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**Corella® Rectangular, Aboveground, Single-Wall Steel Oil/Water Separator**

Product Guide Specification

Specifier Notes: This product guide specification is written according to the Construction Specifications Institute (CSI) 3-Part Format, including *MasterFormat, SectionFormat,* and *PageFormat,* as described in *The Project Resource Manual - CSI Manual of Practice, Fifth Edition.*

This section must be carefully reviewed and edited by the Architect or Engineer to meet the requirements of the project and local building code. Coordinate this section with other specification sections and the Drawings. **Delete all “Specifier Notes” after editing this section.**

Section numbers are from *MasterFormat 2014 Edition*.

SECTION 46 25 13

CORELLA® COALESCING OIL/WATER SEPARATOR(S)

Specifier Notes: This section covers Highland Tank & Mfg. Co., Inc. Corella® Rectangular, Aboveground, Single-Wall Steel Oil/Water Separator25000RECSWHTCCSI. Consult Highland Tank & Mfg. Co., Inc. for assistance in editing this section for the specific application.

PART 1 GENERAL

1.1 SECTION INCLUDES

A. Corella® Rectangular, Aboveground, Single-Wall Steel Oil/Water Separator(s).

1.2 RELATED REQUIREMENTS

Specifier Notes: Edit the following list of related sections as required. Delete related sections not required. List other sections with work directly related to this section.

A. Section 03 30 00 - Cast-in-Place Concrete (Concrete for Reinforced Concrete Slab)

B. Section 22 14 13 - Facility Storm Drainage Piping

C. Section 22 14 26.19 - Facility Trench Drains

D. Section 22 14 29.19 - Sump-Pump Basins and Pits

1.3 REFERENCE STANDARDS

Specifier Notes: List reference standards mentioned in this section, complete with designations and titles. Delete reference standards not included if guide specification is edited. This article is merely a listing of some of the standards used for equipment compliance.

A. AASHTO - American Association of State Highway and Transportation Officials

B. ANSI - American National Standards Institute

C. API - American Petroleum Institute

* API Publication 421, Monographs on Refinery Environmental Control - Management of Water Discharges.

D. ASTM - American Society for Testing and Materials

* ASTM Standard Specification for Carbon Structural Steel - ASTM International.

E. AWS - American Welding Society

* Structural Welding Code – Steel.

F. NEC - National Electric Code

G. NEMA - National Electric Manufacturers Association

H. NFPA - National Fire Protection Association

* NFPA 30, Flammable and Combustible Liquids Code;
* NFPA 70, NEC National Electric Code.

I. OSHA - U. S. Department of Labor, Occupational Safety and Health Administration

* OSHA 29 CFR 1910.106, Occupational Safety and Health Standards, particularly Flammable and Combustible Liquids.

J. PEI - Petroleum Equipment Institute.

* RP200, Recommended Practices for Installation of Aboveground Storage Systems for Motor Vehicle Fueling.

K. SSPC - Steel Structures Painting Council/NACE - National Association of Corrosion Engineers.

* SSPC-SP 6/NACE No. 3, Commercial Blast Cleaning.
* SSPC-SP 10/NACE No. 2, Near-White Blast Cleaning.

L. STI - Steel Tank Institute

M. UL - Underwriters Laboratories, Inc.

* UL 142 - Steel Aboveground Tanks for Flammable and Combustible Liquids

N. U.S. Code of Federal Regulations (CFR) Title 33 and Title 40

* Oil Pollution Act (Title 33 U.S.C. 2701 ET SEQ.; 104 STAT. 484);
* Clean Water Act (Title 40 Effluent Guidelines and Standards).

O. U.S. EPA - United States Environmental Protection Agency

* EPA Test Method 1664A - Oil and Grease Recoverable Extraction.

Specifier Notes: In case of differences between building codes, state laws, local ordinances, utility company regulations, and contract documents, the most stringent shall govern. The codes and standards listed are the latest as of this publication. Codes and standards are continuously updated. The Contractor shall confirm the construction standard edition enforced by the authority having jurisdiction.

