

SNAPSHOT OF THE NEW ILLINOIS AMMONIA RULES



Illinois Fertilizer &
Chemical Association
Supply • Service • Stewardship

(8 IL Adm Code Part 215)

Illinois Fertilizer & Chemical Association - 14171 Carole Drive-Bloomington, IL 61705
309-827-2774

(A copy of the complete rules is available at www.ifca.com)

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**.

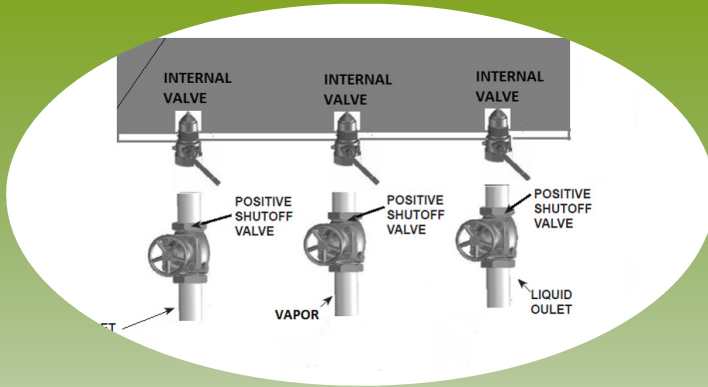


215.25 (d)

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)

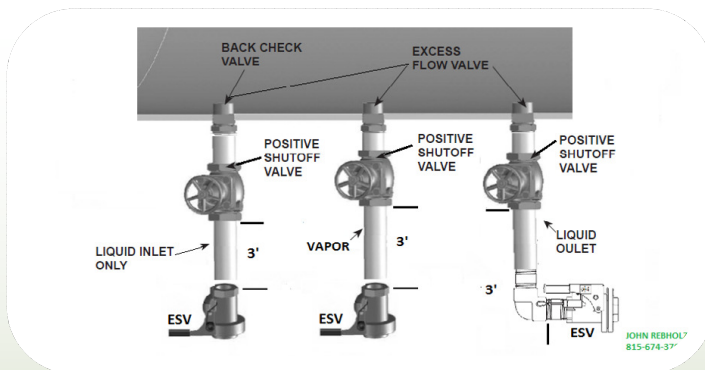
Each facility shall provide the minimum protection at each non-refrigerated storage tank opening on or before **December 31, 2020** by:

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.



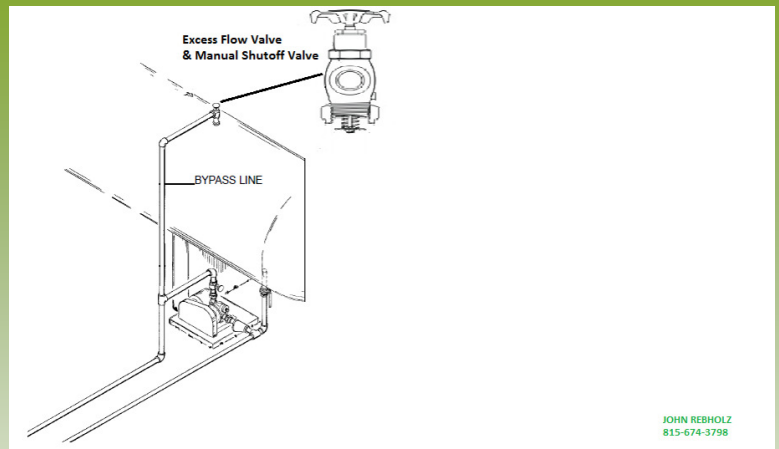
ESVs & internal valves shall be tested annually for the functions required. A record of each test result shall be kept at the facility for a minimum of 5 years.



