

## PRE-ASSEMBLY CONSIDERATIONS

1. A tank assembly dimensional drawing including all tanks connections shall be supplied to Customer for approval.

Customer shall approve the drawing within one week. Once approved, the delivery and assembly time will be approximately 45 days.

2. Customer shall afford the Geotechnical soil report.

3. To easier the hydraulic lifters operation, a 50 mm (preferable 1 m) clear distance to any obstruction around the tank perimeter shall be maintained.

4. A complete foundation drawing shall also be provided. MASTIC type tanks base building process include two steps, while Membrane tanks only require one.

Frist step is the same for both, the second one is only needed for Mastic tanks and must be built up one the tank is fully assembled.

5. Once the foundation works are done, and to check it proper ending, a photographic report of the works will be requested from the Customer

6. ***The external perimeter steel rods will not be placed until the tank is fully assembled.***

*(The rods will be fixed with epoxy resin)*



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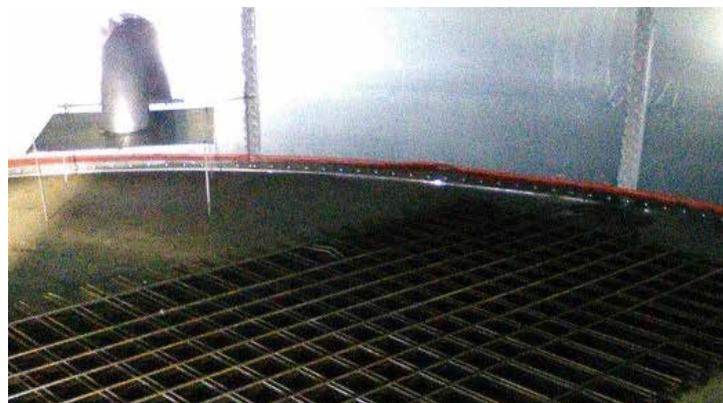
FIRE PIPING

TANKS



## CONSIDERATIONS DURING ASSEMBLY

1. Material transportation to job site will be Engineered FIREPIPING responsibility.
2. Material unloading will be Customer responsibility:
  - o To easier the assembly process tank shell steel plates shall be stacked centred on the tank foundation.
  - o Remaining materials can be placed outside and around tank base.
  - o If, as per Customer requirement, the shipment is done before the jobs start, to avoid possible damages and rust, material shall be stored in a closed and dry place.



3. A 220/380 v 50 Hz power socket as close as possible to the tank, should be provided.
4. Before tank assembly start, Customer shall inform installers about the situation of tank connections, ladder, platform and manhole.
5. In order to allow the realisation of the internal jobs, in the MASTIC type tanks, one of the first level tank steel sheets won't be installed. The open space will be used to entering all the required material for internal jobs to be done.

6. Further visits to job site, not related with tank assembly, shall be charged apart.
7. To avoid damages to the Hydrotite strips, Steel meshes placement shall be carefully done. To avoid the Hydrotite expansion in event of rain, the foundation 2nd PHASE jobs, must be built-up within the 48-72 hours of tank assembly end.



8. Once the deposit assembly jobs are properly ended, a conformity form shall be issued, to be signed by the Customer.

## POST-ASSEMBLY CONSIDERATIONS

1. Waste management will be Customer responsibility. Material not used shall be collected for proper disposal.
6. A 2 years certificate of guarantee will be issued, covering manufacturing and assembly defects



7. Internal and external tank components should be periodically inspected.

2. Tank must be filled with fresh and clean water. To avoid floating valve clogging, tank filling line should be fitted with a “Y” filter.

3. In the case of membrane tanks, when the assembly is finished, tank must be water filled up to a 10-30 cm level. This will require a water connection placed near the tank as well as some means to transport the water. It is important to avoid membrane movements until the tank is completely water filled.

4. The suction connection must be covered until it is connected to the pipe network to prevent animals or foreign objects from entering and damaging the membrane.

5. The tank must be filled within 30 days after installation.