

TANK CUTTING PROCEDURE

The following procedures will be used to minimise the risks associated with cutting up disused tanks for storage and eventual disposal in the Palmerston North yard. Providing these steps are followed an individual can perform this task.

PREPARE TANK FOR CUTTING

1. Ensure you are wearing the correct PPE for the job - Overalls, steel toe-capped boots and welding gloves.
2. Uplift tank from stockpile with T lift (special modified crane for manoeuvring tanks)
3. Ensure chains are positioned so tank will not fall off lift.
4. Position tank on cutting pad between container and fence. Ensure there is at least 2m clearance on either side of tank so that when it's been cut it can fall on the ground.
5. Chock the tank in the middle to stop it from rolling
6. Unhitch T Lift, remove chains, and park T Lift
7. Re- chock the tank to stop the tank from rolling using 100 mm x 100 mm blocks protruding approximately 300 mm from the end of the tank
8. Place the chocks using your feet (see photo below) lean against the tank to roll it against the 1st chock .
9. Position gas plant near the work. Check that hoses can reach the job and you have enough spare hose to allow the length of cut.
10. Scrape the excess soil/spoil off the tank with a spade along the path where you are going to use the gas axe - this will allow the cutting torch to cut more efficiently, minimise blowbacks and reduce the need clean the cutting tip.

Clear an escape path away from the tank - make sure you won't trip on hoses or rubbish



Position chocks protruding 200 – 300mm from the end of the tank using your feet – hold tank to stop it rolling

CUTTING THE END OFF THE TANK

1. Ensure you are wearing the correct PPE for the job - Overalls, Steel toe-capped boots, welding gloves and welding goggles or welding shield(see photo 2)
2. Start by cutting out the end of the tank.
3. Cut from the top down at mid point on the edge.
4. If you are too short to cut across the top use a ladder. Make sure you cut as much as you can in either direction using the ladder. Once the ladder is no longer required store it out of the way and NOT in your escape path.
5. **STOP** when the end has only 100 mm more to be cut. *(continued on next page)*

6. Reposition your body to one side so when you finish the final 100 mm strip the end will not fall out and hit you. **Then carefully complete the cut.**
7. Clear a path to the job and bring the T-Lift
8. Attach the claws from the T-Lift firmly on an exposed edge of the end and pull the end off the tank using the T-Lift.
9. Drop the end on the stockpile, unhitch T Lift and park T Lift.



Ensure you leave at LEAST this much tank to be cut before repositioning yourself for the final cut

Photo 2 – PPE to be worn when cutting tanks

CUTTING THE TANK IN HALF DOWN ITS LENGTH

1. Ensure you are wearing the correct PPE for the job - Overalls, Steel toe-capped boots, welding gloves and welding goggles or welding shield(see photo 2).
 2. Position gas plant near the work. Ensure you have enough spare hose to available to cut the full length of the tank - reposition the gas plant if necessary.
 3. Ensure your cutting path down the length of the tank is clear of any obstructions and the tank is still supported by the chocks on either side.
 4. Start the cut at one end - Keep the tip 5 - 10 mm from the job and try to cut straight.
- STOP** the cut a hand width (100 - 200 mm) from the end (*continued on next page*)



Stop cut 100 – 200 mm from the end of the tank and reposition the body so you are as far off the job as possible

CUTTING THE TANK IN HALF - FINAL CUT

This is the most hazardous part of this operation - follow these steps carefully.

5. To make the final cut of 100 - 200 mm reposition your body away from the job see photo on previous page
6. Ensure you have established your escape path
7. Ensure gas lines will not get crushed when the tank splits open - which will form a steel half pipe and take up 50% more ground space.
8. Cut with the torch at arms length - standing away from the job
9. Watch the cut and the remaining steel joint - when it breaks the tank walls which are under pressure will split open very quickly.

CUTTING THE TANK IN QUARTERS AND STORING MATERIALS

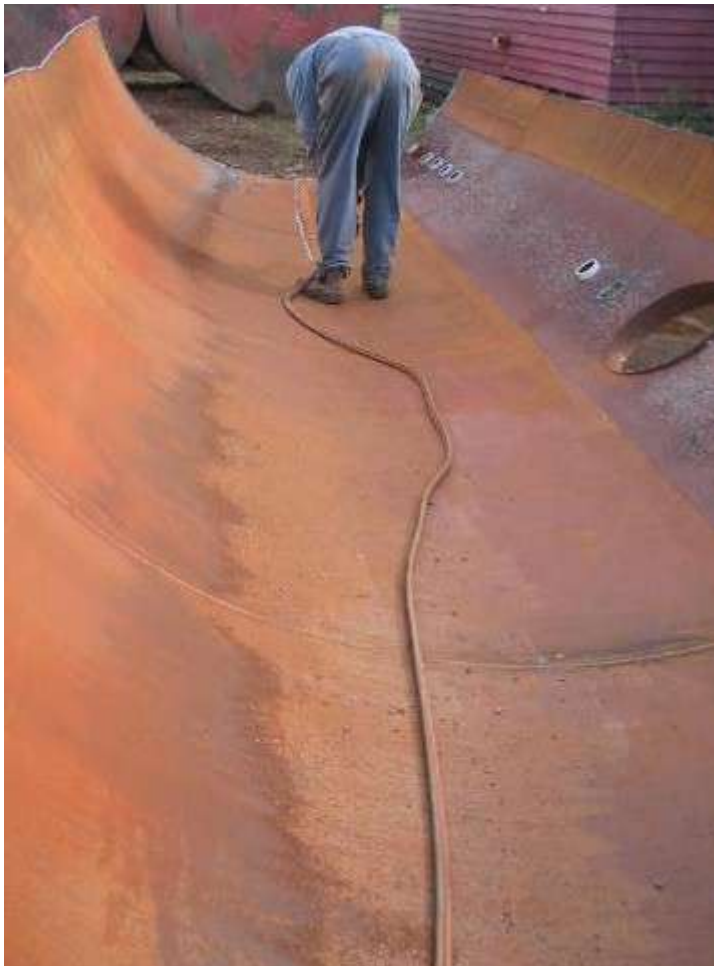
Follow the above steps to complete cutting the tank in quarters down its length

- Cut the remaining plumbing and pipe work off the tank and place in a heap
- Cut the quarters into manageable sizes
- Use the T-Lift to stack the manageable pieces in the scrap metal heap

When finished for the day tidy equipment away and store in the garage.

You will note that the gas cutting hoses are laid out down the job with plenty of clear room to escape if something were to go wrong.

The cut is made at one end furthest from the gas plant so that the stress on the gas torch and hoses is minimised.



STAFF ACKNOWLEDGMENT

I hereby acknowledge that I have contributed in the development, read, understand and will abide by these additional health and safety rules and operating procedures when cutting tanks.

Name	Signature	Date