1.4 SUBMITTALS

Specifier Notes: Edit submittal requirements as required. Delete submittals not required.

A. Comply with Section 01 33 00 - Submittal Procedures.

B. Shop Drawings: Submit shop drawings of the coalescing oil/water separator(s) by the manufacturer showing principal dimensions and location of all fittings.

C. Product Data: Submit manufacturer’s product data, including installation, operation and maintenance instructions.

D. Quality Control: Quality control, inspection procedures, and reports shall be considered part of the submittal package.

E. Manufacturer’s Certification: Submit manufacturer’s certification that the coalescing oil/water separator(s) comply with specified requirements and are suitable for intended application.

F. Warranty Documentation: Submit manufacturer’s standard warranty.

Specifier Notes: There shall be a limit to the number of submittals for the specified oil/water separator. If the oil/water separator is not “Approved” or “Approved as Noted” on the second submittal for approval, the engineer reserves the right to refuse further submittals from the same manufacturer and may require the contractor to submit for approval a different manufacturer’s product.

1.5 QUALITY ASSURANCE

A. Manufacturer’s Qualifications:

1. Manufacturer regularly engaged, for past 20 years, in manufacture of coalescing oil/water separator(s) of similar type to that specified. No subcontracting of oil/water separator(s) fabrication shall be permitted.

2. Manufacturer shall provide written documentation that the oil/water separator was “Made in USA.” The product must be "all or virtually all" fabricated in the United States, including the 50 states, the District of Columbia, and the U.S. territories and possessions.

3. Verification and Inspection:

* 1. Manufacturer shall permit scheduled plant inspections for:
     1. Verification of manufacturing location.
     2. Inspection during manufacturer’s welding operations.
     3. Inspection during manufacturer’s coating operation.
     4. Review of QA/QC Documentation.
  2. Manufacturer shall provide inspector with a minimum of fourteen (14) days advanced notice prior to when the in-process inspection point is scheduled to occur.

B. Installer's Qualifications:

1. Installer regularly engaged, for past 5 years, in installation of coalescing oil/water separator(s) of similar type to that specified.

2. Employ persons qualified for proper installation of coalescing oil/water separator(s).

1.6 DELIVERY, STORAGE, AND HANDLING

A. Deliver, store, and handle coalescing oil/water separator(s) in accordance with manufacturer’s instructions.

B. Protect coalescing oil/water separator(s) during delivery, storage, handling, and installation to prevent damage.

1.7 WARRANTY

A. Warranty Period:

1. The manufacturer shall:

a. warrant its products to be free from defects in material and workmanship for a period

of one (1) year from the date of shipment. The warranty shall be limited to repair or

replacement of the defective part(s).

PART 2 PRODUCTS

2.1 MANUFACTURER

A. Highland Tank & Mfg. Co., Inc.

One Highland Road

Stoystown, PA 15563

Phone 814-893-5701

Fax 814-893-6126

E-mail: wastewater[@highlandtank.com](mailto:bbb@aaaa.com)

Website: [www.highlandtank.com](http://www.highlandtank.com)

Specifier Notes: Specify type of facility or operation, oil/water separator location, and type of influent flow (pumped or gravity). Caution: Pumping of influent will mechanically emulsify oil in water unless a positive displacement pump or other low emulsifying pump is used.

2.2 CORELLA® COALESCING OIL/WATER SEPARATOR(S)

A. Corella® Coalescing Oil/Water Separator(s) shall be designed for gravity separation of free oils (hydrocarbons and other petroleum products) along with some settleable solids from wastewater associated with \_\_\_\_ \_\_\_\_\_\_\_\_ operations.

1. Oil/Water Separator shall be installed [aboveground] [at grade] or [below ground in a vault].
2. The source of the influent to the separator shall be [pumped] [gravity] flow from [storm water runoff] [facility indoor drainage], hydrocarbon spills, and/or cleaning/maintenance operations.

