SERENA SINCE 1998 UK®

INSTALLATION INSTRUCTIONS

2025

WATER STORAGE

HYDROCARBON, BIOGAZ

FIRE FIGHTING

DRINKABLE WATER

RAIN WATER

LIQUID FERTILIZERS

WASTE WATER

FLEXIBLE TANK

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Certificat *Certificate*

Référentiel de certification */ Certification reference system*
QB - Assainissement (QB09) */ Sewerage*

N° 002-102-01-337_V1

Le CSTB accorde le droit d'usage de la marque QB à la société :
CSTB grants the right to use the QB Mark to the company:

Nom du titulaire
Holder name

SAS SERENA
6 RUE JEAN BAPTISTE PERRIN ZA DE LA GRAVETTE
33320 EYSINES
France

Site(s)
Site(s)

Tunisie - MATEUR - SERMT00

Pour les produits listés ci-après, certifiés conformes aux exigences du référentiel de certification en vigueur, par le CSTB.
For the products listed below, certified conform to the applicable certification reference system requirements by CSTB.

Designation
Name

CITERNES SOUPLES D.E.C.I. SERENA GROUP

Évaluation technique
Technical evaluation

Conformité à l'Avis Technique n° */Compliance with Technical Notice n* : **17.1/24-337_V1**

La validité de ce certificat et la liste des produits certifiés sont vérifiables sur le site Internet ou en flashant le QR-code ci-contre :
The validity of this certificate and the certified products list can both be checked on the website or by flashing the QR-Code:

https://database.cstb.fr

Décision de Certification / Certification decision N° **002-102-01-337_V1** du **26/03/2025**
Cette décision se substitue à la décision / This decision replaces the decision N° **001-102-01-337_V1**
Décision d'admission initiale **001-102-01-337_V1** du **31/01/2025**

Fait à : **Marne-la-Vallée, France**
Done at

Date de décision : **26/03/2025**
Decision date

Président du CSTB
Etienne CREPON

ACCREDITATION N° 5-0010
List of sites and Scope available on / Listes des sites et portée disponibles sur WWW.COFRAC.FR
cofrac CERTIFICATION DE PRODUITS ET SERVICES

En vertu de la présente décision, le CSTB accorde le droit d'usage de la Marque QB à la société qui en est titulaire pour les produits visés par ce certificat, dans les conditions définies par les Exigences générales de la Marque QB et par les référentiels de certification QB, pour autant que les contrôles réguliers de la fabrication et les vérifications par tierce partie soient satisfaisants.
On the strength of the present decision, CSTB grants the right to use the QB Mark to the licence holder for the products mentioned in this certificate, within the frame of the general requirements of the QB Mark and of the QB certification reference system, as far as the regular checking and third party verifications of the production are satisfactory

CENTRE SCIENTIFIQUE ET TECHNIQUE DU BATIMENT - ORGANISME CERTIFICATEUR
84 avenue Jean Jaurès – Champs-sur-Marne – 77447 Marne-la-Vallée Cedex 2
Tél. (33) 01 64 68 82 82 – Fax (33) 01 64 68 89 94 – www.cstb.fr
MARNE-LA-VALLÉE / PARIS / GRENOBLE / NANTES / SOPHIA-ANTIPOLIS

CSTB le futur en construction

N°: 1701

SERENA flexible tanks

Dear Customer,

We are glad that you have chosen SERENA flexible tanks for your business! Your QB (building quality) certified tank was manufactured in our own factory, which is certified ISO 9001-2015, ISO 45001, and ISO 14001. These certifications cover product quality, environmental concerns and health and safety. They motivate all our teams, and this commitment, both financial and human, is why we have such an impressive machine park as well as a high-quality and high-precision manufacturing process. So our team is working to offer you a robust tank suited to your needs, with reliable and durable welding and customizable accessories, very quickly.
SERENA is also a family business: we know each of our customers and do our very best to keep them satisfied!

Now it's time to install your tank! This leaflet is designed to be consulted before installation, and to provide help during installation and the rest of the life cycle of the tank.

For any questions or suggestions, please get in touch with your usual contact. You will also find our telephone and postal contact details, country by country, on the back cover.

Happy installation!
The entire SERENA team

CSTB le futur en construction

QB

TÜVRheinland CERTIFIED
ISO 9001:2015
ISO 45001:2018
ISO 14001:2015
Valid until: 2027-12-19
www.tuv.com
ID 9108656305

