is not strictly followed and completed, signed and returned to Westeel within thirty (30) calendar days of the date of installation or ninety (90) calendar days of the date of shipment to the purchaser, whichever occurs first.

General

The following disclaimers apply to the goods in all circumstances:

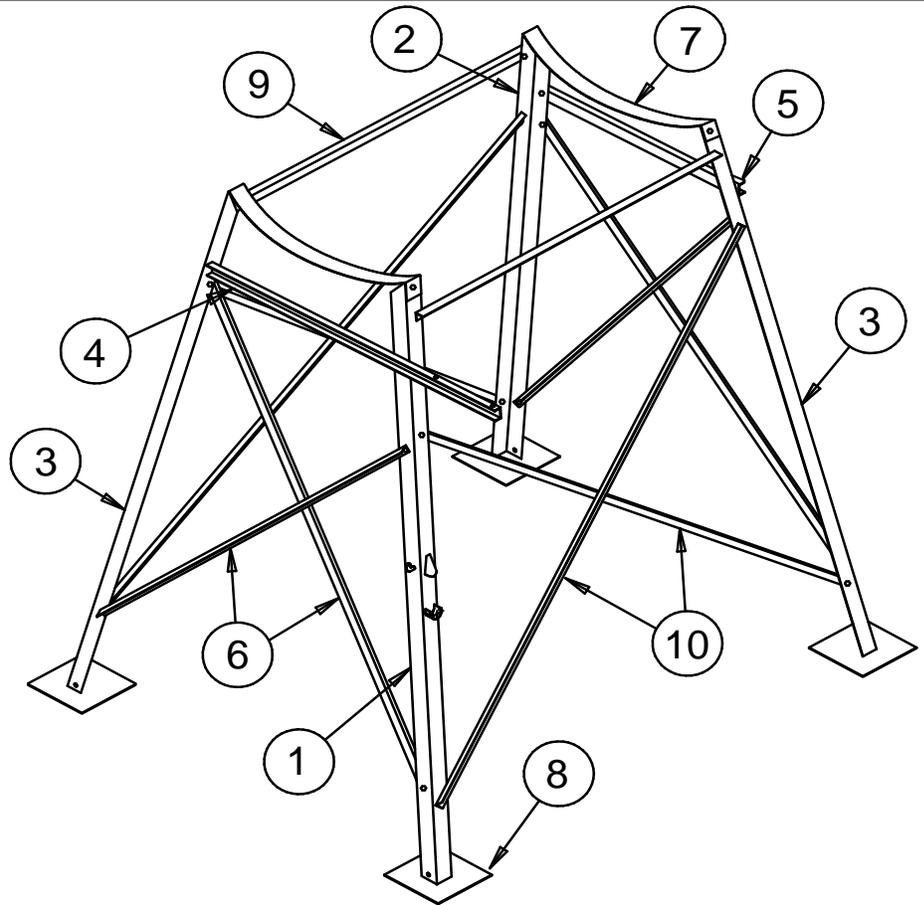
- I. The goods must be installed by a certified installer recognized by local authorities, where applicable, and strictly in accordance with Westeel's Installation Instructions as well as all applicable installation and building codes and accepted trade practices. Without limiting the generality of the foregoing, proper foundation assembly, installation and use solely for the purposes intended as specified in Westeel's published product literature is essential. As well, tank venting for both normal and emergency situations must be installed properly and kept unobstructed at all times.
- II. The goods must be handled at all times (including but not limited to shipping, loading and unloading, positioning) only when empty and must be secured at all times in a manner as specified in the Owners' Manual. Any damage caused during handling is not covered by the warranty.
- III. Any damage caused by foreign debris entering into the tanks, including but not limited to moisture, is not covered by the warranty. It is extremely important for the owner/user to check for foreign debris inside the tank at the time of delivery as well as before commencing use of the goods and regularly during use of the goods. Moisture can cause irreparable damage to the goods including but not limited to a leak due to microbial corrosion. For further information on moisture monitoring and removal you may contact:
 - [Steel Tank Institute \(STI\)](#)
 - [Westeel website](#)
 - [Petroleum Equipment Institute](#)
- IV. Accessories and parts on the goods may not have been manufactured by Westeel ("third party manufactured goods"). Third party manufactured goods are not covered by the warranty. Warranty terms applicable to third party manufactured goods are as per the terms published by the applicable manufacturer. For further information on accessing the website of the applicable manufacturer please contact a Westeel representative.
- V. Modifications made to the goods that have not been approved in writing by an authorized representative of Westeel will result in the warranty being null and void. This will be the case for any and all damages howsoever caused to the goods at any time after the modification has been made.
- VI. The goods must be maintained and used at all times in a manner consistent with all Westeel procedures contained in the Owners' Manual as well as prudent, accepted practice.

