

**Recommended Regulatory Standard
for
TANK VEHICLES
FOR FLAMMABLE LIQUIDS**

Prepared by the
NFPA Committee on Flammable Liquids

Adopted by the NFPA

1948

Twenty-five Cents



NATIONAL FIRE PROTECTION ASSOCIATION

International

60 Batterymarch St., Boston 10, Mass.

National Fire Protection Association

International

Executive Office: 60 Batterymarch St., Boston 10. Mass.

The National Fire Protection Association was organized in 1896 to promote the science and improve the methods of fire protection and prevention, to obtain and circulate information on these subjects and to secure the cooperation of its members in establishing proper safeguards against loss of life and property by fire. Its membership includes over a hundred and fifty national and regional societies and associations and nearly thirteen thousand individuals, corporations, and organizations.

Membership in the National Fire Protection Association is open to any society, corporation, firm or individual interested in the protection of life or property against loss by fire. All the valuable engineering and popular literature issued by the Association is sent, as issued, to every member. The Association is the clearing house for all authoritative information on fire protection and prevention, and members are privileged to submit to it their individual problems for solution. The Association is always glad to send samples of its publications to prospective members upon request.

This pamphlet is one of a large number of publications on fire safety issued by the Association. The standards prepared by the technical committees of the National Fire Protection Association and adopted in the conventions of the Association, are intended to prescribe reasonable measures for minimizing fire losses. All interests concerned have opportunity through the National Fire Protection Association to participate in the development of the standards and to secure impartial consideration of matters affecting them.

RECOMMENDED REGULATORY STANDARD FOR TANK VEHICLES FOR FLAMMABLE LIQUIDS.

This recommended state or provincial regulatory standard for Tank Motor Vehicles for Flammable Liquids prepared by the NFPA Committee on Flammable Liquids was officially adopted by the National Fire Protection Association at its 1948 annual meeting, and certain amendments in section 129 were subsequently approved by the NFPA Board of Directors on recommendation of the Committee on Flammable Liquids. The present text supersedes the present Tank Truck Ordinance (refer to National Fire Codes, Vol. I, 1948 edition, or to separate pamphlet, edition of 1933).

This standard is prepared for issuance by state and provincial authorities as a regulatory standard.

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RECOMMENDED REGULATORY STANDARD FOR TANK VEHICLES FOR FLAMMABLE LIQUIDS.

100. GENERAL.

110. Scope.

This standard applies to tank motor vehicles to be used for the transportation of flammable liquids. It is intended to provide minimum requirements for the design, construction and operation of tank motor vehicles, their appurtenances, and certain features of tank motor vehicle chassis.

NOTE: This standard does not apply to tank motor vehicles for the transportation of liquefied petroleum gases, requirements for which are given in the National Fire Protection Association Standard for Liquefied Petroleum Gases published in National Fire Codes, Vol. I, and Pamphlet 58 of the National Board of Fire Underwriters.

120. Definitions.

121. Tank Truck. Any single self-propelled motor vehicle equipped with a cargo tank mounted thereon, and used for the transportation of flammable liquids.

122. Tank Full Trailer. Any vehicle, without motive power, equipped with a cargo tank mounted thereon or built as an integral part thereof and used for the transportation of flammable liquids, and so constructed that, when drawn by a truck or tractor, no part of its weight rests upon the towing vehicle.

123. Tank Semi-Trailer. Any vehicle, without motive power, equipped with a cargo tank mounted thereon or built as an integral part thereof, and used for the transportation of flammable liquids, and so constructed that, when drawn by a tractor by means of a fifth wheel connection, some part of its load and weight rests upon the towing vehicle.

124. Tank Vehicle. Any tank truck, tank full trailer, or tractor and tank semi-trailer combination.

125. Cargo Tank. Any container having a liquid capacity in excess of 100 gallons, used for the carrying of flammable liquids, and mounted permanently or otherwise upon a tank vehicle. The term "cargo tank" does not apply to any container used solely for the purpose of supplying fuel for the propulsion of the tank vehicle upon which it is mounted.

126. Baffle. A perforated transverse partition of a cargo tank.

127. Compartment. A liquid-tight division of a cargo tank.

128. Head and Bulkhead. A liquid-tight transverse closure at the end of a cargo tank or between compartments of a cargo tank.