B. The free oil and grease concentration in the effluent from the Corella® Coalescing Oil/Water Separator(s) shall not exceed 10 mg/l (10 ppm). To achieve this goal, it will be necessary to remove all free oil droplets equal to and greater than 20 microns.

Specifier Notes: Specify quantity.

C. Quantity: \_\_\_\_\_\_

D. Nominal Oil/Water Separator Capacity: 25000-gallons, as indicated on the drawings.

1. Oil/Water Separator capacity and associated oil holding capacity have been calculated to comply with Spill Prevention Control and Countermeasures (SPCC) plan and National Pollutant Discharge Elimination System (NPDES) permit requirements of the facility. The sizing of this oil/water separator is consistent with industry protocols for complying with the minimum federal spill and discharge regulations therefore a separator of smaller volume is not permissible.

E. Nominal Dimensions:

1. Nominal Length: 33-feet, 6-inches, as indicated on the drawings.

2. Nominal Width: 10-feet, 0-inches, as indicated on the drawings.

3. Nominal Height: 10-feet, 0-inches, as indicated on the drawings.

F. Maximum Flow Rate: 2500 gallons/minute, as indicated on the drawings.

G. Conformance:

1. API Publication 421, Monographs on Refinery Environmental Control - Management of Water Discharges.
   1. Oil/Water Separator shall be designed in accordance with Stokes Law and the American Petroleum Institute Publication 421, "Monographs on Refinery Environmental Control - Management of Water Discharges; Design and Operation of Oil/Water Separators.”
   2. Effective surface area calculations, signed and stamped by a Registered Professional Engineer shall be submitted to document specified effluent quality based on complete removal of the specified oil globule at design flow.
   3. An oil/water separator with lower effective surface area than required is not permissible.
2. Oil/Water Separator capacities, dimensions, construction and thickness shall be in strict accordance with Underwriters Laboratories, Inc. Subject UL 142 - Steel Aboveground Tanks for Flammable and Combustible Liquids, Single-Walled Construction.
3. Pressure testing of oil/water separator.
   1. The oil/water separator(s), their welds, seams and connecting fittings must be factory-tested for tightness using standard engineering practices.
   2. Oil/Water Separator(s) must be guaranteed by the manufacturer to be tight.
4. Oil/Water Separator shall comply with National Fire Protection Association NFPA 30 Flammable and Combustible Liquids Code.
5. Oil/Water Separator volume shall allow for a nominal hydraulic retention time of ten (10) minutes.
   1. Oil/Water Separator volume has been calculated to ensure laminar flow conditions which result in hydraulic uniformity and high effluent quality.
   2. Volume reduction will adversely affect oil/water separator performance by increasing horizontal velocity and turbulence, therefore a separator of smaller volume is not permissible.
6. The oil/water separator shall have the structural strength to withstand static and dynamic hydraulic loading while empty and during operating conditions.
7. To prevent extensive shutdown and maintenance, the oil/water separator’s coalescer design must allow solids to fall unhindered by turbulence, and oil droplets to rise, without risk of re-emulsifying due to collisions with interfering solids.
   1. The use of plastic perforated tubes, spherical balls, or irregular shaped media will increase the facility’s maintenance costs and shall not be permitted.
8. The oil/water separator’s top access covers shall be easily removable for visual inspection and maintenance of the separator and its subsystem components.

