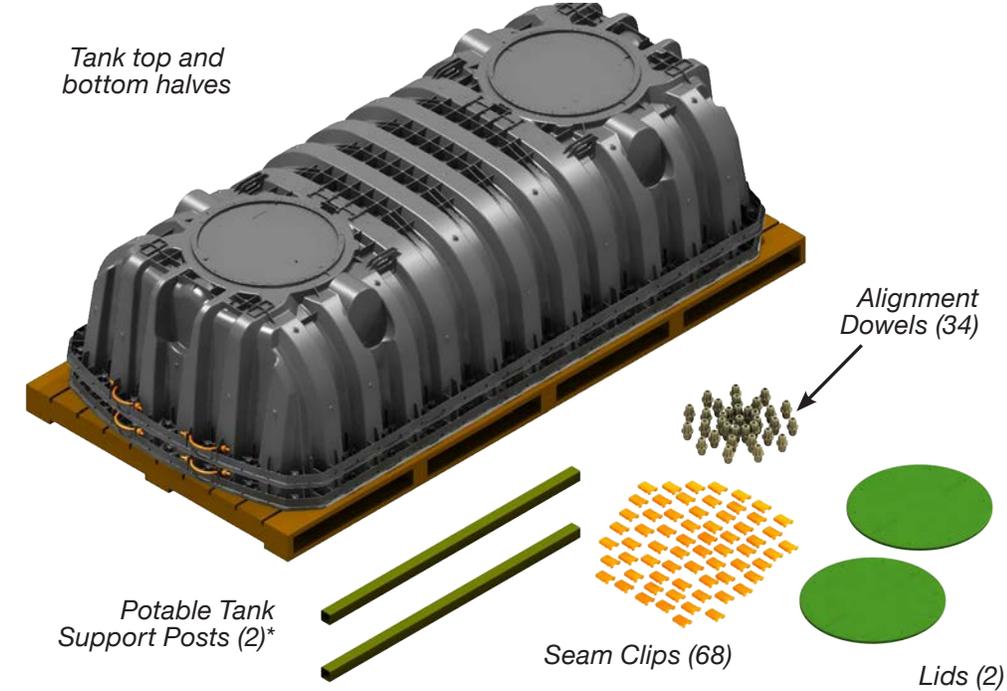




Infiltrator IM-1280C Potable Tank Assembly Instructions



NOTE: The support parts use in potable tanks are different than those use in Infiltrator septic tanks and ARE NOT interchangeable.

It is recommended that two people participate to safely assemble the tank. Assemblers must wear safety glasses during the entire assembly. Each tank half weighs approximately 160 pounds (73 kg) and must be lifted approximately 30 inches (750 mm) above ground during the assembly process. There must be enough side and overhead clearance to freely maneuver the tank components and to operate lifting machinery when used.

The IM-1280C tank must be assembled by an Infiltrator Water Technologies Authorized Assembler. Tanks assembled by unauthorized assemblers will not be warranted by Infiltrator Water Technologies. A signed copy of the IM-Series Potable Water Tank Assembly Checklist & Assembly Authorization is required for all Authorized Assemblers.

Before you Begin

The following is a complete list of tank components:

- Tank top half
- Tank bottom half (with pre-installed midseam gasket)
- Alignment dowels (34)
- Seam clips (68)
- Support posts (2)
- Lids (2)
- Lid shipping screws (6) and washers (6)
- Lid spacers (3)
- Lid screw kits (2)

The following tools facilitate tank assembly:

- Fork lift (3,000-lb. [1,361 kg] capacity, min. 66" [1.70 m] arm pick height)
- Infiltrator Lifting Strap Assembly
- NSF 61 certified lubricant
- Utility knife
- Coarse-bristled paint brush
- Metal hammer (16-20 oz. [0.5 kg])
- Rubber mallet
- Hole saw (appropriately sized, per engineer design)
- Nut driver (3/8", 5/16" sockets)
- Clean rags
- Headlamp or flashlight
- Screw gun
- Safety glasses

WARNING

IMPLOSIONS MAY CAUSE SERIOUS INJURY
 Follow Infiltrator Water Technologies vacuum test instructions NEVER EXCEED 2.5 inches mercury vacuum pressure

WARNING: These assembly instructions do not include a protocol for vacuum testing the IM-1280C tank. Vacuum tests on the IM-1280C tank shall only be performed in strict accordance with Infiltrator's IM-1280C tank vacuum testing guidance documents. Failure to follow an Infiltrator vacuum-testing protocol and/or exceeding 2.5 inches (63 mm) of mercury vacuum pressure could result in personal harm. Never apply a positive air pressure to the IM-1280C tank. Infiltrator will not be liable for any problems that arise from such unauthorized use.

