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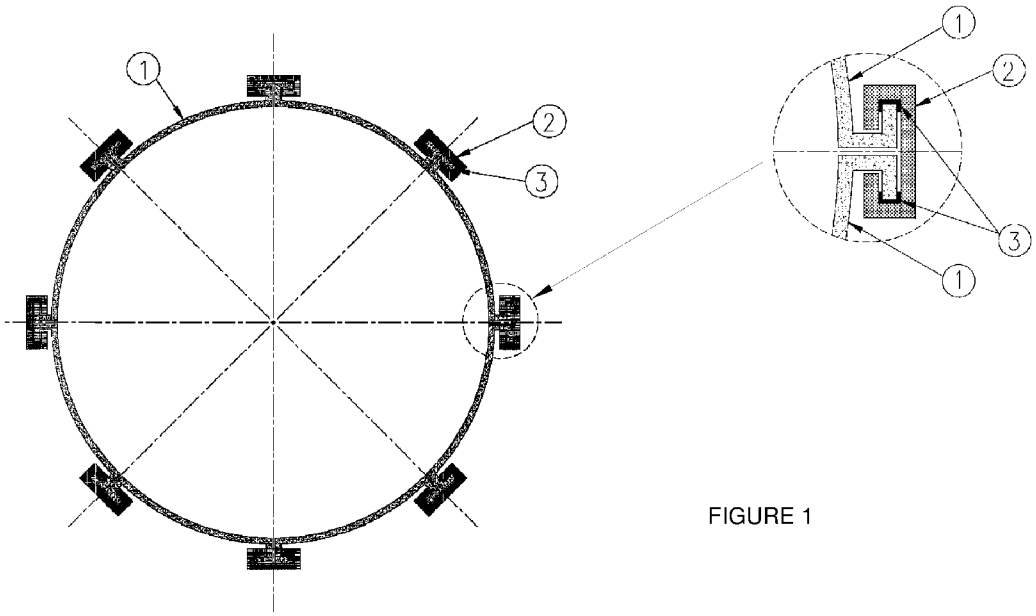

FIGURE 1

(57) Abstract: The present invention relates to prefabricated and modular liquid storage tanks developed for storing drinking water, water used for utility, industrial, fire, agricultural purposes, waste waters and chemical liquids. With the present invention it is aimed to counter the peripheral forces occurring due to the water pressure via the side body panels manufactured to engage with each other, and to transfer said forces from one panel to the other through said engaging connections. The gaskets between the engaging connections of the side body panels of the prefabricated and modular storage tanks for water and other liquids, and the gaskets at the junctures of the side panel-storage base plate or side panel-impermeable flat ground are tightened by water pressure, peripheral forces occurring due to water pressure or by the weight of the body panels and they provide impermeability under water pressure thanks to their shapes and structures. In models with inner cover, the peripheral load is carried by the body panels and permeability is provided by the inner cover.

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PREFABRICATED and MODULAR STORAGE TANKS FOR STORING WATER OR OTHER LIQUIDS

SPECIFICATION

FIELD OF THE INVENTION

The present invention relates to prefabricated and modular liquid storage tanks developed for storing drinking water, water for utility, industrial, fire, irrigation purposes, waste waters and chemical liquids.

PRIOR ART

In the known art, a liquid tank is made of steel or plastic material; it has a cylindrical or spherical shape and can be manufactured and transported in factories with small capacities, after being conjoined via welding. However, large capacity tanks are manufactured at construction sites. The manufacturing of such large capacity tanks which cannot be transported requires welding operations to be performed on site. Furthermore, the welding and assembly teams have to stay at the site for a long time and lifting equipment has to be rented for a long duration for the assembly.

Another kind of liquid tank in the known art is made of steel or plastic material, it has a prismatic shape and is manufactured in a way that the water pressure force can be transferred to counter surfaces with steel rope and similar structural elements. In such tanks, it is obligatory to balance the water pressure affecting a surface by transferring said pressure to the counter surface via intermediate elements. For instance, the water pressure forces at the counter surfaces in cubical and similar prismatic tanks are balanced by transferring said forces via multiple steel ropes. Such liquid tanks provide complicated, impractical, imbalanced and expensive solutions.

Yet another kind of liquid tank in the known art is built as a solid structure such as a reinforced concrete structure like a pool. Construction of such tanks takes a long time and can go on for months. Moreover, the cracks that occur during the manufacturing of the reinforced concrete cause leakages.

PROBLEMS SOLVED BY THE INVENTION, ADVANTAGES GAINED and OBJECTIVES IN DEVELOPING THE INVENTION

The prefabricated and modular storage tanks for water and other liquids developed according to the present invention solve the problems of manufacturing large capacity tanks at site, not being able to transport the tanks, sending in welding and assembly teams, long manufacturing period and high costs associated with the tanks used for storing water and other liquids in the known art.

The prefabricated and modular storage tanks for water and other liquids developed according to the present invention is developed to provide the below mentioned characteristics;

- can be manufactured in a modular and fabricated way at the desired capacity,
- can be manufactured in a prefabricated way with sizes allowing land transportation,
- does not require special workmanship for assembly such as welding etc.,
- can be stored in storage at the factory in a standard fashion while being ready for sale, can be immediately transferred to the application site after order, can be assembled easily and rapidly at site and can be commissioned shortly,
- can serve as a rapid solution to the requirement of urgent water or liquid storage,
- can be easily transported elsewhere after being disassembled (dismantling) and can be re-assembled,
- can provide cost-saving, rapid manufacturing and assembly with baseless models (tanks directly mounted to flat ground without a tank base),
- has lower costs compared to other alternatives.

DESCRIPTION OF THE FIGURES

The figures prepared in order to better explain the prefabricated and modular storage tanks for water and other liquids developed according to the present invention, have been provided in the annexes. The definitions of the figures are provided below.

