
USACE / NAVFAC / AFCEC / NASA UFGS-33 56 13.15 (May 2012)

Preparing Activity: NAVFAC NEW

UNIFIED FACILITIES GUIDE SPECIFICATIONS

References are in agreement with UMRL dated October 2013

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DIVISION 33 - UTILITIES

SECTION 33 56 13.15

UNDERTANK INTERSTITIAL SPACE

05/12

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SECTION 33 56 13.15

UNDERTANK INTERSTITIAL SPACE 05/12

NOTE: This guide specification is intended to be used in conjunction with Section 33 56 13.13 STEEL TANKS WITH FIXED ROOFS.

Adhere to UFC 1-300-02 Unified Facilities Guide Specifications (UFGS) Format Standard when editing this guide specification or preparing new project specification sections. 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, suggestions and recommended changes for this guide specification are welcome and should be submitted as a Criteria Change Request (CCR).

Use of electronic communication is encouraged.

Brackets are used in the text to indicate designer choices or locations where text must be supplied by the designer.

NOTE: The following information shall be shown on the project drawings:

1. The extent of the work included in the project should be indicated on drawings showing the site layout and other data required for design by the Contractor.
2. If concrete foundation work is provided under a separate contract, Government work should include foundations, setting anchor bolts and other pertinent work such as piles and ringwall penetrations.

NOTE: For steel and stainless steel piping, pipe fittings, flanges, gaskets, and bolting, refer to Section 33 52 43.13 AVIATION FUEL PIPING or Section 33 52 43 AVIATION FUEL DISTRIBUTION (NON-HYDRANT).

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.

AMERICAN PETROLEUM INSTITUTE (API)

API Std 650 (2013; Errata 2013) Welded Tanks for Oil Storage

ASTM INTERNATIONAL (ASTM)

ASTM B221 (2013) Standard Specification for Aluminum and Aluminum-Alloy Extruded Bars, Rods, Wire, Profiles, and Tubes

ASTM B221M (2013) Standard Specification for Aluminum and Aluminum-Alloy Extruded Bars, Rods, Wire, Profiles, and Tubes (Metric)

ASTM C33/C33M (2013) Standard Specification for Concrete Aggregates

ASTM C88 (2013) Standard Test Method for Soundness of Aggregates by Use of Sodium Sulfate or Magnesium Sulfate

ASTM D2136	(2002; R 2012) Coated Fabrics - Low-Temperature Bend Test
ASTM D2665	(2012) Standard Specification for Poly(Vinyl Chloride) (PVC) Plastic Drain, Waste, and Vent Pipe and Fittings
ASTM D3389	(2010) Coated Fabrics Abrasion Resistance (Rotary Platform, Double-Head Abrader)
ASTM D3786/D3786M	(2013) Hydraulic Bursting Strength of Textile Fabrics-Diaphragm Bursting Strength Tester Method
ASTM D396	(2013) Standard Specification for Fuel Oils
ASTM D4354	(2012) Sampling of Geosynthetics for Testing
ASTM D4491	(1999a; R 2009) Water Permeability of Geotextiles by Permittivity
ASTM D4533	(2011) Trapezoid Tearing Strength of Geotextiles
ASTM D4632/D4632M	(2008; E 2013; R 2013) Grab Breaking Load and Elongation of Geotextiles
ASTM D471	(2012a) Standard Test Method for Rubber Property - Effect of Liquids
ASTM D4751	(2012) Determining Apparent Opening Size of a Geotextile
ASTM D4759	(2011) Determining the Specification Conformance of Geosynthetics
ASTM D4814	(2013a) Automotive Spark-Ignition Engine Fuel
ASTM D4833/D4833M	(2007; E 2013; R 2013) Index Puncture Resistance of Geotextiles, Geomembranes, and Related Products
ASTM D5677	(2005; R 2010) Fiberglass (Glass-Fiber-Reinforced Thermosetting-Resin) Pipe and Pipe Fittings, Adhesive Bonded Joint Type, for Aviation Jet Turbine Fuel Lines
ASTM D751	(2006; R 2011) Coated Fabrics
ASTM D814	(1995; R 2010) Rubber Property - Vapor Transmission of Volatile Liquids

