

Hazardous Waste Facility Permit
Safety-Kleen Barre Service Center
EPA ID NO. VTD000791699
Waste Storage Tanks
March 2022

APPENDIX L
TANKS

APPENDIX L
WASTE STORAGE TANKS

The following information is provided pursuant to 40 CFR § 270.16 and the Vermont Hazardous Waste Management Regulations (VHWMR).

L – 1.0 DESCRIPTION OF TANKS

The following tanks are used to store spent hydrocarbon-based parts washing solvent, used oil, and vacuum service waste at the Barre Service Center (BSC), as described in **Appendix B** (Facility Description):

Tank ID	Tank Contents	Capacity (Gallons)
#1	Used oil	15,000
#2	Used oil	15,000
#3 (HWMU #1)	Spent hydrocarbon-based solvent	15,000
#5	Vacuum waste	18,000

The Tank #3 (HWMU #1) system, including the wet dumpster, piping, and pump, was installed in 1985 and is therefore regulated as an “existing tank system” under 40 CFR § 270.16. The design of and specifications for Tanks #1, #2, and #3 (Tank Farm) are described by **Table L-1**, below, and the following attached figures:

- **Figure L-1** includes the Tank Farm Piping Plan with Secondary Containment Volume/Capacity Calculations
- **Figure L-2** includes the Tank Farm/Return and Fill Environmental Piping Schematic
- **Figure L-3** includes the Tank Farm & Shelter Details
- **Figure L-4** includes the Truck Pad Concrete Plan
- **Figure L-5** includes the Emergency & Gate Valve Installation Details

Specifications for Tanks #1, #2, and Tank #3 (HWMU #1) are provided in **Table L-1**.

TABLE L - 1

	Tank #3 (HWMU #1)	Tanks #1 and #2 (Used Oil)
Design standard	UL-142	UL-142
Construction material	Carbon steel	Carbon steel
Lining material	None	None
Corrosion allowance	0.064 inches	0.064 inches
Capacity (nominal)	15,000 gallons	15,000 gallons
Fabricated shell thickness	0.25 inch	0.25 inch
Fabricated top thickness	0.187 inch	0.187 inch
Fabricated bottom thickness	0.312 inch	0.312 inch
Type of tank bottom	Flat	Dish
Diameter (nominal)	10 ft, 6 in.	10 ft, 6 in.
Height	23 ft	23 ft
Operating pressure	Atmospheric	Atmospheric
Maximum liquid level	95% of capacity	95% of capacity
Operating temperature	Ambient	Ambient
Containment capacity	24,911 gallons	24,911 gallons
Year of construction	1985	Tank #1: 1992 Tank #2: 1985
Level indicator present	Yes	Yes
Labeling	“Hazardous Waste”, NFPA Diamond, Maximum Fill level	“Used Oil”, NFPA Diamond, Maximum Fill level
Freeze Protection	Heat Tracing and Insulation	NA

All three tanks are painted to minimize corrosion and located within the same covered concrete secondary containment system.

L – 2.0 TANK SYSTEMS

L – 2.1 Description of Feed Systems, Safety Cutoff, Bypass Systems and Pressure Controls

Tanks #1 and #2 (used oil) are filled and emptied by direct connection with a tank truck located on the transfer pad. The pump on the truck is used to transfer the oil.

The wet dumpster, located in the warehouse, is used to transfer spent hydrocarbon-based parts washer solvent emptied from containers received from customers to Tank #3 (HWMU #1), as described in **Appendix B** (Facility Description), via aboveground carbon steel piping that passes through the outside wall of the warehouse and enters the secondary containment structure for the Tank Farm. All piping connections and fittings located outside of secondary containment are welded, and all piping outside the heated warehouse is insulated.

Tank #3 (spent hydrocarbon-based solvent), which operates at atmospheric pressure and is vented to the atmosphere, is equipped with an emergency vent (pressure relief only) that operates at 16 ounces of pressure; the tank is also equipped with a 24-inch manway on top of the tank. A copy of the specification sheet for the emergency vent is included as Attachment L-1. The vapor pressure of hydrocarbon-based solvent at 68°F is 2 mm Hg.

Tanks #1, #2 and #3 are equipped with a siren and strobe light high-level alarm system that alerts employees when the tank is approximately 95 percent full. Electronic sensors mounted inside the tank activate the audible and visual indicators. The wiring for the alarm system is mounted in a separate rigid conduit. The alarm and the strobe light are located on the outside of the warehouse next to the tank farm.

L – 2.2 Ignitable, Reactive, and Incompatible Wastes

Reactive and incompatible wastes are not stored in tanks at the facility, and Tank #3 (HWMU #1) is the only tank used to store ignitable hazardous waste. To ensure that ignitable wastes are properly managed, the following precautions are taken:

1. Tank #3 is located more than 50 feet from the property line, in accordance with NFPA Code 30, and is separated from sources of extreme heat, fire, and potential explosion. As described above,

Tank #3 is vented to minimize the potential for pressure buildup and the material stored in Tank #3 is not subject to violent reactions.

2. To prevent the production of uncontrolled toxic mists, fumes, dusts, or gases in quantities sufficient to threaten human health, Tank #3 is operated at atmospheric pressure and equipped with a pressure/vacuum vent that operates at two ounces of pressure and one ounce of vacuum. The vaporization of stored spent hydrocarbon-based solvent is minimal given its low vapor pressure (i.e., 2 mm Hg) under normal working conditions.
3. To minimize the risk of fire or explosion, smoking, open flames, and ignition sources are prohibited in the vicinity of the tank farm. "No Smoking" signs are posted in all areas where hydrocarbon-based solvents are handled or stored, and fire extinguishers, which are tested annually by a fire extinguisher company, are maintained in the tank area, warehouse, and at the return and fill station (See **Figure G-1**).

L – 2.3 Assessment of Tank System Integrity

External portions of Tanks #1, #2, and #3 are inspected daily for signs of cracks, leaks, or corrosion in accordance with the Inspection Schedule (See **Table E - 1**). In addition, Tanks #1 and #2 are assessed under the supervision of an independent Vermont-registered professional engineer on a 20-year interval, or shorter if recommended by the engineer, and Tank #3 is assessed under the supervision of an independent Vermont-registered professional engineer on a 5-year interval, or shorter if recommended by the engineer.

The engineer assessments are conducted to determine the tank shell and bottom thickness and evaluate the tank interior surface for scaling, pitting, and corrosion. In addition, the condition of all welded joints and fittings is assessed. The assessments are performed using recognized and accepted engineering standards and practices (See **Table L-2**), and if an assessment finds that the condition of a tank is deficient, Safety-Kleen will initiate procedures to replace or repair the tank.

Within 90-days of each assessment, an assessment report certified in accordance with 40 CFR § 270.11(d), shall be submitted to the Agency.

Tank assessments are conducted according to the following schedule:

Table L-2

Tank	Inspection Method	Last Inspection Date	Date of Next Scheduled Inspection
Tank #1	STI SP001 (Current Edition) – Standard for Inspection of In-Service Shop Fabricated Above Ground Tanks for Storage of Combustible and Flammable Liquids	September 2015	Before August 2035
Tank #2		August 2014	Before August 2034
Tank #3		August 2019	August 2024

L - 2.4 Requirements for Secondary Containment and Leak Detection

L - 2.4.1 Plans and Descriptions of the Design, Construction, and Operation of the Secondary Containment System

The secondary containment structure for Tanks #1, #2, and #3 consists of a steel-reinforced monolithically poured concrete slab and dike walls which are epoxy-coated. The slab is approximately six-inches thick, and the walls are approximately eight-inches thick concrete. The containment system is designed to resist pressure gradients from above and below and resist failure due to settlement, compression, or uplift. See **Figure L-3** (Tank Farm & Shelter Details).