129. Flammable Liquids. Liquids having a flash point below 200 degrees F. and a vapor pressure not exceeding 40 pounds which, for the purpose of this specification shall be divided into two classes, viz.:

Class "A," embracing those flammable liquids having a flash point below 70 degrees F. and a vapor pressure not exceeding 40 pounds.

Class "B," embracing those flammable liquids having a flash point from 70 to 200 degrees F., inclusive.

The flash point of flammable liquids having a flash point below 175° F. (79° C.) shall be determined by the Standard Method of Test for Flash Point by means of the Tag Closed Tester, of the American Society for Testing Materials (A.S.T.M.:D56-36). This method is also the Standard of the National Fire Protection Association (National Fire Codes, Vol. I), the Standard of the American Petroleum Institute (A.P.I. No.:509-36), and the Standard of the American Standards Association (ASA:Z11.24-1936).

The flash point of flammable liquids having a flash point of 70° F. or below shall be determined by the apparatus and procedure called for in Sections 7 and 8 of this A.S.T.M. Method (D56-36).

The flash point of flammable liquids having a flash point of 175° F. or higher shall be determined by the Standard Method of Test for Flash Point by means of the Pensky-Martens Closed Tester of the American Society for Testing Materials (A.S.T.M.:D93-46). This method is also the Standard of the National Fire Protection Association (National Fire Codes, Vol. I), the Standard of the American Petroleum Institute (A.P.I. No.:510-46), the Standard of the American Association State Highway Officials (A.A.S.H.O.T.-73-46), and Standard of the American Standards Association (ASA:Z11.7-1947).

Vapor pressure shall be determined by the Standard Method of Test for Vapor Pressure of Petroleum Products (Reid Method) of the American Society for Testing Materials (A.S.T.M. D 323-43), which is also the Standard of the American Petroleum Institute (A.P.I. 539-43) and of the American Standards Association (A.S.A. Z11.44-1943).

200. CARGO TANKS, PIPING AND CONNECTIONS.

210. Cargo Tanks Constructed of Hot Rolled Tank Steel.

211. Material. All sheets for such cargo tanks shall be of hot rolled tank steel to meet the following requirements:

Yield Point, minimum	25,000 pounds per square inch
Ultimate Strength, minimum.....	45,000 pounds per square inch
Maximum Elongation, standard 2-inch sample.....	20 per cent

212. Thickness of Sheets. The minimum thicknesses of tank sheets shall be limited by the volume capacity of the tank expressed in terms of gallons per inch of length; and by the distance between bulkheads, baffles, or other shell stiffeners, as well as by the radius of shell curvature in case of shell sheets; as follows:

Hot Rolled Tank Steel

MINIMUM THICKNESS OF HEAD, BULKHEAD AND BAFFLE SHEETS*

Heads, Bulkheads, or Baffles	(Dished, Corrugated, Reinforced or Rolled)			
	10 or Less	Over 10 to 14	Over 14 to 18	Over 18
Volume Capacity of Tank in Gallons per Inch of Length				
U. S. Standard Gauge No.	14	18	12	11

*Thickness of exterior head sheets shall never be less than the maximum requirements for shell sheets in any specific unit.

MINIMUM THICKNESS OF SHELL SHEETS
Hot Rolled Tank Steel

VOLUME CAPACITY OF TANK IN GALLONS PER INCH OF LENGTH	Distance Between Attachments of Bulkheads, Baffles or Other Shell Stiffeners		
	36 inches or less	Over 36 inches to 54 inches	Over 54 inches to 60 inches
U. S. Standard Gauge for Maximum Shell Radius of less than 70 inches:			
10 gallons or less.....	14	14	14
Over 10 to 14 gallons.....	14	14	13
Over 14 to 18 gallons.....	14	13	12
Over 18 gallons.....	13	12	11
U. S. Standard Gauge for Maximum Shell Radius of 70 inches or more, but less than 90 inches:			
10 gallons or less.....	14	14	13
Over 10 to 14 gallons.....	14	13	12
Over 14 to 18 gallons.....	13	12	11
Over 18 gallons.....	12	11	10
U. S. Standard Gauge for Maximum Shell Radius of 90 inches or more, but not over 125 inches:			
10 gallons or less.....	14	13	12
Over 10 to 14 gallons.....	13	12	11
Over 14 to 18 gallons.....	12	11	10
Over 18 gallons.....	11	10	9

220. Cargo Tanks Constructed of Aluminum.

221. Material. All sheets for such cargo tanks shall be of aluminum alloy, known as 3S or other alloy of equal or greater properties, as defined in Specification B209-46-T of the American Society for Testing Materials, meeting the following minimum requirements:

Ultimate Strength, minimum.....19,500 pounds per square inch
Maximum Elongation, standard 2-inch sample.....6 per cent

222. Thickness of Sheets. The minimum thicknesses of tank sheets shall be limited by the volume capacity of the tank, expressed in terms of gallons per inch of length; and by the distance between bulkheads, baffles, or other shell stiffeners, as well as by the radius of shell curvature in the case of shell sheets as follows:

Aluminum				
MINIMUM THICKNESS OF HEAD, BULKHEAD AND BAFFLE SHEETS*				
Heads, Bulkheads, or Baffles	(Dished, Corrugated, Reinforced or Rolled)			
Volume Capacity of Tank in Gallons per Inch of Length	10 or Less	Over 10 to 14	Over 14 to 18	Over 18
Brown & Sharpe's Standard Gauge	7	6	5	4

*Thickness of exterior head sheets shall never be less than the maximum requirements for shell sheets.

MINIMUM THICKNESS OF SHELL SHEETS

Aluminum

**VOLUME CAPACITY
OF TANK IN
GALLONS PER INCH
OF LENGTH**

**Distance Between Attachments of Bulkheads,
Baffles or Other Shell Stiffeners**
36 inches or less Over 36 inches to 54 inches Over 54 inches to 60 inches

**Brown & Sharpe's Standard Gauge
for Maximum Shell Radius of less
than 70 inches:**

10 gallons or less.....	7	7	7
Over 10 to 14 gallons.....	7	7	6
Over 14 to 18 gallons.....	7	6	5
Over 18 gallons.....	6	5	4

**Brown & Sharpe's Standard Gauge
for Maximum Shell Radius of 70
inches or more, but less than 90
inches:**

10 gallons or less.....	7	7	6
Over 10 to 14 gallons.....	7	6	5
Over 14 to 18 gallons.....	6	5	4
Over 18 gallons.....	5	4	3

**Brown & Sharpe's Standard Gauge
for Maximum Shell Radius of 90
inches or more, but not over 125
inches:**

10 gallons or less.....	7	6	6
Over 10 to 14 gallons.....	6	5	4
Over 14 to 18 gallons.....	5	4	3
Over 18 gallons.....	4	3	3

COMPARATIVE THICKNESS OF METAL SHEETS

Approximate Thickness		Steel Sheets	Aluminum Sheets
Fractions of Inch	Decimals of Inch	U. S. Standard Gauge No.	Browne & Sharpe's Gauge No.
$\frac{1}{16}$	0.598	16	
	0.673	15	
	0.0747	14	
	0.0897	13	
	0.1046	12	
	0.1196	11	
$\frac{1}{8}$	0.1345	10	
	0.1443		7
	0.1495	9	
	0.1620		6
$\frac{3}{16}$	0.1819		5
	0.2043		4
	0.2294		3

230. Cargo Tanks Constructed of Low Alloy Low Carbon (High Tensile) Steel.

231. Material. All sheets for such cargo tanks shall be of low alloy, low carbon steel, commonly known as high tensile, meeting the following requirements:

Yield Point, minimum	50,000 pounds per square inch
Ultimate Strength, minimum.....	65,000 pounds per square inch
Maximum Elongation, standard 2-inch sample.....	20 per cent

232. Thickness of Sheets. The minimum thicknesses of tank sheets shall be limited by the volume capacity of the tank, expressed in terms of gallons per inch of length; and by the distance between bulkheads, baffles, or other shell stiffeners, as well as by the radius of shell curvature in the case of shell sheets; as follows:

Low Alloy Low Carbon (High Tensile) Steel

MINIMUM THICKNESS OF HEAD, BULKHEAD AND BAFFLE SHEETS*

Heads, Bulkheads, or Baffles	(Dished, Corrugated, Reinforced or Rolled)			
	10 or Less	Over 10 to 14	Over 14 to 18	Over 18
Volume Capacity of Tank in Gallons per Inch of Length				
U. S. Standard Gauge No.	15	14	13	12

*Thickness of exterior head sheets shall never be less than the maximum requirements for shell sheets in any specific unit.

