215.25 (a) & (f)

If a storage tank is currently in use and does not have a U1-A form or a build sheet or a legible data plate, it must be taken out of service by January 1, 2030.

Railroad car tanks permanently mounted and used for storage shall be removed from service no later than December 1, 2025.

215.25 (d)

Repair or alteration to a storage tank, nurse tank, piping and associated appurtenances shall be performed by an R stamp holder.

Effective immediately.
215.40 (g) (1)

Each facility shall provide the minimum protection at each non-refrigerated storage tank opening on or before December 31, 2020 by:

A. The installation of an internal valve with a manual shutoff valve

OR

B. An approved excess flow valve or back check valve, a manual shutoff valve, and an approved Emergency Shutoff Valve (ESV) located within 3 feet of the opening of the manual shutoff valve.

ESVs & internal valves shall be tested annually for the functions required. A record of each test result shall be kept at the facility for a minimum of 5 years.
The minimum protection for all bypass lines shall consist of an excess flow valve and a manual shut-off valve provided the bypass is located at the highest elevation of the storage tank.

Any bypass line on the underside of the tank shall have the same type of protection as all other outlets on the underside of the tank.
215.40 (g) (2)
Approved emergency shutoff valve(s) or internal valves shall incorporate a reliable actuation system that will close all of the emergency shutoff valve(s) or internal valves(s) of the piping system on the first attempt in the event of emergency or testing from a remote location. A minimum of 2 remote actuation devices shall be located no less than 25 feet reasonably opposed to each other.


215.55 (p)
Container pressure relief valves shall not be used over 5 years past the manufactured date.

215.65 (v) & 215.65 (i) (2)
Bulkheads shall provide protection during transport unloading.

215.65 (v) 6)
Caution signs at Bulkheads
ADDITIONAL SAFETY ENHANCEMENT WITH BREAKAWAY PROTECTION
(Recommended but not a requirement)

BULKHEAD PROTECTION CANNOT BE ATTACHED TO THE CONTAINER PIERS.
Consider adding barrier protection around the entire storage tank when performing any updates. (USEPA, OSHA & CGA G-2.1-2014 Safety Standards)

215.110 (k)

Nurse tank withdrawal valves shall be protected by an excess flow valve matched to the designed flow rate. Flow capacity of the excess flow valves shall not exceed 45 GPM for 1¼” connections and 60 GPM for 1½” connections. Each valve shall be removed from service and inspected at an interval not to exceed 5 years.

215.120 (a)
No liquid transfer hose shall be joined between any nurse tank and any toolbar during transport upon a public right-of-way.

Effective immediately.

Example of current breakaway technology for tandem tanks

215.120 (c) (3)
When nurse tanks are pulled in tandem a breakaway coupling device or other means of protection shall be installed at each point where the hose crosses a hitching point. Deployment of equipment designed to achieve this protection shall be installed and maintained in accordance with the manufacturer’s instructions.

215.120 (g)

The hose length from the towed implement mechanically secure point to the breakaway coupler on the towing implements shall have sufficient length to allow breakaway couplers to articulate freely but prevent the hose from contact with the nurse tank tongue. This shall be achieved without securing the hose mechanically through the use of chains, elastomeric straps, wire ties or other means.


215.120 (c) (1)

All break-away couplers shall be installed and maintained according to the manufactures instructions (IOM). Adhere to any replace by dates stamped on break-away couplers.

Effective immediately.
215.25 (e)

Written record of all inspections and maintenance shall be kept at the facility for a period of 5 years or until sold or removed from service.

215.20 (a)

Any person at a commercial or noncommercial site who makes or breaks a connection on anhydrous ammonia equipment pertaining to the loading and unloading, or who maintains or repairs anhydrous ammonia vessels or associated equipment shall be a certified competent attendant.

Effective immediately.

Refresher training shall be at least every 3 years and documentation of completed training shall be maintained.
215.20 (d)

Any individual who conducts anhydrous ammonia safety training to certify individuals as certified competent attendants shall:

1) Train with a Department approved or equivalent training program and associated materials.

2) Submit a roster of the attendees with the name, company name, company address & date of the training.

3) Attend a Department sponsored training program annually.

Aboveground plumbing is not listed as a requirement under the new Illinois Department of Agriculture rules, although highly recommended under the OSHA/PSM standards.
This brochure is an overview of the regulations. Some of these requirements are complex and cannot be fully outlined in this brochure. For questions or assistance with compliance, please contact IFCA. We can also visit your facility to provide guidance on the updates you may be considering to your ammonia systems to comply with these regulations and the OSHA Process Safety Management rules.

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