L - 2.4.2 Requirements for Secondary Containment and Leak Detection

Tanks #1, #2, and #3 (HWMU #1) are located within a concrete secondary containment system designed to contain 100% of the contents of Tank #3 (HWMU #1) with a total capacity of 20,549 gallons (**Figure L-1** provides the secondary containment calculations). Each operating day, the tanks are inspected for leaks, and the secondary containment system is inspected for gaps and cracks, and accumulated precipitation and releases in accordance with **Appendix E**. In the event a gap or crack is identified, Safety-Kleen will initiate procedures to repair the compromised portion of the secondary containment system. In addition, the tanks and the secondary containment system are enclosed and protected from precipitation (run-on) by a framed, soft-sided tent structure. **Figure L-3** provides further design details of the tent structure.

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ATTACHMENT I

Model 244 Emergency Vents | 8-inch

SPECIFICATION SHEET

Application

UL Listed emergency vent (pressure relief only) used on aboveground storage tanks, as a code requirement, to help prevent the tank from becoming over-pressurized and possibly rupturing if ever exposed to fire. The vent must be used in conjunction with a “normal vent.” Correct application of this vent requires proper vent size and selection for the tank system in order to meet the specific venting capacity.

Code Compliance

When properly sized for the tank, this vent will conform to the requirements of the International Fire Code; National Fire Code of Canada; National Fire Protection Agency—NFPA 20, 30, 30A, 31, 37, 110; Petroleum Equipment Institute—PEI RP200, PEI RP800; Underwriters Laboratories Inc.—UL-142, UL-2085, UL-2244; Underwriters Laboratories of Canada—CAN/ULC S601, CAN/ULC S602, CAN/ULC S652

Approvals

California Air Resource Board (CARB) Phase 1 Enhanced Vapor Recovery (EVR) AST Certified Products (VR-402-B) 
Underwriters Laboratories Inc. UL-2583



WARNING: DO NOT FILL OR UNLOAD FUEL FROM A STORAGE TANK UNLESS IT IS CERTAIN THAT THE TANK VENTS WILL OPERATE PROPERLY. Morrison tank vents are designed only for use on shop fabricated atmospheric tanks which have been built and tested in accordance with UL 142, NFPA 30 & 30A, and API 650 and in accordance with all applicable local, state, and federal laws. In normal operation, dust and debris can accumulate in vent openings and block air passages. Certain atmospheric conditions such as a sudden drop in temperature, below freezing temperatures, and freezing rain can cause moisture to enter the vent and freeze which can restrict internal movement of vent mechanisms and block air passages. All storage tank vent air passages must be completely free of restriction and all vent mechanisms must have free movement in order to insure proper operation. Any restriction of airflow can cause excessive pressure or vacuum to build up in the storage tank, which can result in structural damage to the tank, fuel spillage, property damage, fire, injury, and death. Monthly inspection, and immediate inspection during freezing conditions, by someone familiar with the proper operation of storage tank vents, is required to insure venting devices are functioning properly before filling or unloading a tank.

Item numbers on next page...



Item Number	A	B	C	D	E	F	G	Overall Diameter	Height	Weight
244O--0600 AV	8"	503,517		8	I	A	AL	11"	4.6"	43.0
244O--0600 AVEVR	8"	503,517		8	I	B	AL	11"	4.6"	43.0
244O--0700 AV	8"	503,517		16	I	A	AL	11"	5.8"	62.0
244O--0700 AVEVR	8"	503,517		16	I	B	AL	11"	5.8"	62.0
244OF-0100 AV †	8"	503,517	F	8	I	A	AL	13.5"	3.3"	43.0
244OF-0100 AVEVR	8"	503,517	F	8	I	B	AL	13.5"	3.3"	43.0
244OF-0200 AV †	8"	503,517	F	16	I	A	AL	13.5"	4.5"	67.0
244OF-0200 AVEVR	8"	503,517	F	16	I	B	AL	13.5"	4.5"	67.0
244OM-0600 AV	8"	503,517	M	8	I	A	AL	11"	5.8"	44.0
244OM-0600 AVEVR	8"	503,517	M	8	I	B	AL	11"	5.8"	44.0
244OM-0700 AV	8"	503,517	M	16	I	A	AL	11"	6.9"	63.0
244OM-0700 AVEVR	8"	503,517	M	16	I	B	AL	11"	6.9"	63.0
244OMB0700 AV	8"	503,517	M	16	I	A	AL	11"	6.9"	63.0
244OMBSP0600 AV	8"	503,517	M	8	I	B	AL	11"	5.8"	44.0

Flange = 13.5" OD ; eight (8) .88" Diameter holes on 11.75" diameter B.C.

SPECIFICATION OPTIONS:

A—Size (inches)
B—Venting capacity / SCFH at 2.5 P.S.I.
C—Mounting connection: Female N.P.T. (BLANK); Male N.P.T.(M); Flanged (F)
D—Pressure settings: 8, 16 oz/in². Pressure required to open vent.
E—Cover: Cast iron powder coated (I)
F—Seat material: O-Ring Viton A (A) or Viton B (B)
G—Body material: Aluminum (AL) or Iron (I)
Diameter—Dimension across vent (inches)
Height—Dimension from base to top when closed (inches)
Weight—Shipping weight (lbs)
Bolt—Zinc plated steel

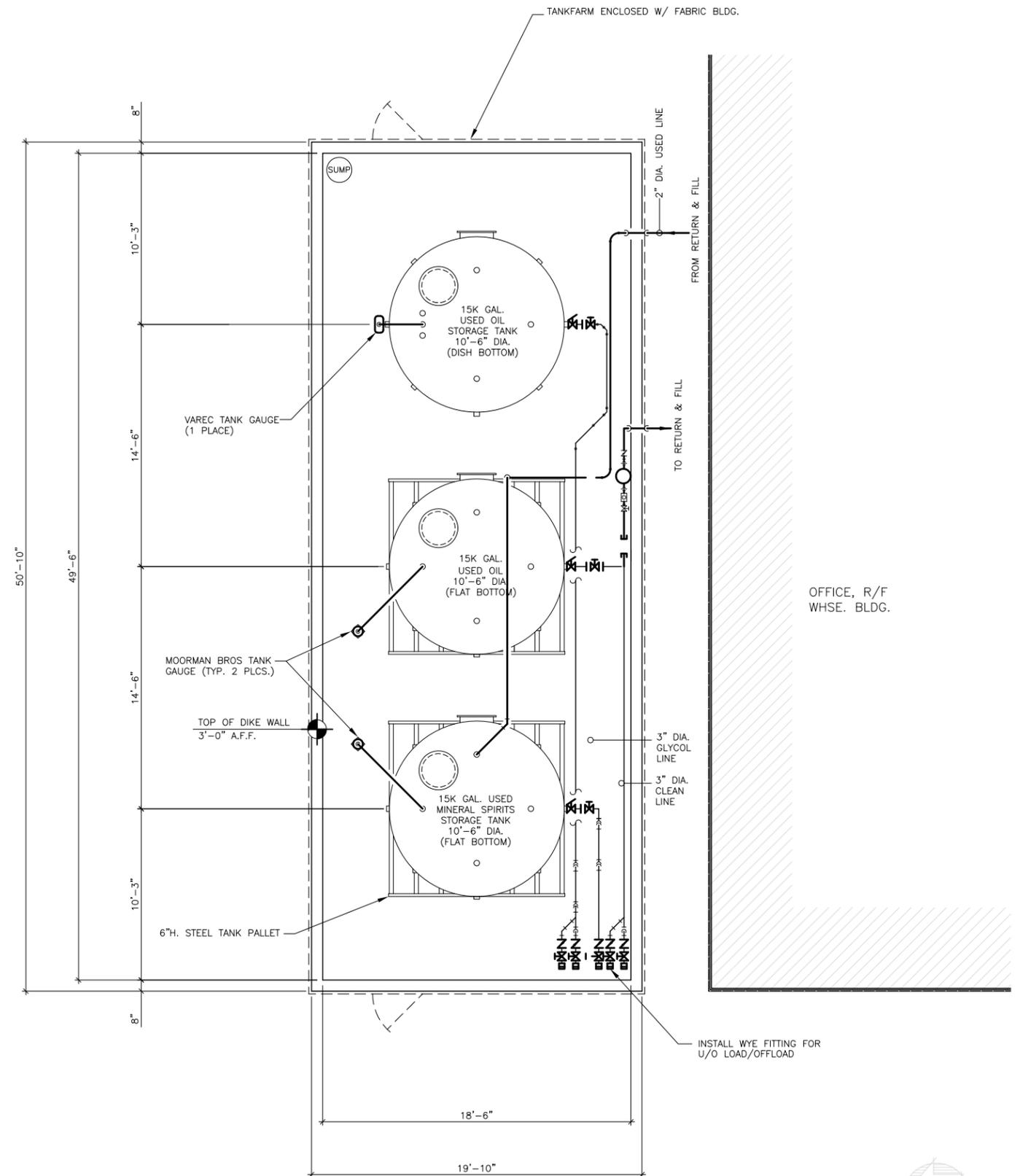
† Indicates model is available in a kit.