FIGURE - 1 Top view of the water or liquid tank according to the present invention, comprising corner guide clamps and the prefabricated Type A body panels which are conjoined with each other via said clamps and which fit into the hooked end corner guide clamps,

FIGURE - 2 Top perspective view of the water or liquid tank according to the present invention, comprising corner guide clamps and the prefabricated Type A body panels which are conjoined with each other via said clamps and which fit into the hooked end corner guide clamps,

FIGURE - 3 Top view of the water or liquid tank according to the present invention, comprising Type B single type hooked end engagement body panels,

FIGURE - 4 Top view of the water or liquid tank according to the present invention, comprising Type C1 and Type C2 dual type hooked end engagement body panels,

FIGURE - 5 Sectional view of the water or liquid tank according to the present invention, comprising body panels which have tank base and which engage with the hooked end corner guide clamps (Type A) or body panels which engage with each other (Type B, Type C1, Type C2) with gaskets in between,

FIGURE - 6 Sectional view of the water or liquid tank according to the present invention, comprising body panels which do not have tank bases and which engage with the hooked end corner guide clamps (Type A) or body panels which engage with each other (Type B, Type C1, Type C2) with gaskets between panels and the flat ground,

FIGURE - 7 Sectional view of the implementation (model) of the water or liquid tank according to the present invention where inner rubber is completely laid on the inner surfaces of the tank base and where a tank base is present, comprising body panels engaging with the hooked end corner guide clamps (Type A) or body panels which engage with each other (Type B, Type C1, Type C2),

FIGURE - 8 Sectional view of the implementation (model) of the water or liquid tank according to the present invention where a tank base with inner rubber completely laid on the inner surface and the flat surface is not used, comprising body panels engaging with the hooked end corner guide clamps (Type A) or body panels which engage with each other (Type B, Type C1, Type C2).

DESCRIPTION OF THE COMPONENTS/ELEMENTS/PARTS IN THE FIGURES

The parts included in the figures prepared in order to better explain the prefabricated and modular storage tanks for water and other liquids developed according to the present invention, have been enumerated separately. The numbers correspond to the following:

1- Type A Body Panels engaging with the hooked end corner guide clamps

2- Corner Guide Clamp

3- Sealing Gasket between Corner Guide Clamp and Body Panel

4- Type B Single Type hooked end engaging Body Panels

5- Sealing Gasket between Type B Single Type hooked end engaging Body Panels

6- Type C1 hooked end engaging body panel

7- Type C2 hooked end engaging body panel

8- Sealing gasket between Type C1 and Type C2 Body Panels

9- Sealing gasket between body panel and tank base

10- Tank base

11- Sealing gasket between body panel and flat ground

12- Inner Sealing Rubber

DETAILED DESCRIPTION OF THE INVENTION

The detailed description of the prefabricated and modular storage tanks for water and other liquids developed according to the present invention is presented below.

Type A (1) body panels engaging with hooked end corner guide clamps are prefabricated portable tank body panels which are sized according to the tank capacity and which have edges that are cornered or folded (bent) to a rounded U shape. They are implemented as single type for a tank.

Corner guide clamp (2) provides the force transfer between Type A Panels (1). Corner guide clamp (2) has a U-section and it's a part where the inward-bent corners thereof are straight or rounded depending on the shape of the edge curvatures/bends of the

Type A body panel (1) (whether it is cornered or a rounded U shape) and depending on the shape and structure of the gasket (3).

The sealing gasket (3) remaining between the corner guide clamp (2) and the body panel (1) provides impermeability. The gasket (3) may be of a lip type (with 1 or more lips) providing impermeability by swelling under water pressure or of an O-ring type providing impermeability by tightening under the forces occurring due to water pressure or under the forces applied during assembly or of a combination of the previous 2 methods (both lip type and O-ring type). The corner guide clamp (2) and the sealing gasket (3) can be manufactured separately or as a single part.

In the application comprising Type A body panels (1) engaging with hooked end corner guide clamps and corner guide clamps (2); the peripheral force occurring as a result of water pressure is carried by the body panels (1) and is transferred to the adjacent panels (1) via the Corner Guide Clamps (2). The gasket (3), which is tightened between the panel (1) and the corner guide during the forcing of the panels (1) to open outwards as a result of the load of the forces occurring due to water pressure (in addition to the tightening occurring during assembly), provides impermeability.

Type B (4) single type body panels are prefabricated portable tank body panels which have one edge folded (bent) inwards and the other folded (bent) outwards, which are sized according to the tank capacity. It's implemented as single type for a tank.

Single type body panel gasket (5) is the gasket which provides impermeability by tightening between the single type body panels (4) under the forces occurring due to water pressure and under the forces applied during assembly. The gasket (5) may be of a lip type (with 1 or more lips) providing impermeability by swelling under water pressure or of an O-ring type providing impermeability by tightening under the forces occurring due to water pressure or under the forces applied during assembly or of a combination of the previous 2 methods (both lip type and O-ring type).

In the application comprising single type tank body panels (4); the peripheral force occurring as a result of water pressure is carried by the body panels (4); the panel (4) edges, which are engaged with each other during the outward opening of the panels (4) due to being loaded with the forces occurring as a result of water pressure, prevent the outward opening and provide impermeability by tightening the gasket (5).

The assembly of the single type body panels (4) is carried out by engaging the edge of each panel with the edge of the adjacent one.

In the application comprising single type body panels (4) and gaskets (5), even though a clamp is not required at the juncture of the single type body panels (4), clamps can be used from the outside if necessary.

Type C1 (6) tank body panels are prefabricated portable tank body panels which can be sized according to tank capacity, with hooks on the outside of both edges (folded/bent outwards).

Type C2 (7) tank body panels are prefabricated portable tank body panels which can be sized according to tank capacity, with hooks on the inside of both edges (folded/bent inwards).

The sealing gasket (8) between Type C1 and Type C2 (6 and 7) Body Panels is a gasket which provides impermeability by tightening under the forces occurring due to the water pressure between Type C1 and Type C2 body panels and under the forces applied during assembly. The gasket (8) may be of a lip type (with 1 or more lips) providing impermeability by swelling under water pressure or of an O-ring type providing impermeability by tightening under the forces occurring due to water pressure or under the forces applied during assembly or of a combination of the previous 2 methods (both lip type and O-ring type).