U.S. DEPARTMENT OF DEFENSE (DOD)

MIL-DTL-38219	(1998; Rev D) Turbine Fuel, Low
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Volatility, JP-7

MIL-DTL-5624

(2013; Rev V) Turbine Fuel, Aviation,
Grades JP-4 and JP-5

MIL-DTL-83133

(2011; Rev H; Am 1 2012) Turbine Fuels,
Aviation, Kerosene Type, JP-8 (NATO F-34),
NATO F-35 and JP-8 + 100 (NATO F-37)

U.S. GENERAL SERVICES ADMINISTRATION (GSA)

CID A-A-52557

(Rev A; Notice 1) Fuel Oil, Diesel; for
Posts, Camps and Stations

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.

The Guide Specification technical editors have designated those items that require Government approval, due to their complexity or criticality, with a "G". Generally, other submittal items can be reviewed by the Contractor's Quality Control System. Only add a "G" to an item, 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.] The following shall be submitted in accordance with Section 01 33 00 SUBMITTAL PROCEDURES:

SD-02 Shop Drawings

Flexible membrane liner[; G][; G, [_____]]

SD-03 Product Data

FML Ringwall Sealant[; G][; G, [_____]]

Sand cushion[; G][; G, [_____]]

Flexible membrane liner (FML)[; G][; G, [_____]]

Geotextile Fabric[; G][; G, [_____]]

Geotextile Filter Fabric[; G][; G, [_____]]

Leak Detection Tell-Tale Pipe Well Screen[; G][; G, [_____]]

CP/Tracer Pipe Well Screen[; G][; G, [_____]]

PVC Pipe, Fittings, and Adhesive[; G][; G, [_____]]

Fiberglass Pipe, Fittings, and Adhesive[; G][; G, [_____]]

Aluminum Flat Bar[; G][; G, [_____]]

SD-04 Samples

FML Samples[; G][; G, [_____]]

SD-06 Test Reports

FML inspections

FML tests

Sand cushion tests - Prior to Delivery

Sand cushion tests - Post Delivery

Photographic Construction Documentation of the Undertank
Interstitial Space

CP/Tracer Pipe Installation Test

SD-07 Certificates

Qualifications of FML field engineer

Certificate of surface preparation[; G][; G, [_____]]

FML Manufacturer's Representative

Liner Manufacturer's Certification[; G][; G, [_____]]

SD-08 Manufacturer's Instructions

Flexible membrane liner (FML)

SD-09 Manufacturer's Field Reports

FML factory test[; G][; G, [____]]

1.3 RELATED REQUIREMENTS

Product to be stored in the tank is [JP-5] [JP-8] [____].

1.4 QUALIFICATIONS

1.4.1 Qualifications of FML Field Engineer

**NOTE: Include any local regulatory requirements
that must be met by the Contractor.**

The Contractor shall meet the licensing requirements of the State in which the work is to be performed. The Contractor shall provide a field engineer full time to this project during FML installation and testing. The field engineer shall have successfully completed manufacturer's training for handling and installing FML systems, as well as have at least 100,000 square meter one-million square feet of installation experience. Submit a letter providing evidence of the Contractor's and the field engineer's experience, training, and licensing. Statements of previous FML job experience shall be provided with a point of contact, a phone number, address, the type of installation, and the current status of the installation.

1.5 QUALITY ASSURANCE

1.5.1 Flexible Membrane Liner Drawing Requirements

Submit drawings of the FML installation indicating the locations of field seams, penetrations, contours, and transitions and details of penetrations, boots, and miscellaneous components.

1.5.2 FML Manufacturer's Representative

Submit a letter, prior to placing the FML, from the FML manufacturer naming their authorized representative complete with their address, phone number, and a point of contact.

1.6 Liner Manufacturer's Certification

Following the successful installation and testing of the liner, submit a letter signed by the liner manufacturer's authorized representative certifying that the liner installation and testing results are satisfactory and that each meets the company's quality expectations and warranty. Include in the letter the representative's name, address, phone number, and qualifications for being a manufacturer's representative.