Components



Alignment Dowels (34)



Seam Clips (68)



Lid Screw Kit

IM-1280C Tank Pallet Handling

The IM-1280C pallet holding 10 tank halves is 127" (3.2 m) long, 67" (1.70 m) wide and 86" (2.18 m) high and weighs 5,500 lbs (1,134 kg). A forklift that has the following minimum specifications 3,000 lb (1,361 kg) capacity, 24" (0.61 m) load center, minimum 67" (1.70 m) arm and minimum 10' (3.05 m) pick height is needed to safely handle and off load the IM-1280C pallet. The tank halves can be safely removed from the pallet using the Infiltrator lifting strap assembly. (The IM-1280C tank pallets should never be tipped over!) The lifting strap is sized to pick up a maximum of 4 tank halves at a time using a forklift. The safety lock spring hooks are to be connected to the rope handles on the end walls of each tank. Set the tank halves on a clean surface, pallet, across several 2"x4"s, or a tarp to prevent damage or introducing dirt and debris to the mid-seam area where the gasket is located. Never set the tank half with the gasket on any surface with the gasket facing downward.

Tank Assembly

1. Remove all plastic wrap and strapping from the IM-1280C tank and components shipping pallet.
2. Using the Infiltrator Lifting Strap Assembly, carefully depalletize the tanks. This will provide access to the potable-specific pultrusions located under the bottom tank on the pallet. Using the Infiltrator Lifting Strap Assembly, carefully depalletize the tanks. This will provide access to the potable-specific pultrusions located under the bottom tank on the pallet.

WARNING: The Infiltrator Lifting Strap Assembly is sized to pick up a maximum of four (4) IM-1280C tank halves at one time. Never lift more than four (4) IM-1280C tank halves at one time with the Infiltrator Lifting Strap Assembly. Infiltrator Water Technologies will not be liable for any problems that arise from unauthorized use of the Infiltrator Lifting Strap Assembly.

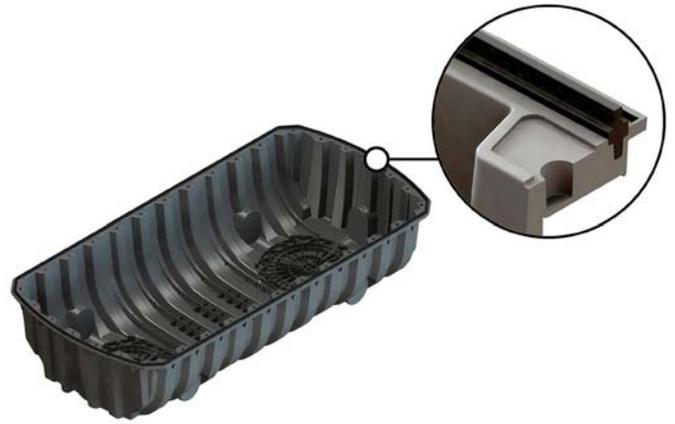
Tank Flipping Procedure

1. Position yourself and your assembly partner at opposite ends of the nested tank halves. Using the four lifting handles, two on either end of the tank half, lift the inverted bottom tank half off of the tank top half nested below it. Tilt the tank half so that the tank flange is close to a 60-degree angle relative to the ground. Rest the lower tank half edge on the ground surface clear of the nested tank half. Together, gently roll the tank bottom half onto its flat base so that the flange groove and mid-seam gasket are facing upward.



WARNING: Never set the tank half with the gasket on any surface with the gasket facing downward.