In the application comprising Type C1 (6) and Type C2 (7) tank body panels; the peripheral force occurring as a result of water pressure is carried by the body panels (6 and 7), the panels (6 and 7), which are engaged with each other during the outward opening of the panels (6 and 7) prevent the outward opening and provide impermeability by tightening the gasket (8).

The assembly of the Type C1 (6) and Type C2 (7) tank body panels (6 and 7) is carried out by engaging the edges of each panel (6 or 7) with the edge of the adjacent panel (7 or 6).

In the application comprising Type C1 (6) and Type C2 (7) tank body panels and gasket (8), even though a clamp is not required at the juncture of the type C1 (6) and type C2 (7) tank body panels, clamps can be used from the outside if necessary.

Storage base (10) is the base of the storage which is prefabricated or manufactured on site. It is also called the base plate.

In the applications comprising various body panels (1, 4, 6, 7) described above, a tank base (base plate) (10) will be placed at the base of the tank and a sealing gasket (9) will be placed between the base plate and the body panels (1, 4, 6, 7). Thus, the leakage from the base can be prevented.

The sealing gasket (9) between the base plate and the body panels (1, 4, 6, 7) may be of a lip type (with 1 or more lips) providing impermeability by swelling under water pressure or of an O-ring type providing impermeability by tightening under the forces occurring due to water pressure or under the weight of the tank body panels or of a combination of the previous 2 methods (both lip type and O-ring type).

In the applications comprising various body panels (1, 4, 6, 7) described above, the tank can be placed on a flat, impermeable ground. A gasket (11) for body panels and flat ground (flat ground base gasket) can be placed between the impermeable flat ground and the body panels (1, 4, 6, 7). Thus, the leakage from the base can be prevented.

The sealing gasket (11) between body panels and flat ground (flat ground base gasket) may be of a lip type (with 1 or more lips) providing impermeability by swelling under water pressure or of an O-ring type providing impermeability by tightening under the forces occurring due to water pressure or under the weight of the tank body panels or of a combination of the previous 2 methods (both lip type and O-ring type).

Inner sealing cover (12) is an element which is placed on the inner surface of the tank, which provides impermeability for the water or the liquid and which is made of rubber, gum elastic, polymer or other impermeable flexible materials.

In the applications comprising various body panels (1, 4, 6, 7) described above, the tank can be placed on a flat, impermeable or permeable ground. The inner sealing cover (12) appropriate for the tank shape is placed inside the tank body panels. The liquid to be stored inside the tank is transferred inside the inner sealing cover (12). Thus, an additional base plate (10) is no longer required and the tank can be used without a base.

In the applications comprising various body panels (1, 4, 6, 7) described above and having been built with a base, an inner sealing cover (12) which completely covers the tank body panels and the tank base and which is appropriate for the shape of the tank can also

be placed. The liquid to be put inside the tank is transferred inside the inner sealing cover (12). Thus, an application with both a base and an inner sealing cover (12) can be obtained.

Very high storage capacities can be reached even if the body panels (1, 4, 6, 7) of the prefabricated and modular storage tanks for water or other liquids developed according to the present invention are manufactured at sizes within the confines of portability.

The 1st basic feature of the invention is that the peripheral force occurring as a result of the water pressure is carried by the body panels (1, 4, 6, 7) which are manufactured to engage with each other and that the peripheral force is transferred directly from one panel to another via the engaging joints or transferred from one panel to another via corner guide clamps.

The basic features of the invention with regards to providing impermeability are as follows.

2nd Basic Feature: tightening of the gaskets (3, 5, 8) between the engaging joints between side body panels (1, 4, 6, 7) under water pressure, the forces occurring due to water pressure and the pressure applied during assembly, and the tightening of the gaskets (9) at the body panels-storage base plate under water pressure, the forces occurring due to water pressure and additionally the forces occurring due to the weight of the body panels; and obtaining impermeability under water pressure thanks to the special shape and structure of said gaskets.

3rd Basic Feature: Manufacturing of the tanks without a base plate. In the applications without a base, the gaskets (11) between the body panels (1, 4, 6, 7) and the impermeable flat ground, provide impermeability thanks to the water pressure, the forces occurring due to water pressure and additionally the forces applied by the weight of the body panels, and the special shape and structure of the gaskets. Thus, an impermeable tank without a base is manufactured. In order for this function of the gasket (11) to be carried out, the lower end of the body panels can be widened by creating as much footing as necessary.

4th Basic Feature: Providing impermeability with an inner impermeability cover (12) which completely cover the inner tank surface and which is made of rubber, gum elastic, polymer or other impermeable materials.

The model with inner cover can be implemented with or without a tank base.

It is possible to create a cylindrical body when the body panels (1, 4, 6, 7) of the prefabricated and modular storage tanks for water and other liquids developed according to the present invention are manufactured in a curved (dished) manner and conjoined; it is also possible to create a polygonal prismatic (polygon-sectioned) body when said panels are manufactured as flat plates or in shapes that create different visuals while allowing the force to be carried and transferred through engagement.

It is possible to manufacture the side body panels (1, 4, 6, 7) of the prefabricated and modular storage tanks for water and other liquids developed according to the present invention to have the same (consistent) wall thickness along the height of the tank; it is also possible to manufacture said panels in a way that they are thinner at the upper sections while becoming thicker towards the ground depending on the forces occurring due to water pressure.

The side body panels (1, 4,6, 7), roof and base (10) of the prefabricated and modular storage tanks for water and other liquids developed according to the present invention can be manufactured from plastic materials as well as from metal materials.

When it is required to assemble the tank roof (not shown in the figures), said roof;

a) Can be carried by the side body panels

b) Can be carried by struts to be erected inside the tank

c) Can be carried by struts to be erected outside the tank

d) Can be carried with a combination of the 3 previously mentioned methods.

In other words, the tank roof;

a) Can be placed on the side body panels,

b) Can be placed on struts to be erected inside the tank

c) Can be placed on struts to be erected outside the tank

d) Can be placed on a combination of the 3 previously mentioned methods.

The present invention also covers the manufacturing at the construction site or where the tank will be used, in case it is required to manufacture at dimensions too large to be transported on land or in case it is preferred to perform the manufacturing at the construction site.

