
USACE / NAVFAC / AFCESA / NASA UFGS-43 41 13.19 (August 2008)

Preparing Activity: NASA Superseding
UFGS-43 41 13.19 (June 2006)

UNIFIED FACILITIES GUIDE SPECIFICATIONS

References are in agreement with UMRL dated October 2008

SECTION TABLE OF CONTENTS

DIVISION 43 - PROCESS GAS AND LIQUID HANDLING, PURIFICATION, AND STORAGE
EQUIPMENT

SECTION 43 41 13.19

FIBERGLASS GAS AND LIQUID PRESSURE VESSELS

08/08

PART 1 GENERAL

- 1.1 REFERENCES
- 1.2 SUBMITTALS
- 1.3 GENERAL REQUIREMENTS
- 1.4 PRODUCT DELIVERY AND STORAGE

PART 2 PRODUCTS

- 2.1 LOADING CONDITIONS
- 2.2 CHEMICAL STORAGE REQUIREMENTS
- 2.3 CAPACITY AND DIMENSIONAL REQUIREMENTS
- 2.4 CONSTRUCTION REQUIREMENTS
- 2.5 ACCESSORIES
 - 2.5.1 Flanged Nozzles
 - 2.5.2 Inlet Nozzles
 - 2.5.3 Outlet Nozzles
 - 2.5.4 Vent
 - 2.5.5 Flanged Manways
 - 2.5.6 Removable Cover
 - 2.5.7 Tiedown Lugs
 - 2.5.8 Tank Lifting Lugs
 - 2.5.9 Identification Plate
 - 2.5.10 Certification Plate

PART 3 EXECUTION

- 3.1 INSTALLATION
- 3.2 HYDROSTATIC TEST
- 3.3 CLEANING
- 3.4 INSPECTION
- 3.5 Record Drawings

-- End of Section Table of Contents --

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SECTION 43 41 13.19

FIBERGLASS GAS AND LIQUID PRESSURE VESSELS 08/08

NOTE: This specification covers the requirements for fiberglass-reinforced polyester storage tanks and accessories for use in aggressive chemical service at atmospheric pressures and is limited to flat-bottomed, aboveground, vertical, cylindrical tanks.

This section includes NASA Reliability Centered Building and Equipment Acceptance (RCBEA) Guide criteria. The Project Manager and Design staff should evaluate and select products and related Predictive Testing and Inspection (PT&I) criteria which will optimize the life-cycle costs of the project.

Acceptance criteria testing should include:

- Tank Integrity testing
- Verification of Liquid Level
- Verification of Relief Devices.

This section does not cover vertical tanks with dished or conical bottoms, vertical tanks for buried service, pressure vessels, and horizontal tanks for both above ground and buried services.

Related work specified elsewhere includes:

- Cast-in-place concrete

- Anchor bolts (provide calculations that determine bolt types, sizes and quantities required.)

- Plastic pipe

- Acid-resistant pipe

- Chemical valves

- Liquid level gages

Drawings should show:

The physical location of each tank

The location of all accessories to be furnished with each tank

Concrete-foundation details for each tank

Anchoring details for each tank to the foundation

A schedule with connections, size, quantity, and location of tanks.

Specify connection usage such as drain, vent, or overflow and location by top or side. This schedule should be coordinated with all accessories and their locations shown on drawings.

Edit this guide specification for project specific requirements by adding, deleting, or revising text. For bracketed items, choose applicable items(s) or insert appropriate information.

Remove information and requirements not required in respective project, whether or not brackets are present.

Comments and suggestions on this guide specification are welcome and should be directed to the technical proponent of the specification. A listing of technical proponents, including their organization designation and telephone number, is on the Internet.

Recommended changes to a UFGS should be submitted as a Criteria Change Request (CCR).

PART 1 GENERAL

1.1 REFERENCES

NOTE: This paragraph is used to list the publications cited in the text of the guide specification. The publications are referred to in the text by basic designation only and listed in this paragraph by organization, designation, date, and title.

Use the Reference Wizard's Check Reference feature when you add a RID outside of the Section's Reference Article to automatically place the reference in the Reference Article. Also use the Reference Wizard's Check Reference feature to update the issue dates.

References not used in the text will automatically

be deleted from this section of the project
specification when you choose to reconcile
references in the publish print process.