Size	Item Number	Flanged Kits	Weight (lbs)
8"	244OF-08080 AK	Includes 244OF-0100 AV vent, flange adaptor, gasket, and nuts/bolts	N/A
	244OF-08160 AK	Includes 244OF-0200 AV vent, flange adaptor, gasket, and nuts/bolts	N/A

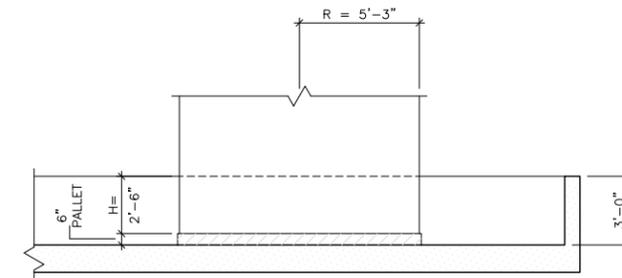


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FIGURES



DIKE VOLUME CALCULATION:



VOLUME OF DIKE:

$[(49'-6" L)(18'-6" W)(3'-0" H)] (7.48 \text{ GAL/CUFT.}) = 20549 \text{ GAL (+)}$

TANK DISPLACEMENT VOLUME (2 TANKS):

$2 [T(5'-3" R)(2'-6" H)] (7.48 \text{ GAL/CUFT.}) = 3238 \text{ GAL (-)}$

25HR/24HR RAINFALL N.A.

LARGEST TANK VOLUME

= 15000 GAL (-)

TOTAL EXCESS

= 2311 GAL (+)

FIGURE L-1

PROPRIETARY STATEMENT

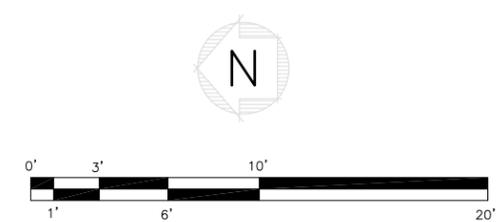
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TITLE
EXISTING TANK FARM PIPING PLAN

SAFETY-KLEEN SYSTEMS, INC.
5400 LEGACY DR. CLUSTER III BLDG. 3 PLANO, TX. 75024
PHONE 800-669-5740

NO.	DESCRIPTION	BY	CHK	APPR	DATE
D	EXISTING PIPING PLAN	JEK	DS	DS	091621
C	CONVERT 105 TANK TO U/O- ADD WYE FITTING	JEK	DDP	DDP	081610
B	REVISE FOR PART B PERMITTING	JEK	MH	MH	090204
A	NEW RELEASE; MADE FROM DWG 210501-2001-00	MBH	KJM	-	100292
REVISIONS					

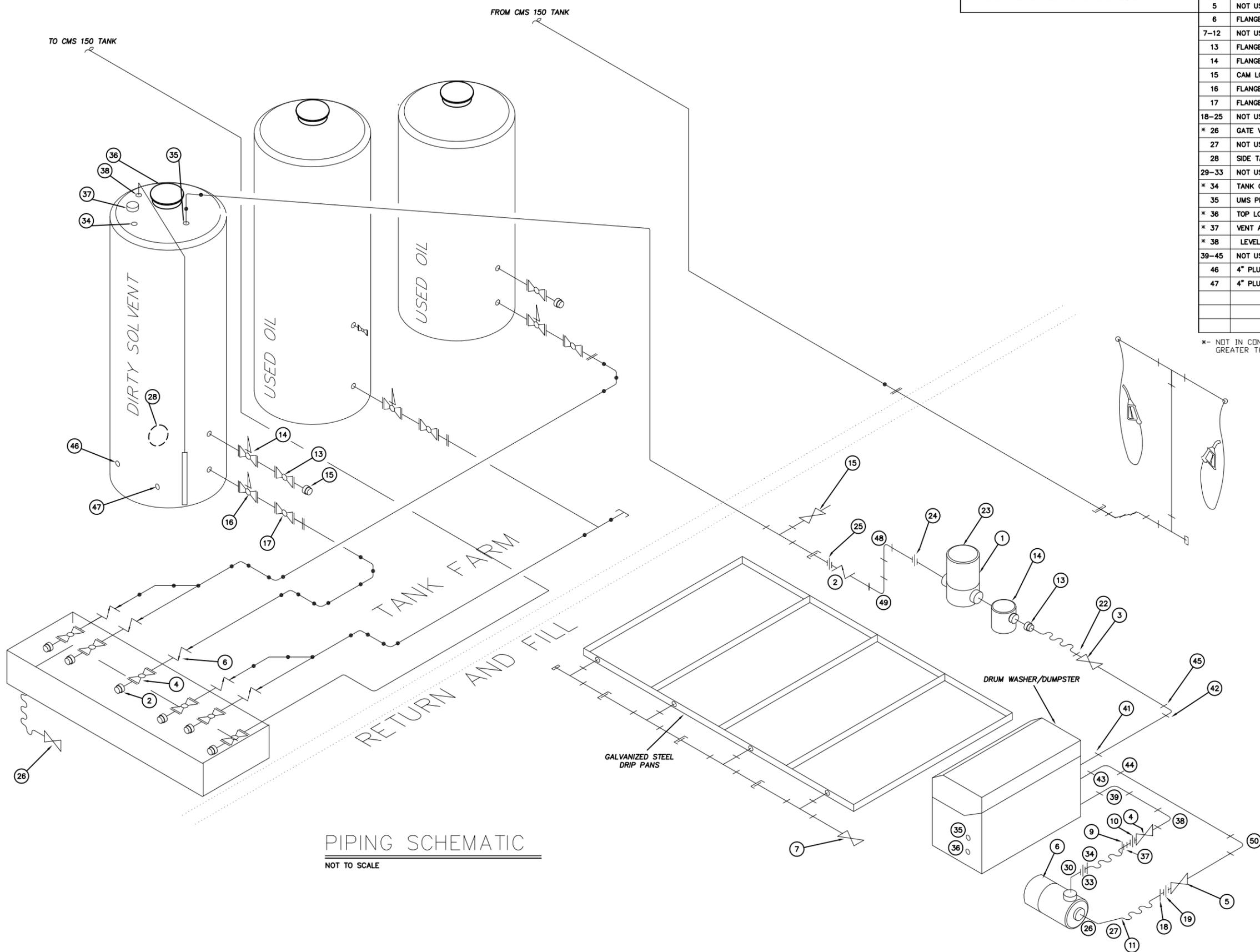
SCALE	BY	CHKD	APPROVED	OPERATIONS	DATE
1/4" = 1'-0"	MBH	KJM	-	-	10-02-92
SERVICE CENTER LOCATION				SC-DWG NUMBER	REV. NO.
BARRE, VT				7015-4100-301	D



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TANK FARM EQUIPMENT		RETURN AND FILL EQUIPMENT	
ID TAG	DESCRIPTION	ID TAG	DESCRIPTION
2	FLANGED CAM LOCK	1	USED SOLVENT PUMP
3	NOT USED	2	CHECK VALVE
4	FLANGED BALL VALVE	3	GATE VALVE
5	NOT USED	4	GATE VALVE
6	FLANGED CHECK VALVE	5	GATE VALVE
7-12	NOT USED	6	RECIRCULATING PUMP (BARREL WASHER)
13	FLANGED BALL VALVE	* 7	GATE VALVE
14	FLANGED EMERGENCY BALL VALVE	8	NOT USED
15	CAM LOCK	9	HOSE CLAMP
16	FLANGED EMERGENCY BALL VALVE	10	UNION
17	FLANGED BALL VALVE	11	HOSE CLAMP
18-25	NOT USED	12	NOT USED
* 26	GATE VALVE	13	CAM LOCK
27	NOT USED	14	BASKET STRAINER
28	SIDE TANK MANWAY	15	GATE VALVE
29-33	NOT USED	16	NOT USED
* 34	TANK CONNECTION	17	NOT USED
35	UMS PIPE CONNECTION	18	BAND CLAMP
* 36	TOP LONG BOLTED MANWAY	19	UNION
* 37	VENT ASSEMBLY TANK CONNECTION	20-21	NOT USED
* 38	LEVEL GAUGE ASSEMBLY TANK CONNECTION	22	HOSE CLAMP
39-45	NOT USED	23	STRAINER CAP
46	4" PLUG	24	UNION
47	4" PLUG	25	UNION
		26	ELBOW FITTING
		27	THREADED FITTING
		28-29	NOT USED
		30	ELBOW FITTING
		33	UNION
		34	HOSE CLAMP
		35	THREADED FITTING
		36	THREADED FITTING
		37	THREADED COUPLER
		38	ELBOW FITTING
		39	ELBOW FITTING
		40	NOT USED
		41	THREADED NIPPLE
		42	ELBOW FITTING
		43	ELBOW FITTING
		44	ELBOW FITTING
		45	ELBOW FITTING
		46-47	NOT USED
		48	ELBOW FITTING
		49	ELBOW FITTING
		50	ELBOW FITTING

*- NOT IN CONTACT WITH HAZARDOUS WASTE GREATER THAN 300 HR/YR.



PIPING SCHEMATIC
 NOT TO SCALE

REVISIONS					
NO.	DESCRIPTION	BY	CHK	APPR	DATE
A	ORIGINAL RELEASE	RBS	NDE		061593
B	ADDED MANWAYS & TAGS 28,29,30 REVISED EQPT NOTES 7-12	MCL	KJM		083195
C	ADDED TAGS 31 & 32 TO USED OIL TANK, & REVISIONS EQPT. NOTES	MCL	KJM		111795
D	REVISE EQP. SCHEDULES	JEK	MH		040609
E	CONVERT TANK 2 TO USED OIL	JEK	MH		102710
F	REVISE TAGGING TO CURRENT CONDITIONS	JEK	MH		030811
G	REVISE TAGGING TO CURRENT CONDITIONS	JEK	DS		103114
H	REVISED TAG LEGEND	JEK	TB		031716
I	REVISED TAG LEGEND	JEK	TB		062216
J	REVISED TAG LEGEND	JEK	TB		072716
K	REVISED TAGGING/ LEGEND	JEK	DS		112918

TITLE: **ENVIRONMENTAL PIPING SCHEMATIC**

SAFETY-KLEEN SYSTEMS, INC.
 2600 N. CENT EXPRESSWAY STE 400 RICHMOND, TX 75080
 PHONE 800-688-6740

SCALE	BY	CHKD	APPROVED	OPERATIONS	DATE
AS NOTED	RBS	NDE			061593
SERVICE CENTER LOCATION			SC-DWG NUMBER		SHEET NO.
BARRE, VERMONT			7015-4100-300		

FIGURE L-2

GENERAL NOTES:

1. STRUCTURE DESIGN LOADS ARE:
 - A. GROUND SNOW LOAD 50 PSF.
 - B. WIND LOADING IS 90 MPH.
2. ALL WIRING INSIDE SHELTER SHALL BE CLASS 1, DIVISION 1, NEC.
3. PORTABLE FIRE EXTINGUISHERS MEETING NFPA #10-1988
3. TANKS TO BE VENTED OUTSIDE SHELTER.
4. TWO EXIT DOORS TO BE INSTALLED AS INDICATED FOR EGRESS
5. MECHANICAL VENTILATION TO BE PROVIDED TO PREVENT VAPOR BUILDUP
6. SHELTER FABRIC TO BE FLAME RETARDANT, SELF-EXTINGUISHING
7. FABRIC COLOR TO BE LIGHT GRAY.
8. ALL STRUCTURAL MEMBERS TO BE HOT DIP GALVANIZED.
9. SHELTER TO BE BY RUBB BUILDING SYSTEMS, WITH MODEL BVC TRUSSES.
10. TRUSS BASEPLATES TO BE CONNECTED TO 8" X 8" PRESSURE TREATED WHALER BOLTED TO TOP OF EXISTING CONCRETE DIKE WITH 1/2" EPOXY ANCHORED BOLTS, 18" OC.
11. FABRIC TENSIONING SYSTEM TO BE ANCHORED TO WHALER.

