



AGRO

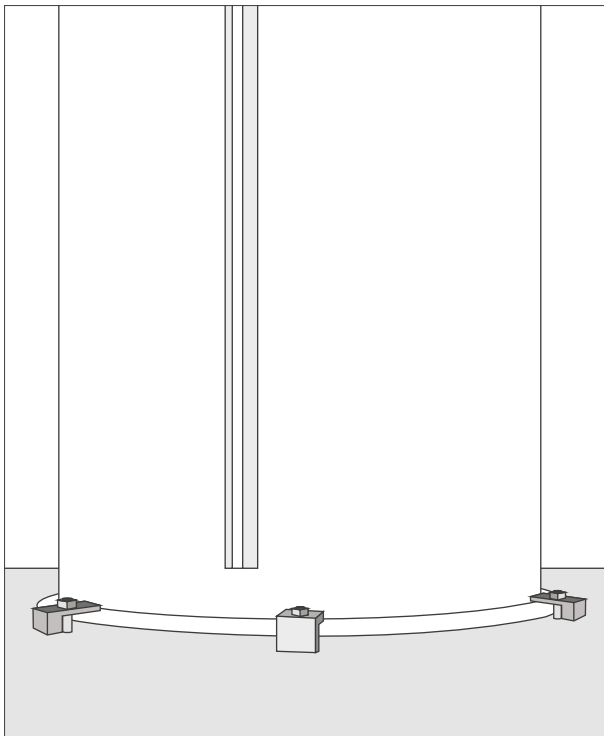
MOUNTING INSTRUCTIONS

for products with

ANCHORING FOOT



TUNETANKEN



1. Foundation

A new foundation is made in concrete according to calculations and drawings for the specific mounting or the supplier's instruction.

An existing concrete foundation must be checked for suitability by e.g. conducting calculation and testing.

2. Check the concrete foundation

Check that the concrete foundation has the right quality and that there is compliance between the specific and actual relationship before anchoring the product.

3. Attachment

The attachment must be carried out according to the calculations and the drawing of the product or the suppliers' instructions.

Use the prescribed or designated tools with torque settings in order to ensure correct fastening and to avoid overstrain.

How to do it:

3.1 Drill holes in the concrete foundation with the diameter and depth specified in the product mounting instructions. (See fig. 1).

The mounting depth for the concrete foundation is marked on the adhesive anchor. (See fig. 4).

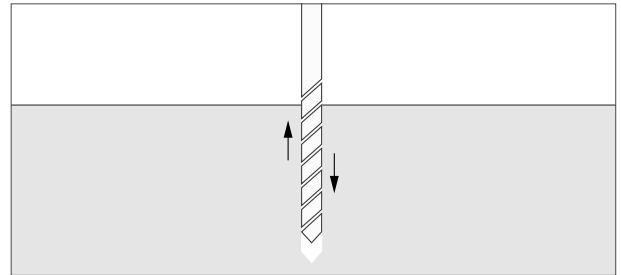


Fig. 1: Drill holes in the concrete foundation of the correct diameter and depth.

3.2 Clean the hole thoroughly for dust with a brush or air. (See fig. 2)

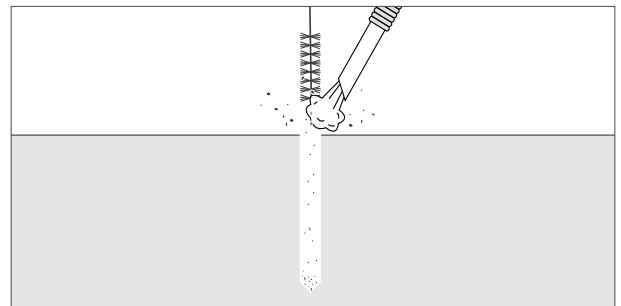


Fig. 2: Clean the hole thoroughly for dust.