The publications listed below form a part of this specification to the
extent referenced. The publications are referred to within the text by the
basic designation only.

ASME INTERNATIONAL (ASME)

ASME B16.5 (2003) Standard for Pipe Flanges and
Flanged Fittings: NPS 1/2 Through NPS 24

ASTM INTERNATIONAL (ASTM)

ASTM C 581 (2003; R 2008e1) Standard Practice for
Determining Chemical Resistance of
Thermosetting Resins Used in
Glass-Fiber-Reinforced Structures,
Intended for Liquid Service

ASTM D 5948 (2005e1) Standard Specification for
Molding Compounds, Thermosetting

BRITISH STANDARDS INSTITUTE (BSI)

BSI 4994 (1987; Amendment 1990) Specification for
Design and Construction of Vessels and
Tanks in Reinforced Plastics

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION (ISO)

ISO 7005-2 (1988) Metallic Flanges Part 2: Cast Iron
Flanges

NATIONAL AERONAUTICS AND SPACE ADMINISTRATION (NASA)

RCBEA 2.63 (2004) Tank and Storage Tank Un-pressurized

1.2 SUBMITTALS

NOTE: Review Submittal Description (SD) definitions
in Section 01 33 00 SUBMITTAL PROCEDURES and edit
the following list to reflect only the submittals
required for the project. Submittals should be kept
to the minimum required for adequate quality control.

A "G" following a submittal item indicates that the
submittal requires Government approval. Some
submittals are already marked with a "G". Only
delete an existing "G" if the submittal item is not
complex and can be reviewed through the Contractor's
Quality Control system. Only add a "G" if the
submittal is sufficiently important or complex in
context of the project.

For submittals requiring Government approval on Army

projects, a code of up to three characters within the submittal tags may be used following the "G" designation to indicate the approving authority. Codes for Army projects using the Resident Management System (RMS) are: "AE" for Architect-Engineer; "DO" for District Office (Engineering Division or other organization in the District Office); "AO" for Area Office; "RO" for Resident Office; and "PO" for Project Office. Codes following the "G" typically are not used for Navy, Air Force, and NASA projects.

Choose the first bracketed item for Navy, Air Force and NASA projects, or choose the second bracketed item for Army projects.

Government approval is required for submittals with a "G" designation; submittals not having a "G" designation are [for Contractor Quality Control approval.] [for information only. When used, a designation following the "G" designation identifies the office that will review the submittal for the Government.] Submit the following in accordance with Section 01 33 00 SUBMITTAL PROCEDURES:

SD-01 Preconstruction Submittals

Submit Record Drawing of [Existing Conditions](#) to the Contracting Officer.

Submit [Material, Equipment, and Fixture Lists](#) and [Construction Equipment Lists](#) in accordance with paragraph entitled, "General Requirements" of this section.

SD-02 Shop Drawings

Submit [Coordination Drawings](#) in accordance with paragraph entitled, "General Requirements" of this section.

[Cleaning
Inspection
Tests](#)

Submit [Equipment Room Layout](#) drawings in accordance with paragraph entitled, "Inspection" of this section.

Submit the following in accordance with paragraph entitled, "General Requirements" of this section.

[Fabrication Drawings
Installation Drawings
Listing of Product Installation](#)

SD-03 Product Data

Submit [Equipment and Performance Data](#) to the Contracting Officer prior to start.

Submit [Equipment Foundation Data](#) for fiberglass-reinforced polyester storage tanks including equipment weight and operating

loads, horizontal and vertical loads, seismic data, [wind loads] [hurricane force windloads], location and projection of anchor bolts, horizontal and vertical clearances for installation, plan dimensions of foundations and relative elevations, and other installation requirements such as utility services.

Submit Manufacturer's catalog data for the following items including spare parts.

Storage Tanks
Accessories

SD-04 Samples

Submit Manufacturer's Standard Color Charts for Laminates.

SD-05 Design Data

Submit certified copies of Design Analysis and Calculations for fiberglass-reinforced polyester storage tanks including live and dead loads, [wind loads], [hurricane force wind loads], [seismic data], and equipment and accessory loads affecting tank shells and tops.

SD-06 Test Reports

Submit Test Reports for Chemical Resistance Tests in accordance with paragraph entitled, "Chemical Storage Requirements" of this section.