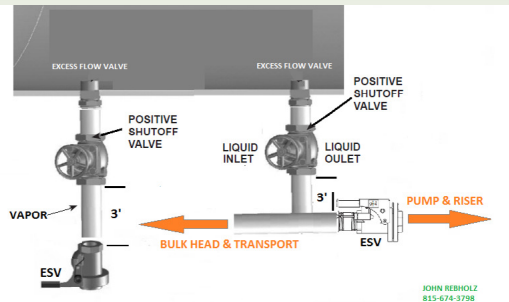
215.65 (i) (3)

The minimum protection for all bypass lines shall consist of an excess flow valve and a manual shutoff valve provided the bypass is located at the highest elevation of the storage tank.

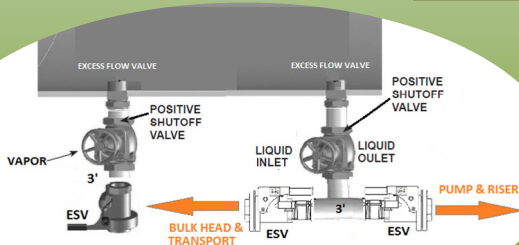
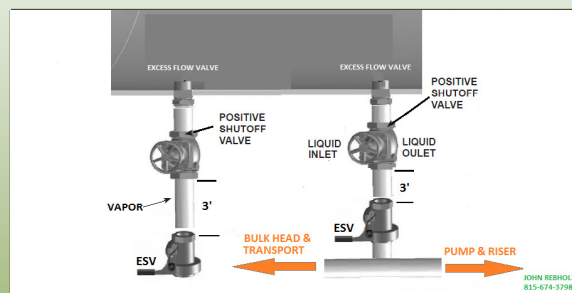
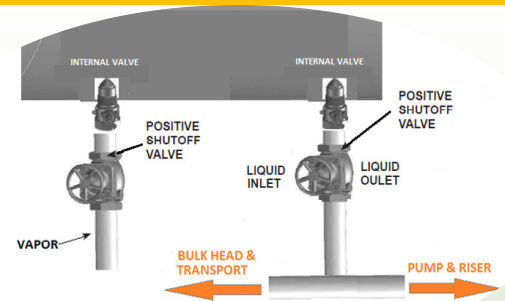
Any bypass line on the underside of the tank shall have the same type of protection as all other outlets on the underside of the tank.



INCORRECT INSTALLATION EXAMPLE
(incorrect protection on liquid inlet/outlet)



CORRECT INSTALLATION EXAMPLES





ESVs & internal valves shall be tested annually for the functions required.



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.

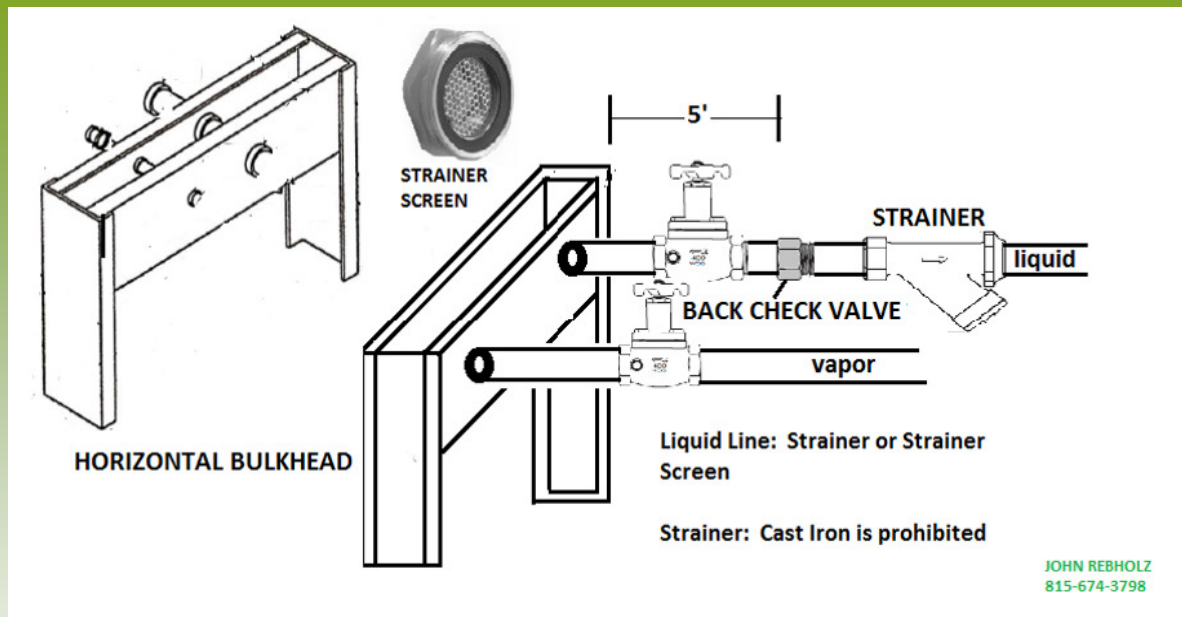
Compliance no later than **December 31, 2020.**