PART 2 PRODUCTS

2.1 STEEL PIPE AND FITTINGS

Steel and stainless steel pipe and fittings shall be provided in accordance with Section 33 52 43.13 AVIATION FUEL PIPING or Section 33 52 43 AVIATION FUEL DISTRIBUTION (NON-HYDRANT) and API Std 650.

2.2 LEAK DETECTION TELL-TALE PIPE

NOTE: Since a leak in the undertank tell-tale pipe could result in contamination of ground water and PVC manufacturers have been unable to certify that PVC adhesive is suitable for use in jet fuel, PVC is not an acceptable material for the undertank drain tell-tale pipe.

2.2.1 Fiberglass Pipe, Fittings, and Adhesive

Fiberglass pipe and fittings shall be **ASTM D5677**, Type 1, Grade 1; PVC pipe shall not be used. Pipe shall be Class F. Fiberglass adhesives shall be as recommended by the manufacturer for use with jet fuel and water.

2.2.2 Leak Detection Tell-Tale Pipe Well Screen

Well screen shall be fiberglass pipe as specified above. The **100 mm 4 inch** well screen shall have four rows of **0.25 mm 0.010 inch** wide slots with a net open area of at least **62 square centimeters 9.6 square inches**.

2.3 CP/TRACER PIPE

2.3.1 PVC Pipe, Fittings, and Adhesive

CP/tracer pipe and leak simulation probe pipe, fittings, and well screen shall be **ASTM D2665** SCH 40 PVC Pipe. PVC adhesives shall be as recommended by the manufacturer.

2.3.2 CP/Tracer Pipe Well Screen

CP/Tracer Gas Detection well screen shall be PVC pipe as specified above and shall have three rows of **0.25 mm 0.010 inch** wide slots. CP/Tracer Gas Detection piping shall be slotted, starting at **600 mm 2 feet** within the ringwall on one side of the tank and continuing under the tank bottom to within **600 mm 2 feet** of the foundation ringwall on the other side of the tank.

2.4 FLEXIBLE MEMBRANE LINER (FML)

The secondary containment (under-tank-bottom) FML shall demonstrate the acceptable limits of the properties listed under Table 1. The FML shall be factory produced from a base fabric that is completely covered with a polymer. The base fabric shall be made of aramid (kevlar), polyester, or nylon. Factory seams shall be made with a **50 mm 2 inch** overlap, plus or minus **6 mm 1/4 inch**, by an automatic thermal high-pressure welding process. The FML shall retard the growth of mildew and be capable of containing the liquid stored, withstanding temperatures up to **71 degrees C 160 degrees F**, and withstanding humidity up to 100 percent relative humidity.

2.4.1 Job Lot of FML

A job lot of FML is defined by this specification as the amount of FML product that can be produced from a singular mixture of chemicals. Any FML material created from a new or altered mixture of chemicals shall be considered a new job lot.

2.4.2 FML Samples

Twenty four samples shall be cut from every job lot of FML. Each sample shall be approximately 216 by 280 mm 8 1/2 by 11 inches in size. Eight of the samples shall be cut across factory seams.

2.4.3 FML Factory Test

Each manufacturer's job lot of FML shall have each of the FML properties verified by the factory test procedures and methods listed below. No substitute methods shall be allowed for verification of any property. Each separate verification of a property shall be made on a separate sample. The FML shall demonstrate through factory testing the acceptable limits of the following properties listed in Table 1. The properties shall be verified by each of the test standards listed.

NOTE: Include testing for permeability using the
liquid stored in addition to Fuel B.