Submit Test Reports for Tank Integrity
Submit Test Reports for Verification of Liquid Level Indication Results
Submit Test reports for Verification of Relief Device Results

SD-07 Certificates

Submit Listing of Product Installation in accordance with paragraph entitled, "General Requirements" of this section.

Certificates shall be submitted for the following items:

Storage Tanks
Installers

SD-08 Manufacturer's Instructions

Submit Manufacturer's Instructions describing the installation of specified system, including special notices and material safety data sheets, special signage and data relating to impedances, hazards, and safety precautions.

SD-09 Manufacturer's Field Reports

Submit written Manufacturer's Field Reports of all test data made at the job site for review and final approval no later than 30 calendar days prior to contract completion.

SD-10 Operation and Maintenance Data

Submit [_____] copies of the [Operation and Maintenance Manual](#) 30 calendar days prior to testing the system involved. Update and resubmit all data for final approval no later than 30 calendar days prior to contract completion.

[Storage Tanks](#)
[Flanged Nozzles](#)
[Inlet Nozzles](#)
[Outlet Nozzles](#)

SD-11 Closeout Submittals

Submit [Record Drawings](#) no later than 30 days prior to final completion.

1.3 GENERAL REQUIREMENTS

NOTE: If Section 23 00 00 AIR SUPPLY, DISTRIBUTION, VENTILATION, AND EXHAUST SYSTEMS is not included in the project specification, applicable requirements thereof should be inserted and the following paragraph deleted.

Section 23 00 00 AIR SUPPLY, DISTRIBUTION, VENTILATION, AND EXHAUST SYSTEMS applies to work specified in this section.

Submit [Existing Conditions](#) drawings, including any underground utilities, prior to start.

Submit [Fabrication Drawings](#) for fiberglass-reinforced polyester storage tanks.

Include construction and anchorage details within [Installation Drawings](#) for fiberglass-reinforced polyester storage tanks. Submit [Listing of Product Installation](#) for fiberglass-reinforced polyester storage tanks identifying at least five units, similar to those proposed for use, that have been in successful service for a minimum of five years. Identify purchaser, address of installation, service organization, and date of installation.

Provide [Coordination Drawings](#) showing the processes, structural, and architectural elements of the work. Indicate where conflicts or clearance problems exist between the various functions. Drawings must clearly show and include:

Manufacturer's certification that [Storage Tanks](#) are suitable for storage of specified chemicals.

Certificates providing confirmation that [Installers](#) have knowledge of the requirements of the applicable standard, including NASA [RCBEA 2.63](#), and that installation practices are enforced to ensure installation in a sound, undamaged condition.

[Material, Equipment, and Fixture Lists](#) including manufacturer's style or catalog numbers, specification and drawing reference numbers, warranty information, and fabrication site.

Construction Equipment Lists consisting of proposed construction equipment to be used in the project, including descriptive data.

1.4 PRODUCT DELIVERY AND STORAGE

Handle and store tanks per manufacturer's guidelines to prevent damage. Deliver each tank in compliance with specifications and provide verification of no damage, surface defects, or poor quality laminates.

Concurrent with delivery of tanks submit three copies of manufacturer's Operation and Maintenance Manual.

All damaged or defective tanks or removable covers will be rejected. Remove immediately from the project site.

PART 2 PRODUCTS

2.1 LOADING CONDITIONS

NOTE: Show equipment and accessory loads affecting tank shells and tops, if required. Show windload for exterior tanks and tank top design load when top manways are specified.

Conform tanks to meet loading conditions specified in project requirements.

2.2 CHEMICAL STORAGE REQUIREMENTS

Provide Design Analysis and Calculations for fiberglass-reinforced polyester storage tanks complying with BSI 4994, and loading conditions specified in project requirements.

NOTE: Project Manager should review NASA RCBEA criteria under section 2.63 (2.63.1, 2.63.2, and 2.63.3 to determine the extent of required acceptance documentation.

Submit Test Reports for Chemical Resistance Tests in accordance with ASTM C 581.

Submit Test Reports for the following:

Tank Integrity
Verification of Liquid Level Indication Results
Verification of Relief Device Results

Results of previous successful tests are acceptable provided laminates are representative of the tanks specified for this project.

2.3 CAPACITY AND DIMENSIONAL REQUIREMENTS

NOTE: Capacities vary from approximately 10 to 75,000 gallons 40 liter to 300 kiloliter.

