

MONOLITHIC, REINFORCED TANKS FROM ROTOMOULDING OF "GLASS" AND "BELL" TYPE

Endlessly a step ahead of the competitors...

Considering the new expectations of our customers who are looking for inexpensive and durable container for use in construction in particular sewage treatment plants, operating on the basis of low-pressured sludge and sewage pumping stations, water meter wells, tanks for the capture, storage and reuse of treated water from sewage or rainwater, wells and all kinds of lymph underground shafts, we offer a complete ideal product - series of four specially designed tanks of various sizes aptly named "glass" and "bell" along with covers and manholes. Tanks are made as a monolith with circuit reinforcements on the basis of strength tests carried out, by technology rotomoulding on the machine of latest generation.

For production we use materials with the following features of PP;

PROPERTIES	TESTING METHOD	UNIT	VALUE
<i>* WSPÓŁCZYNNIK PŁYNIĘCIA</i>	<i>ISO 1133</i>	<i>g/10min</i>	<i>7</i>
<i>DENSITY</i>	<i>ISO1183</i>	<i>g/cm3</i>	<i>0,900</i>
<i>SOFTENING POINT VICAT</i>	<i>ISO 306 METHOD A</i>	<i>°C</i>	<i>148</i>
<i>MODULUS OF ELASTICITY</i>	<i>ISO 527-1,-2</i>	<i>Mpa</i>	<i>1200</i>
<i>STRESS AT YIELD</i>	<i>ISO 527-1, -2</i>	<i>Mpa</i>	<i>26</i>
<i>IMPACT STRENGTH OF CHARPY(23°C)</i>	<i>ISO 179</i>	<i>Kj/m²</i>	<i>7,5</i>

All tanks are produced of plastic with UV stabilization.

Than a few words on the technology used:

ROTO-molding means a rotary thermal forming of materials from thermo-plast family. As the primary raw material the granulate is used in the form of powder which is poured after weighting to a form, heated and under the influence of gravitational forces and slow movements of form in both planes evenly distributed throughout the form. The process of cooling and opening of the form results in the product free from any expansion of material and having no joints or welds.

Each product offered at the end of service life, in the future may be fully recyclable. Therefore, we declare with full responsibility that we take care of a good state of our environment and every product bears recycle symbol that is required.

The products offered can be processed by generally available methods such as: cutting, drilling, using the dedicated tools for woodworking.

Combining of products, installation of bulkheads, ports and any other changes are possible by

welding method using hot air and binders - welding wire PE, PP - any type of plate material - flat sheets, ribbed panels, grills, welding wires (round, triangular) and equipment for welding of triack / extruder type-available "in stock" on sale of AMARGO.

Other products (containers, lids, utensils, etc.), according to customer ideas and suggestions, we are in a position in to also produce for you by the technology of rotomoulding, assuming a minimum amount of several hundred pieces a year. For customers planning new production, we offer professional advice and assistance in choosing the type of form, design and implementation.

Tanks, aptly named "glass" are made of polyolefin-type materials polyethylene, polypropylene. These polymers are characterized by high mechanical strength and chemical resistance to many acids and bases.

The shape of the inner tank and embossing at the stage of the project take into account the need to install the forms inside the tank technological baffles (eg, the need for sewage treatment plants) and other necessary weapons.

After considering the needs of most clients, we decided to manufacture two sizes of tanks type of "glass" - respectively with a capacity of 2.25 m³ and 1.50 m³.

Standard color is natural and black. But it is possible to produce containers in different colors for specific customer needs.

In addition, we enable you placing logos as lasting relief of the tank to the needs of the customer.

Glass tank 2.25 m³:

The wall thickness of 7-8mm, weight 80kg

The wall thickness of 9-1mm, the weight of 106kg - a variant with increased static strength (with the corresponding value of strength - stiffness to 4MPa) also to be used as such a rainwater tank (filled or not).

Tank "glass" capacity of 1.5 m³.

The wall thickness of 7-8mm, weight 75kg

Tank "bell" capacity 2.25 m³

Thickness 7-8mm, weight 85kg.

Tank "bell" capacity 1.25 m³

Thickness 7-8mm, weight 65kg.

WELDING OF BAFFLES, SPOUTS, PREFABRICATION

We recommend welding of accessories of tanks by extruder-type devices that use hot air and additional material - binder. Welding wire is automatically fed through a system called "wire feed". Retractable welding wire is heated, milled and pressed by the worm as a thermoplastic mass. Extrusion welding is recommended especially when connecting components with greater wall thickness.

Welding optimum parameters for PP and PE materials:

melting temperature of the wire in the extruder (worm) and the extrusion 200 ° C - 230 ° C.

Surface air temperature warming combining 250 ° C - 300 ° C (at air stream 350-4001/min).

In the case of welding parts with a smaller wall thickness can be used triack devices - then the welding wire is fed by hand is not ground but only plasticized through the hot air and placed at the interface between two surfaces.

PP Welding recommended temperature is 280 ° C - 330 ° C.

For the welding of PE recommended temperature is 270 ° C - 310 ° C.
The optimum volume of air flow is 60l/min.

ADDITIONAL RECOMMENDATIONS FOR WELDING.

In all types of welding we do not recommend crossing the temperature values that are given as this causes degradation of the material, resulting in bond strength decrease. Also the temperature too low and too small stream of air cause insufficient warming of the surface.

Moreover, to achieve the maximum possible strength it is recommended to use welding wire manufactured from the same material as the tank.

Based on flow rate tests, we recommend using only a wire of AMARGO.

Prior to welding the surfaces to be joined to clean up, remove any oxidized layer and degrease. Full weld strength is obtained after full-time weld has cooled for about two hours.

If you have questions or concerns please contact us. Welcome to cooperation!

www.amargo.pl

Current prices are in the "tanks of rotomoulding" catalogue, available on our website