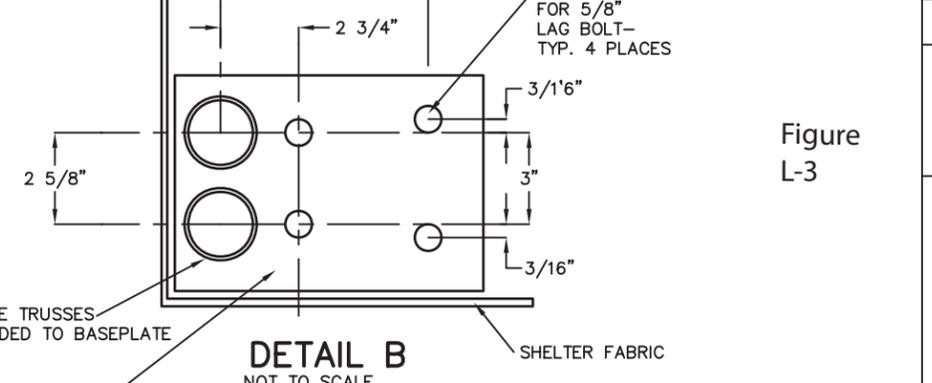
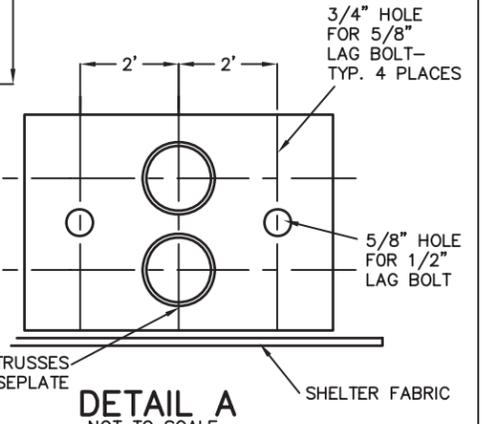
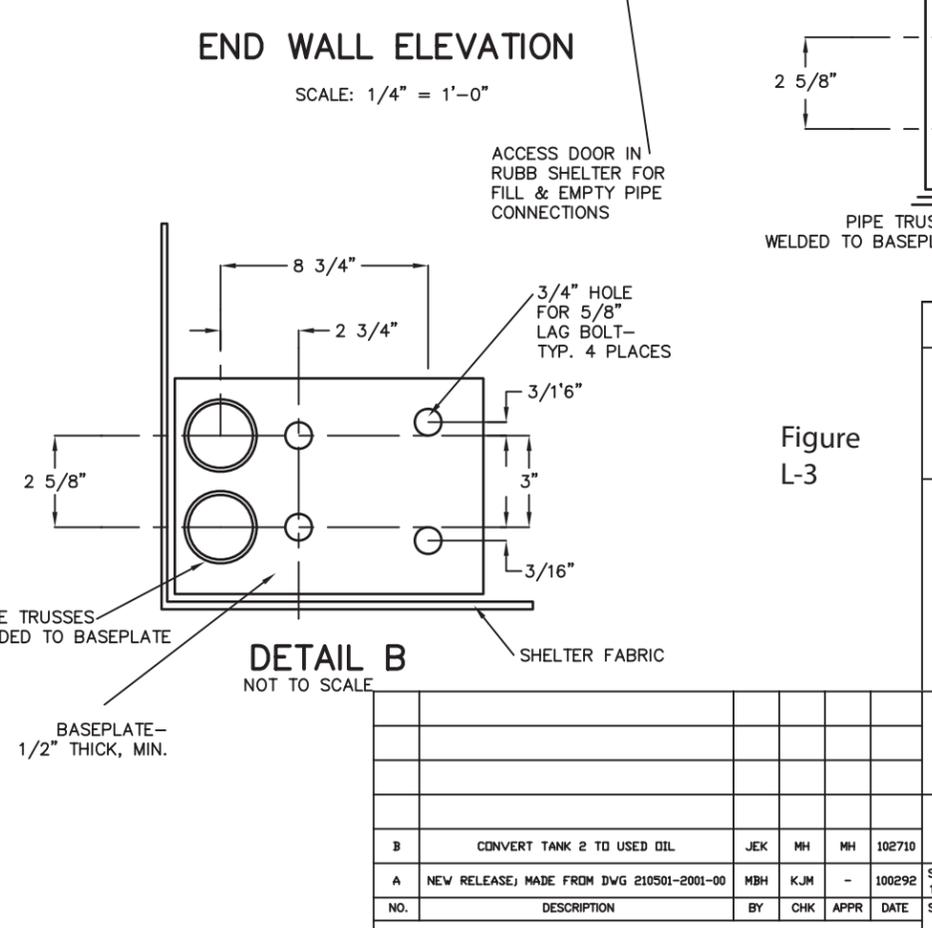