UV ANTI-UV

3 PVC BÂCHE

CONTENTS

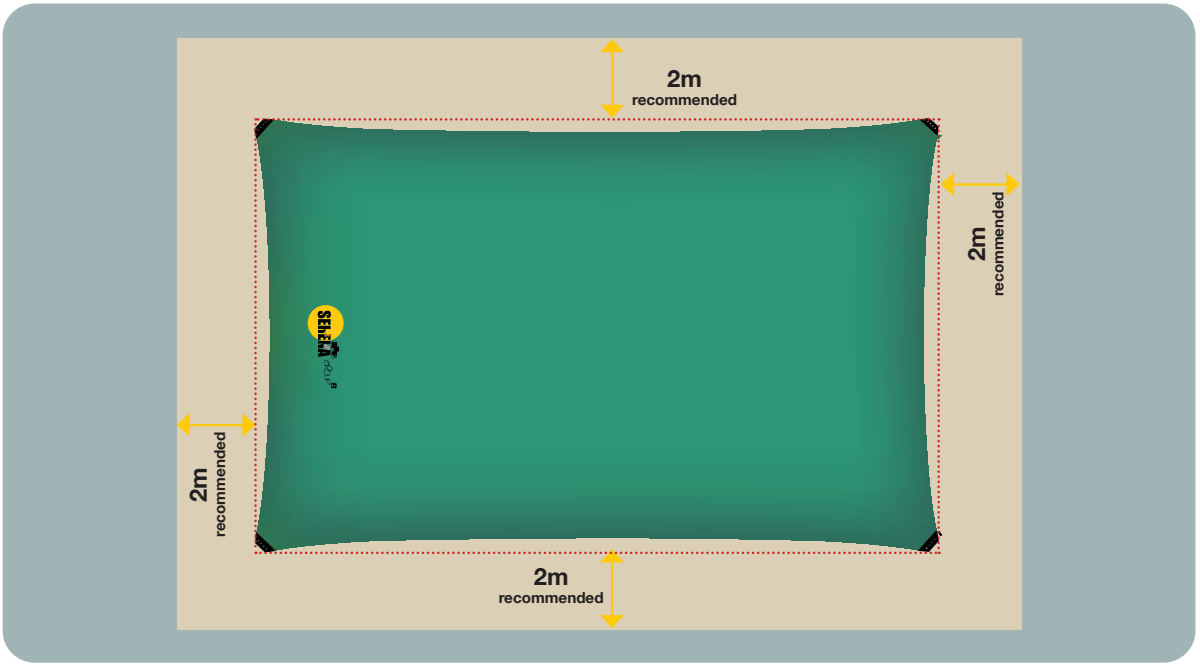
I. Platform

Preparing the platform is an essential step that should not be neglected. You need to think about it before even taking delivery the tank. We recommend that you read the following instructions in full before unpacking your tank to ensure a secure and durable installation. In case of doubt or difficulties, do not hesitate to seek assistance from an engineering company or call our team of installers in the UK.

A. Dimensions and requirements

1 Dimensions

The surface of the platform must be equivalent to the size of the tank indicated on the validated, to which two metres are added in width and length. Thus, your tank will be surrounded by a safety perimeter of one metre, thus protecting it from, for example the growth of brambles or strimmers, etc.



2 Weight-bearing and pitch

The platform must be perfectly flat to prevent the tank from rolling, or welding from being overstressed on one side.

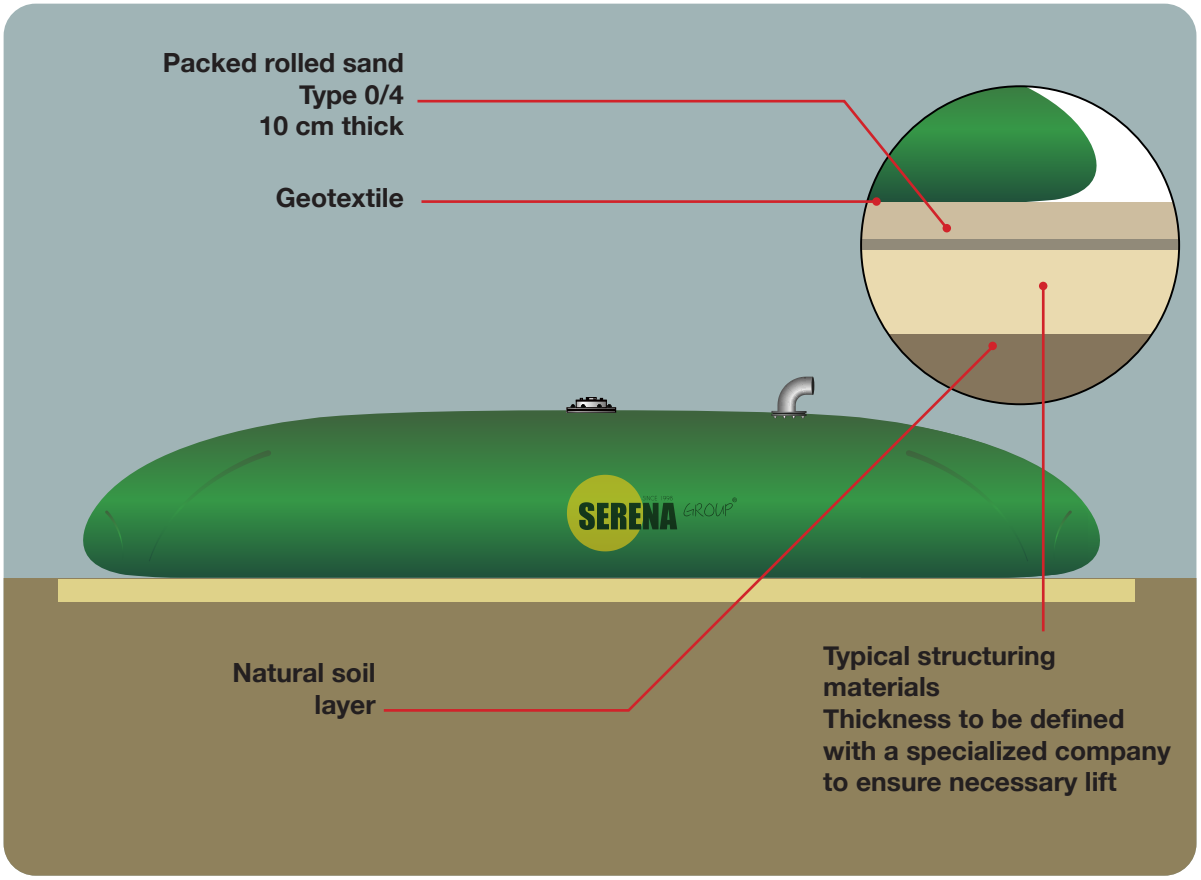
The floor of the platform must also be stable enough to support the weight of the full tank; if the weight distorts the floor, this will eventually damage the tank.