TABLE 1. Standards and Limits for FML Properties (Metric)	
<u>Property</u>	<u>Minimum Acceptable Value</u>
Base Fabric Weight (nominal)	441 g/m ²
Finished Coated Weight ASTM D751	1085 g/m ² <u>plus</u> 70 g/m ²
Thickness ASTM D751	0.86 mm
Grab Tensile ASTM D751	3338 N
Strip Tensile ASTM D751 Procedure B	490 daN/5cm
Adhesion ASTM D751 Dielectric Weld	18 daN/5cm
Hydrostatic Resistance ASTM D751 Procedure A	5.52 MPa
Bursting Strength ASTM D751 Ball Tip	5340 N
Low Temperature ASTM D2136 3 mm mandrel, 4 hour	Pass minus 46 degrees C
Abrasion Resistance ASTM D3389 H22 wheel/1000 g load	10,000 cycles (min) before fabric exposure

TABLE 1. Standards and Limits for FML Properties (Metric)	
<u>Property</u>	<u>Minimum Acceptable Value</u>
Permeability ASTM D814 Fuel B and [_____]	19.1 mL/m ² /24 hr

TABLE 1. Standards and Limits for FML Properties (English)	
<u>Property</u>	<u>Minimum Acceptable Value</u>
Base Fabric Weight (minimum)	13.0 oz/yd ²
Finished Coated Weight ASTM D751	30 oz/yd ²
Thickness ASTM D751	0.034 inches
Grab Tensile ASTM D751	750 lb _f /in
Strip Tensile ASTM D751 Procedure B	550 lb _f /in
Adhesion ASTM D751 Dielectric Weld	20 lb _f /in
Hydrostatic Resistance ASTM D751 Procedure A	800psi
Bursting Strength ASTM D751 Ball Tip	1200 lb _f
Low Temperature ASTM D2136 1/8 inch mandrel, 4 hour	Pass minus 50 degrees F
Abrasion Resistance ASTM D3389 H22 wheel/1000 g load	10,000 cycles (min) before fabric exposure
Permeability ASTM D814 Fuel B and [_____]	0.05 fl. oz/ft ² /24 hr

2.4.4 FML Components

Components, such as sleeves, boots, etc., shall be factory prefabricated from the FML material and have the same fabrication characteristics.

2.4.5 Fuels for Testing FML

Other materials, in addition to the FML, shall be resistant to the fuel or fuels being stored. Fuels, as required or mentioned by this specification, shall be in accordance with the following:

2.4.5.1 Motor Gasoline (Mogas)

Mogas shall be in accordance with [ASTM D4814](#) REV B.

2.4.5.2 Diesel

Diesel shall be in accordance with [CID A-A-52557](#).

2.4.5.3 No. 2 and No. 4 Fuel Oils

Oils shall be in accordance with [ASTM D396](#).

2.4.5.4 JP-4 and JP-5

Fuels shall be in accordance with [MIL-DTL-5624](#).

2.4.5.5 JP-7

Fuel shall be in accordance with [MIL-DTL-38219](#).

2.4.5.6 JP-8

Fuel shall be in accordance with [MIL-DTL-83133](#).

2.4.5.7 ASTM Fuel B

ASTM Fuel B as referenced in this section shall be in accordance with [ASTM D471](#).

2.5 GEOTEXTILE FABRIC

Provide geotextile fabric between sand and underside of flexible membrane liner under the tank bottom with the following properties:

PROPERTY	TEST VALUE	TEST METHOD
Unit Weight g/sq. meter (oz/yd ²)	335 min. (10)	ASTM D4632/D4632M
Elongation at Break, Percent	50	ASTM D4751
Apparent Opening, mm (mil)	0.15 max. (6)	ASTM D4491
Permittivity, sec-1	1.2 max.	ASTM D4491
Puncture, N (lbs)	730 min. (165)	ASTM D4833/D4833M
Grab Tensile, N (lbs)	1110 min. (250)	ASTM D4833/D4833M
Trapezoidal Tear, N (lbs)	445 min. (100)	ASTM D4533
Burst Strength, kPa (psi)	3600 min. (500)	ASTM D3786/D3786M