H. Construction:

1. Oil/Water Separator shall be rectangular, horizontal, atmospheric-type steel vessel intended for the separation and storage of flammable and combustible liquids.
   1. Separator shall be fabricated of \_\_\_\_\_\_ mild carbon steel with shell seams of continuous lap weld construction. A separator with a reduced shell thickness is not permissible
2. The oil/water separator shall be a pre-packaged, pre-engineered, ready to install unit consisting of:
   1. An influent connection, 18-inch, flanged.
      1. An internal influent nozzle at the inlet end of the separator.
      2. Nozzle discharge to be located at the furthest diagonal point from the effluent discharge opening.
   2. A Velocity Head Diffusion Baffle at the inlet to:
      1. reduce horizontal velocity and flow turbulence.
      2. distribute the flow equally over the separators cross sectional area.
      3. direct the flow in a serpentine path in order to enhance hydraulic characteristics and fully utilize all separator volume.
      4. completely isolate all inlet turbulence from the Oil/Water Separation Chamber.
3. A Sediment Chamber to disperse flow and collect oily solids and sediments.
4. A Sludge Baffle to retain settleable solids and sediment and prevent them from entering the Oil/Water Separation Chamber.
5. An Oil/Water Separation Chamber containing a removable Corella® inclined parallel flat/corrugated plate coalescer.
   1. The coalescer shall have individual removable plates, sloped towards the Sediment Chamber.
   2. Each coalescing plate shall be flat on the top and corrugated on the bottom. The flat top plate shall resist clogging and clotting with solids to minimize the facility’s maintenance costs.
   3. The corrugations of each of the plate bottoms shall be shaped and positioned to enhance collisions between the rising oil droplets and coalescence between them thereby improving separator efficiency.
   4. The Corella® coalescer shall:
      1. effect separation of both oil and solids from all strata of the wastewater stream.
      2. shorten the vertical distance that an oil globule or solid particle has to raise or sink, respectively, for effective removal. The minimum plate gap to be one inch.
      3. enhance coalescence and agglomeration by causing the smaller globules and particles (those possessing smaller rising/settling rates) to coalesce and collect on the plates thereby forming larger globules and particles that separate rapidly in water.
      4. direct the flow paths of the separated oil to the surface of the separator and separated solids to the bottom of the separator.
      5. allow solids to fall unhindered by turbulence, and oil droplets to rise, without risk of re-emulsifying due to collisions with interfering solids.
6. The Oil/Water Separation Chamber shall also contain a sectionalized removable "Petro-Screen" polypropylene impingement coalescer designed to intercept oil globules of 20 microns in diameter and larger.
   1. Heavy, one-piece impingement coalescers are not permissible for safety reasons.
7. An oil dam with two (2) effluent transfer pipes.
8. An integral Effluent Clearwell.
9. An internal effluent downcomer at the outlet end of the separator, to allow for discharge from the bottom of the Effluent Clearwell only.
10. An effluent connection, 18-inch, flanged.
11. Fittings for vent, interface/oil level sensor, waste oil pump-out, gauge, and drain.
12. Removable vapor-tight top cover(s), gasket, and bolts with large wing nuts for easy access.
13. Lifting lugs at balancing points for handling and installation.
14. Identification plates: Plates to be affixed in prominent location and be durable and legible throughout equipment life.

Specifier Notes: Specify quantity and size of any additional threaded NPT fittings in item E.

1. Threaded NPT Fittings: Threaded fittings with thread protectors shall be supplied as follows:

a. One (1), 2-inch Diameter: Interface/Oil Level Sensor

b. One (1), 2-inch Diameter: Normal Vent

c. One (1), 3-inch Diameter: Oil/Sludge Level Gauging

d. One (1), 4-inch Diameter: Oil Pump-Out

e. \_\_\_\_ (\_\_\_), \_\_\_-inch Diameter: NPT fittings located as indicated on the Drawings.

I. Corrosion Protection System:

1. Exterior Protective Coating:
   1. Surface Preparation: Steel Grit Blast - SSPC-SP 6/NACE No.3 Commercial Blast Cleaning.
   2. Finish: High-solids, VOC conforming acrylic polyurethane paint system, 5-7 mils DFT. Color to be Reflective White with Gloss Finish.
2. Internal Protective Lining:
   1. Surface Preparation: Steel Grit Blast - SSPC-SP 10/NACE No. 2, Near-White Blast Cleaning.
   2. Internal surfaces coated with 15 mils DFT solvent-free, two component polyurethane lining.

Specifier Notes: Specify Optional Equipment. Indicate quantities, delete unwanted items.