Minimum capacity (gallons) (liter) measured to the top of the straight shell or wall height must be as indicated.

NOTE: Diameters vary from approximately 2 to 16 feet
0.6 to 5 meter. Wall heights vary from
approximately 1 to 47 feet 0.3 to 14 meter.

Approximate diameter and approximate straight shell or wall height must be as specified.

2.4 CONSTRUCTION REQUIREMENTS

NOTE: Select either filament-wound or contact-molded construction.

Filament winding is a process for tank fabrication in which continuous strands of fiberglass impregnated with resin are wound over the inner corrosion barrier in a predetermined geometric pattern.

Contact molding is a process for tank fabrication in which the structural reinforcement comprises sprayed, chopped-fiberglass supplemented with woven-glass roving fabric. This process is also known as hand layup, spray layup, pressure molding, or contact pressure molding. The pressure is seldom greater than that required to hold the materials together during fabrication.

Tanks up to 5 feet 1.5 meter are less expensive when fabricated by contact-molding methods. Strength requirements in larger tanks make filament-wound structures more economical. Filament winding offers equivalent strength with less shell thickness, and laminate quality is also improved.

NOTE: ASTM D 5948 is English system units, for designer information, if needed.

[Tank must be contact-molded, conforming to ASTM D 5948 BSI 4994 (ASTM D 5948).]

[Tank must be filament-wound, conforming to ASTM D 5948. BSI 4994 (ASTM D 5948).]

NOTE: Select one of the following for tank top.

[Tank must have an open top, with reinforcing flange in compliance with

ISO 7005-2 or rib [and removable cover].]

[Tank must have a closed top.]

NOTE: Select one of the following types if tank is
to have closed top.

The end of a filament-wound cylindrical container
normally appearing convex is called a domed top.

The end of a filament-wound or contact-molded tank
normally appearing concave is called a dished top.

[Tank must have a closed top and be type [dome] [dished] [flat].]

NOTE: Select one of the following for top
fabrication.

Separate fabrication of top and shell is most common.

[Closed top must be [integrally fabricated with shell] [separately
fabricated and laminated to the shell].]

NOTE: Select one of the following two paragraphs
for flat bottom fabrication.

Integral fabrication offers greater strength and
does not rely on laminating procedures to join
separate sections.

The flat bottom must be fabricated [integrally with the shell] [separately
and laminated to the shell].

NOTE: Specify any additional special surfaces based
on accessories and equipment required.

Tank must have bracketed flat surfaces for [identification plate]
[certification plate] [liquid-level gage] [mounting lugs].

Submit Manufacturer's catalog data for [Storage Tanks](#) including spare parts.

Submit [Manufacturer's Standard Color Charts](#) for visual inspection of
surface finish and color of [Laminates](#).

2.5 [ACCESSORIES](#)

NOTE: Accessories specified are common items for
general usage. Consult manufacturer's literature
for other standard and special accessories.

2.5.1 Flanged Nozzles

NOTE: Standard nozzles are suitable for most applications, but conically gusseted nozzles should be specified when vibratory or thermal stresses are anticipated.

Nozzles must be [standard] [conically gusseted].

Conform Flange diameter and drilling to ASME B16.5, ISO 7005-2, 150 pounds per square inch 1050 kilopascal (150 psi).

2.5.2 Inlet Nozzles

NOTE: Double-flanged inlet nozzles should be specified when interior pipe connections are desired.

Inlet connections must be [single] [double] flanged.

2.5.3 Outlet Nozzles

NOTE: Double-flanged outlet nozzles should be specified when interior pipe connections are desired.

Outlet connections for side shell and top must be [single] [double] flanged.

Drain must be [side-bottom] [full] [siphon] [bottom] type.

[Bottom elbow must be provided.]

2.5.4 Vent

NOTE: Select one of the following types of vents for closed-top and removable-top tanks. Show vent size on drawings.

Vent for tank top must be [v-vent] [gooseneck] [mushroom].

2.5.5 Flanged Manways

[Manway not required.]

Tank must have [top-flanged] [side-flanged] manway.

[Conform Flange diameter and drilling to ASME B16.5, ISO 7005-2, 150 pounds per square inch 1050 kilopascal.]

2.5.6 Removable Cover

[Cover not required.]

Cover style must be [domed] [dished] [flat].

[Provide lifting ring at center of cover.]

[Provide three lifting lugs on cover.]