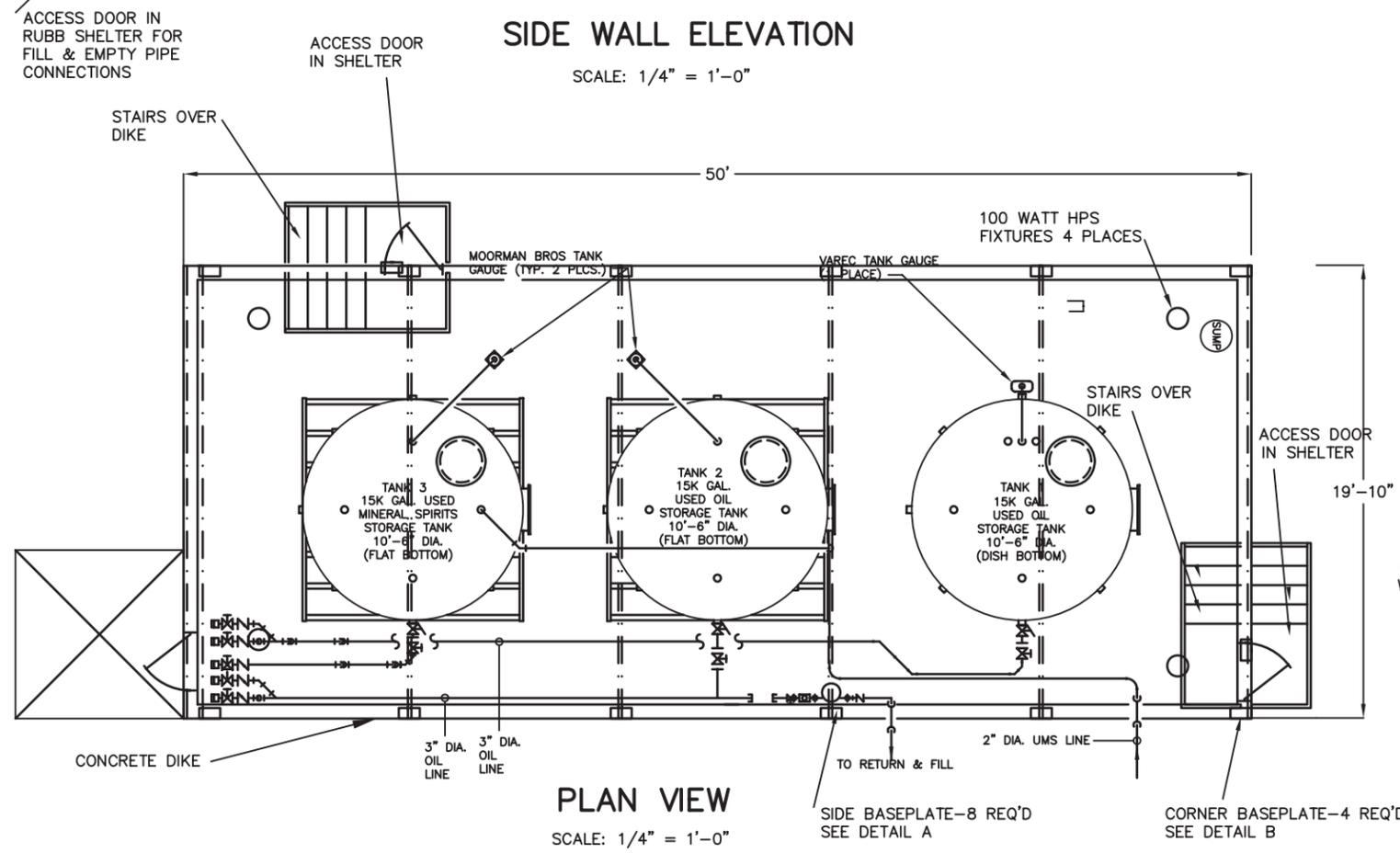
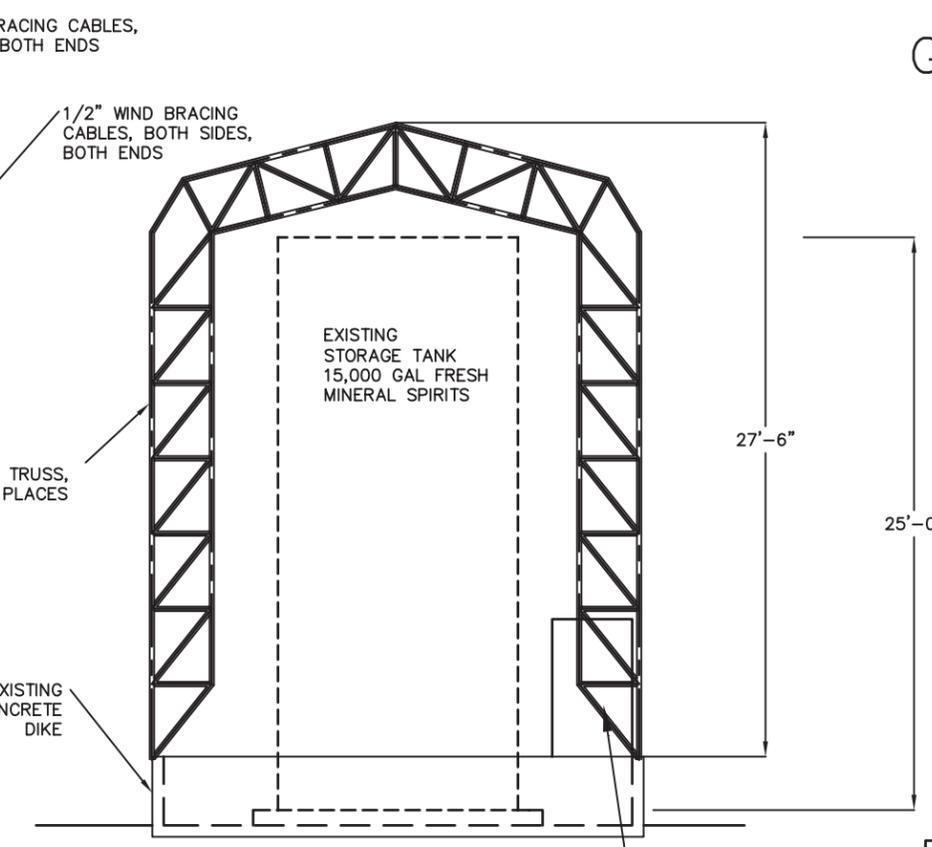
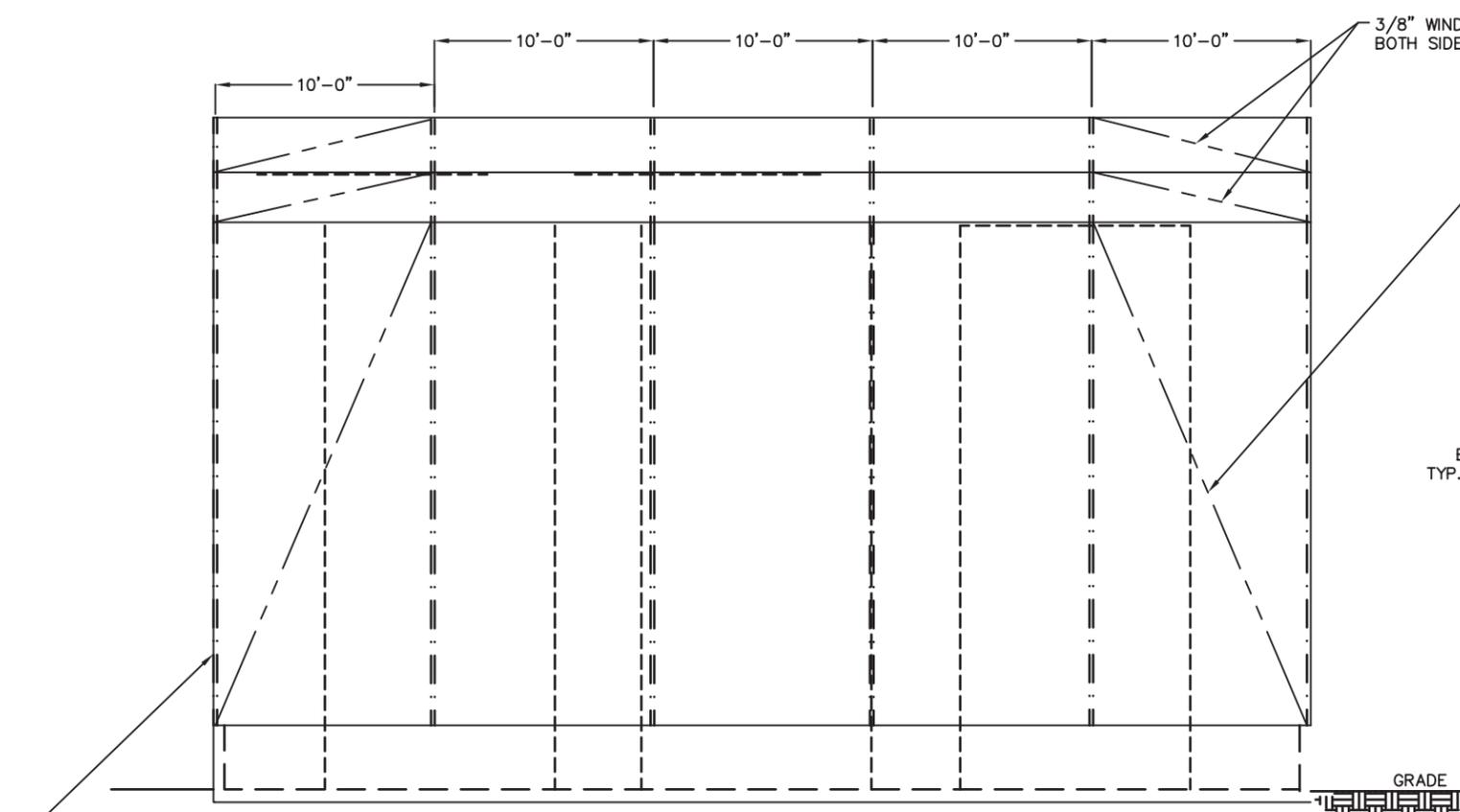