2.5.1 Geotextile

Geotextile shall be a woven or nonwoven (as noted) pervious sheet of polymeric material and shall consist of long-chain synthetic polymers

composed of at least 95 percent by weight polyolefins, polyesters, or polyamides. The use of woven, slit-film geotextiles (i.e. geotextiles made from yarns of a flat, tape-like character) will not be allowed. Stabilizers and/or inhibitors shall be added to the base polymer, as needed, to make the filaments resistant to deterioration by ultraviolet light, oxidation, and heat exposure. Regrind material, which consists of edge trimmings and other scraps that have never reached the consumer, may be used to produce the geotextile. Post-consumer recycled material may also be used. Geotextile shall be formed into a network such that the filaments or yarns retain dimensional stability relative to each other, including the selvages. Geotextiles and factory seams shall meet the requirements specified in Table 1. Where applicable, Table 1 property values represent minimum average roll values (MARV) in the weakest principal direction.

2.5.2 Manufacturing Quality Control Sampling and Testing

Manufacturing quality control sampling and testing shall be performed in accordance with the manufacturer's approved quality control manual. As a minimum, geotextiles shall be randomly sampled for testing in accordance with [ASTM D4354](#) Procedure A. Acceptance of geotextile shall be in accordance with [ASTM D4759](#). Tests not meeting the specified requirements shall result in the rejection of applicable rolls.

2.6 GEOTEXTILE FILTER FABRIC

Wrap Leak Detection Tell-Tale and CP/Tracer Pipe well screen, with filter fabric, with the following qualities:

PROPERTY	TEST VALUE	TEST METHOD
Elongation at Break, Percent	50	ASTM D4632/D4632M
Apparent Opening, mm (U.S. Sieve)	0.212 max. (70)	ASTM D4751
Permittivity, sec-1	2.1 max.	ASTM D4491
Puncture, N (lbs)	240 min. (55)	ASTM D4632/D4632M
Grab Tensile, N (lbs)	400 min. (90)	ASTM D4632/D4632M
Trapezoidal Tear, N (lbs)	175 min. (40)	ASTM D4533
Burst Strength, kPa (psi)	1270 min. (185)	ASTM D3786/D3786M

2.7 BATTEN BAR

The FML shall be installed using a batten bar bolted to the concrete ringwall as indicated. Batten bar shall be [ASTM B221M ASTM B221 aluminum flat bar](#) rolled to the inside diameter of the ringwall foundation. Anchor bolt, nut, and washer shall be galvanized steel. Neoprene mounting pad shall be rated with a Shore A hardness of not more than 40.

2.8 FML RINGWALL SEALANT

The FML-to-ringwall sealant shall be fuel and water resistant and as recommended by the FML manufacturer.

2.9 SAND CUSHION

Sand shall be fine sand aggregate in accordance with ASTM C33/C33M, except maximum allowable percentage passing a 150 micron sieve and a 300 micron sieve shall be reduced to zero and 5 percent, respectively. Cushion shall contain no more than 300 parts per million (ppm) chlorides, no more than 150 ppm sulfates, and have a pH greater than 7. Cushion shall have a minimum electrical resistivity of 50,000 ohm-cm 19,685 ohm-inch. Magnesium sulfate shall be used in the ASTM C88 soundness test.

PART 3 EXECUTION

3.1 CONSTRUCTION

3.1.1 Sand Cushion

**NOTE: Include the first bracketed paragraph for
self anchored tanks. Include the second bracket
paragraph for anchored tanks.**

[Provide compacted clean sand above and below the FML as indicated. Thoroughly compact the sand cushion below each of the interstitial space components (i.e. liner, CP anodes, leak detection tell-tale pipe, CP/tracer pipe, etc.) Grade sand to match slope of the tank bottom and protect from contamination and disturbance until after the tank bottom is installed. Provide self-draining protective covering over the top of any sand placed on top of FML and keep sand dry at all times during construction.]

[For anchored tanks, build up the sloped sand pad so that the tank bottom will rest on the sand and the foundation ringwall shims. For unanchored tanks, build up the sand so that the tank bottom will rest on the sand and the foundation ringwall gasket. Do not use or place fiberboard on top of the foundation ringwall or on top of the sand.]

