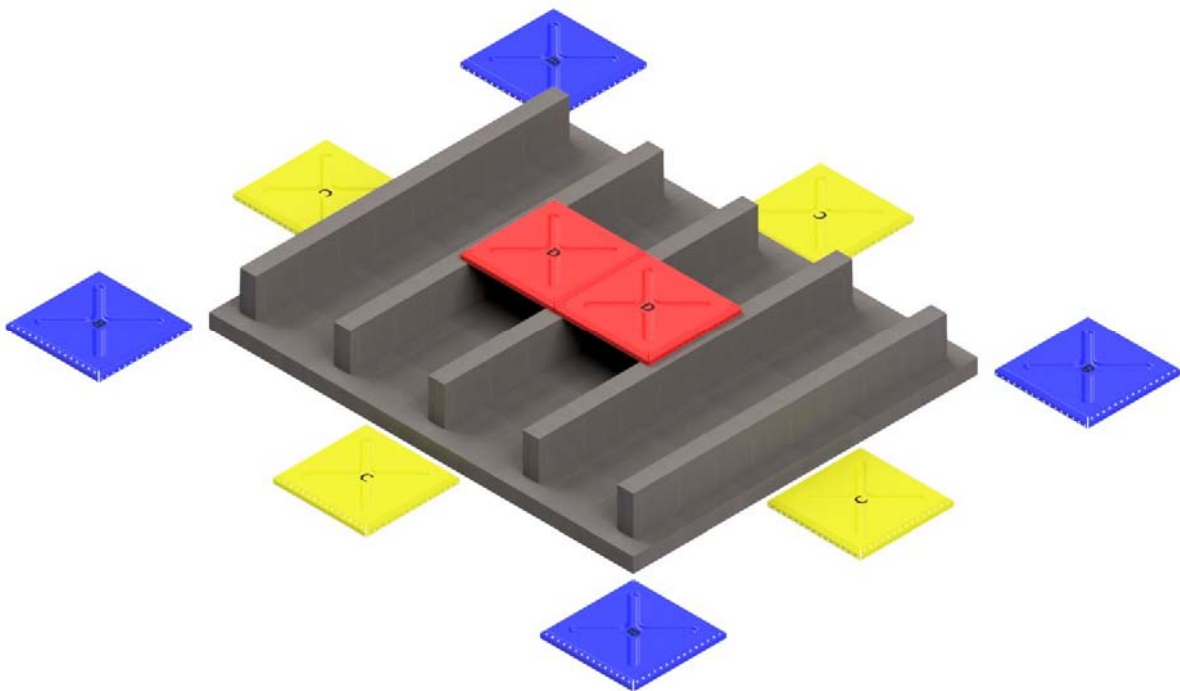


1. The open tank layout drawings show the position of the various types of tank panels. Each panel is marked with its type number - eg. B6, C6 or D6
2. Tank panels should firstly be sorted by type. If sufficient space is available it is useful to layout the tank panels as shown on the drawing alongside the tank supports.