3.3 Fill approximately 75% of the hole with adhesive. Use approx. 1 tube adhesive for 4 adhesive anchors. Follow the manufacturer's instructions for application, curing times etc. (See fig. 3)

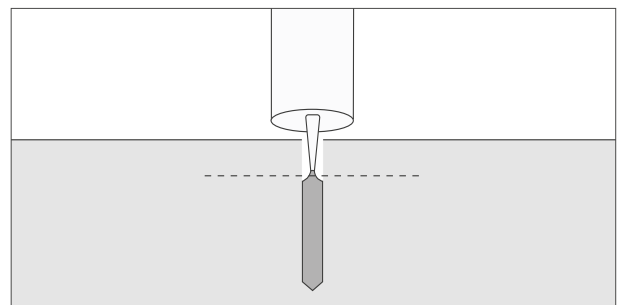


Fig. 3: Fill approx. 75% of the hole with adhesive.

3.4 Push an anchor into the adhesive filled hole. (See fig. 4) Wipe off excess adhesive pressed up from the hole.

NOTE! The anchor must be cut diagonally to ensure an optimal adhesive distribution and thereby to achieve the best adhesive effect.



- 3.5** Mount the washer and nut to the anchor. Tighten manually with your fingers. Tightening must be done at the earliest when the adhesive has hardened.

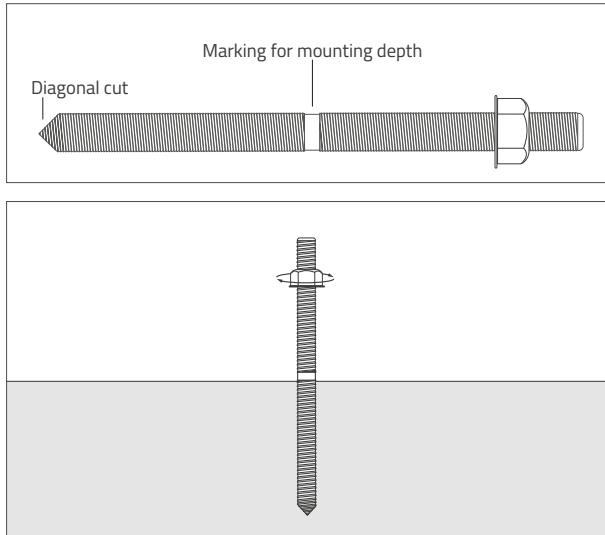


Fig. 4. Mount the anchor and dry off excess adhesive pushed up from the hole.

- 3.6** Tightening with torque is done when the adhesive has hardened – see the adhesive curing time in the instructions. Use the formula (fig. 5) to calculate the tightening torque.

Tightening torque in Nm

The formula is a guideline for bolts and nuts where the material and quality fit together. Always check whether the manufacturer indicates the tightening torque.

Material quality according to ISO R898						Stainless, acid-proof A2/A4		
	5.6	8.8	10.9	12.9	14.9	KI. 50	KI. 70	KI. 80
M8	12,3	26,1	36,8	44,1	51,5	7,8	17,0	22,0
M10	24,1	51,5	72,4	86,9	101	15,0	33,0	44,0
M12	42,0	89,4	125	151	176	27,0	57,0	76,0
M14	66,8	143	201	241	281	43,0	91,0	121
M16	102	218	306	367	429	65	140	187
M18	142	305	428	514	600	91,0	195	260
M20	199	425	598	718	837	127	273	364
M22	269	574	807	968	1130	171	367	490
M24	344	735	1033	1240	1447	220	472	629
M27	499	1064	1496	1795	2095	318	682	909
M30	680	1450	2039	2446	2854	434	930	1240

Fig 5. Tightening torque in Nm.

Anchoring with brackets

The specific number of anchoring brackets are evenly distributed around the anchoring foot of the tank. The anchoring brackets are bolted with the specific fastening bolts for the project.

See section 3 »How to do it«.

Tank mounted on the concrete foundation and anchored with anchoring brackets. (See fig. 6 and 7).