3.1.2 INSTALLATION OF FML

3.1.2.1 Field Engineer

The field engineer shall supervise the complete installation of the FML and perform each FML inspection and test.

3.1.2.2 Preparation

Prior to laying out the FML, three sample field seams shall be performed. Each seam shall be 1500 mm 5 feet in length. Seams shall be made only when the ambient temperature and the temperature of the FML are both minus 4 degrees C 25 degrees F or higher.

3.1.2.3 Surface Preparation

The surfaces to be covered shall be concrete or clean sand, as specified in the paragraph titled "Sand Cushion," free of rocks, debris, etc., and smooth with no abrupt projections of any kind. Submit a certificate of surface preparation signed by the field engineer, prior to placing any geotextile or liner, stating the subgrade was adequately prepared per the specification and the liner manufacturer's recommendations. Prior to

laying the FML, cover prepared surfaces with geotextile fabric as indicated.

3.1.2.4 FML Layout and Installation

After successful completion of the FML visual inspection, the FML shall be laid out. Install FML over geotextile fabric. Laying out and welding of FML shall only be done when the ambient temperature and the temperature of the FML are both **minus 4 degrees C 25 degrees F** or higher. Field seams shall have a **50 mm 2 inch** overlap, plus or minus **6 mm 1/4 inch**. Panels or sheets of FML to be seam welded together shall be laid out prior to welding field seams. The overlapped areas shall be cleaned and prepared according to the installation instructions and procedures. Welds shall be tightly bonded. Seal the FML around the penetrations using preformed boots. Use fuel resistant adhesive sealant between the boot and the penetration. Clamp the boots to the penetrations using stainless steel hose clamps as indicated. Prepare and weld the boots to the FML using the same preparation and welding methods used to weld the FML seams.

3.1.3 Cathodic Protection

Provide the underside of the tank bottom with impressed current cathodic protection. Install the cathodic protection anodes, slotted PVC tube for portable reference cell, and portable reference cell in the sand between the FML and the tank bottom in accordance with Section **26 42 19.00 20** CATHODIC PROTECTION BY IMPRESSED CURRENT.

3.1.4 Leak Detection Tell-Tale Pipe

NOTE: Include verbiage in the coating specification and on the drawing to provide, on the lower (300 mm) one foot of the shell, **50 mm 2 inch** high black stencil lettering with an arrow, pointing down, over the "Leak Detection Tell-Tale", the "Leak Simulation Probe", and the CP/Tracer Pipe. Identify the later as "Tracer Gas/CP Slider Tube" and identify the CP/Tracer pipe by its unique number.

Prior to steel tank construction, install leak detection tell-tale pipe through the ringwall and in the sand below the planned location of the tank bottom as indicated. System piping shall slope evenly downward (gravity draining) from the interior termination point at the tank bottom FML sump to the exterior termination point as indicated. Interior termination point shall be fiberglass well screen as indicated and covered with two wraps of geotextile filter fabric held in place with nylon ties or straps. Exterior termination point shall be as indicated. System piping shall be fiberglass, except as noted or indicated.

3.1.5 CP/Tracer Pipe

NOTE: Locate the CP/Tracer gas detection well screens, with one well screen at **600 mm 2 feet** off from tank center, no greater than **13411 mm 44 feet** apart and with all areas of the tank bottom within **6700 mm 22 feet** of at least one well screen.

Prior to steel tank construction, install the CP/tracer pipe and well screen piping through the ringwall and in the sand below the tank bottom as indicated. Cover with two wraps of filter fabric held in place with nylon ties or straps. The material, number, and lengths of the well screens and pipe shall be as indicated.

3.1.6 Leak Simulation Probe

NOTE: Locate the end of the leak simulation probe under the tank approximately 3000 mm 10 feet from the ringwall foundation and as far from a CP/Tracer gas well screen as practical.

Prior to steel tank construction, install the leak simulation probe through the ringwall and in the sand below the tank bottom as indicated. Interior termination point (under tank bottom) shall be an open ended coupling with two wraps of geotextile filter fabric held in place with nylon ties or straps.