How to calculate the weight that the platform will have to support?

Maximum height of the tank (metre) x density of the liquid (t/m3).

For a fire reserve with a maximum height of 1.6 metres, the platform must support at least 1.6 tonnes per square metre.

Did you know?
The density of liquid water is 1000kg/m³ or 1 t/m³



3 Nature of the soil

Your platform must then be covered with a bed of compacted gravel.

It may be necessary at this stage to employ the services of specialists who will be able to determine the nature of your soil and thus the thickness of this gravel bed. This step is essential and must not be neglected or erosion may occur.

Once this bed of compacted gravel has been prepared, you must add a layer of fine packed sand, type 0/4, approximately 10 cm deep. Be sure to remove all items that could damage the tank.

Finally, we recommend that you install a ground sheet, which we can provide on request. This should cover the entire surface of the platform (including under the tank and on the surrounding safety perimeter). In 600g/m2 PVC, it will provide additional protection and guarantee a clean installation.

Summary

The platform must:

- Measure 2 metres more in length and width than the dimensions of the empty tank
- Be flat and support the weight of the full tank
- Be stable (compacted gravel bed + layer of fine packed sand + ground sheet)

B. Special installations:

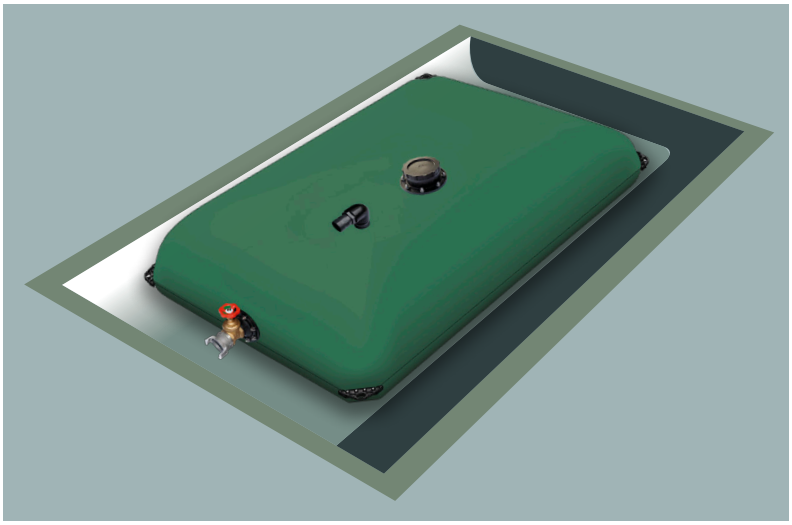
In some cases, it may be necessary to build a retention system, particularly when storing polluting liquid.

There are two types of retention: A retention slope and a retention wall.

These two systems require a few additional steps to the classic installation detailed above.

1 Slope

This retention system, also called a retention pit, is an external installation. It will require an additional preliminary step consisting of creating a pit with a 45° slope, working to the dimensions indicated in the diagram below



The next steps to be follow for building the platform are the same as those mentioned previously

2 Wall

This retention basin system on a low wall consists of surrounding the tank platform with 4 walls. To determine the height of these walls, please refer to your order form.

The next steps to follow for building the platform are the same as those mentioned previously. The groundsheet must be fixed to the top of the wall using the eyelets with which it is fitted.