J. Corella® Coalescing Oil/Water Separator(s) Options/Accessories:

1. \_\_\_\_ UL-Listed Interface/Oil Level Sensor and Controls.
   1. Oil/Water Separator shall be supplied with an audible and visual alarm system that indicates high level and high-high level (audible and visual) of accumulated oil in the oil/water separator.
   2. Level sensor to be intrinsically-safe, separator-mounted magnetic float probes, suitable for use in Class I, Division II, Group D locations.
   3. Level sensor floats to be made of Buna-N.
   4. The control panel shall be NEMA 4X (FRP).
   5. A silence control shall be provided for the audible alarms.
   6. Power to the control panel is to be [ \_\_\_\_\_ ] volt, [ \_\_\_\_\_ ] phase.
2. \_\_\_\_ Ladders, Stairs, Platforms, Catwalks, Walkways, and Handrails.
   1. Access is required for convenient and safe inspection and maintenance of the oil/water separator. Access locations shall be provided as detailed on the Drawings.
   2. Design and fabrication of all ladders (interior or exterior), stairs, platforms, catwalks, walkways, and handrails shall be in accordance with applicable OSHA safety regulations, pertinent building codes, acceptable engineering practices, and the following additional requirements:
   3. Interior and/or Exterior Ladders shall be fabricated of [coated] [galvanized] carbon steel.
   4. Stairs, Platforms, Catwalks, and Walkways shall be fabricated of [coated], [galvanized] carbon steel with anti-slip fiberglass treads and walking surfaces.
3. \_\_\_\_ Manufacturer On-Site Training Assistance
   1. On-site training will be included. This project requires Factory Personnel/Factory Representative to perform on-site training upon completion of field wiring and filling of oil/water separator(s).

PART 3 EXECUTION

**3.1 GENERAL**

A. Installation and testing of Corella® Coalescing Oil/Water Separator(s) shall be in strict accordance with the Highland Tank’s Oil/Water Separator Users’ Manual available at [www.highlandtank.com](http://www.highlandtank.com).

B. No modifications shall be made to the oil/water separator(s) without the prior written approval of the manufacturer and the Engineer. This includes any welding on oil/water separator shell, adding penetrations, modifying the separator structure, or repairing damage that might affect the integrity of the separator.

C. Contractor shall install oil/water separator(s), piping, and equipment (inlet/outlet shut off valves, sensors, pumps, vents, gauges, etc.) in accordance with the manufacturers' installation instructions, industry standard recommended practices and federal, state and local regulations.

D. Oil/Water Separator(s) shall be handled, lifted, stored, and secured in accordance with the manufacturer's instructions. Unload with equipment having sufficient lifting capacity to avoid accidents or damage to the separator

E. Oil/Water Separator(s) located in areas subject to flooding must be protected against floatation. Consult manufacturer for supplemental hold down straps if required.

F. The hazards associated with the cleaning, entry, inspection, testing, maintenance or other aspects of oil/water separator(s) are significant. Safety considerations and controls should be established prior to undertaking physical activities associated with oil/water separator(s).

1. Never enter an oil/water separator or enclosed space, under any condition, without proper training and OSHA approved equipment. (Consult OSHA regulation 29 CFR 1910.146 “Permit Required Confined Spaces.”)
2. Entry and cleaning of oil/water separator(s) must be per federal (OSHA), state, and local regulations as well as company requirements.

G. Familiarity with the Site.

1, Contractor shall familiarize self with the location of all public utility facilities and structures that may be found in the vicinity of the construction.

2. The Contractor shall conduct his operation to avoid damage to the utilities or structures.

3. The Contractor is responsible for meeting all the requirements established by the agencies for utility work, as well as work affecting utilities and other government agencies.

3.2 EXAMINATION

A. Examine location to receive aboveground Corella® Coalescing Oil/Water Separator(s).

B. Notify site supervisor or engineer of conditions that would adversely affect installation.

C. Do not begin installation until unacceptable conditions are corrected.

3.3 PREPARATION

Specifier Notes: Include the following paragraph when specifying Aboveground Single-Walled Corella® Coalescing Oil/Water Separator(s).