3.1.7 Filter Fabric Wrap

Prior to steel tank construction, cover all of the well screen pipe segments with two wraps of geotextile filter fabric held in place with nylon ties or straps placed 300 mm 1 foot on center.

3.1.8 CP/Tracer Pipe Installation Test

After installation of the CP/tracer pipe and well screen is complete, prove that each of the CP/tracer pipes is clear (without obstructions or bends) in the presence of the contracting officer using a continuous length (including couplings) of 25 mm 1 inch PVC pipe at least as long as the pipe being tested plus 1 meter 3 feet. The test shall be performed by passing the 25 mm 1 inch PVC pipe through each of the 50 mm 2 inch CP/tracer pipes and removing the 25 mm 1 inch PVC pipe from the opposite end of the 50 mm 2 inch pipe on the other side of the ringwall. Notify the contracting officer at least 24 hours prior to the test.

3.1.9 Leak Simulation Probe[and Leak Detection Tell-Tale Pipe] Test[s]

Repeat the "CP/Tracer Pipe Installation Test" for the Leak Simulation Probe; exercise care not to damage the geotextile filter fabric wrap at the end. [For elevated foundation type tanks, repeat the "CP/Tracer Pipe Installation Test" for the Leak Detection Tell-Tale Pipe but use a 65 mm 2 1/2 inch PVC pipe. Exercise care not to damage the end.]

3.2 FIELD QUALITY CONTROL

The Contractor shall perform all trial operations and field tests and provide all labor, equipment, and incidentals required for testing. The FML manufacturer authorized representative shall be present for all FML tests. The representative shall supervise and approve all FML tests. He or she shall provide detailed test results. Notify and provide the

Contracting Officer with the opportunity to witness all field tests at least 24 hours in advance of their performance.

3.2.1 FML Inspections

3.2.1.1 FML Initial Visual Inspection

A visual inspection of the FML shall be performed on each FML panel or sheet as it is unrolled. The Contracting Officer shall be notified of any visually detected damage. The visual inspection shall also verify the finished surface to be covered with the FML is properly graded and compacted.

3.2.1.2 Sample Field Seam Inspection

Field seam samples shall be subjected to a visual inspection performed within 30 hours after the seam has been made, cured, and cooled.

3.2.2 FML Tests

3.2.2.1 FML Seam Pull Test

Just prior to vacuum box testing the FML field seams, perform manual pull testing of the FML field seams at ten locations selected by the Contracting Officer. The test shall be performed by applying at least **222 N 50 pounds** of force across the selected seams and maintaining for at least 60 seconds.

3.2.2.2 FML Vacuum Box Test

After successful completion of the FML visual inspection, a vacuum box test shall be performed on all field seams, the area around the seams, and all FML surfaces showing scuffing, penetration by foreign objects, or distress from rough subgrade. A glass topped vacuum box, which has a neoprene sealing gasket, shall be used. The vacuum box test shall be performed as follows:

- a. A commercial bubble forming solution shall be applied to the area to be tested.
- b. The vacuum box shall be positioned over the area and a vacuum slowly applied until a differential pressure of **7 kPa one psi** is achieved and held for at least 5 seconds while observing the solution for bubble formation.
- c. If the vacuum box test indicates a continuous stream of bubbles on repeated testing at the same location, then the area being tested shall be considered damaged and shall be repaired and retested.
- d. If the vacuum box test does not indicate a leak, then the vacuum shall be slowly increased until a maximum differential pressure of **14 kPa plus 0.0 or minus 2 kPa 2 psi plus 0.0 or minus 0.25 psi** is achieved and held for at least 20 seconds. If the test indicates a continuous stream of bubbles on repeated testing at the same location, then the area being tested shall be considered damaged and shall be repaired and retested. Care must be taken to limit the vacuum to no more than the maximum differential pressure because, if it is exceeded by more than **2 kPa 0.25 psi**, the FML shall be considered damaged and shall be replaced and retested.

