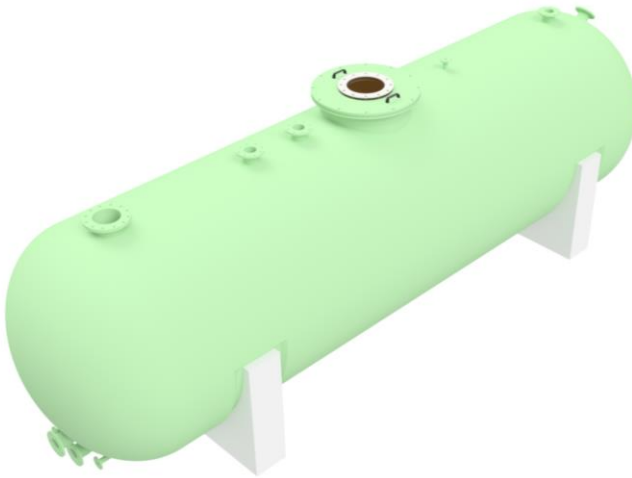


INSTALLATION GUIDE

Horizontal & Above Ground
Storage Tanks

REWATEC CALONA



CE

Installation Guide

Horizontal & Above Ground Tanks

Manual Version OMI029 Rev 4 ATG 01

Created On: June 2022



**Installers: To Safeguard Warranty Please
Ensure You Are Using The Latest Installation Guide
Premiertechaqua.com/en-ie**

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General Notes

1. These guidance notes refer only to the installation of above ground horizontal tanks.
2. These guidance notes do not provide specific, site-related installation instructions.
3. If in any doubt whatsoever about any aspect of the installation please contact your Premier Tech point of contact.

Transportation, Unloading & Storage of Tanks

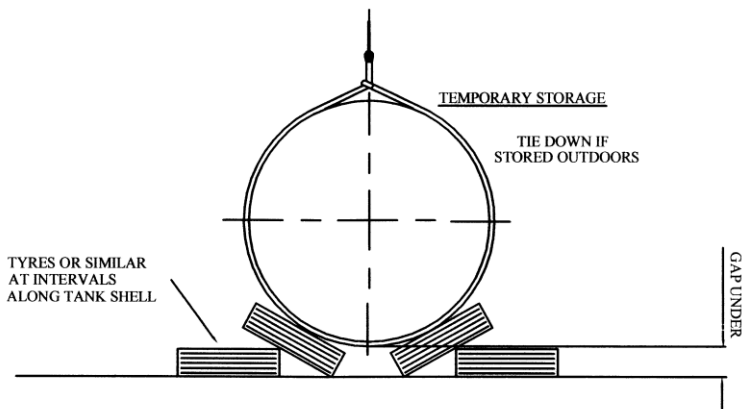
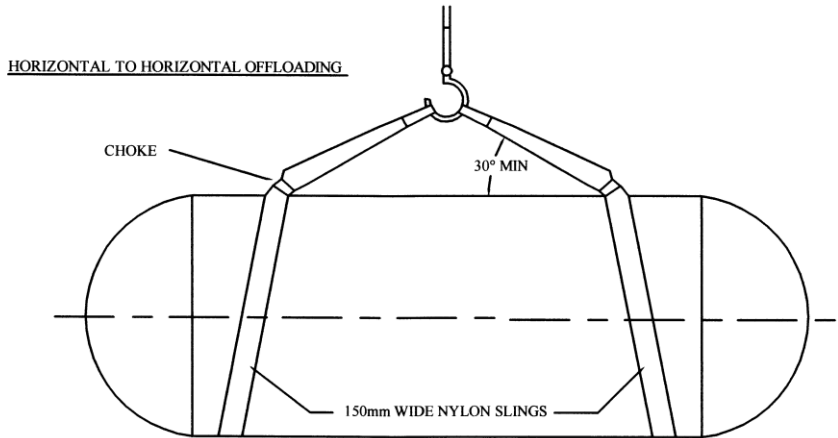
1. Tanks must be held down during transportation using nylon straps, do not use cables or chains to hold tanks.
2. Do not over tighten straps to cause deformation of the tank shell.
3. Tanks must be lifted by crane and webbing lifting straps – do not use chains or wire ropes in contact with the tank. When lifting, care should be taken not to apply shock loads to the tank or any connections.
4. Connections / nozzles must not under any circumstances be used as lifting positions
5. Premier Tech recommend the use of a lifting beam for tanks longer than 8 meters.
6. Move tanks only by lifting and setting, do not drag or roll.
7. Do not drop or roll tanks from the delivery vehicle.
8. Place tanks carefully onto a smooth level even surface, free from rocks, large stones or other debris that could cause point loads.
9. Chock tanks using tires, sandbags or similar to prevent rolling.
10. In high wind conditions, consideration should be given to strapping down the tanks to prevent damage.