Figure L-3

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Project Solutions
 Companies
 1390 Boone Industrial Drive, Suite 200 • Columbia • MO 65202
 Phone: (573) 443-7100 • Fax: (573) 443-7181

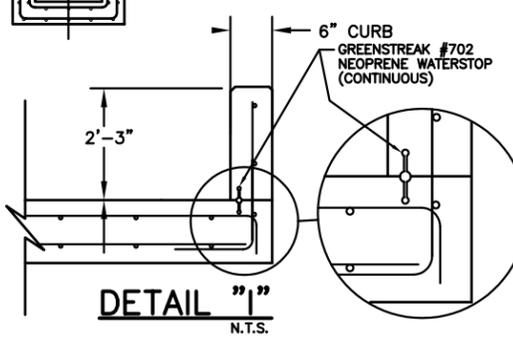
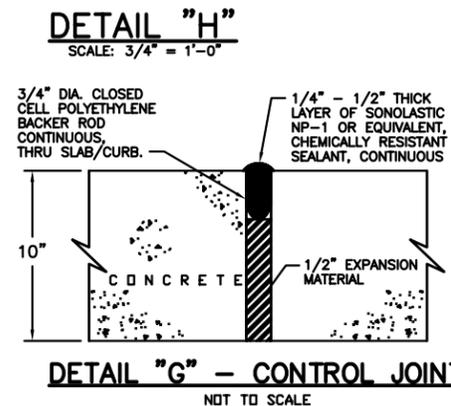
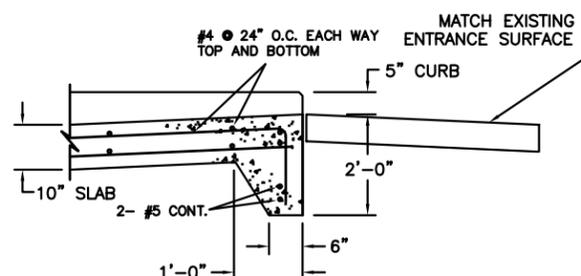
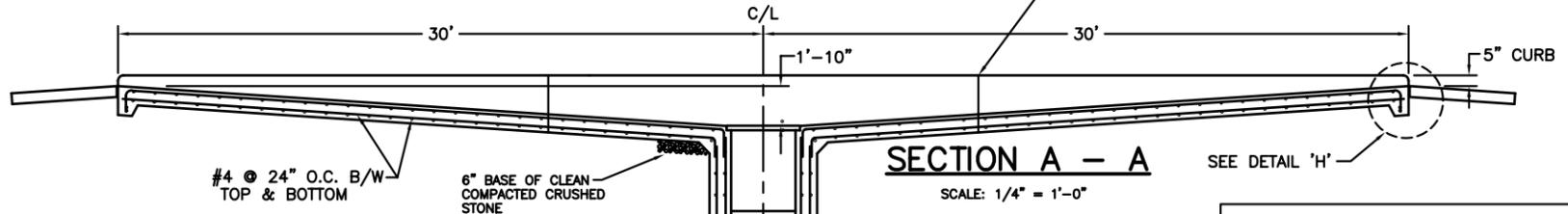
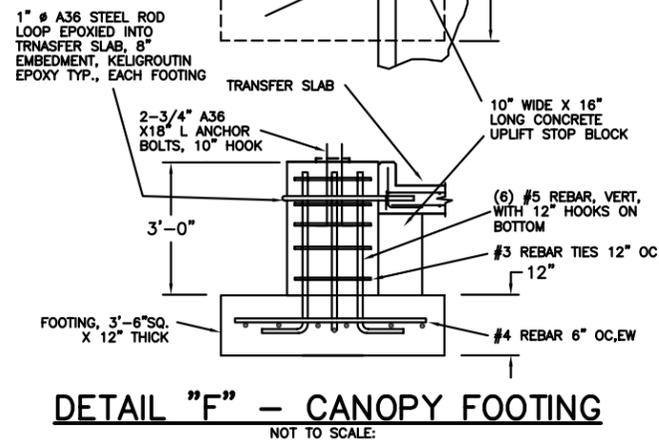
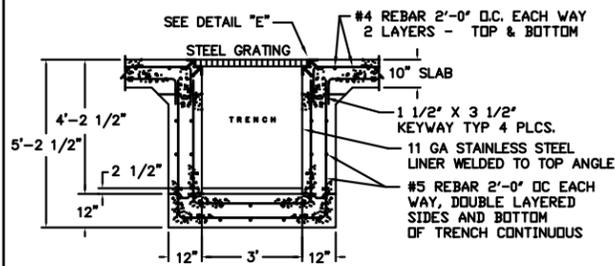
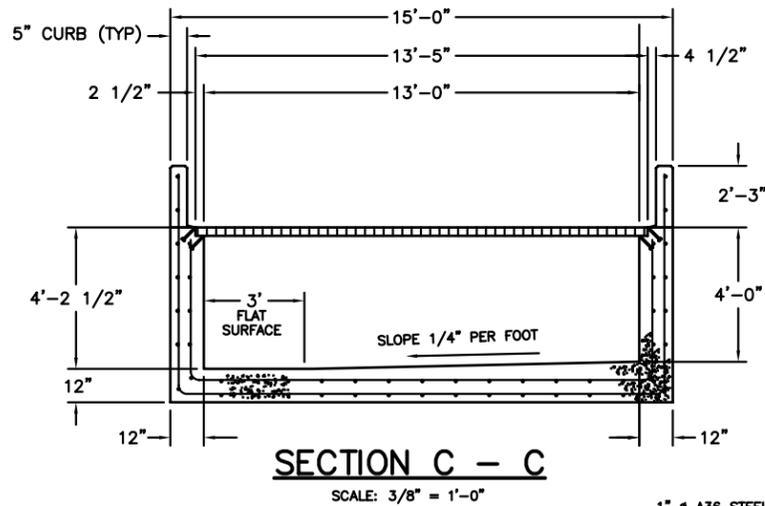
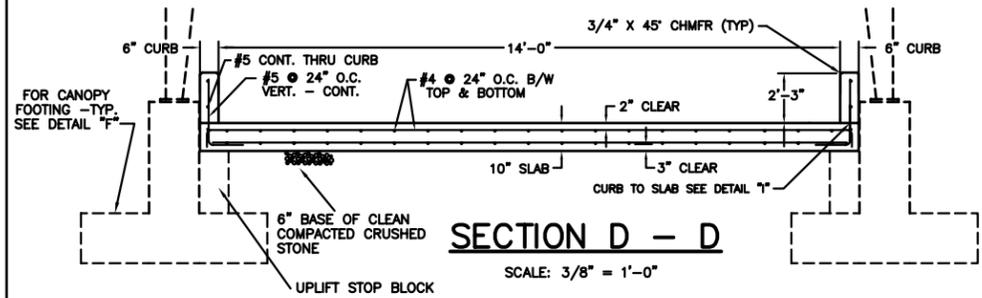
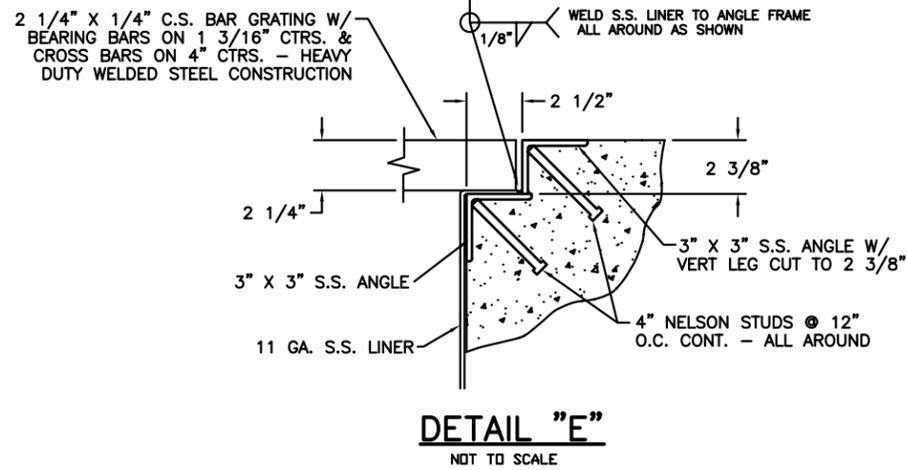
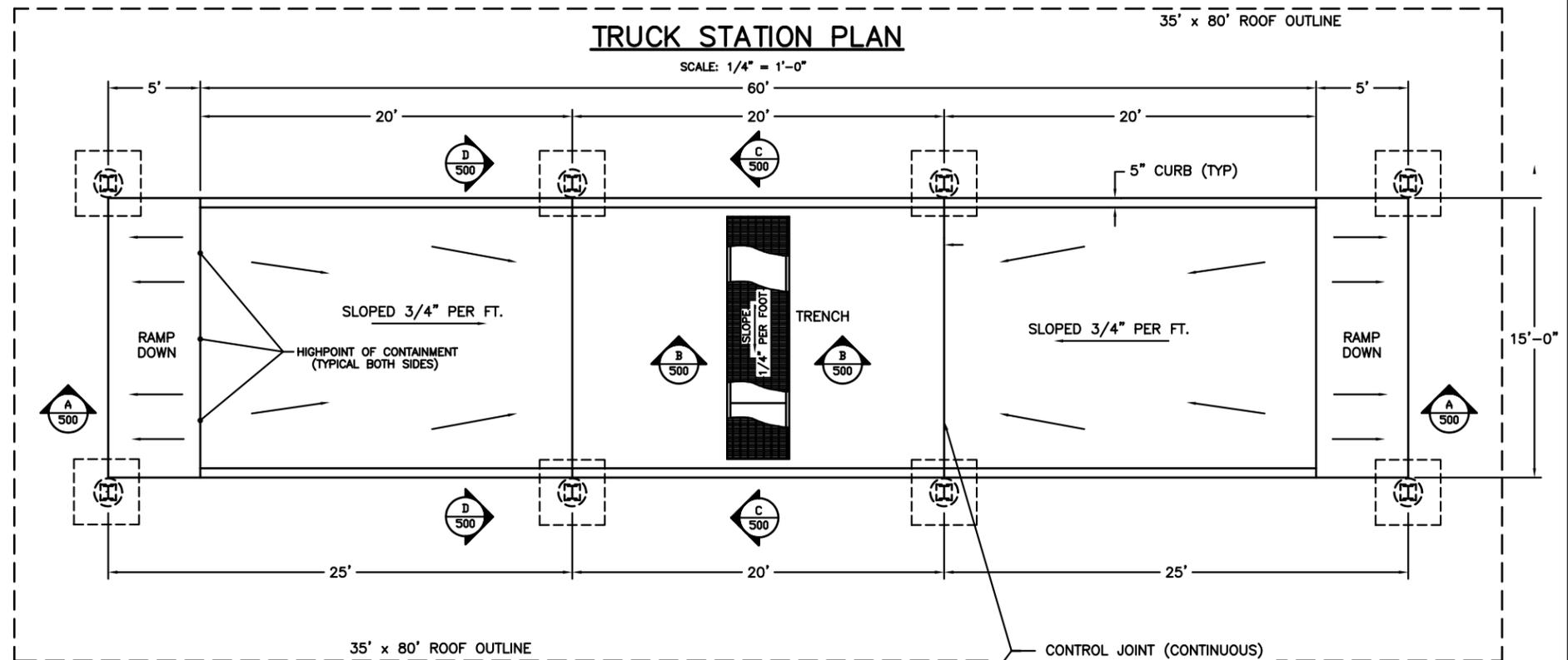
TITLE		TANKFARM PLAN SHELTER & DETAILS	
SCALE		1/4" = 1'-0"	
BY		MBH	
CHKD		KJM	
APPROVED		-	
OPERATIONS		-	
DATE		10-02-92	
SERVICE CENTER LOCATION		SC-DWG NUMBER	
BARRE, VT		7015-6100-600	
REV. NO.		B	

NO.	DESCRIPTION	BY	CHK	APPR	DATE
B	CONVERT TANK 2 TO USED OIL	JEK	MH	MH	102710
A	NEW RELEASE, MADE FROM DWG 210501-2001-00	MBH	KJM	-	100292
REVISIONS					

TRUCK STATION PLAN

35' x 80' ROOF OUTLINE

SCALE: 1/4" = 1'-0"



CONTAINMENT VOLUME CALCULATION

TRENCH SUMP VOLUME -	
L X W X H X 7.48 GAL/CU. FT	
13' X 3' X 4.1' X 7.48	= 1197 GALLONS
TANKER PAD VOLUME -	
(1/2)L X W X H X 7.48 GAL/CU. FT	
(1/2)60' X 14' X 1.83' X 7.48	= 5750 GALLONS
TOTAL CONTAINMENT VOLUME -	
1197 GAL + 5750 GAL	= 6947 GALLONS

- NOTE:**
1. CONTAINMENT VOLUME CALCULATION DOES NOT INCLUDE ANY ALLOWANCE FOR RAINWATER VOLUME.
 2. REFER TO DRAWING NO. AA06605B FOR CANOPY DESIGN & DETAILS.