MINIMUM THICKNESS OF SHELL SHEETS

Low Alloy Low Carbon (High Tensile) Steel

VOLUME CAPACITY OF TANK IN GALLONS PER INCH OF LENGTH	Distance Between Attachments of Bulkheads, Baffles or Other Shell Stiffeners		
	36 inches or less	Over 36 inches to 54 inches	Over 54 inches to 60 inches

**U. S. Standard Gauge for Maximum
Shell Radius of less than 70 inches:**

10 gallons or less.....	16	16	15
Over 10 to 14 gallons.....	16	15	14
Over 14 to 18 gallons.....	15	14	13
Over 18 gallons	14	13	12

**U. S. Standard Gauge for Maximum
Shell Radius of 70 inches or
more, but less than 90 inches:**

10 gallons or less	16	15	14
Over 10 to 14 gallons.....	15	14	13
Over 14 to 18 gallons	14	13	12
Over 18 gallons	13	12	11

**U. S. Standard Gauge for Maximum
Shell Radius of 90 inches or
more, but not over 125 inches:**

10 gallons or less	15	14	13
Over 10 to 14 gallons.....	14	13	12
Over 14 to 18 gallons.....	13	12	11
Over 18 gallons	12	11	10

240. Joints.

241. Joints shall be made in accordance with recognized good practice and the efficiency of any joint shall be not less than 85 per cent of that of the adjacent metal in the tank. Low alloy, low carbon (high tensile) steel sheets, however, shall be joined by fusion welding.

242. Hot rolled tank steel and low alloy low carbon steel may be used in the construction of a single tank, provided each material, where used, shall comply with the minimum requirements of its respective specifications for that section of the tank.

250. Test.

251. Every cargo tank shall be tested by a minimum air or hydrostatic pressure of 3 pounds per square inch applied to each compartment, or to the whole tank if it be not divided into compartments. Such pressure shall be maintained for a period of at least 5 minutes, during which, if the test is by air pressure, the entire exterior surface of all the joints shall be coated with a solution of soap and water, heavy oil, or other material suitable for the purpose, foaming or bubbling of which will indicate the presence of leaks. Hydrostatic pressure, if used, shall be gauged at the top of the tank; and the tank shall be inspected at the joints for the issuance of liquid to indicate leaks. Any leakage discovered by either of the methods above described, or by any other method shall be deemed as evidence of failure to meet the requirements of this specification.

260. Tank Outlets.

261. Outlets shall be substantially made and so attached to the tank.

270. Bulkheads and Baffles.

271. Every cargo tank having a total capacity in excess of 1500 gallons and used for the distribution of Class "A" flammable liquids to service stations or other premises to which the public is invited shall be divided into compartments, no one of which shall exceed 1200 gallons. A tolerance of 10 per cent shall be allowed for capacities of individual compartments or tanks.

272. Bulkheads or compartments shall not be required in any cargo tank used for transportation service, regardless of total capacity, which, when loaded and transporting its cargo over streets and highways will contain not less than 80 per cent of the total tank capacity and will discharge its entire contents at one unloading point, provided such cargo tank is not used for the delivery of flammable liquids to service stations or other premises to which the public is invited.

273. Every cargo tank, and every compartment over 90 inches in length, shall be provided with baffles, the number of which shall be such that the linear distance between any two adjacent baffles, or between any tank head or bulkhead and the baffles nearest it, shall in no case exceed 60 inches.

274. The cross sectional area of each baffle shall be not less than 80 per cent of the cross sectional area of the tank and the thickness of such baffle shall be not less than that required for heads and bulkheads of the cargo tank in which installed.

275. Cargo tanks with compartments carrying flammable liquids of different classes shall be provided with an air space between compartments and this air space shall be equipped and maintained with drainage facilities operative at all times.

280. Vents.

281. Each cargo tank or compartment shall be provided with a vacuum and pressure operated vent with a minimum effective opening of 0.44 square inch, and each cargo tank or compartment used for the transportation of Class "A" flammable liquids shall also be provided with an emergency venting facility so constructed as to provide a minimum free-venting opening having a net area in square inches equal to 1.25 plus 0.0025 times the capacity of the cargo tank or compartment in gallons. If the emergency venting facility operates in response to elevated temperatures, the critical temperature for such operation shall not exceed 200°F.

290. Valve and Faucet Connections.

291. Draw-off valves and faucets shall have discharge ends threaded, or they shall be so designed as to permit being tightly connected to hose extending to fill pipe.

