

8.3 Another method is to cut the vault horizontally into 2 pieces. Cut the top 20 inches of the vault off horizontally, then pass both pieces through the mandoor and reassemble once inside the tank, welding both inside and outside of the vault. Weld them back together and install as per normal instructions.

8.4 **FULL FACE RETROFIT VAULTS** – Enviro Vault has developed a retrofit vault that includes the face, doors, nozzles, etc.

- Ensure the tank to be retro-fitted with the Enviro Vault has been properly cleaned and all applicable corporate and government safety guidelines relating to confined space entry and hot work have been followed to ensure the safety of the installation personnel. Have a fire extinguisher close by.
- On the foamed exterior of the tank, in the exact area the Enviro Vault will be located, draw an outline using the following measurements. From the point which will be the centre of the Enviro Vault, mark an opening that is 8” larger than the vault to be installed (8” smaller than the outside dimensions of the 8” wide faceplate). Using a banana knife, make a cut 4 inches either side of the lines, then remove this 8” strip of foam using a scraper. (This removes the flammable foam from the area to be cut out, and the finished product will be much neater looking).
- Repeat the drawing of the lines as described in step 2 on the exposed metal of the tank **using a 3 inch radius cut on each top corner.**
- Cut out this entire section of the tank wall. **Caution: Urethane foam is very flammable and emits poisonous and harmful vapors when burned.**
- Insert the full faced Enviro Vault through the opening in the side of the tank and center it in the opening. There should be a 4” gap from the side of the vault wall to the opening in the tank. This allows enough room to weld the tank shell to the back side of the vault face overlap flange.
- Inside the tank, weld tank shell to the back of the overlap flange using 1/4” fillet weld, first on the vertical seams, then on the horizontal seam.
- Then, on the exterior of the tank, weld the front overlap flange to the exterior of the tank shell using a 1/4” fillet weld, first on the vertical then on the horizontal seams.
- Along the floor of the tank, weld the outside of the back of the Enviro Vault to the tank floor with a 1/4” fillet weld.
- Weld the inside of the back (inside the vault) to the floor with a 1/4” groove weld at 45 degrees.

