

ASSEMBLY DETAILS FOR SECTIONAL TANKS

1. Component Check.

Tank sections.
Nuts, Bolts & Washers.
Sealant.
Flange support channels (If required).

2. Flanges.

Ensure that flanges to all sections are clean and free from dust/grit etc....and totally dry.

3. Base Support.

Position bottom sections of tank on flat level surface so that **THE BASE OF TANK IS FULLY SUPPORTED OVER ITS ENTIRE AREA.** If placed on joists @ 500mm centres a minimum off 22mm plywood decking should be provided.

For example: 2mx1mx1m size tank, tank should be positioned on new RSJ support beams (152x89) @ 500mm centres, these shall be leveled to 2-3mm, and then position a new 22mm plywood sheet on to the steels. Plywood should be 100mm larger than the external size of the tank.

4. Assembly Bases.

(Internally or Externally Bolted)

The base panels should be laid out with drilled flange uppermost for internally bolted base assembly. Alternatively downwards if externally bolted panels are used.

Ensure that all flange faces are thoroughly wiped clean and that the sealant strip does not come into contact with dust from the floor area.

Press sealant in position and ensure sealant is returned beyond corners.
Bolts may be pushed through the sealant strip when bolting panels together.

The next stage of assembly is to bolt the rows panels together. Prevent dust falling into the joints.

IMPORTANT: Initially assemble panels with the bolts being hand tight. Never tighten any bolts before the whole tank assembly is complete.

The next stage of assembly is the side to base panels. Use a podger to align panels, insert bolts from inside of the tank.

Where base panels are assembled in screeded bases or steel & plywood bases, all base fixings will be stainless steel. It is recommended that grommets as shown in the diagram.

Commence assembly at one corner and proceed simultaneously in two directions to the diagonally opposite corner.

Press sealant strip into position around the periphery of assembled base and similarly apply sealant to the vertical face of flanges of the side panels returning the strip around the corners
Note the placing of the sealant at the cross joints of the panels.

IMPORTANT: All bolts are fitted hand tight only.



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Build the tank walls as described. When the side panels is the top course, commence the installation of the heavy duty cover.

After the tank has been fully assembled and prior to filling, proceed to tighten bolts as follows:

4. Sealant.

All sealants are **WRAS** approved products.

Roll out flange Deccaseal sealant gasket and apply (Butyl Rubber Surface Down) to the long flanges of the bottom tank section, ensure that the Deccaseal to the one edge of the tape is facing towards the inside of the tank and set back approx 5mm from the inside face.

Apply a second strip to fully cover other flange surface, any excess can be trimmed off after the sections have been bolted together (Care must be taken to ensure that the gasket is protected from dust and grit as this will impair the seal).

Apply Deccaseal to remaining flanges ensuring that a 12mm-15mm lap occurs at the corners etc.... over the previously laid gasket

6. Tightening & Testing.

Proceed to tighten bolts mechanically in two stages working around the tank, stage 1 to approximately 30lbs/ft finally stage 2 to 50lbs/ft.

Fill tank, should any leakage occur carefully re-tension bolts around area until it stops.

In tropical conditions reduce the bolted pressure by 10% approx.

7. Pipework & Connections.

Installers should use standard type hole cutters.

When drilling from outside always ensure that there is adequate support on the inside of the tank.

Extreme care should be taken when working inside the tank not to damage the inner surface, and appropriate footwear should be worn. Any ladders used for access should also be provided with suitable to avoid damage to the tank base/walls.

Where tanks are fitted with internal steel bracing, under no circumstances should the bracing be stood on or walked across, as the could compromise the 'SEAL' where the bracing passes through the tank wall. We cannot accept responsibility should any leaks occur and any remedial work will be chargeable.

All pipework, valves etc must be independently supported and must not impose a point load on the tank wall.

8. Maintenance & After Sales.

Recommendations are set out in BS6700; 1997 Section4.

Please review product Operations & Maintenance manuals for further information.

Please contact our after sales service for maintenance Agreements and extended warranty packages.

9. Application.

Decca Sectional tanks are suitable for the storage of water at ambient temperatures up to 50C and at atmospheric pressure. If higher heat resistance is required or storage other than water please contact our technical support team. Please confirm in writing details of chemicals make up, temperature or pressure, prior to manufacture.

10. Important.

Where installation of a sectional tank has been made by untrained or unsupervised labour, no responsibility can be accepted by the company for the installation.

The company reserves the right to amend specifications and dimensions as necessary without prior notice.



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Design and installation of all types of tank bases are undertaken by the customer/others.
The company will not hold itself responsible for any consequential cost or workmanship where the installation or design has been undertaken by other.

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