Pre-Installation Inspection

1. Tanks should be subject to a visual inspection prior to installation.
2. Any damage should be notified to the delivery driver and to Premier Tech.
3. Do not attempt to carry out any unauthorised repairs, as this will invalidate the warranty on the tank.
4. Check for, fractures to the shell, delaminations, scratches or abrasions deeper than 1.5mm, stress cracks or star crazing.

The details of these guidance notes should be strictly adhered to in all respects. **If the tank is installed outside these parameters it may suffer irreparable damage.**

Technical Data Sheet ATG 01



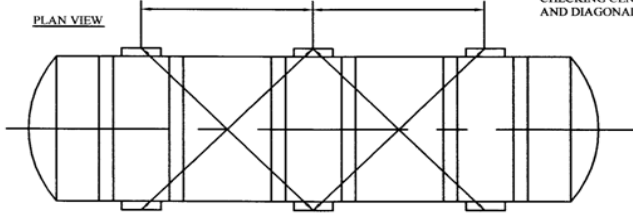
Technical Data Sheet ATG 01

Tank Installation

1. Refer to cradle layout drawing for cradle numbering system to ensure cradles are in correct location.
2. Ensure centre line of cradle aligns with centre line of the cradle support bands
3. Ensure neoprene cradle liner is positioned centrally in cradle
4. Shim under tank cradles to ensure cradle is in full contact with the tank shell
5. Fix tank cradles to base slab using mechanical or chemical anchor bolts
6. Care should be taken to ensure that the vessel is not subject to any form of mechanical damage.
7. Do not drop or abrade the tank.
8. Personnel should wear soft soled shoes if working in or on the tank (after appropriate risk assessments and safe systems of works have been adopted).
9. Tools etc. should not be dropped onto the tank and should be suitably padded to prevent scratching.

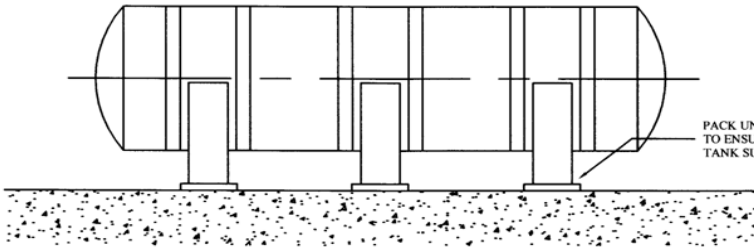
HORIZONTAL TANK - CRADLE SUPPORTED

PLAN VIEW



ALIGN CRADLES BY
CHECKING CENTRES
AND DIAGONALS

ELEVATION



PACK UNDER BASEPLATES
TO ENSURE FULL
TANK SUPPORT

Tank Connections / Nozzles

1. All flanged joints should be drawn up gradually and evenly.
2. Gaskets should be of soft rubber, (shore hardness 40 – 70.
3. The maximum torque applied must not exceed the figures shown in the table below
4. All pipework and valves etc. are to be independently supported so that no loads are applied to the tank connections / nozzles.

Flanged Joints Bolt Torque

Nozzle Size	Bolt Torque
40mm (1.5")	2.76kg.m (20lbs.ft)
50mm (2")	3.45kg.m (25lbs.ft)
80mm (3") 4 Hole	4.00kg.m (29lbs.ft)
80mm (3") 8 Hole	2.00kg.m (15lbs.ft)
100mm (4")	2.35kg.m (17lbs.ft)
150mm (6")	3.45kg.m (25lbs.ft)
200mm (8")	4.84kg.m (35lbs.ft)
250mm (10")	5.53kg.m (40lbs.ft)
300mm (12")	6.22kg.m (45lbs.ft)
500mm (20")	4.84kg.m (35lbs.ft)
600mm (24")	6.22kg.m (45lbs.ft)

