

## Liner Fabrication and Quality

Flexi-Liner Corporation™ has been a leading provider of tank linings and containment products since 1953. Our commitment and focus on product quality keeps our customers coming back. Strict adherence to the following procedures assures you that all Flexi-liner products are built to last.

### **Receiving**

Materials and services that are purchased from vendors shall conform to specified requirements to ensure appropriate levels of quality, value, and service are received. All rolls will be visually inspected upon receiving shipment. Any damaged rolls will not be accepted.

### **Production**

The Company strives to maintain and ensure world-class production and quality by adhering to defined and documented procedures and detailed work instructions. All liner panels will be cut from rolls per required length based on customer drawings or specifications. Cut panels shall be inspected and placed in welding area.

All plant welds will be made using an RF dielectric weld and will be inspected and tested prior to shipment. Material to be seamed will have sample cut to set machine thickness and weld time. One of two liner panels will be placed under weld bar. The second panel will be placed under RF welding bar and will overlap bottom panel by no less than 2". Operators will verify that material is overlapped properly. Weld will be made and operators will visually inspect the seam before proceeding to next weld. Each seam will be welded following these steps until lining seams are all satisfactorily welded. During fabrication, a micrometer will be used at specified intervals to check consistency of material thickness at weld location. Thickness of the finished weld shall not be more than 0.010" more than the thickness of the un-welded original material. At scheduled intervals, a welded seam sample will be taken and tested for shear strength and peel adhesion in accordance with ASTM D 4437.

### **Testing**

Upon completion of welding, the liner will be measured to assure its dimensions match the production order and customer specifications. Liner seams will be randomly tested using a vacuum box method. Any weaknesses in seams will be repaired. All material used will be logged in the file by size and material, lot number, roll number and panel number. Liner will be cleaned of any dirt or marks. Liner will be accordion folded and/or rolled. During folding, all panels and seams will be visually inspected for defects.

### **Packaging & Shipping**

Rolls will be wrapped in protective padding, either secured to a pallet or crated, and labeled for field placement. All documents will be shipped with liner.

**New Life for Old Tanks, Long Life for New Tanks**