215.55 (p)

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

Compliance no later than **December 31, 2020.**





215.65 (v) & 215.65 (i) (2)

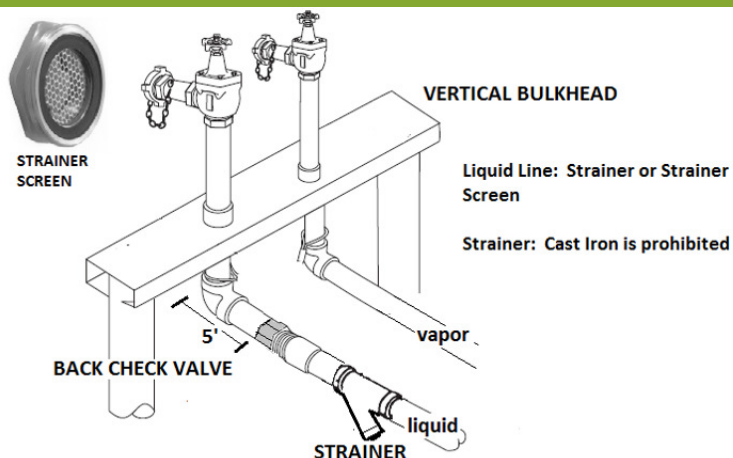
Bulkheads shall provide protection during transport unloading.

215.65 (v) 6)

Caution signs at Bulkheads



**BULKHEAD
PROTECTION
CANNOT BE
ATTACHED TO
THE CONTAINER
PIERS.**

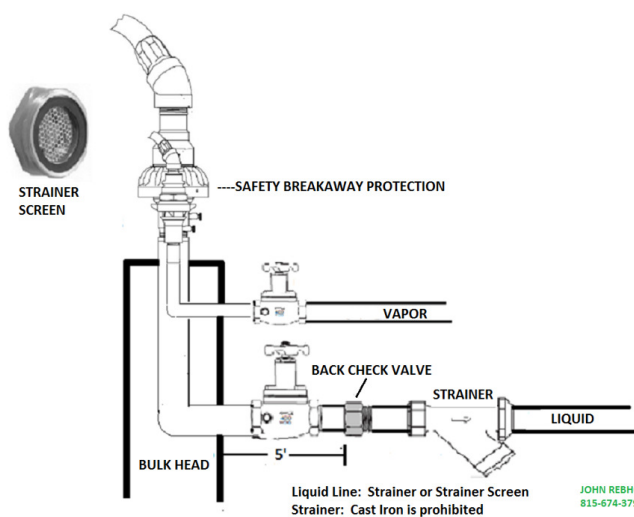


JOHN REBHOLZ
815-674-3798



**ADDITIONAL SAFETY
ENHANCEMENT WITH
BREAKAWAY
PROTECTION**

**(Recommended but not a
requirement)**



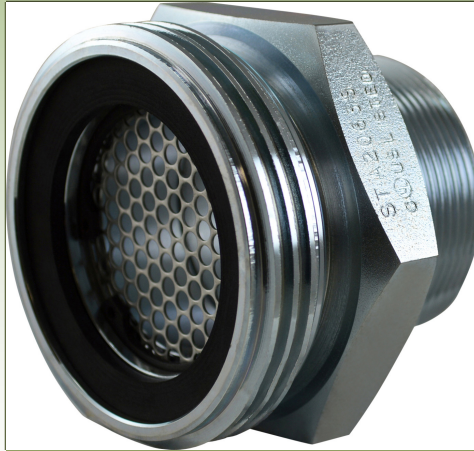
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215.65 (i) (4)

Installation of an in-line strainer or a strainer screen on the liquid unloading line at the Bulkhead.