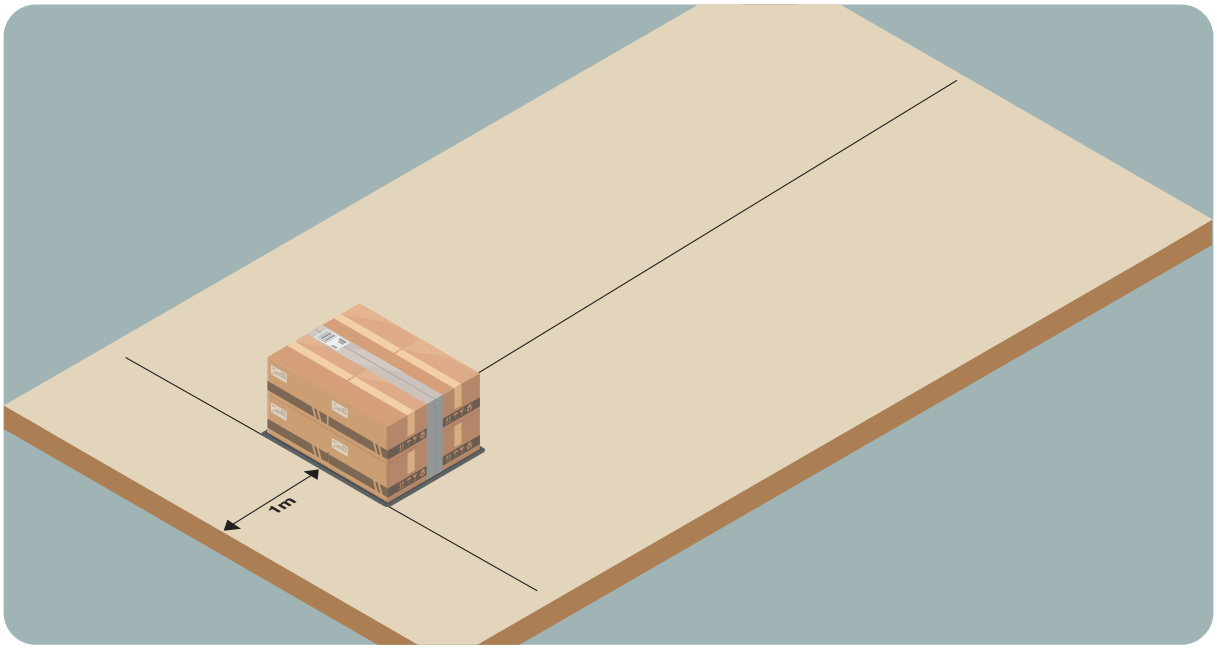
II. Installing the tank

Only begin installing the tank if the previous steps preparing the platform have been carried out according to the installation manual. if you have any doubts, it is advisable to call a professional. You will need the help of others for the following steps.

A. Position of the tank before unpacking

If your tank is packed in a cardboard box, carefully remove the packaging using a cutter without touching the tank inside.
During this step, make sure you have to hand the drawing you approved when you ordered the tank. You will find see a red cross on this drawing, identical to the one on the folded tank. This cross indicates in which direction you should unroll the tank.

Once the red cross is visible, the tank and the pallet must be placed 1 metre from the edge, given that the tank will be rolled out over its entire length.



Flow chart diagram

B. Unrolling the tank

The tank must be rolled out over its entire length, paying attention to keep it parallel to the edges of the platform. We strongly recommended you do not stand behind the tank as you risk being crushed.

Once the tank has been rolled out to its full length, remove all boxes and pallets that might be on the platform. If necessary, the tank can be lifted slightly to remove the transport pallet.

C. Unfolding the tank

This step aims to deploy the tank across its width. Position yourself along the first section, allowing one person every 2 to 4 metres, and pull on the tarpaulin to unfold it. Repeat the operation for each section of each width.

Once deployed, lift opposite corners and shake lightly to create a carpet of air. If the position of the tank needs to be adjusted, do not drag the tank but proceed by shaking it.

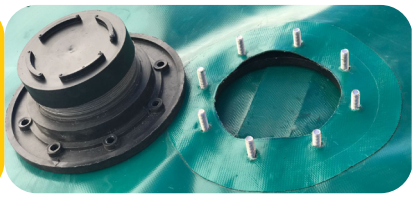
III. Fitting accessories

Depending on the type of tank ordered, the accessories may or may not be fitted on the tank.

A. General case

If the accessories are not pre-fitted, follow the steps below to safely set it up:

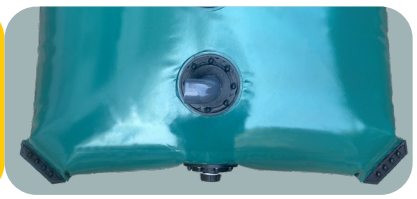
1. **Preparing the counter-flanges: Insert the counter flanges into the intended openings in the tank, as shown in the adjacent diagram.**
   (If the counter-flanges are already installed, remove the nut covers, unscrew the nuts, remove the washers, then install the flange).



2. **Fix the overflows, vents, and filling valves on the counter-flanges, ensuring they are in the correct position.**

3. **Tighten the nuts gradually in a crisscross fashion to ensure they are fixed uniformly and securely.**

4. **Check that the corner reinforcements are correctly attached to the four corners of the tank, following the same tightening precautions mentioned above.**



5. **Ensure the seal using a gasket, sealing paste or Teflon tape.**

With above ground connections, a flexible pipe of at least 3 metres must be used. We strongly advise you not to use a rigid pipe as this could damage the flanges and the tank.

B. Fire tanks

Our fire tanks comply with the NF S 62 250 and NF S 62 240 standards, and have received QB certification issued by the CSTB. However, for tanks installed in France, it is important that you refer to the SDIS to which you are affiliated to check their recommendations and have your installation approved. The information in this leaflet is provided for informational purposes only and may not affect the guaranteed cover in the event of a problem resulting from the improper installation of the underground network.

The flanges and counter-flanges of above-ground and frost-protected tanks must be installed in accordance with part A. General Case, above.

1 Above ground:

The above-ground fire tank is equipped with one or more valves. As part of fire regulations, the valve must be straight, in the noon position. Be careful to check its installation before filling, otherwise you will have to empty the tank.