2.5.7 Tiedown Lugs

NOTE: Indicate quantity of lugs and angular spacing based on manufacturer's recommendations. Lugs should be specified on tanks subject to vibratory stresses and those erected outdoors. Three to six lugs evenly spaced are standard practice, depending upon tank size.

Provide tiedown lugs as indicated.

2.5.8 Tank Lifting Lugs

Provide three lifting lugs spaced 90 degrees apart at top portion of straight shell; provide one lug below center top lug.

2.5.9 Identification Plate

Provide phenolic-plastic identification plate stating chemical to be stored, with letters at least 2 inches 50 millimeter high.

2.5.10 Certification Plate

Provide stainless-steel certification plate, stating chemical to be stored, concentration, specific gravity, and maximum temperature.

PART 3 EXECUTION

3.1 INSTALLATION

Install Tank on foundation in accordance with recommended [Manufacturer's Instructions](#). Submit [Equipment Foundation Data](#) to the Contracting Officer.

3.2 HYDROSTATIC TEST

After tank has been installed, before piping connections are made and equipment attached, block outlets and fill straight-shell portion with chemically compatible fluid. Perform Hydrostatic [Tests](#) to determine if leak proof storage is provided, and correct deficiencies. Submit written [Manufacturer's Field Reports](#) of all test data made at the job site for review and final approval. Repair or replace unsatisfactory tanks and retest at no additional cost to the Government until leak proof systems are obtained.

3.3 [CLEANING](#)

After installation has been completed and piping connections have been made, clean tank and nozzles in accordance with [Manufacturer's Instructions](#).

3.4 INSPECTION

Inspect installed tanks for indications of defective workmanship or improper installation practices. Repair or replace all faulty construction and damaged work at no additional cost to the Government.

Submit [Equipment and Performance Data](#) by the storage tank manufacturer indicating use life, safety features, and mechanical automated details.

Show on drawings of [Equipment Room Layout](#) structural and fenestration features, and items requiring installation that could reduce the available space. Detail all ductwork and piping .

3.5 Record Drawings

Record drawings must include all civil site developments such as new facility and/or land modifications, external structural changes to aboveground structures, and changes to underground structures and utilities external to facilities located on lands owned by or held in leasehold interest of the federal government.

Acceptance of the completed drawings by the Contractor certifies accuracy and completeness of the documents. Nonconformity with any of the following requirements will result in withholding of vendor payments.

Information in record drawings must include, but not be limited to:

- a. Location of all new lines, conduits, valves, fittings, fire hydrants, meters, terminal points using at least two ties to permanent points (manholes, power poles, curbs, or storm water inlets), or GPS coordinates with accuracy to at least 1 meter, or better if more stringent accuracy requirements are specified in other sections of this subcontract. An acceptable station and offset system may be used for service lines and fittings only.
- b. Location of new lines from property easement lines or edges of pavement at intervals of [300 feet](#) [90 meter](#).
- c. All utility routing and interface changes shall be reflected on the drawings to scale and defined with sufficient dimensions.
- d. Provide support for obtaining surveyed coordinates for facility footprint corner and underground structures and utilities external to facilities by submitting Form ENG-F-CE06 to the Subcontract Administrator at least five (5) working days prior to foundation construction or open excavation as notification to the JBOSC Survey Services Department.
- e. Prepare record drawing prints at a minimum scale of 1 inch equals 100 feet. Enlarge as necessary all areas requiring additional detail.
- f. Provide record drawings in digital format. Geospatially referenced files must be in ESRI GIS Geodatabase, ESRI GIS Shapefile, Microstation DGN, AutoCAD DWG or DXF file format. Information should be provided in separate layers/levels as specified by GIS in at least the same degree of separation as the design drawings provided. Contain in the same levels any new like items to permit easy conversion to GIS layers.

- g. Use spatial reference as:

Horizontal accuracy: Reference all surveys/drawings to Florida State Plane Coordinate System, East Zone, North American Datum 1983/1990 adjustment based on Second Order Class II horizontal control monument.

Vertical accuracy: Reference all surveys to North American Vertical Datum (NAVD) 1988. Include a description of the reference benchmarks from which the NAVD has been determined in the survey.

- h. Make all lines, letters, and details sharp, clean, and fully legible.
- i. One reproducible print and one digital copy in an electronic storage media are required for submittal.

-- End of Section --