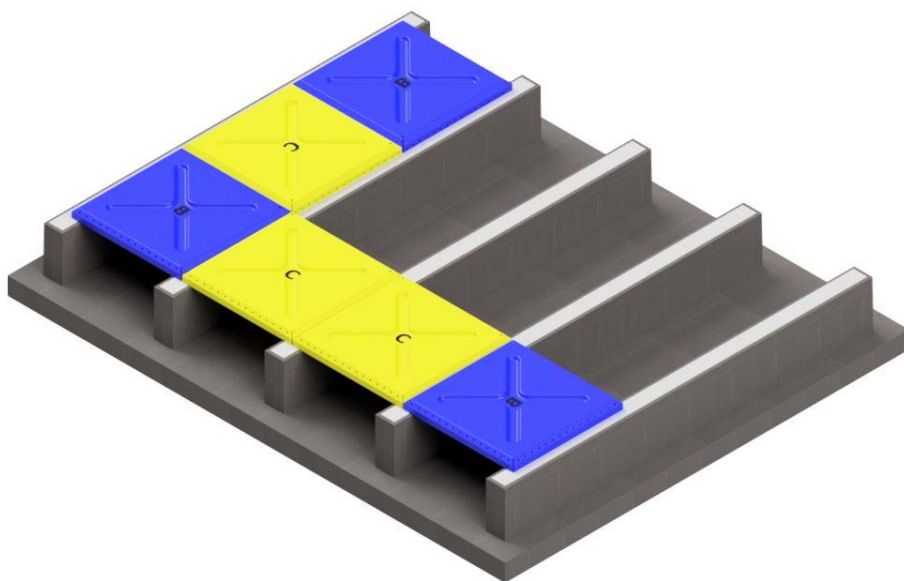
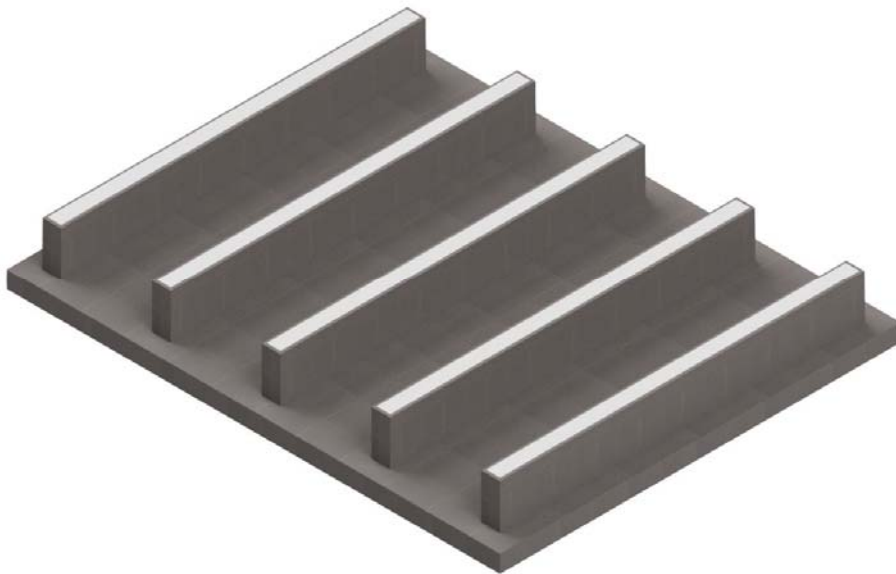


3. The tank panels thickness may vary depending on the depth of the tank. Our standard tank panel thicknesses are as follows.

Tank height	Base	Level 1	Level 2	Level 3	Level 4	Level 5
1	3mm	3mm				
2	3mm	3mm	3mm			
3	4.5mm	4.5mm	3mm	3mm		
4	4.5mm	4.5mm	4.5mm	3mm	3mm	
5	6mm	6mm	4.5mm	4.5mm	3mm	3mm

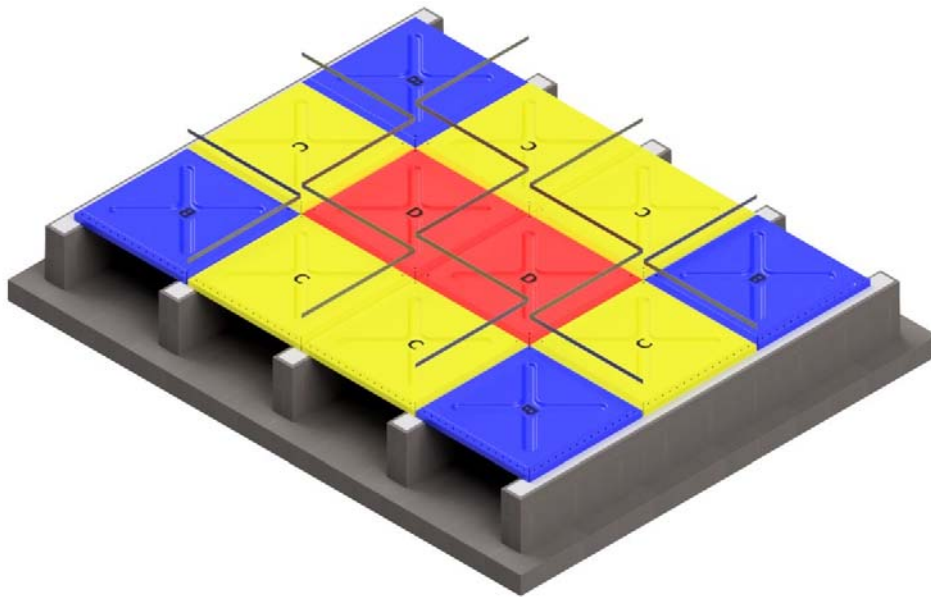
4. When starting to build tank on plinths or steel structure create a L shape to ensure that the tank is going to be square with plinths or steel structure as illustrated below