2. Visually inspect the midseam gasket to ensure that it is undamaged, seated properly in the groove, and free of debris that may compromise the watertightness of the connection. The gasket inspection shall include an examination while viewing the tank from both the top and side perspectives. When viewing from the top, visually examine the gasket for damage, an undulating appearance (where the gasket is not fully inserted into the groove and its height varies), dirt and debris, and any other signs of defect or damage. When viewing from the side, position yourself so that your eyes are at gasket height, and you can see and evaluate the height of the top of the gasket around the entire midseam perimeter. Looking horizontally across the tank at seam level (from top of gasket to top of gasket across the tank axes), inspect the gasket along the long and short axes of the tank. Verify that the gasket does not undulate, where the top elevation of the gasket varies. Correct deficiencies if identified. If the gasket is not properly seated in the groove, it can be manually pressed into place. Use a coarse-bristled paint brush and clean rags to thoroughly remove any dirt or debris present on the gasket.



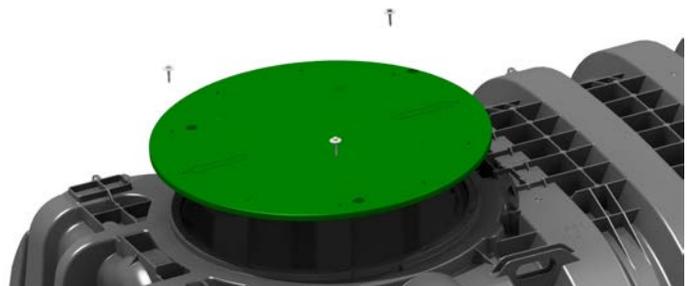
3. Insert the 34 alignment dowels into the receiving holes in the tank bottom half. The alignment dowel flange must seat firmly against the tank body for



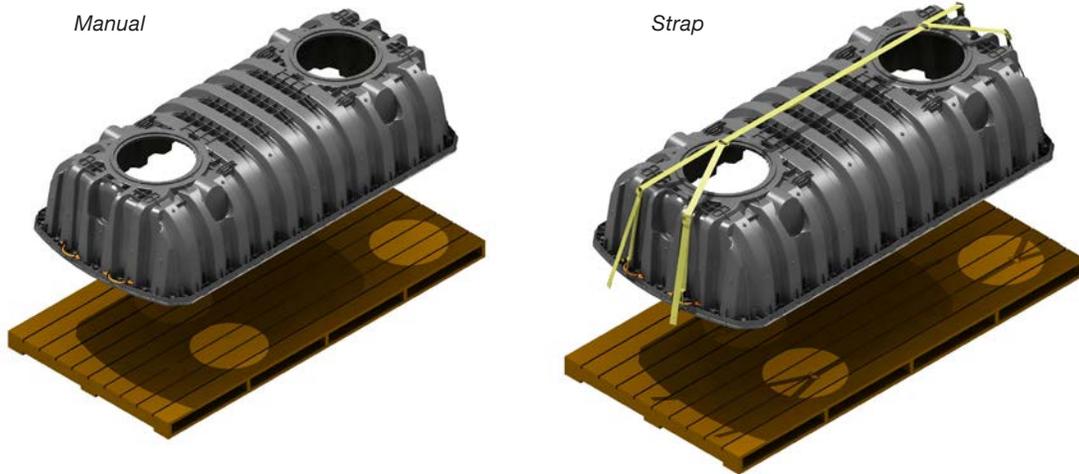
4. Before joining the tank halves, apply an even coat of NSF-61 certified lubricant to all surfaces of the exposed gasket along its entire length, so both sides of the gasket are lubricated equally. This will facilitate engagement of the gasket in the groove on the tank top half during tank assembly in step 7.