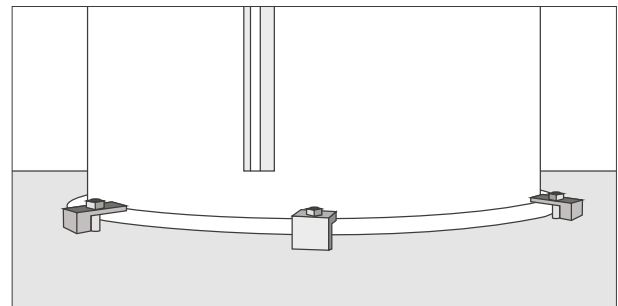


Fig. 6. Anchoring brackets are evenly distributed around the anchoring foot.

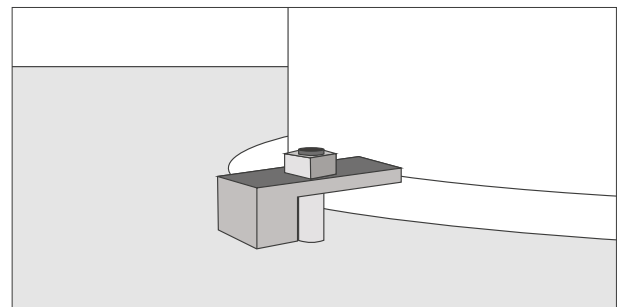
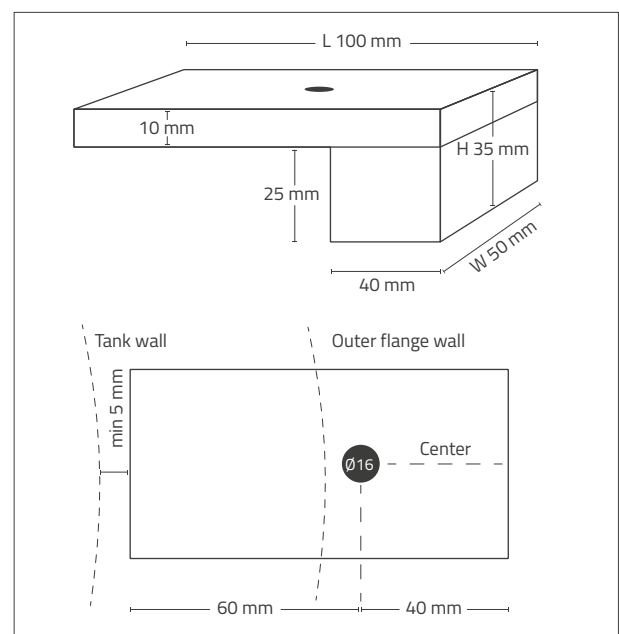


Fig. 7. Anchoring brackets above the anchoring foot.

Dimensional drawing:





Anchoring with anchoring foot

Center the adhesive anchor in the saddle of the anchoring foot to ensure correct and uniform tightening. (See fig. 8)

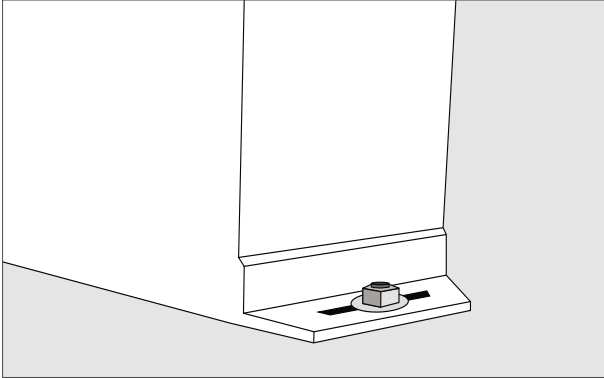


Fig. 8. A correctly mounted adhesive anchor is placed at the center of the anchor foot's saddle.

4. Loads

After anchoring the product/construction must not be exposed to loads, for example vibrations, push, pull, bad weather conditions etc. that it is not intended/manufactured for.