SPRAYER TANK INSPECTION PROCEDURE

When you suspect that a sprayer tank is out of specifications for our quality standards, you must use the following procedure to determine if the tank is OK or if it is a reject. Experience will help you to identify tanks which may require an inspection. Be alert for possible tank defects when you handle and prepare the tanks for assembly.

1) **Sump Thickness:** The wall thickness of the tank in the sump area must be no less than 3/16" (0.1875") and no more than 3/8" (0.375"). The sump side walls should be within the above measurements but the end walls of the sump will be thicker. Use a measuring tape to measure the sump wall thickness through the drilled holes. Use a caliper to make the final decisions on "borderline calls".
2) **Bottom of Tank Thickness:** Measure the bottom of the tank thickness through the agitation holes. The range should be between 0.395" and 0.435". Use a caliper to take this measurement.
3) **Barrel of Tank Thickness:** The minimum wall thickness on the barrel of the tank must be 3/8" (0.375"). We have no 'cut and dry' way to measure the barrel wall thickness as there are no open holes to take measurements from. Push and tap against the tank to determine 'soft' spots. Also from inside the tank check to see if areas of the tank emit significantly more outside light then other areas. If in doubt, check with you (Company) Supervisor.
4) **Gauge End Bottom Thickness:** Measure through the hole in the bottom of the gauge end of the tank. This should be a minimum of 3/8" (.375") thick.
5) **Hole Thickness Uniformity:** Check the thickness of the tank wall at different spots around the circumference of the drilled holes. The variation cannot be more than 1/32", (0.03125"). Holes with more then 1/32" variance are very difficult to seal with any bulkhead fitting.
6) **Hole Edge Profile:** The surface on the inside of the tank around the edge of each hole should be smooth and free of lumps, rough, and other surface irregularities. If the surface is not smooth it is very difficult to seal with any bulkhead fitting.
7) **Warping:** Check both the inside and outside surfaces of the tank for warping, bulges, cave-ins, waves, or any other deformities. Also any sharp extrusions should be noted and reported to the manufacturer so that the mold can be repaired.
8) **Colour:** Check the colour uniformity on both the inside and outside of the tank. There should be no discoloured areas or blotches on the tank. Also check the "(Company)" logo to make sure that the letters are in place and that the colour has not smudged.

9) **Hole Placement:** Check to make sure that all holes have been drilled in tank and positioned according to its drawing. If a hole is missing, the tank should not be rejected, but the hole should be drilled as required and it should be documented and reported to the supplier.

10) **Lid:** The lid should be in place, in good shape and in working condition. When new, the lid will be stiff to work, this is OK. Also check to make sure that all the screws holding the lid are in place, replace any missing screws. The lid should flip front to back.

Sprayer Tank Check Sheet

Tank Part # _____Serial # _____

Checked by _____

Date_____

1. _____The wall thickness of the tank in the sump is no less than 3/16" (0.1875") and no more than 3/8" (0.375"). The sump end walls may be thicker.

2. _____Bottom of tank thickness is within the 0.395" to 0.435" range. Measured through the agitator holes.

3. _____The barrel of tank thickness is a minimum of 3/8" (0.375"). Based on a guesstimate.

4. _____Gauge end bottom thickness is a minimum of 3/8" (0.375"). Measured through the hole in the bottom of the gauge end.

5. _____Hole thickness Uniformity does not vary more then 1/32" (0.03125") around each hole.

6. _____Hole edge Profile around the inside surface of each hole is free of lumps, roughness, and other surface irregularities.

7. _____Warping. Both the inside and outside surfaces of the tank are free of any warping, bulges, cave-ins, waves, or any other defects.

8. _____Colour. Both the inside and outside surfaces of the tank are free of discoloured areas or blotches. The Company logo is in place and the colour is not smudged.

9. _____Hole Placement. All holes are drilled as per the drawing of the tank. Holes in the sump are positioned so as not to interfere with the sealing of the bulkhead fittings, (near corners, edges, etc.).

10. _____Lid. The lid is in place, in good shape and in good working condition. All screws are in place. The lid flips front to back.

Comments: