



Model Tanker Wash Guidelines For the Fruit Juice Industry

February 2006

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I. Purpose:

To provide minimum standard procedures and practices for the safe and sanitary transport of bulk fruit juice products.

II. Definitions of terms used in this guideline:

- a. “Clean in Place” or “CIP system”- Cleaning and sanitizing equipment that automatically delivers rinses, cleaners, sanitizers at a given pressure, time, and concentration, that eliminates the need for manual cleaning and allows for consistent repeatable cleaning each time.
- b. “Food Grade” - Cleaners and sanitizers approved for use as food additives and permitted for direct human consumption; used in accordance with 21 CFR 170-199
- c. “High Pressure Wash Equipment” or HPWE - Wash equipment that can deliver solutions/water with sufficient force to provide impingement to the bulkheads of the tanker.
- d. “Potable” - Potable water shall at a minimum meet either the applicable U.S. Government requirements (i.e., EPA) or at a minimum the *Guidelines for Drinking Water Quality of the World Health Organization* (Volumes 1 and 2, 2nd Edition).
- e. Circulate - The movement of water or cleaners through a CIP process during one cleaning cycle and then dumping to drain.
- f. “Recycled rinse water” – Collected water that can be used as a rinse for a pre-cleaning step. It shall be limited to rinse water used in a maximum of three rinses.
- g. “Re-use”- Water or cleaners that are collected and used again.
- h. “Same Product”- Fruit juices of the same kind, variety or botanical designation (i.e., apple, orange, grape) and same form (i.e., concentrate, reconstituted, direct). Juices of different form or variety are not considered the “same product” for purposes of this guideline.
- i. “Tamper Evident Seal” - Seal that is constructed in such a way that it can be used only once, not resealable, can be easily noticed if tampered with, is uniquely identified and fabricated from non-toxic, non-corrosive, cinchable, and appropriate materials.
- j. “Sealed” - The proper application of seals to all openings to prevent the introduction of foreign materials or contaminants.
- k. “COP” Clean out of Place – Process of removing components and food contact/transfer equipment for cleaning in a separate wash tank following strict specific protocol. Tank has the ability to circulate and heat cleaning solutions to provide for adequate sanitation.
- l. “Cleaners and Chemicals” – Must be “food grade” and have been validated by a third party as meeting its advertised performance. This means if a product states it is effective against coliforms, data must be submitted that validates the claim.

III. Tanker Wash Facility Requirements:

- a. Wash facility must use Potable Water from a source certified annually. Certification must be available upon request.
- b. Wash facility must declare type of wash performed on wash tickets.
- c. Wash facility must be able to document chemical (detergent, degreaser and sanitizer) concentration, wash time and wash/rinse temperatures for each step performed and this documentation must be available upon request.
- d. Wash facility must be constructed and operated in a manner as to prevent contamination and to operate in compliance with 21 CFR 110.
- e. Food Grade and non-food grade tankers must be washed using separate equipment in segregated wash bays.
- f. Wash facility must have incorporated into their process a Food Safety plan based on Hazard Analysis Critical Control Point (HACCP) principles.
- g. Wash facilities must have prerequisite programs implemented including employee training protocols.

IV. Tanker Requirements:

- a. Only food grade tankers are to be used and are to be permanently dedicated and clearly identified "food grade."
- b. Only approved food products should have been hauled in the tanker. (See VII-Tanker Wash Type Based Upon Food Commodity Previously Hauled).
- c. Tanker interior and fittings are composed of food grade stainless steel and must be in good condition. If a tanker has been damaged to the extent that its function and integrity are compromised, then it should not be used.
- d. Only tankers (including valve systems) that are cleanable and seal-able may be used.
- e. Tanker openings must be sealed, using tamper evident seals.
- f. Gasket material that will potentially come into contact with food must be of food contact approved material. All gaskets will be appropriately sized, will be intact with no visible tears breaks or rips and be capable of being cleaned and sanitized.
- g. It is the recommendation of this Association that a carriers' pumps, fittings, and hoses not be used. Section VI Tanker Accessory Cleaning Pumps, Hoses, Fittings details cleaning practices recommended for these items. However, the sanitation of pumps, fittings & hoses should be the ultimate responsibility of the receiving facility.