5. When using concrete plinths place capping strips on top of the plinths as shown below

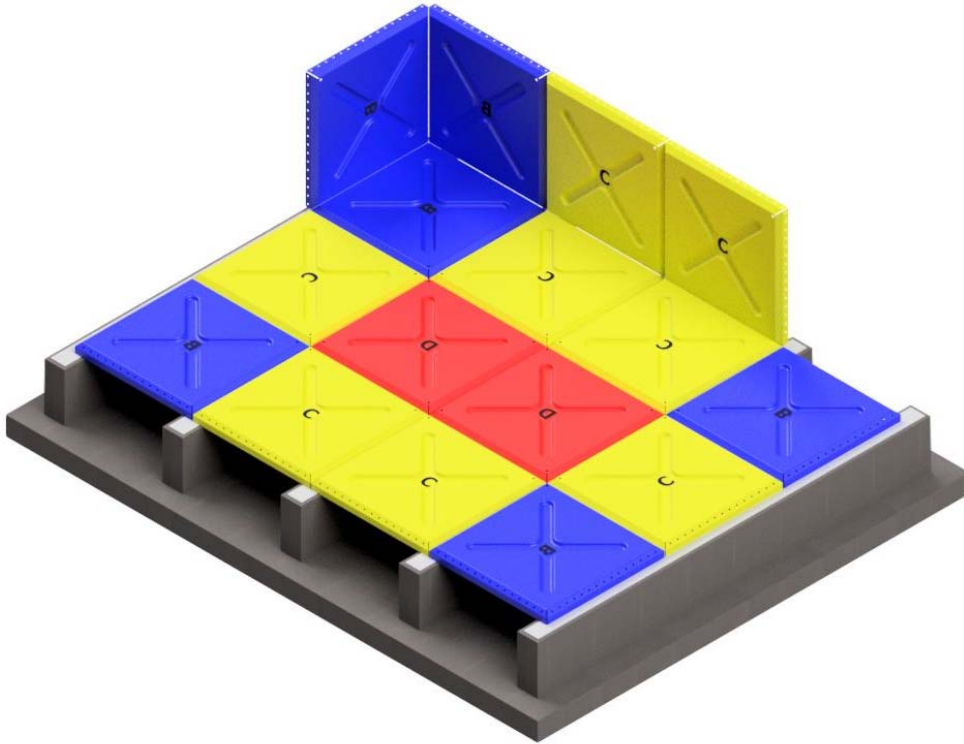


6. Lay the panels and bolt them loosely to one another with two to three bolts until the base is completed.

7. Install gasket as per below illustration



8. Erect and loosely bolt up the side wall panels completing the first row before starting the next.



8. At each point where the four panels come together a U cleat is required, place four blocks of butyl (white blocks ) in the centre where the four panels meet  
place U cleat on top use 20mm bolts, nuts, washers and butyl and loosely secure.
9. Place U cleats on base and first level to be able to install bracing to keep up side wall.
10. Repeat steps 7, 8 and 9 until third level is reached.
11. Install external and internal ladders to be able to have access to the tank.
12. Install all roof trusses and pipe columns then start to install the roof
13. All the above have drawings to illustrate how to install.
14. All bolts, nuts and washers to be fitted now you can impact the bolts in sequence.
15. Impact the base first, then the U cleats on base, then the U cleats on the side walls, then the bracing, then the side walls can be impacted from the bottom up.
16. After impacting check all bolts with torque wrench. M12 Gr8.8 = 88Nm
17. When you see a leak you can just tighten the bolt. If the leak does not stop loosen the bolt rap some butyl around the bolt in front of washers and retighten.

