

Nicholson Plastics Ltd
Work Procedure / Method Statement
for

Assembly of two part
tanks.

1. Ensure the base support area is flat, level, free of projections or debris and capable of adequately supporting the filled tank.
2. Site the base section of the tank on the base support making sure it is correctly orientated for plumbing.
3. Clean all joint faces thoroughly ensuring that they are all dry and free from dust.
4. Apply sealing tape to flanges of base section overlapping the corners by approx. 30mm and thinning the tape at the corners to ensure no excessive build up of tape. Peel back approx. 100mm of backing paper at each end of each tape run and fold outwards so that it can be pulled once the top has been placed. This will limit the amount of grab when you are locating the top half on the bottom.
5. Check the orientation of the top and place on top of the base section ensuring it is the correct way round to align the holes.
6. When the alignment is correct and BEFORE entering the bolts, carefully peel the backing paper out of the joint and remove completely. It may help the process if the top is partially supported during this operation.
7. Once the top is sitting on the base insert a bolt and washer at each corner, punching it through the sealant tape with a sharp hammer blow. Do not tighten at this stage.
8. Continue entering bolts and washers in this manner until all are in place.
9. Add washers and nuts to all bolts and finger tighten.
10. Progressively tighten the nuts working opposite pairs of sides alternately until a torque of 40 Nm is achieved uniformly.