V. Tanker Handling Types: Apply the tanker wash applicable to the situation.

1. Tanker Turnaround/Same Product

- a. Where a clean and sanitized tanker is used to haul the same product between facilities, the tanker can be loaded, used to transport such product and be subsequently unloaded and reloaded for a continuous series of cycles, so long as entrance into the tanker interior by any contaminant (i.e. employee entry) does not occur and all refills occur within 12 hours. To qualify for the Tanker Turnaround/ Handling, tankers must be sealed at each facility (both from and to) for each leg.

- New uniquely identified tamper evident seals must be applied and identities be recorded on the Bill of Lading or accompanying paperwork for each shipment.
- b. After 12 hour elapses between fills, the tanker must have a Type 2 wash prior to reloading, even if the same product is reloaded.
 - c. It is recommended, from a quality standpoint, that tankers hauling high Brix concentrated juices have a Type 2 wash at a minimum every 7 days; for single strength thermally treated fruit juice apply a Type 2 wash at a minimum of every 72 hours; for raw fruit juice (not heat treated) apply a Type 2 wash at a minimum of every 24 hours.
2. **Type 1:** A customer specified potable water rinse between loads of same product.
 3. **Type 2- Water Based Products:** Tankers previously hauling water based food products must have the following tanker wash: (See Section VII- Tanker Wash Type Based Upon Food Commodity Previously Hauled)
 - a. All previous product must be drained from tanker interior. Tanker interior scraping or spraying with high-pressure potable water or reuse solutions should be performed as necessary. Drain thoroughly.
 - b. Perform visual inspection to assure effective removal of product from tanker.
 - c. Rinse tanker thoroughly with warm (75 - 110°F) potable water or re-use solutions. Drain thoroughly.
 - d. Remove, hand wash and sanitize all vents and vent tubes. Hand-wash and sanitize rear valve assembly and top hatch If present, air vents located at the top of the tanker must also be hand washed and sanitized, regardless if vent was previously used.
 - e. Apply to the tanker a hot cleaning solution consisting of a USDA-A1 rated Cleaner (at prescribed level) or equivalent food grade cleanser under high pressure through CIP system for a minimum of 15 continuous minutes. The period of 15 minutes should commence only when the effluent at the outlet reaches a temperature of 160°F. A minimum effluent temperature of 160°F should be sustained for the duration of the rinse period. Temperatures below 160°F at drain outlet are never acceptable, unless cleaner is being used at the concentration, the temperature and times recommended by the manufacturer. Cleaners can be “circulated” during this 15 minute cycle. Drain thoroughly. Cleansers used in this cleaning cycle should be single use cleansers and should not be re-cycled cleansers.
 - f. Rinse tanker with potable water until no residual cleaning solution is detected. Do not use recycled rinse water. Drain thoroughly.
 - g. As appropriate, perform visual inspection of tanker interior in a manner providing for safe and sanitary evaluation, without entering tanker. When tanker entry by a person takes place or is required, the cleaning process described in subparagraph (d), (e), and (f) must be repeated.
 - h. Sanitize tanker interior surfaces with a no-rinse food-grade chemical sanitizer solution applied in accordance with manufacturers instruction. Drain Thoroughly. Hot potable water (Exit Temperature should be a minimum of 185°F) for a minimum of 10 continuous minutes may be used as an alternative to a food grade

sanitizer if specifically requested by the customer. A cool down with potable water may immediately follow. Drain as required. Apply seals to all openings immediately and before leaving wash area. Seals must be applied so as to insure all openings are inaccessible unless seals are broken.