Reserve for above-ground fire defense

2 Frost protection:

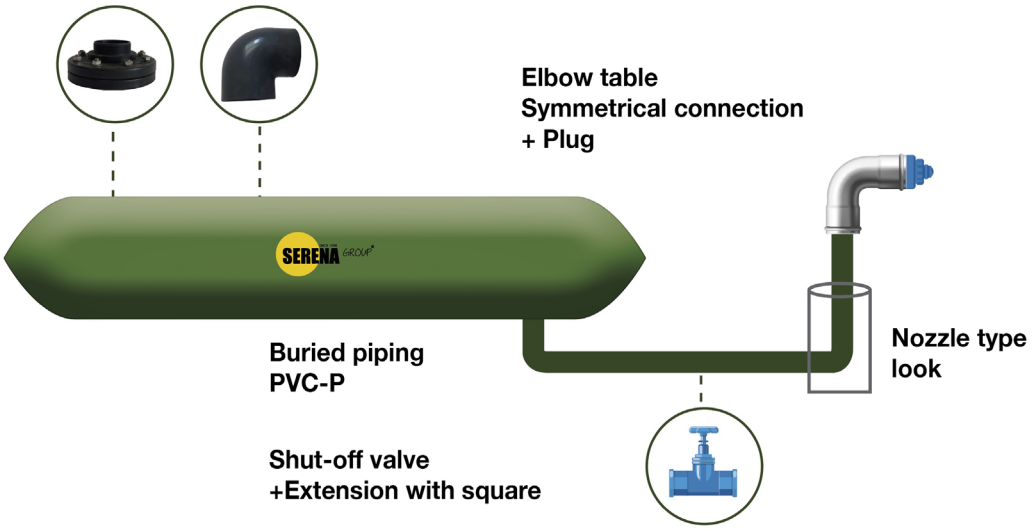
Unlike above ground connections, frost protection connections are made using rigid pipes. This step can be difficult and require professional machines. We recommend that you contact professionals, particularly engineering companies.
Whether the outlet chosen is a fire hydrant or a gooseneck (angled outlet), a trench must be dug. To do this, once the tank is unrolled and unfolded, fold it back up to the tapping under the tank.

The depth of the trench varies depending on the product chosen, here are some useful indications:
- 0.60 m for goosenecks
- 1.10 m for DN100 fire hydrants
- 1.15 m for DN150 fire hydrants

Once the trench has been dug and a layer of sand has been applied to the bottom, refer to the particular steps of each installation in the paragraphs below then backfill the trench with compactable soil.

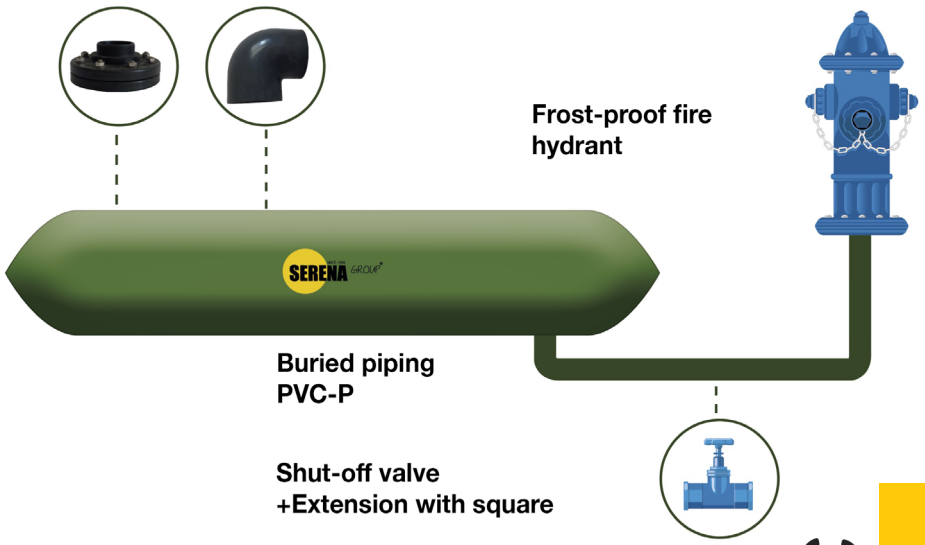
Reserve for frost-free fire protection

A. Gooseneck



The remote socket with a gooseneck or stainless steel column must be equipped with a shut-off valve. The recommended depth is approximately 60cm. Between 50cm and 1 metre must be allowed between the shut-off valve and the gooseneck. It is also essential to install a manhole cover over the entire height of the gooseneck, with a minimum perimeter of 60cm.

B. Fire hydrant



Each fire hydrant must be fixed securely to the ground by a concrete anchor according with the following dimensions:

- perimeter of 30 cm around the exterior wall.
- length of 60 cm in the axis of each half-coupling.
- minimum thickness of 30 cm.

Depending on the model chosen, your fire hydrant may or may not be equipped with a shut-off valve.

C. Basic Tanks

Basic tanks are delivered ready for use. They are pre-equipped along the sides with a DN32 wall pass-through with plug, a DN25 wall pass-through and a DN25 elbow on top. Before filling, you must check that the wall fittings are screwed securely and add PTFE tape if necessary. We invite you to watch our tutorial videos on our YouTube page.

Scan me!
To see our video on
YouTube TikTok

IV. Filling and Connection

Filling and connection must be carried out carefully and under supervision. First, make sure that the previous steps have all been correctly carried out and that the ventilation elbows are not blocked.

A. Filling

The maximum height indicated on the tank and/or on the documents received (validated quotes, technical plans and delivery notes, etc.) must be scrupulously respected. This is a maximum height; it does not need to be reached.

As you are filling, check that the tank is filling evenly. If this is not the case, we recommend you drain the tank and adjust your platform so that it is perfectly horizontal. The risk is that the tank rolls or that the welds on one side are overstressed.

B. Connection

You can connect your tank to the valves or other devices provided on your tank. However, it is imperative you use flexible pipes long enough to withstand variations in the height of the tank.

V. Maintenance and Repair

There you have it, your tank is installed and ready to be used for many years! Here are some tips to extend its lifespan.