Tank Stand Packages

Height of Stand	1363L (300G) / 2273L (500G) Package Part Number	4546L (1000G) Package Part Number
1220mm (4ft)	264264	235070
2134mm (7ft)	264265	264290
2743mm (9ft)	264266	264276

▲ IMPORTANT

Check parts against material list and report any missing components **immediately**. Site chosen must be level and firm with good support under the base plates. Use planks under base plates if necessary.



Materials List

MK	DESCRIPTION	PART NUMBERS						QTY
		1220mm (4ft) Stand		2134mm (7ft) Stand		2743mm (9ft) Stand		
		300/500G	1000G	300/500G	1000G	300/500G	1000G	
1	R/H Upright w/ Lockable Nozzle Hanger	235063	264369	235049	264340	235091	264350	1
2	R/H Upright, Plain	235065	234368	235051	264342	235093	264352	1
3	L/H Upright, Plain	235064	264367	235050	264341	235092	264351	2
4	Safety Ladder Support	235088	264343	235088	264343	235083	264343	1
5	Rear Cross Brace	235058	264344	235058	264344	235059	264344	1
6	End Diagonal Brace	235067 <i>(1349mm Long)</i>	264373 <i>(1594mm Long)</i>	235056 <i>(1943mm Long)</i>	264345 <i>(2266mm Long)</i>	235094 <i>(2350mm Long)</i>	264356 <i>(2754mm Long)</i>	4
7	Saddle Band	235084	264346	235084	264346	235084	264346	2
8	Base Plate	264289	264289	264289	264289	264289	264289	4
9	Side Horizontal Brace	235057 <i>(1580mm Long)</i>	264347 <i>(2400mm Long)</i>	235057 <i>(1580mm Long)</i>	264347 <i>(2400mm Long)</i>	235057 <i>(1580mm Long)</i>	264347 <i>(2400mm Long)</i>	2
10	Side Diagonal Brace	235066 <i>(1911mm Long)</i>	264372 <i>(2764mm Long)</i>	235055 <i>(2413mm Long)</i>	264348 <i>(3302mm Long)</i>	235095 <i>(2778mm Long)</i>	264358 <i>(3704mm Long)</i>	4
11	Hardware Package	264325 <i>(36x3/8" bolts/nuts)</i>	264326 <i>(36x1/2" bolts/nuts)</i>	264325 <i>(36x3/8" bolts/nuts)</i>	264326 <i>(36x1/2" bolts/nuts)</i>	264325 <i>(36x3/8" bolts/nuts)</i>	264326 <i>(36x1/2" bolts/nuts)</i>	1

Tank Stand Assembly Instructions

Prior to assembly, measure the tank diameter to ensure that the proper holes are used during tank stand assembly. **Incorrect assembly may result in failure and will void any warranty.**

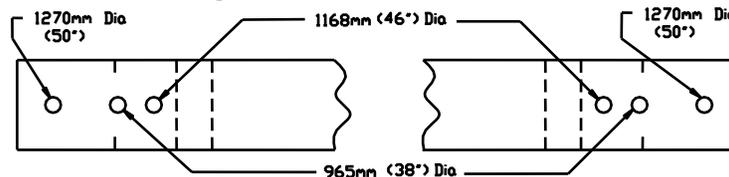
Tighten bolts only hand-tight during assembly. Tighten all bolts with a wrench after tank has been placed onto the assembled stand.

STEP 1: Assemble Front and Rear Frames

- Begin by laying out a left (MK3) and right (MK1 or 2) upright on the ground with center ridge sticking up and the diagonally cut corners facing each other. Bolt on the safety ladder support (MK4) to the first hole located closest to the diagonally cut corner on each upright*. The support should extend off to the right (→) side.
 - ***If assembling a 300G/500G stand:** There are two holes on the left side of the safety ladder support. Use the hole closest to the end for 1270mm (50") diameter tanks only. All others will use second hole in from the end.
- Once the safety ladder support is attached to both uprights, bolt on two end diagonal braces (MK6) using the second and third* holes from the diagonally cut corner. One end diagonal will attach on the front side of the frame, while the other will attach on the back side. Bolt the end diagonal braces together where they cross each other in the center*.
 - ***If assembling a 300G/500G stand:** Use third hole for 1270mm (50") diameter tanks only. All others will use the fourth hole. When bolting the end diagonals together in the middle, use the lower hole on each brace with the 1270mm (50") diameter tank only. All others will use the upper hole on each brace.
- Repeat these steps again for the second pair of uprights using the rear cross brace (MK5) instead of a safety ladder support.