4. **Type 3 – Water/Oil & Oil Based Products:** Tankers previously hauling water/oil or oil based food products must have the following tanker wash. (See Section VII – Tanker Wash Type Based Upon Food Commodity
 - a. All previous product must be drained from tanker interior. Tanker interior scraping or spraying with high-pressure food grade degreaser solution should be performed as required.
 - b. Perform visual inspection to assure effective removal of product from tanker.
 - c. Rinse tanker thoroughly with warm (75 - 110°F) potable water or re-use solutions. Drain thoroughly.
 - d. Remove, hand wash, and sanitize all vents and vent tubes. Hand-wash and sanitize rear valve assembly and top hatch. If present, air vents located at the top of the tanker must also be hand washed and sanitized, regardless if vent was previously used.
 - e. Apply hot (170° - 212°F) food grade degreaser solution (at prescribed manufacturers' recommended temperatures and concentrations) under high pressure through CIP system for a minimum 15 minutes. Drain thoroughly. Temperatures below 160°F are never acceptable at exit unless a cleaner is used at the temperature and times recommended by the manufacturer.
 - f. If degreaser solution is not compatible with cleaning solution in next step prior to applying cleaning solution, rinse tanker with warm (75 - 110°F) water for a minimum of ten minutes. Drain thoroughly.
 - g. Apply to the tanker a hot cleaning solution consisting of a USDA-A1 rated cleaner (at prescribed level) or equivalent food grade cleanser under high pressure through CIP system for a minimum of 15 minutes. The period of 15 minutes should commence only when the effluent at the outlet reaches a temperature of 160°F. A minimum effluent temperature of 160°F should be sustained for the duration of the rinse period. Temperatures below 160°F at drain outlet are never acceptable. (Note: Cleaner should be used at the concentration, temperature, and times recommended by the manufacturer.) Drain thoroughly. Cleansers used in this cleaning cycle should be single use cleansers and should not be re-cycled or re-used cleansers.
 - h. Rinse tanker with potable water until no residual cleaning solution is detected. Do not use recycled rinse water. Drain thoroughly.
 - i. As appropriate, perform visual inspection of tanker interior in a manner providing for safe and sanitary evaluation, without entering tanker. When tanker entry by a person takes place or is required, the cleaning process described subparagraph (d), (g), and (h) must be repeated.
 - j. Sanitize tanker interior surfaces with a no-rinse food-grade chemical sanitizer solution applied in accordance with manufacturers instruction. Drain Thoroughly. Hot potable water (Exit Temperature should be a minimum of 185°F) for a

minimum of 10 continuous minutes may be used as an alternative to a food grade sanitizer if specifically requested by the customer. A cool down with potable water may immediately follow. Drain as required.

- k. Apply seals to all openings immediately and before leaving wash area. Seals must be applied to insure all openings are inaccessible unless broken.
5. **Type Four Wash – where previous load carried foods with potential allergenic risks (Type 3 wash followed by a hot water rinse.)**
- a. Seek specific approval as to the appropriateness of this type wash based upon customer's requirements.
 - b. All previous product must be drained from tanker interior. Tanker interior scraping or spraying with high-pressure food grade degreaser solution should be performed as required.
 - c. Perform visual inspection to assure effective removal of product from tanker.
 - d. Rinse tanker thoroughly with warm (75 - 110°F) potable water or re-use solutions. Drain thoroughly.
 - e. Remove, hand wash, and sanitize all vents and vent tubes. Hand-wash and sanitize rear valve assembly and top hatch. If present, air vents located at the top of the tanker must also be hand washed and sanitized, regardless if vent was previously used.
 - f. Apply hot (170° - 212°F) food grade degreaser solution (at prescribed manufacturers' recommended temperatures and concentrations) under high pressure through CIP system for a minimum 15 minutes. Drain thoroughly. Temperatures below 160°F are never acceptable at exit unless cleaner is used at the temperature and times recommended by the manufacturer.
 - g. If degreaser solution is not compatible with cleaning solution in next step, prior to applying cleaning solution, rinse tanker with warm (75 - 110°F) water for a minimum of ten minutes. Drain thoroughly.
 - h. Apply to the tanker a hot cleaning solution consisting of a USDA-A1 rated Cleaner (at prescribed level) or equivalent food grade cleanser under high pressure through CIP system for a minimum of 15 minutes. The period of 15 minutes should commence only when the effluent at the outlet reaches a temperature of 160°F. A minimum effluent temperature of 160°F should be sustained for the duration of the rinse period. Temperatures below 160°F at drain outlet are never acceptable unless cleaner is being used at the concentration, temperature, and times recommended by the manufacturer. Cleaners can be circulated during this step. Drain thoroughly. Cleansers used in this cleaning cycle should be single use cleansers and should not be re-cycled or re-used cleansers.
 - i. Rinse tanker with potable water of 185°F at exit for a minimum of 20 continuous minutes. A cool down with potable ambient water is required. Drain thoroughly.
 - j. As appropriate, perform visual inspection of tanker interior in a manner providing for safe and sanitary evaluation, without entering tanker. When tanker entry by a person takes place or is required, the cleaning process described subparagraph (e), (h), and (I) must be repeated.