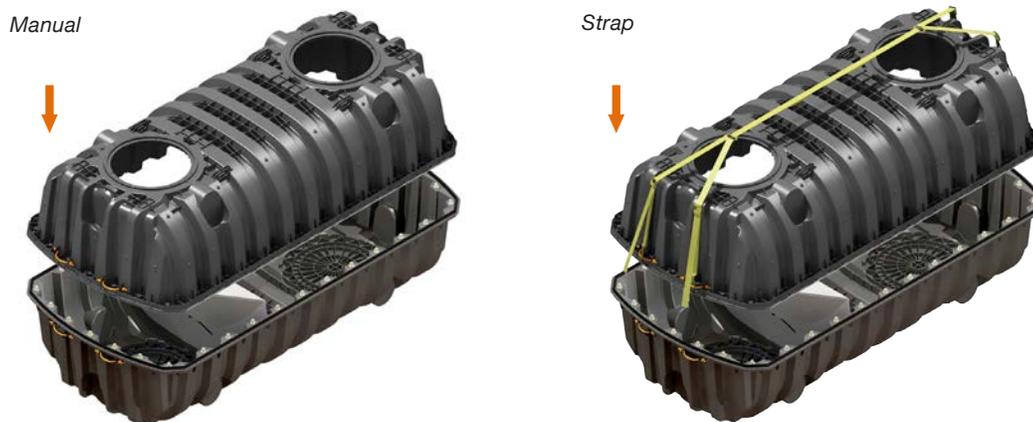
5. Using a nut driver with 3/8" socket, unscrew and remove the two lids from the tank top half (three #14 hex-head shipping screws with washers per lid) and spacers. Set the lids aside and reserve the six shipping screws, washers and spacers for later use in step 13. If the inlet and outlet holes are pre-drilled then spacers are not needed and will not be present.



6. Using the four lifting straps, located two on either end of the tank top half, slowly lift the tank top straight up and off of the shipping pallet or other nested tank half, as applicable. This can be done manually or with lifting machinery such as a forklift and the Infiltrator Lifting Strap Assembly. If the tank halves are to be set down, use a clean surface, pallet, several 2"x4"s, plywood, or a tarp to prevent damage or the introduction of dirt and debris to the midseam area where the gasket and groove are located.



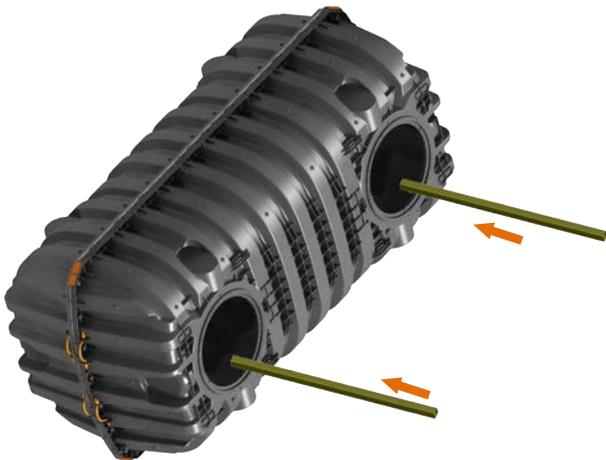
7. Carefully lower the tank top half onto the tank bottom half, aligning the receiving holes on the tank top half with the alignment dowels installed previously in the tank bottom half during step 3. Position yourself so that your eyes are at gasket height, and you can see and evaluate the seam. Inspect the seam around the entire perimeter of the tank. Visually inspect the seam and verify that the gasket is securely seated within the gasket groove of the tank top and bottom halves. If using lifting straps, verify that the strap is not caught within the seam.



8. Identify the distinct clip-attachment locations along the midseam at each chamfered corner of the joined tank halves. There are two clip attachment locations per corner. At each corner, push the top tank half downward to engage the gasket in the top tank half. At each of the eight corner clip locations, place the open side of a seam clip against the joined seam rail of the tank halves at a 45-degree angle relative to the seam rail. The corner seam clips must be attached along the seam rail from the outside in towards the center of the corner chamfer. Using a hammer and holding the top and bottom sides of the seam clip, tap the seam clip along the tank seam rail; the clip will pull towards the seam rail. Engage the clip to a full stop over the locking tabs; the seam clip will click into place when properly engaged. The seam clip is designed to lock in place with two or three swift blows of a hammer. If substantial resistance is encountered engaging the seam clips, remove the top of the tank and inspect the gasket for damage, an undulating appearance (where the gasket is not fully inserted into the groove and its height varies), dirt and debris, and any other signs of defect or damage, as described in step 2. Once engaged, the seam clip cannot be removed without damaging the seam clip or the tank locking tabs. Attach an additional clip at the same corner from the opposite direction. Attach the remaining six corner clips in the same manner to finish this step. This will maintain seam connectivity during assembly steps 9 to 12 that require tilting the tank.