3.2.2.3 FML Air Lance Tests

After successful completion of the FML vacuum box test, an air lance test shall be performed on all seams not accessible with a vacuum box test (i.e. small seams around penetrations, irregular patches, etc.). The air lance test will be performed using a 345 kPa 50 psig jet of air regulated and directed through a 5 mm 3/16 inch diameter nozzle, applied to the upper edge of an overlapped seam or repaired area to detect an unbonded area. Inflation of any section of the seam by the impinging air stream shall be indicative of an unbonded area. Unbonded areas shall be repaired and retested.

3.2.3 FML Acceptance Inspection

As soon as practicable after successful completion of the FML vacuum box test and the air lance tests, an acceptance inspection shall be performed. If the inspection reveals any defects in the work, such defects shall be repaired or the unsatisfactory work replaced before acceptance. The cost of such repairs and replacements shall be borne by the Contractor. The Contractor shall notify the Contracting Officer at least 48 hours in advance of the acceptance inspection.

3.2.4 Manufacturer's Field Service

If any problems are noticed in any inspection of an FML seam, the Contracting Officer shall be notified immediately. The FML manufacturer's point of contact shall also be contacted by telephone and e-mail and informed that the installation of their product cannot be adequately completed. After the FML manufacturer and their authorized representative have identified the problem and developed a solution, another set of sample field seams shall be made and reinspected.

3.2.5 Sand Cushion Tests - Prior to Delivery

Sample and test the sand prior to delivery and demonstrate that the sand meets the requirements of ASTM C33/C33M as well as for other properties described under the paragraph "SAND CUSHION".

For each sample, along with the requirements of ASTM C33/C33M, verify the amount of chlorides (ppm) and sulfates (ppm) and determine the pH value of the sand and the resistivity.

3.2.6 Sand Cushion Tests - Post Delivery

Sample and test the sand after delivery and demonstrate that the sand meets the requirements of ASTM C33/C33M as well as for other properties described under the paragraph "SAND CUSHION".

During delivery, stockpile the sand for each individual storage tank bottom into separate stockpiles.

Take one sample from each tank bottom stockpile, and test. The Contractor shall notify the Contracting Officer at least 48 hours in advance of the sand delivery for each tank in order to allow the Contracting Officer the opportunity to witness the sampling. The sand cushion(s) may be placed before the results of the past delivery testing have been submitted.

For each sample, along with the requirements of ASTM C33/C33M, verify the amount of chlorides (ppm) and sulfates (ppm) and determine the pH value of

the sand and the resistivity.

Deliveries and stockpiles of sand found not to conform to the requirements specified in the paragraph titled "Sand Cushion" shall not be used to construct the sand cushion, but shall be promptly removed from the site. This shall be the case even if the stockpiled sand has been placed and the tank is partially or completely constructed.

3.2.7 Retesting

Deficiencies found shall be rectified and work effected by such deficiencies shall be completely retested.

3.2.8 Photographic Construction Documentation of the Undertank Interstitial Space

Provide photographic documentation of the construction of the undertank interstitial space and the installation of the FML liner. Mark-up a plan view of the liner ringwall penetrations identifying each penetration by a unique number starting clockwise of the fill nozzle and proceeding clockwise. Identify the FML penetration in each photograph by the same number shown for that penetration on the marked-up drawing specified above. Submit the marked-up plan review of the penetrations and all photographs to the Contracting Officer in digital form at high resolution (1MB per picture, minimum) on the media type chosen by the Contracting Officer. As Basis of Bid, provide them on compact disc(s) in JPEG format. Take the photographs prior to placement of the sand cushion. Include photographs of the installation of all ringwall penetrations by undertank piping, [including foundation drains,] and cathodic protection. Particular attention shall be paid to the way the FML is sealed to the pipe and conduit penetrations. Number all ringwall penetrations clockwise from tank fill line nozzle and document all penetrations using the penetration number. Each penetration shall have at least three photographs: left side, right side, and close-up from the open end of the boot seal, caulk, and clamp arrangement.

Particular attention shall also be paid to the way the FML is sealed to the interior tank ringwall [and to the tank column base]; photograph the completed FML/batten bar installation at 1 meter 3 foot intervals.

-- End of Section --