- k. Sanitize tanker interior surfaces with a no-rinse food-grade chemical sanitizer solution applied in accordance with manufacturers instruction. Drain Thoroughly. Hot potable water (Exit Temperature should be a minimum of 185°F for a minimum of 10 continuous minutes) may be used as an alternative to a food grade sanitizer if specifically requested by the customer. A cool down with potable water may immediately follow. Drain as required.
- l. Apply seals to all openings immediately and before leaving wash area. Seals must be applied so as to insure all openings are inaccessible unless seals are broken.

VI. Tanker Accessory Cleaning – Pumps, Hoses, Fittings

- a. Accessory cleaning must be performed on every food contact surface for every component used for unloading.
- b. Cleaning protocol for these components must mimic those of the tanker (i.e., Type 1, Type 2) and are based on the food commodity previously hauled.
- c. Pumps, hoses, and fittings can be CIP'd provided a separate drive capable of turning the pump fast enough to completely fill the size of the hose and fittings used and provide a velocity of at least 5 feet per second.
- d. If a CIP drive is not available that meets the minimum flow requirements, all parts must be physically removed and washed in a "COP" (clean out of place) tank. Every step used for the tanker wash protocol based on wash type must be used on these parts. This includes all parameters for temperature, chemical concentration, duration etc. Each parameter will need to be recorded and documented using test kits, temperature-recording devices etc.
- e. All parts after complete cleaning must be closely inspected to insure proper cleaning. Parts should be re-assembled and sanitized after assembly.
- f. Pumps and hoses must be capped and sealed using tamper evident seals to secure. All seal numbers used on these components must be documented on the wash ticket or accompanying paperwork.

VII. Seals

- a. Only tamper evident seals shall be used to secure tanker openings. The seal shall be constructed in such a way that it can be used only once, not re-seal able, can be easily noticed if tampered with and fabricated from non-toxic, non-corrosive and appropriate materials.
- b. Each seal must be legibly and uniquely identified.
- c. **After Wash:** Suitable seals for use after a tanker is washed but not loaded with food shall be constructed to preserve the cleanliness and security of the clean tanker. The seals used for this purpose may be characterized as temporary and may consist of plastic material.
- d. **After loading:** Seals used to secure openings after a tanker is filled with food must be secure and durable enough to withstand the stresses of handling and transportation. It is recommended that only locking metal cables are used for this purpose. Each seal must be uniquely identified using alpha-numeric codes,

permanently affixed to or stamped into the seal, that can be easily recorded on wash tickets. An example of such a code would be: “CSE 0002349.”

- e. **Broken Seals:** In any case where a seal has been breached or broken (except by reason of loading or unloading product) the breach must be reported, noted on records and appropriate corrective actions taken. Corrective action for a breached seal on a washed but empty tank would include rewashing. Corrective action for a breached seal on a filled tanker could include testing, treating, re-working or destroying the food. Resealing alone is never adequate as a corrective action.

VIII. Tanker Wash Type Based upon Food Commodity Previously Hauled

1. Listed below are various food commodities to be transported in food grade tankers. This is not to be considered a complete list but as a guide as to what food commodities require which type of tanker wash prior to transporting ingredients.
2. Indicated below under “Not Permitted” are foods that disqualify a tanker from hauling products without special arrangements and precautions.
3. Note: Tanker Wash Type 1 guidelines are used when more than one trip rotation (load, transport, and unload) for the same product is used from the same storage site to the same receiving facility. (See page 4.)
4. Tanker trucks transporting all fruit juices must have a Type 2 wash before use.
5. ▲ Food commodities marked below with the symbol ▲ may have heightened allergenic risks and are thus subject to appropriate and necessary washing procedures where trucks haul such foods. A Type 4 wash is mandatory.