PROPRIETARY STATEMENT

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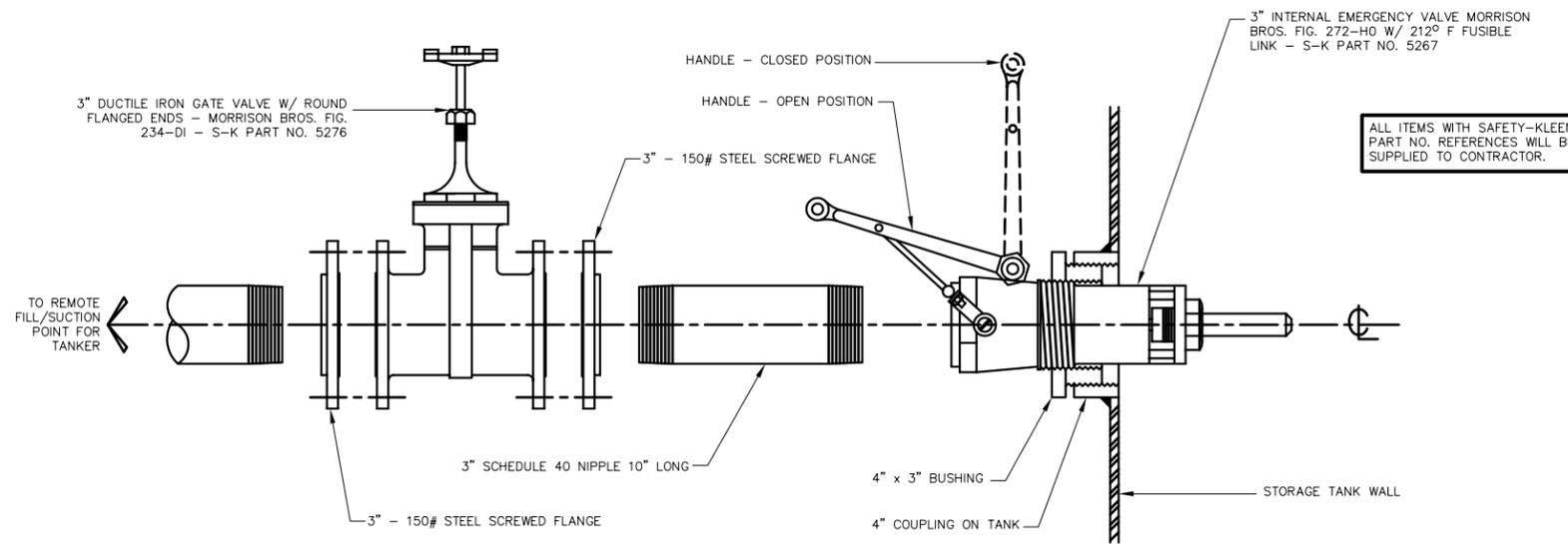
NO.	DESCRIPTION	BY	CHK	APPR	DATE
D	UPDATE DETAILS AND CONTAINMENT CALCS FOR PART B APPLICATION	JEK	DP	DP	090704
C	CONTROL JOINT UPDATE	NDE			052893
B	UPDATE	NDE			012393
A	PRELIMINARY FOR REVIEW	M.O'C			11/2/92

Figure L-4

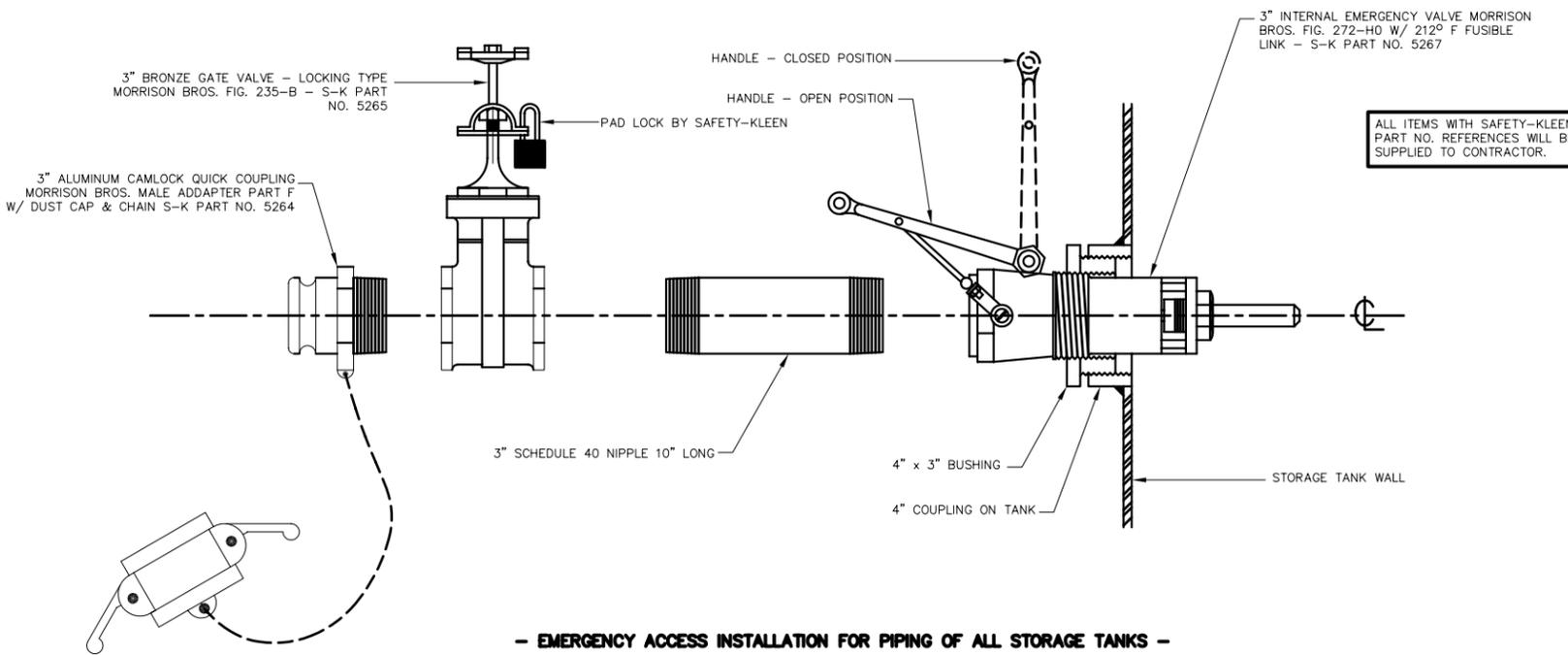
Project Solutions
Companies

1380 Boone Industrial Drive - Suite 200 - Columbia - MO 65202
Phone: (573) 443-7100 • Fax: (573) 443-7181 •

TITLE		SCALE		BY	CHKD	APPROVED	OPERATIONS	DATE
TRUCK STATION & CANOPY CONCRETE PLAN		AS SHOWN		PSC				9/7/04
SAFETY-KLEEN SYSTEMS, INC.		SERVICE CENTER LOCATION		SC-DWG-REV NO	REV. NO.			
5400 LEGACY DR. CLUSTER III BLDG. 3, PLANO, TX 75024 800-669-5740		BARRE, VT.		7015-6100-599	4			



- STANDARD INSTALLATION FOR PIPING OF ALL STORAGE TANKS -



- EMERGENCY ACCESS INSTALLATION FOR PIPING OF ALL STORAGE TANKS -

Figure L-5

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TITLE		EMERGENCY & GATE VALVE INSTALLATION DETAILS	
SCALE		NONE	
BY	CHKD	P.E. APPR	OP. APPR
MBH	-	-	-
DATE		02-03-92	
NO.	DESCRIPTION	BY	CHK APPR DATE
SERVICE CENTER LOCATION		SC-DWG NUMBER	
BARRE, VT		7015-4100-350	
REV. NO.		00	