

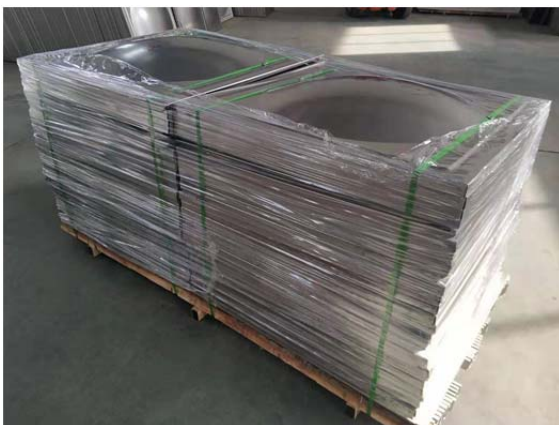
Stainless steel assembled water tank installation plan

KHN WATER TREATMENT EQUIPMENT CO., LTD.



1. Water tank material

Welded stainless steel welded water tanks use SUS304 high-quality stainless steel plates. The manufacturer designs and cuts materials according to the specifications of the water tank, and processes them through a series of procedures such as plate cutting, filming, pressing, shaping, proofreading, and qualified delivery.



2. Installation preparation

1. Before construction, be familiar with the construction drawings and relevant technical data. The construction drawings of the water tank should be

Check the building drawings, be familiar with the water tank process, understand the construction and acceptance standards, and prepare the construction

Work plan.

2. Before construction, the power supply at the construction site should be confirmed, and the construction electricity should be used in consultation with the construction unit, but

It should be able to meet work needs.

3. The construction site should be in order, with a dry and well-ventilated working environment.

4. The strip foundation of the water tank should meet the drawings and installation requirements, and the height should not be less than 300mm. The foundation height error should not be greater than 5mm.

5. Assign a special person to manage the construction site, responsible for the overall management of the construction team, and supervise the quality of the water tank throughout the process.

3. Material preparation

1. The stainless steel pressing plate should be carefully checked before being used after entering the site, and it must conform to the relevant quality and technology.

Technical requirements, and there is a product qualification certificate.

2. The channel steel underframe should be checked carefully before use after entering the site, and it must meet the relevant quality and technical requirements.

Request, and have a certificate of product delivery.

3. The stainless steel tie rods and uprights should be carefully inspected before use after entering the field. They must meet the relevant quality,

Technical requirements, and there is a product qualification certificate.

4. The main equipment preparation

1. Machine tools: argon arc welding machine, electric welding machine, angle grinder, argon cylinder, power box, etc.

2. Tools: adjustable wrenches, hand hammers, screwdrivers, pliers, cutting tools, welding tools, etc.

3. Measuring tools: level ruler, steel tape measure, line sinker, caliper, angle ruler, small line, etc.

5. Installation process

1. Welded basis

Determine the spacing of the channel steel according to the size of the water tank plate. First, fix the channel steel by spot welding, and use a level to check it to ensure that it is flat and then weld it as a whole.

2. Fix the bottom plate

Spot weld the bottom plate of the water tank that has passed the test on the channel steel bottom frame, and fix it to the middle of the bottom frame.

3. Fix the side panel

Spot weld the qualified water tank pressing plate to the bottom of the water tank in sequence. After each plate is fixed, use a level and a wire drop to check the verticality, and then spot weld the next one until all the side plate points are ensured. The welding is complete.

4. Fixed cover

Fix the qualified water tank cover on the side plate, and add a post between the middle of the cover and the bottom of the tank to ensure the overall flatness of the cover.

5. Installation accessories

Fix the internal tie rods according to the water tank structure, and install the internal and external ladders.

6. Opening

Make holes according to the position and pipe diameter requirements shown in the drawings, and spot weld the short flange pipes of each hole. The level and verticality of the flange must meet the requirements.

7. For the overall welding of the water tank, it is required that the weld be free of defects such as blisters, pores, slag inclusions, etc.

6. Sealing performance test

After the welding is completed, wipe all welding parts with a dry towel in the water tank, and then pour water to the marked capacity. After standing for 24 hours, wipe all the welding parts with a dry towel. The towel should not be wet.

7. Water tank cleaning

The living water tank must be cleaned before it is delivered to use. When cleaning, workers must put on plastic shoe covers before they can enter the water tank for cleaning. First wipe off the dirt inside the box with a cleaning agent, and then clean the inside with tap water until the water discharged after cleaning has no particles and is clear and transparent.

8. Water tank insulation

1. The following inspections should be made before heat preservation: the water tank base and fasteners are well anti-corrosion, the full water test is qualified, and the relevant construction records are signed by the personnel of the relevant parties.

2. The insulation material is made of rubber-plastic board with a thickness of 40mm or determined according to design requirements. According to the size of the position between the plates, the uneven part is tightly sealed and flat.

9. Issues that should be paid attention to when installing the water tank:

1. If the foundation of the designed water tank is too low, it will affect the operation of the workers and the installation of the sewage pipe, especially the water tank in the basement or the fire water tank, and it should be revised in time when the drawing is reviewed.

2. When pouring the concrete foundation, the height of the channel steel and veneer should be reserved, and the top surface must be consistent.

3. The location of the water tank in the water tank room and the surrounding space should be able to meet the minimum operating space for construction and maintenance personnel.

4. The height of the water supply pipe at the outlet of the water tank should be able to meet the pressure requirements of the most unfavorable point on the top of the life and production water supply. This problem should be paid attention to when the drawing is reviewed.

5. Multiple water tanks with the same function are arranged in the water tank room, and the installation height should be the same.

6. The water tank materials should be handled carefully, the placement should be flat and stable, and the surface should be clean and should not be polluted.

7. The stainless steel brace and other auxiliary materials used in the water tank must meet the drinking water standard.

8. The opening of the water tank pipe should be checked against the drawing for correctness, and the hole can be opened after inspection by a professional quality inspector.

10. Quality Control

10.1. Quality standards

The water tank installation quality standards are shown in Table 5:

Table 5

S.N	Item		Allowable deviation (mm)
1	Static equipment	coordinate	15
		elevation	±5
		Verticality	Per meter

Note: (The concrete strength of the water tank foundation must meet the design requirements)

The quality standard of water tank insulation is shown in the table 6:

Table 6

S.N	Item		Allowable deviation (mm)
1	Thickness		+ δ
			δ
2	Surface roughness	Coil	5
		smear	10

10.2. Quality control measures:

The equipment professional engineer must pay attention to the construction of the water tank, make a layout plan of the water tank, and verify the foundation position and elevation of the water tank before construction. Check whether the surrounding space, nozzle elevation and position of the water tank meet the design requirements.

The equipment engineer shall make a detailed technical clarification and hand it to the person in charge of construction.

Regarding the water tank room as a key computer room for construction, civil engineering and equipment professional management personnel should pay attention to it.

Choose a water tank manufacturer with a reputation, performance, and quality.

Do a good job in the protection of semi-finished materials and accessories, and strictly prevent pollution and damage.

The piping arrangement of multiple water tanks for the same purpose should be coordinated to ensure that the water tanks are beautiful.

11. Safety, environmental protection and civilized construction measures

1. The transportation of semi-finished materials should be bundled to prevent slipping and injuring people or damaging the materials.

2. Electric and gas welders should have fire watchers when making section steel bases and piping, and be equipped with sufficient appliances to prevent fires. The site should be well ventilated during welding.

3. Someone should be guarded during the irrigation test, and accidents should be dealt with in time.

4. Pay attention to fireworks on site during thermal insulation construction.

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