<u>Food Commodity</u>	<u>Tanker Wash Types</u>
Alcohol Products, All Types (food grade)	2
Amino Acids	4
Apple Juice- Concentrated and Single Strength	2
Aromatic Chemicals- Food Grade Only (GRAS, FCC Certified)	3
Beverage Bases	2
Blood	Not Permitted
Canola Oil	3
Caramel Color	2
Chemicals and Cleaning Agents- Non-Food Grade	Not Permitted
Cherry Juice- Concentrate and Single Strength	2
▲Chocolate – with added ingredients (i.e., milk, sugar)	4
Citric Acid Solution	2
Citrisol- Non-food Grade Cleaning Solvent from Citrus Oils	Not Permitted
Citrus Fruit Aroma and Essence- Aqueous	2
Citrus Fruit Terpenes	3
Citrus Punch- Concentrate and Single Strength	2
Cocoa (powdered)	Not Permitted

Cocoa (chocolate liquor)	4
Colors, Artificial and Vegetable Based- Food Grade Only	Not Permitted
Corn Oil	3
Corn Sweeteners	2
Corn Syrup	2
Cottonseed Oil	3
Cranberry Juice- Concentrate and Single Strength	2
D-Limonene Oil, Food Grade	3
D-Limonene Oil, Non-Food Grade	Not Permitted
▲ Dairy Products, <u>Pasteurized</u> - Cream, Milk, Milk Balancer	4
▲ Dairy Products, Unpasteurized- Cream, Milk, Milk Balancer	4
Dyes, Inks and Pigments- Non-Food Grade	Not Permitted
▲ Eggs and Egg Based Products	4
Essential Oils	3
Fats- Product is solid at 70°F (21°C)	Not Permitted
Fats, Rendered	Not Permitted
Fish Oils	Not Permitted
Flavors, Natural and Artificial	3
Fruit Juice- Concentrates and single strength (including raw or fresh)	2
Fruit Punch and beverage bases	2
Glycerin, Food Grade	3
Glycerin, Unpasteurized- Non-Food Grade	Not Permitted
Grape Juice, All Types- Concentrate and Single Strength	2
Grapefruit Juice- Concentrate and Single Strength (including fresh)	2
High Fructose Corn Syrup	2
Honey	2
Hydrogenated Vegetable Oils- Product is solid at 70°F (21°C)	Not Permitted
Iso-sweet	2
Kiwi Juice- Concentrate and Single Strength (including fresh)	2
Lecithin (emulsifier)	Not Permitted
Lysine (recovered cooking oils)	Not Permitted
Lemon Juice- Concentrate and Single Strength (including fresh)	2
Malt	3
Mineral Oil	3
Mineral Salts (i.e.: Epsom Salt)	Not Permitted
Molasses (food grade)	2
Molasses (non food grade)	Not Permitted
Non-Citrus Fruit Aroma and Essence- Aqueous	2
▲ Nut Products	4
Orange Concentrate- OM	2
Orange Juice- Concentrated and Single Strength	2
Palm Oil	3
Palm Kernel Oil	3

Paraffin Wax	Not Permitted
Peach Juice- Concentrate and Single Strength (including fresh)	2
▲ Peanut Based Products (other than Oil)	4
▲ Peanut Oil	4
Pear Juice- Concentrate and Single Strength (including fresh)	2
Pepper or Plant Mash	4
Preservatives	2
Pharmaceuticals (non food grade)	Not Permitted
Pharmaceuticals (food grade)	3
Pineapple Juice- Concentrate and Single Strength	2
Propylene Glycol (food grade)	3
Prune Juice- Concentrate and Single Strength	2
Raspberry Juice- Concentrate and Single Strength	2
Sorbitol - Food Grade	2
Sorbitol, Non-food Grade	Not Permitted
▲ Soy based products	4
▲ Soybean Oil	4
Strawberry Juice- Concentrate and Single Strength	2
Sugar, Liquid	2
Sunflower Oil	3
Sweeteners	2
Syrups	2
Vegetable Oils- Product Liquid at 70°F (21°C)	3
Vinegar	2
Water (food grade)	2
Watermelon Juice- Concentrate and Single Strength	2
Waxes	Not Permitted
▲ Whey, Pasteurized	4
▲ Whey, raw	4
Witch Hazel (food grade)	2
▲ Yeast- Active and Inactive	4