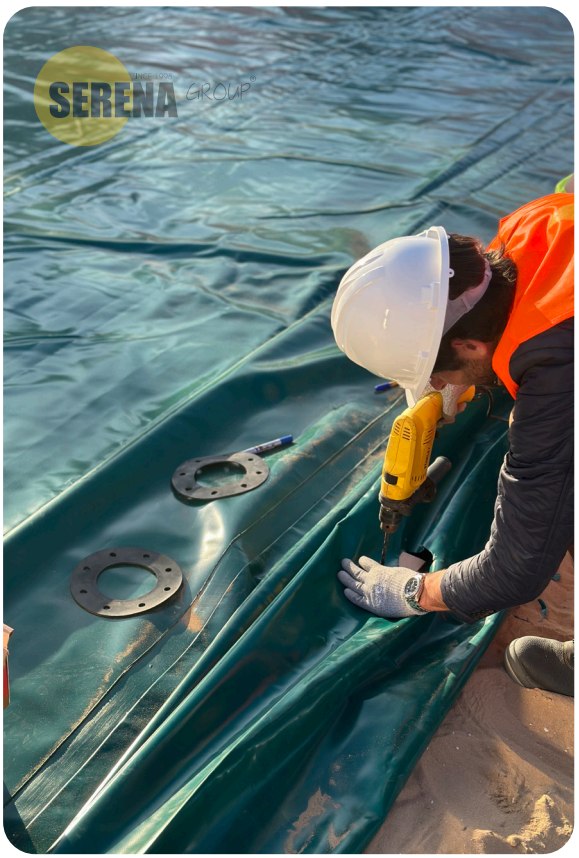
A. Maintenance

The tank does not require any maintenance, other than a regular inspection to check it is in good condition (especially that the valves are working properly) and that it has not been damaged by external events such as vandalism, rodents, or other animals. We advise you to be very careful with gardening tools (mowers and strimmers, etc.) which regularly damage the tanks, and to use a ground sheet to avoid having to get too close to the tarpaulin.

The tank can withstand temperatures between -30°C and + 70°C. The only precautions to take are to insulate the valves in the event of frost, and to shade or cover your tank with an insulating cover if you are storing effluent or drinking water. The tank is not made to be stored for a long time. If this should happen, be sure to store it away from rodents, heat, and humidity.

B. Tear - Hole

It is possible to carry out small scratch repairs on a filled tank or a hole on an empty tank. Contact our team to obtain a repair kit or to carry out a hot repair (with welding) in the event of more serious damage.



DID YOU KNOW?

All the volumes of our fire tanks are indicated as useful volume. We take into account the dead volume, i.e. the volume of water which remains in the tank and which cannot be sucked up when the fire hydrant is on the side of the tank (around 8cm of water). For example, a 120m³ tank will actually contain a nominal volume of more than 130m³.

We have been QB certified since 2025! This French certification is specific to the building sector and guarantees you a high quality tank. All our materials, welds, technical sheets, tools, and production methods, etc. have been examined and are checked annually.

VII. Which tarpaulin to choose?

Each Serena flexible tank is designed for a specific use. The pH of the liquid to be stored is an essential criterion for choosing the appropriate tank. Below you will find the different possible applications.

A. Water Tanks

- **Composite fabric:**
  900 g/m², colour green.
  Under 30m: small tanks.

- **Composite fabric:**
  1300 g/m², colour green.
  From 30m³ to 1,000m³

- **Applications:**
  Water storage for private use, swimming pool water recovery.
  Building and public works, irrigation, professional drip irrigation

B. Tanks for Drinking Water

- **Composite fabric:**
  930 g/m², blue colour.
- **Available capacities:**
  From 0.3 m³ to 100 m³.
- **Applications:**
  Storage of drinking water.

C. Fire Tanks

- **Composite fabric:**
  1300 g/m², green colour.
- **Available capacities:**
  From 30 m³ to 1,000 m³.
- **Applications:**
  Water storage for firefighting.
  QB certified tanks to guarantee their compliance.

D. Tanks for Light Effluents

- **Composite fabric:**
  1300 g/m², green or beige colour.
- **Available capacities:**
  From 1 m³ to 1,000 m³.
- **Applications:**
  Storage of bovine and pig effluents, green water, brown water.
  Suitable for certain industrial effluents.

E. Heavy Effluent Tanks

- **Composite fabric:**
  1400 g/m².
- **Available capacities:**
  From 1 m³ to 1,000 m³.
- **Applications:**
  Storage of cattle, pig, sheep, goat, and poultry effluent, methanization digestates.
  -Industry and wine-growing activities.
  -Recommendation: for a high pH, choose 1400 g/m² fabric.

F. Tanks for Liquid Fertilizer

- **Composite fabric:**
  1400 g/m².
- **Available capacities:**
  From 25 m³ to 1,000 m³.
- **Applications:**
  Storage of liquid fertilizer.
  -Used with a basin on a slope and with a rainwater evacuation system or a retention tank on a wall (manufactured in our factory).

G. Specific Tanks

For specific applications, such as gasoline or chemical products, please contact us for suitable solutions.