Compliance no later than **December 31, 2017** for existing locations.

**CAST IRON
STRAINERS ARE
PROHIBITED**



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.

Compliance no later than **December 31, 2020**.

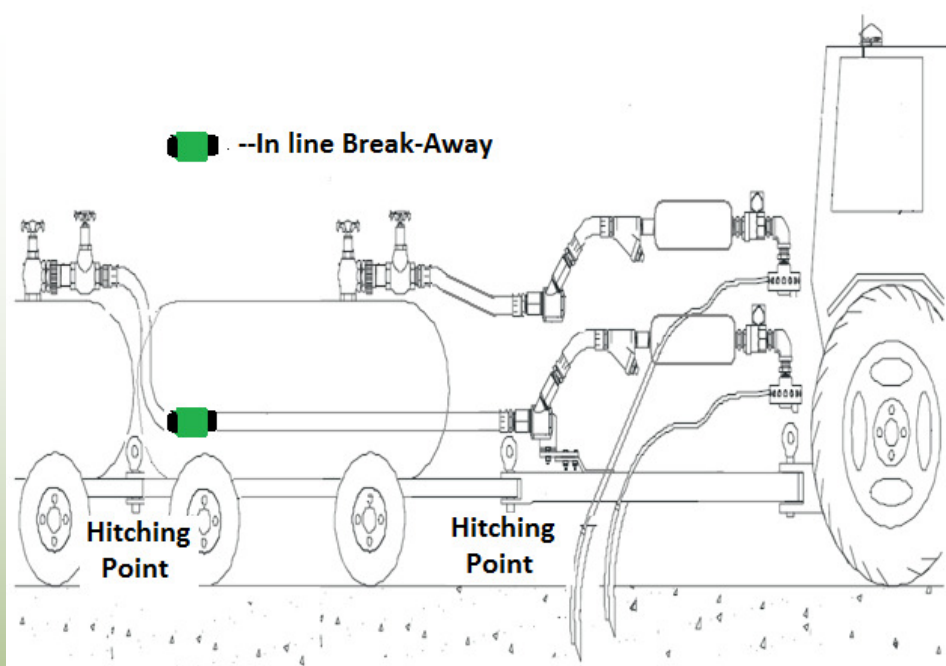




215.120 (a)

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

Effective immediately.



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.

Compliance no later than December 31, 2020.

Example of current breakaway technology for tandem tanks



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.

Compliance no later than
December 31, 2020.



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.



Aboveground Plumbing

CONTRACTORS*

Dibble Enterprises
113 S Route 53
Gardner, IL 60424
815-237-2247
R Stamp

S F Welding & Repair
401 West Lincoln
Saybrook, IL 61770
309-475-2027
R Stamp

Fertilizer Dealer Supply, Inc.
106 Monroe St.
Philo, IL 61864
217-684-2080

Rocket Supply Corporation
404 N Route 115
Roberts, IL 60962
217-395-2278
R Stamp

Petri Welding & Prop Repair
2253 W Morton Ave
Jacksonville, IL 62650
217-243-1748
R Stamp

Paul Akers
3155 West U.S. 40
Greenfield, IN 46140
317-462-9295
R Stamp

Craig's Restoration & Repair LLC
1029 Vail Avenue
Durant, IA 52747
563-785-4887
R Stamp

Two Guys Mechanical
Contractors, Inc.
918 N US Hwy 35
Winamac, IN 46996
574-946-7671

**In providing this list, IFCA is not specifically endorsing or recommending these companies; we are providing this information for the convenience of our members. Any business interactions with these service providers is the sole choice and responsibility of the hiring party.*

FOR ADDITIONAL GUIDANCE

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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