300. Emergency-Discharge Control.

301. Each cargo tank or compartment used for transportation of Class "A" flammable liquids shall be equipped with a reliable and efficient shut-off valve located inside the shell in the outlet; or in the sump when it is an integral part of the shell; and so designed that the valve must be kept closed during loading and unloading operations.

302. The operating mechanism for the valve shall be provided with a secondary control, remote from the fill openings and discharge faucets, for use in the event of accidents or fire during delivery operations.

303. The control mechanism shall be provided with a fusible section which will cause valves to close automatically in case of fire.

304. In every case there shall be provided, between the shut-off valve seat and discharge faucet, a shear section which will break under strain unless the discharge piping is so arranged as to afford the same protection and leave the shut-off valve seat intact.

400. TANK-VEHICLE CHASSIS, ASSEMBLY AND APPURTENANCES.

410. Tires.

411. All tank motor vehicles shall be equipped with rubber tires on all wheels.

420. Assembly.

421. Every cargo tank shall be adequately supported upon and securely attached to or be a part of the tank vehicle upon which it is carried.

430. Bonding and Grounding.

431. Cargo tanks, and vehicle chassis, shall be electrically bonded.

432. Provision shall be made prior to each filling of a tank vehicle for the bonding of vehicle to the fill pipe.

433. Drag chains or other devices of electrically conductive material shall not be construed as meeting the requirements of 432.

440. Protection Against Collision.

441. Draw-off valves or faucets projecting beyond the frame at the rear of a tank vehicle shall be adequately protected against collision by bumpers or similar means.

450. Lighting.

451. No lighting device other than electric lights shall be used on tank vehicles. Lighting circuits shall have suitable over-current protection (fuses or automatic circuit breakers). The wiring shall have sufficient carrying capacity and mechanical strength, and shall be secured, insulated, and protected against physical damage, in keeping with recognized good practice.

460. Fuel System.

461. **Fuel Tanks.** Fuel tanks shall be so designed, constructed and installed as to present no unusual hazard, and shall be so arranged as to vent during filling operations and permit drainage without removal from their mountings.

462. **Fuel-Feed System.** All portions of the fuel-feed system, including carburetor, pumps, and all auxiliary mechanisms and connections shall be constructed and installed in a workmanlike manner, and so constructed and located as to minimize the fire hazard, with no readily combustible materials used therein, and shall, except for diesel fuel connections, be well separated from the engine exhaust system. A pressure-release device shall be provided where necessary. The fuel-feed lines shall be made of materials not adversely affected by the fuel to be used or by other materials likely to be encountered, of adequate strength for their purpose, well secured to avoid chafing or undue vibration, having a readily accessible and reliable shut-off valve or stop-cock. Joints depending upon solder for mechanical strength and liquid tightness shall not be used in the fuel system at or near the engine, or its accessories, unless the solder has a melting point of not less than 340°F., or unless a self-closing, thermally controlled valve set to operate at not exceeding 300°F., or other equivalent automatic device, shall be installed in the fuel line on the fuel-tank side of such joint.

470. Exhaust System.

471. The exhaust system, including muffler (or silencer) and exhaust line shall have ample clearance from the fuel system and combustible materials, and shall not be exposed to accumulations of grease, oil or gasoline.

472. The exhaust system, including all units, shall be constructed and installed in a workmanlike manner. A muffler (or silencer) cut-out shall not be used.

480. Full Trailers and Semi-Trailers.

481. Trailers shall be firmly and securely attached to the vehicle drawing them, in a manner conforming with recognized good practice.

482. Each full trailer, and semi-trailer, shall be equipped with reliable brakes on all wheels, and adequate provision shall be made for their efficient operation from the driver's seat of the vehicle drawing the trailer, or semi-trailer.

483. Trailer connections shall be such as to prevent the towed vehicle from whipping or swerving from side to side dangerously or unreasonably and shall cause the trailer to follow substantially in the path of the towing vehicle.

490. Fire Extinguishers.

491. Each tank vehicle shall be equipped and maintained with at least one approved hand fire extinguisher of a type suitable for extinguishing flammable-liquid fires. Fire extinguishers shall be kept in good operating condition at all times, and they shall be located in an accessible place on each tank vehicle.

492. Fire extinguishers shall be of type and sizes to make one unit of first aid fire protection for Class "B" fires as defined by the National Fire Protection Association Standard for the Installation, Maintenance and Use of First Aid Fire Appliances as published in National Fire Codes, Vol. IV, Extinguishing and Alarm Systems and in Pamphlet No. 10 of the National Board of Fire Underwriters.

