



**Venting:** This is one of the most commonly overlooked steps and by far not least important. "I have a low feed rate" and "just storage tanks" are excuses used to answer why tanks are not vented properly. It is extremely important that polyethylene tanks are not over pressurized or placed under vacuum. Adequate vent size will always be based on flow rates and delivery rates, however you can NEVER have too much venting. Assmann recommends having a minimal vent of one and a half times the largest inlet or outlet of your storage tank. Over pressurization and vacuum are the two leading causes of failure in a polyethylene storage tank.



**Piping:** Easily overlooked is process piping. A polyethylene tank will always vary in size and shape. Polyethylene, unlike steel, will need to move when filling and emptying. Simple temperature changes outdoors will cause your tank to change in size. The use of flexible expansion joints is required on all sidewall connections. Rigid piping will not allow the tank to expand and contract, thus causing undo stress on the tank leading to leaks and eventual failure. Equally important is supporting your process piping; unnecessary weight hanging from your storage tank will cause stress on the tank and lead to future problems. Always support your piping in a manner that will prevent stress on your tank. Expansion joints will protect your tank from weight of process piping, pump vibration and expansion issues.

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