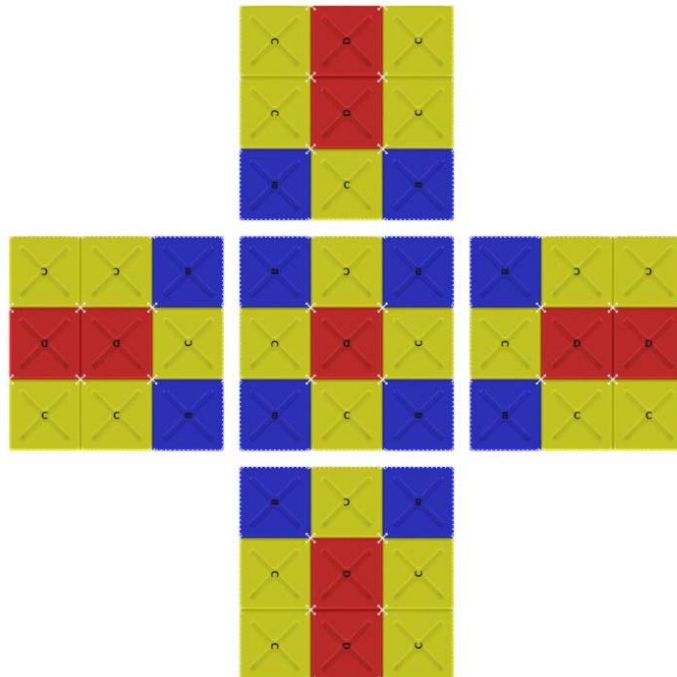
# FTS Pressed Steel Tanks Method Statement



You will receive your tank in "flat-pack" form.



Open Tank Layout 3x3x3High Tank



# FTS Pressed Steel Tanks

## Method Statement



### Nuts, Bolts and Washers

12mm bolt, nut and washer used for external ladder rib cage

10mm bolt, nut and washer for G&Y cleat

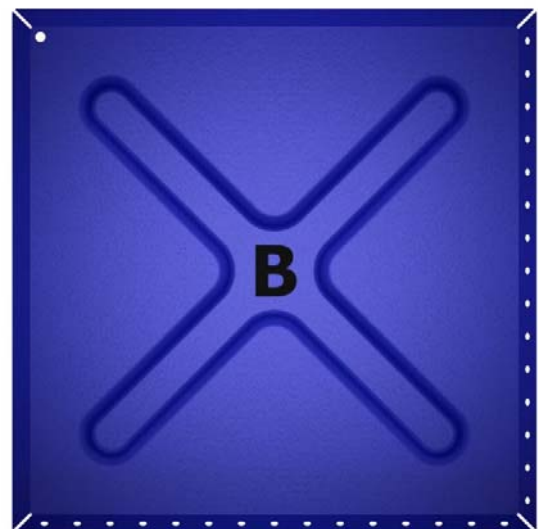
12mm Silo bolt, nut and washer for base and side panels

16mm bolt, nut and washers for stays and bracing

20mm bolt, nut and washer used for U-Cleats(box cleats) and trusses



### Panel Types



# FTS Pressed Steel Tanks

## Method Statement

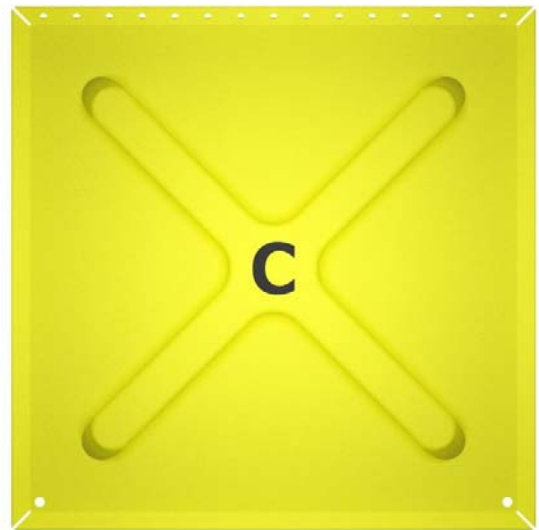


### B Panel

Has 2 x 45degree angled holes and 2 x 90 degree angled holes.