A. The site shall be prepared to ensure adequate support for the oil/water separator system and drainage of surface water. The foundation and oil/water separator supports shall be capable of supporting the weight of the separator and associated equipment when full.

B. Hydrostatic Test (if required):

1. Perform hydrostatic test of aboveground oil/water separator(s) in accordance with manufacturer’s instructions in Highland Tank’s Oil/Water Separator Users’ Manual.

2. After the oil/water separator has been placed on the foundation and leveled, fill the separator with clean, fresh water until water is discharged from the outlet. Allow the oil/water separator to stabilize to a no-flow, static condition.

3. Accurately measure and record the static water level from the top of the separator to the water level.

4. After one hour, verify that the water level has not dropped. A water level change would indicate that there may be a leak. If a leak is detected, contact the manufacturer before proceeding.

C. Before placing oil/water separator(s) on reinforced concrete slab:

1. Remove dirt clods and similar foreign matter from oil/water separator’s bottom.

2. Visually inspect oil/water separator(s) for damage.

3. Notify site supervisor of damage to oil/water separator(s).

4. Repair damaged areas of oil/water separator coating in accordance with manufacturer’s instructions in Highland Tank’s Oil/Water Separator Users’ Manual.

3.4 INSTALLATION

A. Install aboveground Corella® Coalescing Oil/Water Separator(s) in accordance with manufacturer’s instructions in Highland Tank’s Oil/Water Separator Users’ Manual, NFPA 30, and PEI/RP200.

B. Install aboveground oil/water separator(s) at locations indicated on the Drawings.

C. Oil/Water Separator(s) shall be installed on a reinforced concrete base constructed by owner.

D. Oil/Water Separator(s) Placed on Concrete Pad.

Specifier Notes: Specify the section number for cast-in-place concrete.

1. Concrete for Pad: Specified in Section 03 30 00.

E. Ensure oil/water separator(s) foundation is free from materials that may cause damage to oil/water separator or separator’s coating.

F. Oil/Water Separator(s) Handling:

1. Ensure equipment to handle oil/water separator(s) is of adequate size to lift and lower oil/water separator(s) without dragging, dropping, or damaging oil/water separator or separator’s coating.

2. Carefully lift and lower oil/water separator(s) with cables or chains of adequate length attached to lifting lugs provided.

3. Use spreader bar where necessary.

4. Do not use chains or slings around oil/water separator shell.

5. Maneuver oil/water separator with guidelines attached to each end of the separator.

G. Plugs:

1. Remove plugs at unused oil/water separator(s) openings, add pipe compound, and reinstall plugs in unused openings.

2. Do not cross-thread or damage oil/water separator(s) fittings when replacing plugs or installing separator piping.

H. Piping:

1. Piping shall be installed in accordance with Section 22 14 13 - Facility Storm Drainage Piping.

2. All piping shall be externally supported so that the weight of the piping is not transferred to the tank or connection.

I. Final Inspection: Visually inspect oil/water separator(s), separator’s coating, and pipe connections.

**3.5 ELECTRICAL**

A. Installation of all electrical components including (Electric level sensors, alarm/control panels, electronic actuated inlet/outlet shut off valves, pumps, etc.):

1. Installation shall be in accordance with manufacturers' installation instructions and shall conform to state and local electrical codes with special attention to compliance with requirements for work in classified areas.

2. Provide explosion-proof electrical junction boxes, conduit and seal offs as specified in Article 500 514 of the National Electrical Code.

3. Contractor shall provide wiring and seal-offs for all conduits.

3.6 PROTECTION

A. Protect installed aboveground steel storage oil/water separator(s) from damage during construction.

**3.7 START-UP, OPERATION AND MAINTENANCE**

A. Corella® Coalescing Oil/Water Separator(s) shall be started, operated and maintained according to the Highland Tank’s Oil/Water Separator Users’ Manual in effect at time of installation.

END OF SECTION