Technical Data Sheets Available

Water tanks:
- Composite fabric 900 g/m²:
  Under 30 m³
- Composite fabric 1300 g/m²:
  From 30 m³ to 1,000 m³

Drinking water:
- Composite fabric 930 g/m²

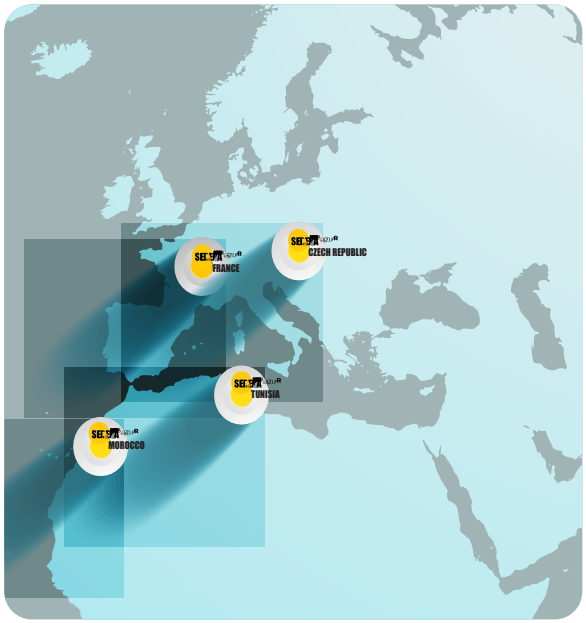
Fire fighting and light effluents:
- Composite fabric 1300 g/m²

Heavy effluents and liquid fertilizer:
- Composite fabric 1400 g/m²

VIII. Where to find us?

We have offices in four countries:

France, the Czech Republic, Tunisia and Morocco, and we deliver all over the world.



Our Distributor

PFC Ltd.

Middle Barlington Roborough
Winkleigh Devon EX19 8AG,
United Kingdom
Tel : (+44) (0)7523 270 710
uk@groupserena.com
www.mycistern.uk

You don’t know who to contact?

Send a message to
uk@groupserena.com

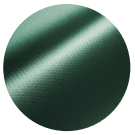
SERENA GROUP® SINCE 1998

TECHNICAL DATA SHEET

Coatings and finishes:

Coating type: PVC
Application: Water, some effluents


BEIGE


GREEN

TYPE OF EFFLUENTS								
Cattle	Pig	Sheep	Goat	Poultry	Cheese making	Methanization digestate	Industries	Wine industry
●	◐	●	●	●	●	◐	●	●

Total weight	1300 g/m²	EN ISO 2286-2
Thickness	ca. 1 mm	DIN EN ISO 2286-3
Warp / weft breaking resistance	4200 / 4000 N/50 mm	EN ISO 1421/V1
Warp / weft tear resistance	500 / 450 N	DIN EN 17679
Adhesion	25 N/cm	PA 09.03 (intern)
Cold resistance	-30°C	EN 1876-1
Temperature resistance	+70°C	PA 07.04 (intern)
Color fastness to light	> 6 Note, Value	EN ISO 105 B02
Bending resistance No breakage	100000 x	DIN 53359 A
SUPPORT		
Material	PES	DIN EN ISO 2076
Thread	1100 dtex	DIN EN ISO 2060
Armor	P 2/2	ISO 3572

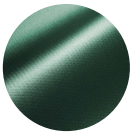
The technical data indicated are average values with a tolerance of -5%. They apply to new products. This information corresponds to the current state of our knowledge and has no legal value. The examples of use do not absolve the buyer from checking whether the material is suitable for the desired use.

SERENA GROUP® SINCE 1998

TECHNICAL DATA SHEET

Coatings and finishes:

Coating type: PVC
Application: Water
Citern smaller than 30 m^3



GREEN

Total weight	900 ± 5 g/m^2	EN ISO 2286-2
Warp / weft breaking resistance	4200/4000 N/5 cm	EN ISO 1421/V1
Warp / weft tear resistance	500/ 400 N	TS EN ISO 4674-1 EN ISO 4674-1
Adhesion	100 N/5cm	TS EN ISO 2411 EN ISO 2411
Cold resistance	-30°C	DIN EN 1876-1
Temperature resistance	+70°C	IVK/Pkt.5
Color fastness to light	6+	BS EN ISO 105-B02
SUPPORT		
Material	PES	DIN EN ISO 2076
Thread	2230 dtex	DIN EN ISO 2060
Armor	P 2/2	ISO 3572

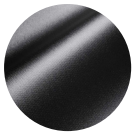
The technical data indicated are average values with a tolerance of -5%. They apply to new products. This information corresponds to the current state of our knowledge and has no legal value. The examples of use do not absolve the buyer from checking whether the material is suitable for the desired use.

SERENA GROUP® SINCE 1998

TECHNICAL DATA SHEET

Coatings and finishes:

Coating type: ALCRYN
Application: Enviro pro hydrocarbon tanks A



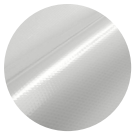
BLACK

MEHLER TEXNOLOGIES
a company of FREUDENBERG

Total weight	1300 g/m²	EN ISO 2286-2
Warp / weft breaking resistance	2800 / 2500 N/50 mm	EN ISO 1421/V1
Warp / weft tear resistance	250 / 250 N	DIN 53363
Adhesion	30 N/cm	PA 09.03 (intern)
Cold resistance	-30°C	EN 1876-1
Temperature resistance	+100°C	PA 07.04 (intern)
Color fastness to light	> 6 Note, Value	EN ISO 105 B02
Methane gas permeability	<150 cm^3/m^2.24h. bar	DIN 53380-2
Bending resistance No breakage	100000 x	DIN 53359 A / DIN EN 7854 B
SUPPORT		
Material	PES	DIN EN ISO 2076
Thread	1100 dtex	DIN EN ISO 2060
Armor	L 1/1	ISO 3572

SERENA GROUP® SINCE 1998

TECHNICAL DATA SHEET



GREY

MEHLER TEXNOLOGIES
a company of FREUDENBERG

Coatings and finishes:

Coating type: PVC
Application: Effluent, liquid fertilizer, slurry

TYPE OF EFFLUENT								
Cattle	Pig	Sheep	Goat	Poultry	Cheese making	Methanization digestate	Industries	Wine industry
●	●	●	●	●	●	●	●	●

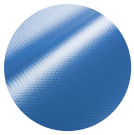
Total weight	1400 g/m²	EN ISO 2286-2
Warp/weft breaking resistance	4200 / 4000 N/50 mm	EN ISO 1421/V1
Warp/weft tear resistance	500 / 500 N	DIN EN 17679
Adhesion	20 N/cm	PA 09.03 (intern)
Cold resistance	-30°C	EN 1876-1
Temperature resistance	+70°C	PA 07.04 (intern)
Color fastness to light	> 6 Note, Value	EN ISO 105 B02
Surface electrical resistance	< 10^11 Ohm	DIN 54345-1
Methane gas permeability	<300 cm³/m².24h .bar	DIN 53380-2
Bending resistance No breakage	100000 x	DIN 53359 A
SUPPORT		
Material	PES	DIN EN ISO 2076
Thread	1100 dtex	DIN EN ISO 2060
Armor	P 2/2	ISO 3572

SERENA GROUP® SINCE 1998

TECHNICAL DATA SHEET

Coatings and finishes:

Coating type: PVC
Application: Potable water



BLEU

MEHLER TEXNOLOGIES
a company of FREUDENBERG

Total weight	930 g/m²	EN ISO 2286-2
Warp/weft breaking resistance	4300 / 4000 N/50 mm	EN ISO 1421/V1
Warp/weft tear resistance	450 / 450 N	DIN 53363
Adhesion	20 N/cm	PA 09.03 (intern)
Cold resistance	-30°C	EN 1876-1
Temperature resistance	+70°C	PA 07.04 (intern)
Color fastness to light	>6 Note, Value	EN ISO 105 B02
Bending resistance No breakage	100000 x	DIN 53359 A
SUPPORT		
Material	PES	DIN EN ISO 2076
Thread	1100 dtex	DIN EN ISO 2060
Armor	L 1/1	ISO 3572
Note	For flexible drinking water tank, Tested according to the standard AS/NZS 4020: 2018	

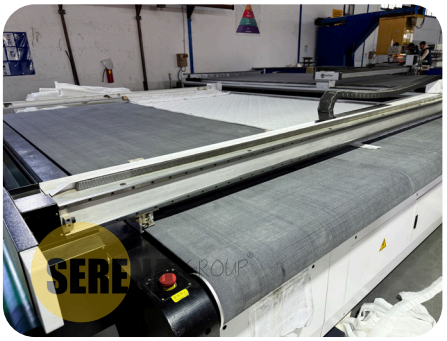
The technical data indicated are average values with a tolerance of -5%. They apply to new products. This information corresponds to the current state of our knowledge and has no legal value. The examples of use do not absolve the buyer from checking whether the material is suitable for the desired use.

IX. Dimensions

VOLUME EN M³	LONGUEUR	LARGEUR	HAUTEUR
0,3 m³	1,20 m	1,00 m	0,40 m
0,5 m³	1,23 m	1,48 m	0,40 m
1,0 m³	1,35 m	2,96 m	0,40 m
2,0 m³	2,30 m	2,96 m	0,45 m
3,0 m³	2,85 m	2,96 m	0,60 m
4,0 m³	3,30 m	2,96 m	0,65 m
5,0 m³	3,90 m	2,96 m	0,70 m
6,0 m³	4,40 m	2,96 m	0,75 m
8,0 m³	5,30 m	2,96 m	0,80 m
10,0 m³	6,20 m	2,96 m	0,90 m
15,0 m³	5,30 m	4,44 m	1,00 m
20,0 m³	6,50 m	4,44 m	1,10 m
25,0 m³	7,60 m	4,44 m	1,20 m
30,0 m³	6,30 m	5,92 m	1,25 m
40,0 m³	7,50 m	5,92 m	1,40 m
45,0 m³	8,15 m	5,92 m	1,40 m
50,0 m³	8,80 m	5,92 m	1,40 m
60,0 m³	10,00 m	5,92 m	1,50 m
70,0 m³	11,40 m	5,92 m	1,50 m
80,0 m³	8,50 m	8,88 m	1,60 m
100,0 m³	10,00 m	8,88 m	1,60 m
120,0 m³	11,70 m	8,88 m	1,60 m
150,0 m³	14,30 m	8,88 m	1,60 m
160,0 m³	15,10 m	8,88 m	1,60 m
180,0 m³	12,40 m	11,84 m	1,60 m
200,0 m³	13,60 m	11,84 m	1,60 m
250,0 m³	19,40 m	10,36 m	1,60 m
300,0 m³	19,70 m	11,84 m	1,60 m
350,0 m³	20,10 m	13,32 m	1,60 m
400,0 m³	20,40 m	14,80 m	1,60 m
450,0 m³	20,60 m	16,28 m	1,60 m
500,0 m³	22,70 m	16,28 m	1,60 m
600,0 m³	24,60 m	17,76 m	1,60 m
800,0 m³	29,70 m	19,24 m	1,60 m
1 000,0 m³	31,70 m	22,20 m	1,60 m

Manufacture of a 1000 m^3 tank

High Frequency welding machine on 30 metre long table



Automatic cutting table

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