Used on the base of the tank- one in each corner

Used on the bottom corners of side walls of the 1st tier



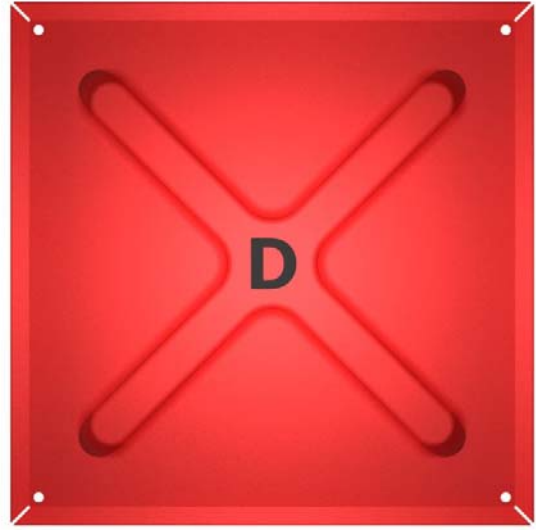
### C Panel-

Has 1 x 45 degree angled holes and 3 x 90 degree angled holes

Used for the corners between the base and sides

As well as between sides

**FTS Pressed Steel Tanks**  
Method Statement



**D-Panel**

Has 4 x 90 degree angled holes

Used in the base and from 2nd tier up

These panels create your sides

Outside Tank