9. Slowly roll the joined tank onto its side along its long axis. The tank will rest tilted as shown. Do not over rotate the tank or drag the tank along the midseam from this position as doing so may damage the tank.



10. Insert the support post through the tank access port on the inlet side of the tank. Place one end of the post in the bottom corrugation with the post seat, beyond the post seat. Do not yet engage the post end in the bottom post seat. Swing the opposite post end into the same corrugation with the top post seat. Do not yet engage the post end in the top post seat. Once each post end is inside the same corrugation with the post seats, the post bottom can be inserted into the bottom seat, and then the top can be inserted into the top seat. A rubber mallet may be used to facilitate proper post seating. Repeat this process with a post through the tank access port on the outlet side of the tank. Use a headlamp or flashlight as needed.

NOTE: Support posts utilized in Potable tanks must be inprinted with the NSF logo indicating that the support is NSF/ANSI 61 certified.

CAUTION! Do not use a metal hammer to strike the support post as this may cause permanent damage.

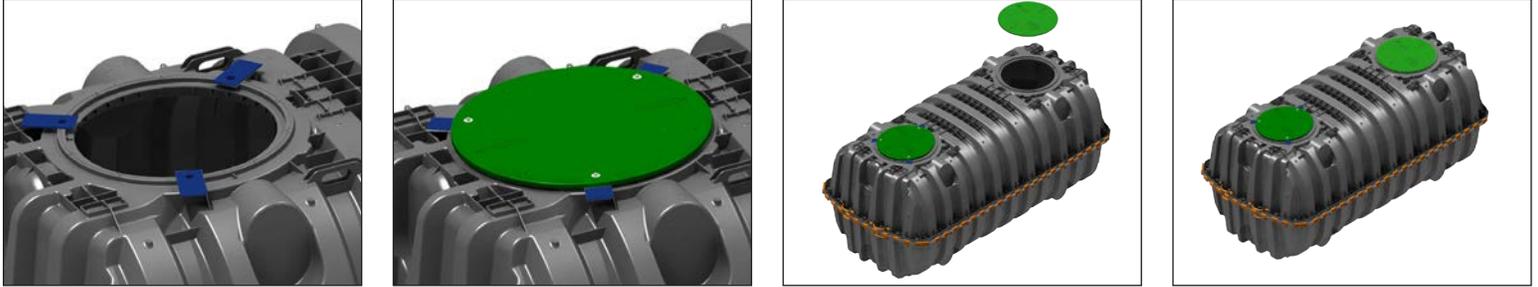
11. Carefully roll the tank back to its upright position. Do not over rotate the tank or drag the tank along the midseam from this position as doing so may damage the tank.



12. Visually inspect the seam to ensure that the gasket remains securely seated within the tank top and bottom half seam grooves. Starting on each of the tank ends, place the open side of a seam clip against the joined seam of the tank halves and fasten as described in step 8. Fasten the remaining seam clips sequentially around the tank; either clockwise or counterclockwise. Fully engage all seam clips as described in step 8.



19. On the inlet side of the tank, place the three lid spacers in a triangular fashion over three of the ten tank lid screw holes located on the tank access opening rim. The spacers allow air exchange during tank storage and delivery, and are required for one lid only (and only in tanks without pre-drilled inlet and outlet holes). Align one of the tank lids over the spacers and access opening. Using a nut driver with 3/8" socket, fasten the lid with three of the six shipping screws and washers reserved in step 5 (#14 hex-drive screws). Place the appropriate plumbing kit and two lid screw kits in the bottom of the tank. Fasten the second lid (no spacers) with the three remaining shipping screws and washers reserved in step 5. The tank is now ready for storage or delivery for installation.



NOTE: Refer to Infiltrator IM-Series Potable Tank General Installation Instructions, Riser Connection Guidance, and Buoyancy Control Guidance documents, and state/local product approvals and applicable regulations prior to tank installation and use.



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