IX. Wash Ticket Documentation

All tankers used to transfer food ingredients must present their Wash Ticket(s) to the designated department of the receiving company upon arrival at the receiving facility.

A) The wash ticket at a minimum must have the following information.

- 1) Date
- 2) Time
- 3) Name of Wash Station and location
- 4) Wash type

(i.e., “Type 1, 2, 3 or 4” or combination as described herein and whether any additional wash or treatment that was applied.

- 5) Original signature certifying information on wash ticket from authorized agent of wash facility.
- 6) Seal identifiers

B) Additional Documentation:

1. The Wash Ticket(s) must be presented prior to sampling and unloading
2. Tanker driver is to obtain or confirm the presence of the tankers' Wash Ticket(s) prior to leaving the tanker wash site or accepting the shipment. This includes vendors who transport their own products.
3. If the Wash Ticket(s) are lost during shipment, the destination site will provide a FAX number so the missing information can be sent; however, it is the responsibility of the tanker driver to have the Wash Ticket(s) sent.**
4. The carrier is required to show the tanker's previous three (3) loads, which must be indicated on the Wash Ticket(s) or on an accompanying document bearing the carriers letterhead, tanker number, and signed by a designated person. The most recent load being listed first, then the preceding two shipments in descending order.**
5. Accurate specific descriptions of the previous three- (3) loads transported by the tanker are required. General descriptions such as "Oil", "Milk" and "Juice" are not acceptable.
Examples of correct descriptions include "Deodorized Soy Bean Oil", "Pasteurized Milk" and "Concentrated Orange Juice."
6. Tankers are to be filled within 72 hours of the cleaning time stamped on the Wash Ticket. If the 72-hour time period has elapsed before the tanker loading commences, then the tanker must at a minimum be sanitized and documentation of this must be present.
7. Upon request, the carrier will furnish a copy of the tanker's load history for at least one year should the tankers previous load history become questioned.

**The signature of the On Duty Dispatcher or Supervisor of the tanker carrier company must be included on all corrected documents that are transmitted to a site designated by the product owner. This procedure is required to confirm the authenticity of the information being provided.

X. Compliance/ Noncompliance with Tanker Wash Guidelines, Audit:

To the extent that these guidelines are incorporated into contract obligations, failure to comply with these guidelines may result in consequences including monetary damages, the rejection or destruction of product and/or termination of contract. To the extent that non-compliance may result in a violation of law, including laws prohibiting adulteration of foodstuffs, non-compliance may *indirectly* result in civil and criminal penalties.

Compliance will be determined as mutually agreed. Audits or other inspections may reveal compliance and/or deficiencies. Appendix I includes an acknowledgement.

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APPENDIX I

MODEL TANK WASH TICKET

Name of Wash Station _____

Location _____

Wash Type **Type 1** **Type 2** **Type 3** **Type 4**

Other (Describe) _____

Unit # _____

Last Prod. _____

Wash Cycle# _____

Dome Lid & Gskt. _____

Vent _____

Pump _____

Hoses # _____

Valve & Plunger Gskts _____

Time In _____ **Time Out** _____ **AM**
PM

Date _____

Seal ID's _____

Shift Supervisor

Signature
(Triplicate)

Acknowledgement

Of

[Company Name] – Tanker Wash Policy

On behalf of [Company Name] I certify the Tanker Washing Policy, [Dated ___/___/___] has been reviewed, understood, and will be complied to by my company:

_____, _____ of _____
(Person Name- Printed) (Title) (Company Name)

(Signature) (Date)

...