500. Auxiliary Internal Combustion Engines.

500. Internal combustion engines, other than those providing propulsive power, installed or carried upon a tank vehicle transporting Class "A" flammable liquids for the purpose of providing power for the operation of pumps or other devices, shall meet the following requirements:

501. The engine air intake shall be equipped with an effective flame arrester, or an air cleaner having effective flame arrester characteristics, substantially installed and capable of preventing emission of flame from the intake side of the engine in event of backfiring.

502. The fuel system shall be so located or constructed as to minimize the fire hazard. If the fuel tank is located above or immediately adjacent to the engine, suitable shielding shall be provided to prevent spillage during the filling operation, or leakage from the tank or fuel system, from coming in contact with the engine or any parts of the ignition and exhaust systems. All parts of the fuel system shall be constructed and installed in a workmanlike manner.

503. Pumps and other appurtenances carrying or containing flammable liquids shall be so located in relation to the engine that spillage or leakage from such parts shall be prevented from coming in contact with the engine or any parts of the ignition and exhaust system, or adequate shielding shall be provided to attain the same purpose. The engine cooling fan shall be so positioned, rotated or shielded as to minimize the possibility of drawing flammable vapors toward the engine.

504. When the engine is located in a position where spillage from the cargo tank or its appurtenances or from side racks might constitute a hazard, suitable shielding shall be provided to prevent such spillage from contacting the engine or engine exhaust system and for draining such spillage away from the vicinity of the engine.

505. Where the engine is carried within an enclosed space adequate provision shall be made for air circulation at all times, to prevent accumulation of explosive vapors and to avoid overheating.

506. The exhaust system shall be substantially constructed and installed and free from leaks. The exhaust line and muffler shall have adequate clearance from combustible materials and the exhaust gases shall be discharged at a location which will not constitute a hazard. When engines are carried as in 505, the exhaust gases shall be discharged outside of each such closed space.

507. The ignition wiring shall be substantially installed with firm connections, and spark plug and all other terminals shall be suitably insulated, to prevent sparking in event of contact with conductive materials. The ignition switch shall be of the enclosed type.

510. Auxiliary Electric Generators and Motors.

510. Electrical equipment, installed or carried upon a tank vehicle transporting Class "A" flammable liquids, for the operation of pumps or other devices used for the handling of product and operating product handling accessories shall meet the following requirements:

511. Electric generators driven from a power-take-off connected to the vehicle transmission or to an auxiliary transmission, or by an auxiliary internal combustion engine, shall be of the explosion proof type.

512. Electric motors shall be of the explosion proof type.

513. Wiring shall be adequate and substantially installed with all terminals firmly connected and insulated to prevent sparking from vibration or in event of contact with conductive materials. Wires shall have oil proof insulation. If overload protection is provided it shall be of the explosion proof type. All switches or other sparking devices shall be of the explosion proof type and all conduit entrances shall be sealed.

514. Where the generator or motor is located within an enclosed space adequate provision shall be made for air circulation to prevent overheating and possible accumulation of explosive vapors.

515. Electrical equipment and wiring shall be so located as to prevent contact with spillage from cargo tank or side racks or suitable shielding shall be provided to attain equivalent protection.

600. OPERATION OF TANK MOTOR VEHICLES.

610. Proper Repair.

611. Tank vehicles shall not be operated unless they are in proper repair, devoid of accumulation of grease, oil, or other flammables, and free of leaks.

620. Filling and Discharging Tank Motor Vehicles.

621. The driver, operator or attendant of any tank vehicle shall not leave the vehicle while it is being filled or discharged. Delivery hose, when attached to a tank vehicle shall be considered to be a part of the tank vehicle.

622. Motors of tank trucks or tractors shall be shut down during making and breaking hose connections. If loading or unloading is done without the use of a power pump, the tank truck or tractor motor shall be shut down throughout such operations.

623. During the filling operation electric conducting contact shall be maintained between the fill pipe and the tank vehicle.

624. In every cargo tank or compartment sufficient space shall be left vacant to prevent leakage or distortion by expansion of the contents due to rise in temperature in transit. No cargo tank or compartment shall be loaded to a volume in excess of 99¼ per cent of its capacity.

630. No Smoking.

631. Smoking by tank motor vehicle drivers or their helpers is prohibited while they are driving, making deliveries, filling, or making any repairs to tank motor vehicles.