STEP 2: Attach Saddle Bands

- ***For 300G / 500G Tank stands:** See the diagram below to determine which set of holes to use:



- Bolt on a saddle band (MK7) to the top of both the front and rear frames with the embossing towards the frame. Bend the band around the top of the upright on both sides and form the band into a curve by hand. **Do not hammer the band into shape**, the weight of the tank will form the band to its final position.

STEP 3: Combine Front and Rear Frames / Stand up Assembly

- Lay the front and rear frames close together on the ground with the tops facing each other. The ladder support and rear cross braces should be facing up.
- Loosely bolt on the side diagonal braces (MK10) to the third and fourth holes on the sides of the frames (counting from the top). Attach two braces on each side: one facing out and one facing in.
- Stand up the assemblies and line up the holes in the side diagonal braces. Once aligned, bolt the side diagonal braces together where they cross and hand tighten any other loose bolts.
- Attach the side horizontal braces (MK9) to the holes directly below the ones used to secure the saddle band. Attach the base plates (MK8) on the bottom of each leg.

STEP 4: Placing Tank and Securing Bolts

- Locate the tank centrally on the stand. Check that the tank sits properly with a snug fit on the saddle bands and tops of the legs. If it doesn't, verify that the correct holes were used during assembly.
- If tank sits properly, tighten all nuts and bolts with a wrench to secure stand assembly.

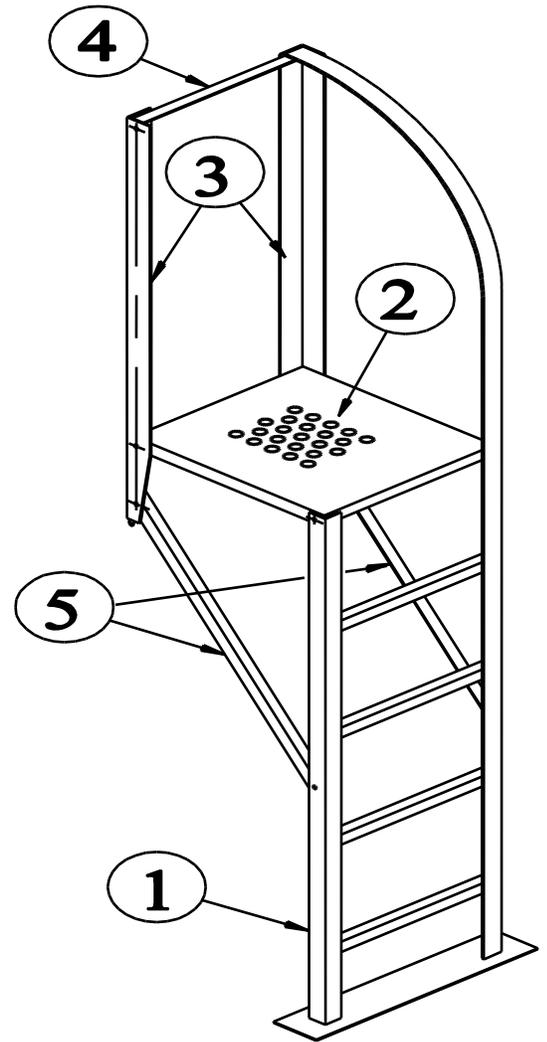
Optional Safety Ladder Assembly Instructions

Height of Stand	Safety Ladder Package Part Number
1220mm (4ft)	264282
2134mm (7ft)	264291
2743mm (9ft)	264280



IMPORTANT: Check parts against material list and report missing components *immediately*. Assemble per instructions, but do not fully tighten nuts until ladder is completely assembled.

- STEP 1:** Attach platform (2) to ladder weldment (1).
- STEP 2:** Bolt uprights (3) to platform and curved handrail of ladder.
- STEP 3:** Bolt top angle (4) to uprights (3).
- STEP 4:** Bolt diagonal braces (5) to ladder (1) and bottom of uprights (3).
- STEP 5:** Insert studs on bottom of uprights into ladder support brace (on tank stand) and secure assembled safety ladder using 1/2" nuts and lock-washers.
- STEP 6:** Tighten all nuts and bolts with a wrench.



Materials List

MK	Description	Qty
1	Ladder Weldment	1
2	Platform	1
3	Mounting Upright	2
4	Horizontal Brace – 400mm (16")	1
5	Diagonal Brace 756mm (29.75")	2
6	½" Hex Nut	2
7	½" Lock-Washer	2
8	5/16" x 1" Hex Screw	11
9	5/16" Lock-Washer	11
10	5/16" Hex Nut	11