The connections of the pipes used for filling the tank with liquid and emptying the tank can be installed at the tank base, the impermeable flat lower surface, the permeable flat lower surface and the body panels or the roof.

The connections for the tank ventilation can be placed on the roof or the body panels.

The tank discharge connections can be placed at the tank base, the impermeable flat lower surface, the permeable flat lower surface or the body panels.

Other required tank connections can be placed at the body panels or the tank roof.

CLAIMS

1- A prefabricated and modular storage tank for water or other liquids, characterized in that it comprises;

- Type A (1) body panels which have edges that are cornered or folded (bent) to a rounded U shape, and which engage with the hooked end corner guide clamps,
- Corner guide clamps (2) which transfer the force between Type A Panels (1), which has a cornered or rounded U-section, inward-bent ends and straight or rounded corners,
- Sealing gasket (3) which is placed between the corner guide clamp (2) and the body panel (1), which provides impermeability by swelling under water pressure or tightening under the forces occurring due to water pressure and under the forces applied during assembly.

2- A prefabricated and modular storage tank for water or other liquids according to Claim 1, characterized in that the sealing gasket (3) is of a 1 or multiple lip type or O-ring type or of both lip and O-ring type.

3- A prefabricated and modular storage tank for water or other liquids according to Claim 1 or 2, characterized in that the corner guide clamp (2) and the sealing gasket (3) is manufactured separately or as a single part.

4- A prefabricated and modular storage tank for water or other liquids, characterized in that it comprises;

- Type B (4) single type body panels which have one edge folded (bent) inwards and the other folded (bent) outwards,
- Single type body panel (4) gasket (5) which provides impermeability by swelling between single type body panels (4) or by tightening under the forces occurring due to water pressure and under the forces applied during assembly.

5- A prefabricated and modular storage tank for water or other liquids according to Claim 4, characterized in that the single type body panel sealing gasket (5) is of a 1 or multiple lip type or O-ring type or of both lip and O-ring type.

6- A prefabricated and modular storage tank for water or other liquids according to Claim 4 or 5, characterized in that it comprises an assembly structure where the edge of each single type body panel (4) engages with the edge of the adjacent one.

7- A prefabricated and modular storage tank for water or other liquids according to Claim 4,5 or 6, characterized in that it allows clamps to be placed from the outside at the juncture of the single type body panels (4).

8- A prefabricated and modular storage tank for water or other liquids, characterized in that it comprises;

- Type C1 (6) tank body panel with hooks on the outside of both edges (folded/bent outwards),
- Type C2 (7) tank body panel with hooks on the inside of both edges (folded/bent inwards),
- Sealing gasket (8) between Type C1 and Type C2 Body Panels (6 and 7) which provides impermeability by swelling between Type C1 and Type C2 body panels or by tightening under the forces occurring due to water pressure and under the forces applied during assembly.

9- A prefabricated and modular storage tank for water or other liquids according to Claim 8, characterized in that the sealing gasket (8) between Type C1 and Type C2 Body Panels (6 and 7) is of a 1 or multiple lip type or O-ring type or of both lip and O-ring type.

10- A prefabricated and modular storage tank for water or other liquids according to Claim 8 or 9, characterized in that it comprises an assembly structure for the Type C1 (6) and Type C2 (7) tank body panels where the edge of each body panel (6 or 7) engages with the edge of the adjacent one (7 or 6).

11- A prefabricated and modular storage tank for water or other liquids according to Claim 8,9 or 10, characterized in that it allows clamps to be placed from the outside at the juncture of the Type C1 (6) and Type C2 (7) tank body panels (6 and 7).

12- A prefabricated and modular storage tank for water or other liquids according to any of the above-mentioned Claims, characterized in that a tank base (base plate) (10) is placed at the base of tank; and that the sealing gasket (9) between body panels and tank base, which provides impermeability by swelling under water pressure or by

tightening under the forces occurring due to water pressure or under the weight of the body panels, can be placed between the base plate and the body panels (1, 4, 6, 7).

13- A prefabricated and modular storage tank for water or other liquids according to Claim 12, characterized in that the sealing gasket (9) between the body panels and the base plate, is of a 1 or multiple lip type or O-ring type or of both lip and O-ring type.

14- A prefabricated and modular storage tank for water or other liquids according to any of the above-mentioned Claims, characterized in that the tank assembled with the body panels (1, 4, 6, 7,) is placed on an impermeable flat ground; and that the sealing gasket (11) between body panels and impermeable flat ground, which provides impermeability by swelling under water pressure or by tightening under the forces occurring due to water pressure or under the weight of the body panels, can be placed between the impermeable flat ground and the body panels (1, 4, 6, 7).

15- A prefabricated and modular storage tank for water or other liquids according to Claim 14, characterized in that the section of the sealing gasket (11) between the body panels and flat ground, is of a 1 or multiple lip type or O-ring type or of both lip and O-ring type.

16- A prefabricated and modular storage tank for water or other liquids according to any of the above-mentioned Claims, characterized in that, in the applications where the tank manufactured with body panels (1, 4, 6, 7,) is placed on a permeable or impermeable flat ground, it has a structure allowing the inner sealing cover (12), which completely covers the body panels and the tank base and which is appropriate for the shape of the tank, to be placed inside the tank.

17- A prefabricated and modular storage tank for water or other liquids according to Claim 16, characterized in that, in the applications where the tank manufactured with body panels (1, 4, 6, 7,) is placed on a permeable or impermeable flat ground, the inner sealing cover (12) placed inside the tank is made of rubber, gum elastic, polymer materials.

18- A prefabricated and modular storage tank for water or other liquids according to Claim 16 or 17, characterized in that the inner sealing cover (12) is made of an impermeable and flexible material.

19- A prefabricated and modular storage tank for water or other liquids according to any of the above-mentioned Claims, characterized in that, in the applications comprising

various body panels (1, 4, 6, 7) and having been built with a base, it has a structure allowing the inner sealing cover (12), which completely covers the body panels and the tank base and which is appropriate for the shape of the tank, to be placed.