Inside Tank



**FTS Pressed Steel Tanks**  
Method Statement



G&Y Used to seal the corner joints

X-Cleat Joint procedure



Step 1



Step 2

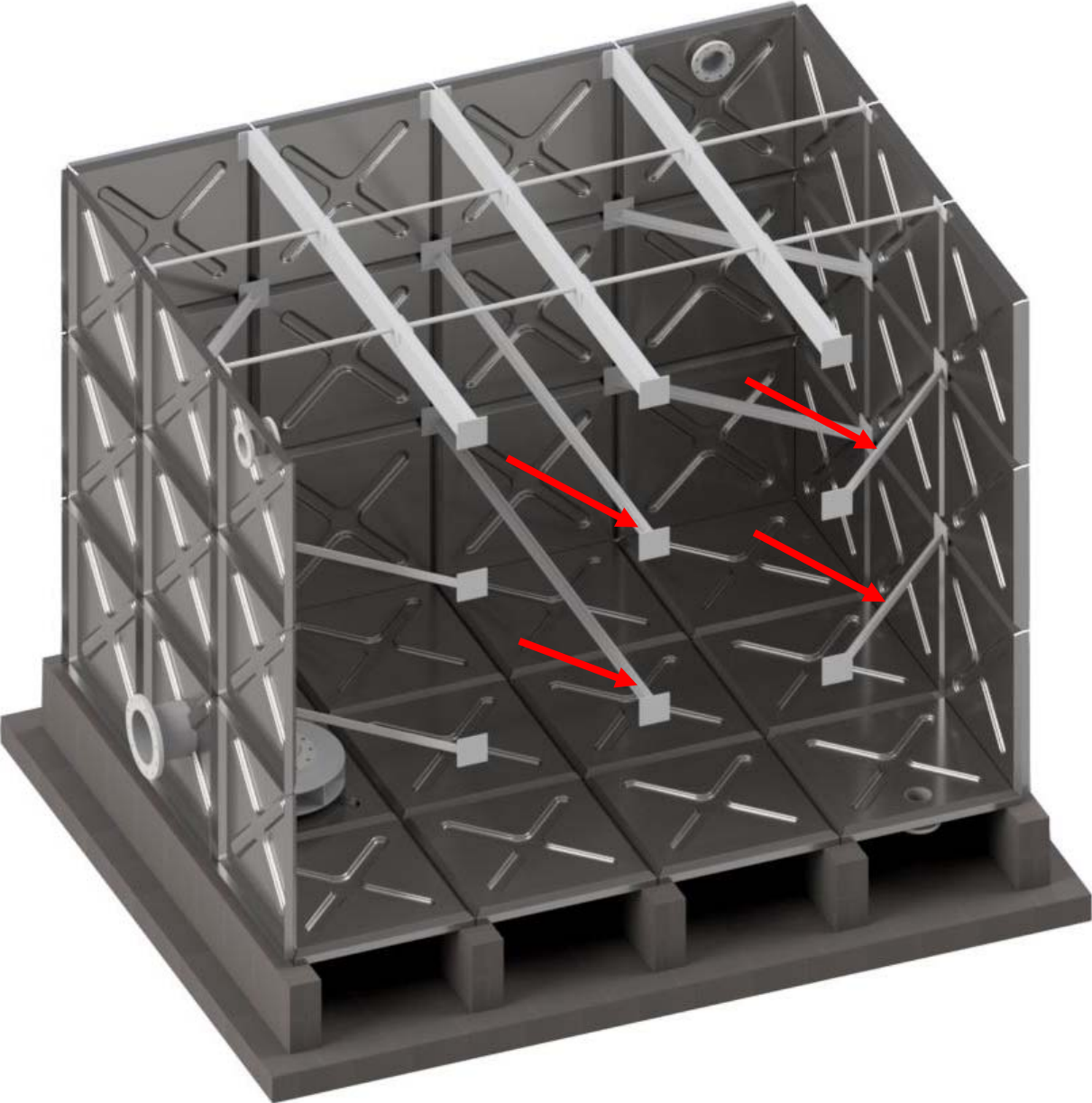


Step 3

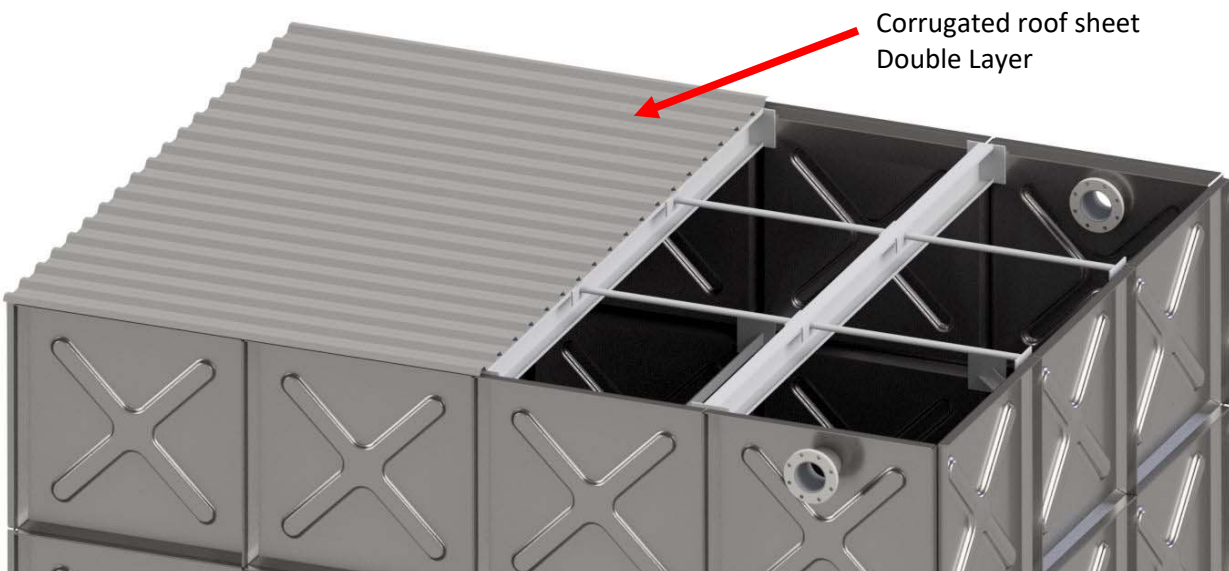
**FTS Pressed Steel Tanks**  
Method Statement

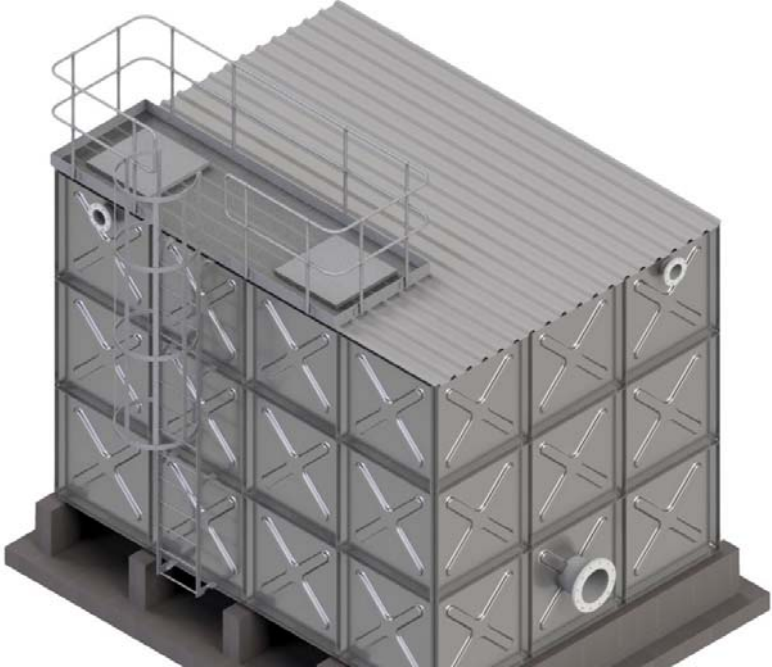


Bracing Installation



Roof Structure





External ladder with landing and access to tank

**FTS Pressed Steel Tanks**  
Method Statement