20- A prefabricated and modular storage tank for water or other liquids according to any of the above-mentioned Claims, characterized in that the side body panels (1, 4, 6, 7) are manufactured in a curved (dished) manner or in shapes that create different visuals in order to create a cylindrical tank body.

21- A prefabricated and modular storage tank for water or other liquids according to any of the above-mentioned Claims, characterized in that the side body panels (1, 4, 6, 7) are manufactured as flat plates or in shapes that create different visuals in order to create a polygonal prismatic (polygon-sectioned) tank body when conjoined.

22- A prefabricated and modular storage tank for water or other liquids according to any of the above-mentioned Claims, characterized in that the wall thicknesses of the side body panels (1, 4, 6, 7) can be the same (consistent) along the height of the tank, or that the panels are manufactured in a way that they are thinner at the upper sections while becoming thicker towards the ground.

23- A prefabricated and modular storage tank for water or other liquids according to any of the above-mentioned Claims, characterized in that it comprises a tank roof which

- Can be placed on the side body panels,
- Can be placed on struts to be erected inside the tank
- Can be placed on struts to be erected outside the tank, or
- Can be placed on a combination of these parts.

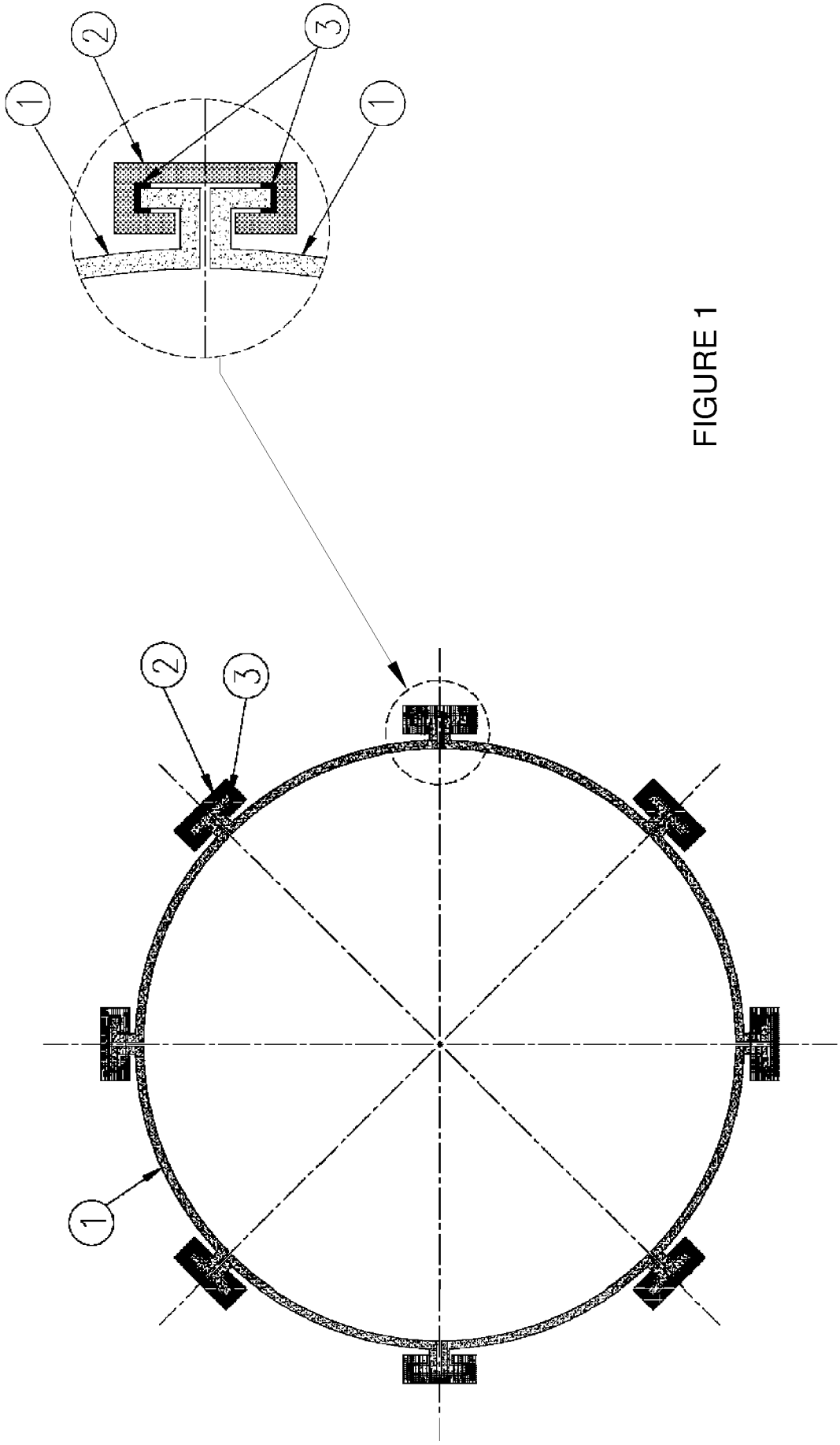

FIGURE 1

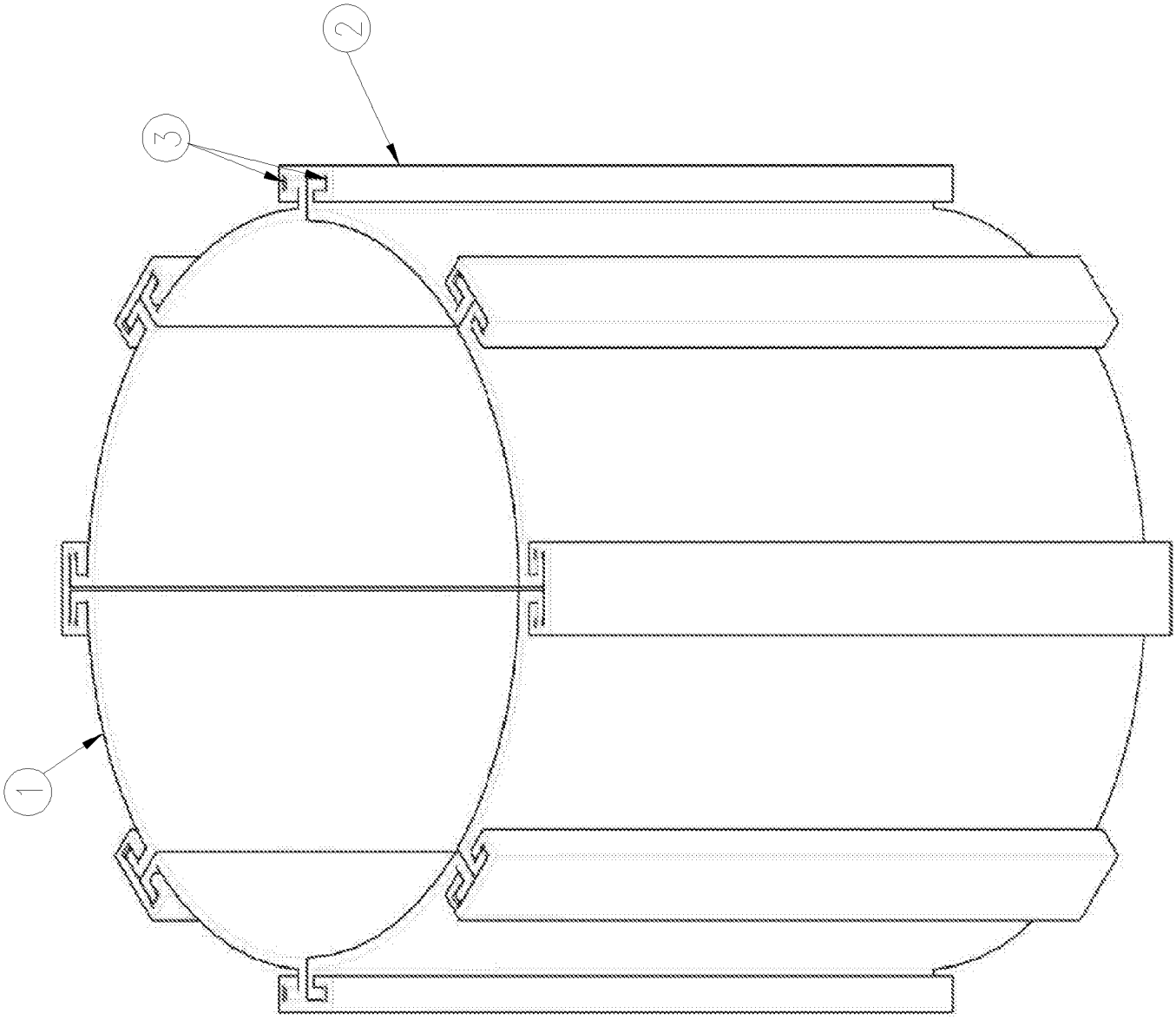

FIGURE 2

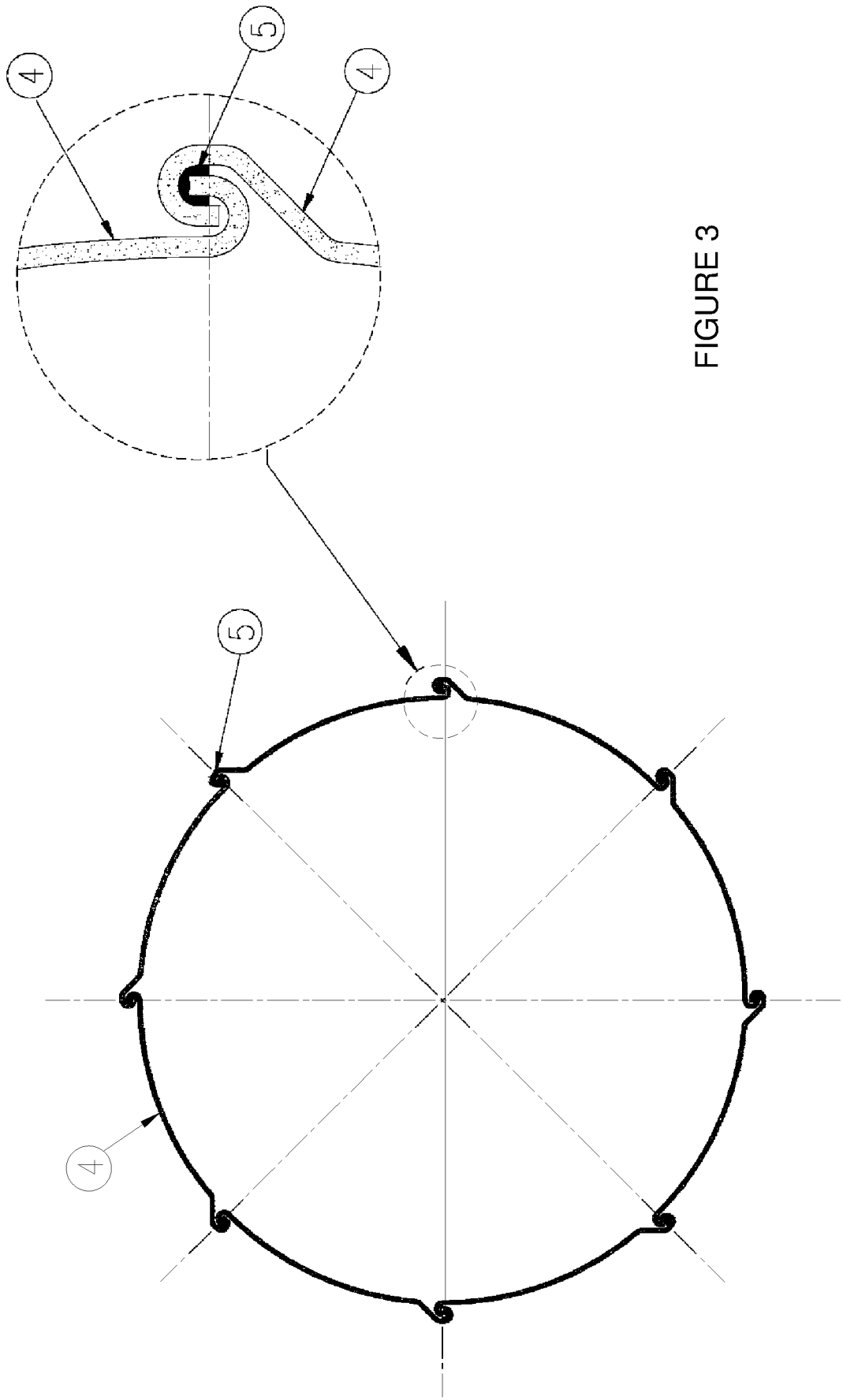

FIGURE 3

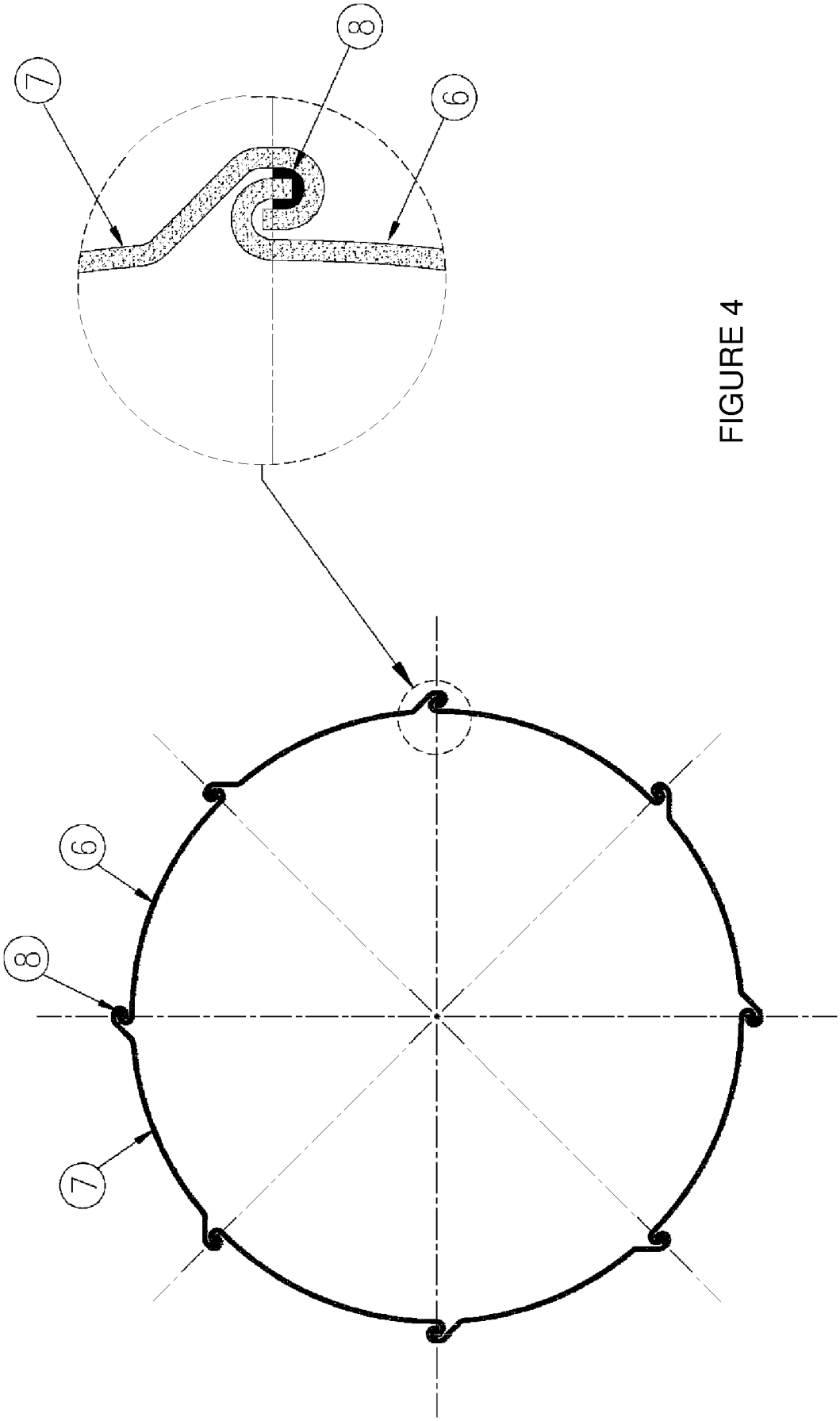

FIGURE 4

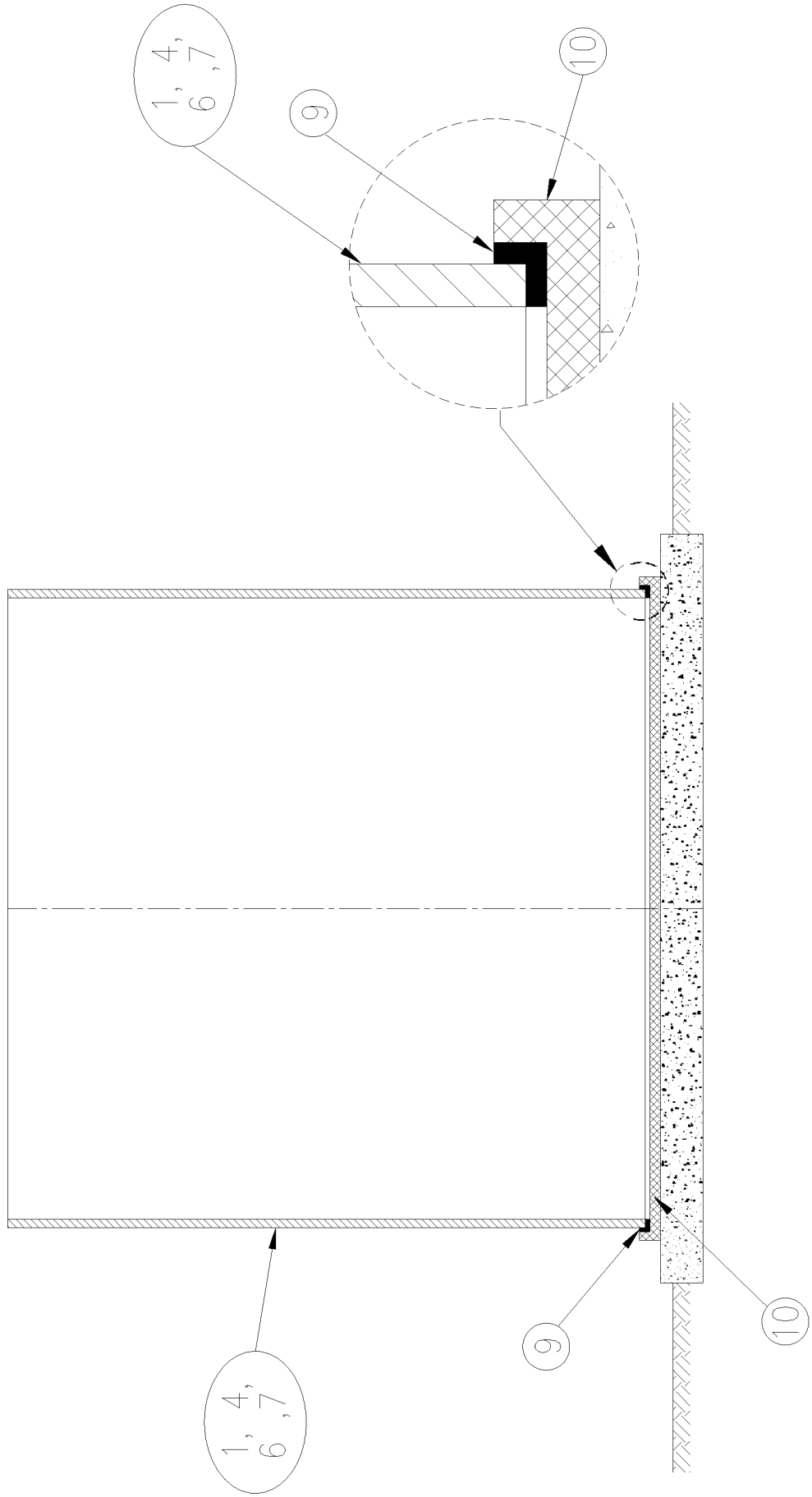

FIGURE 5

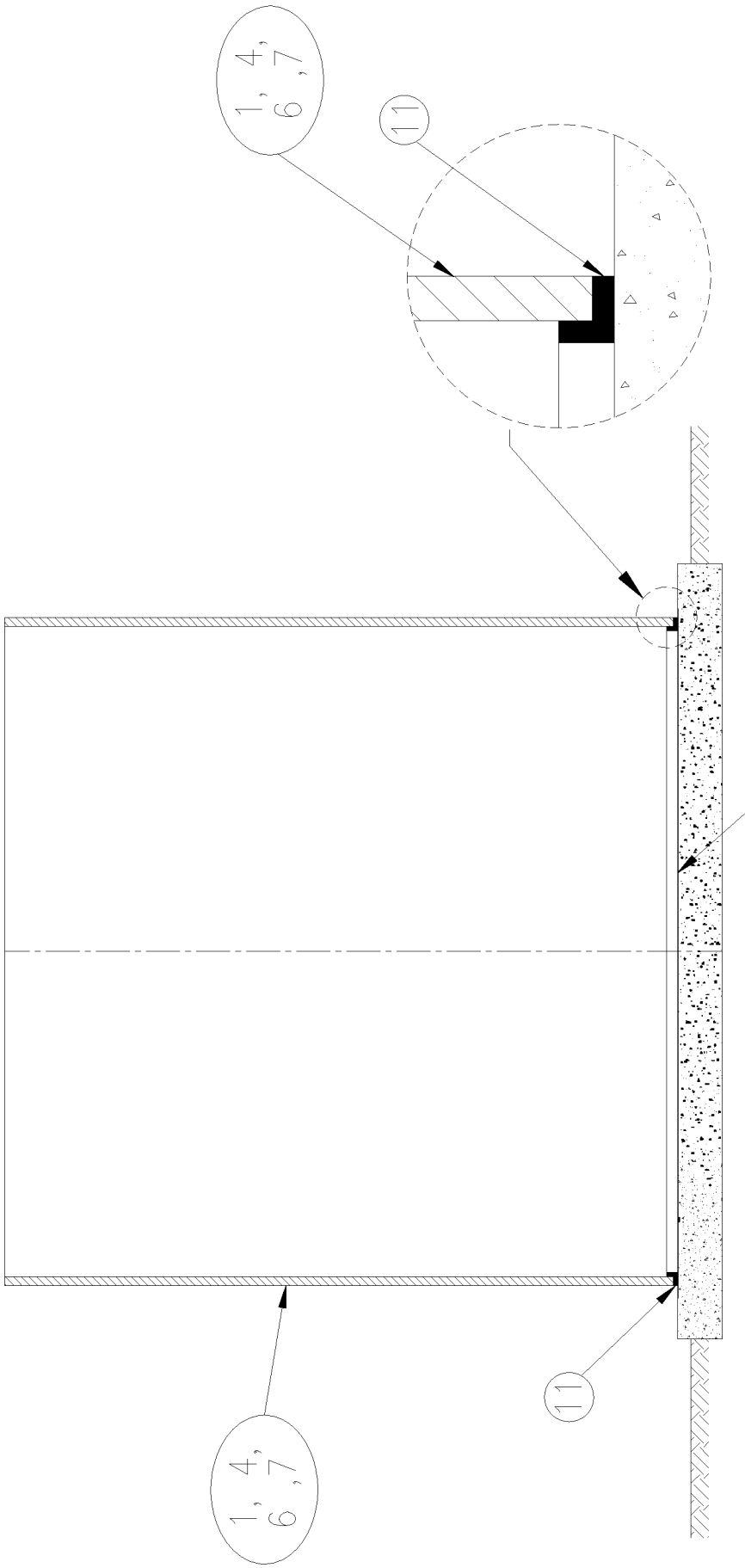

FIGURE 6

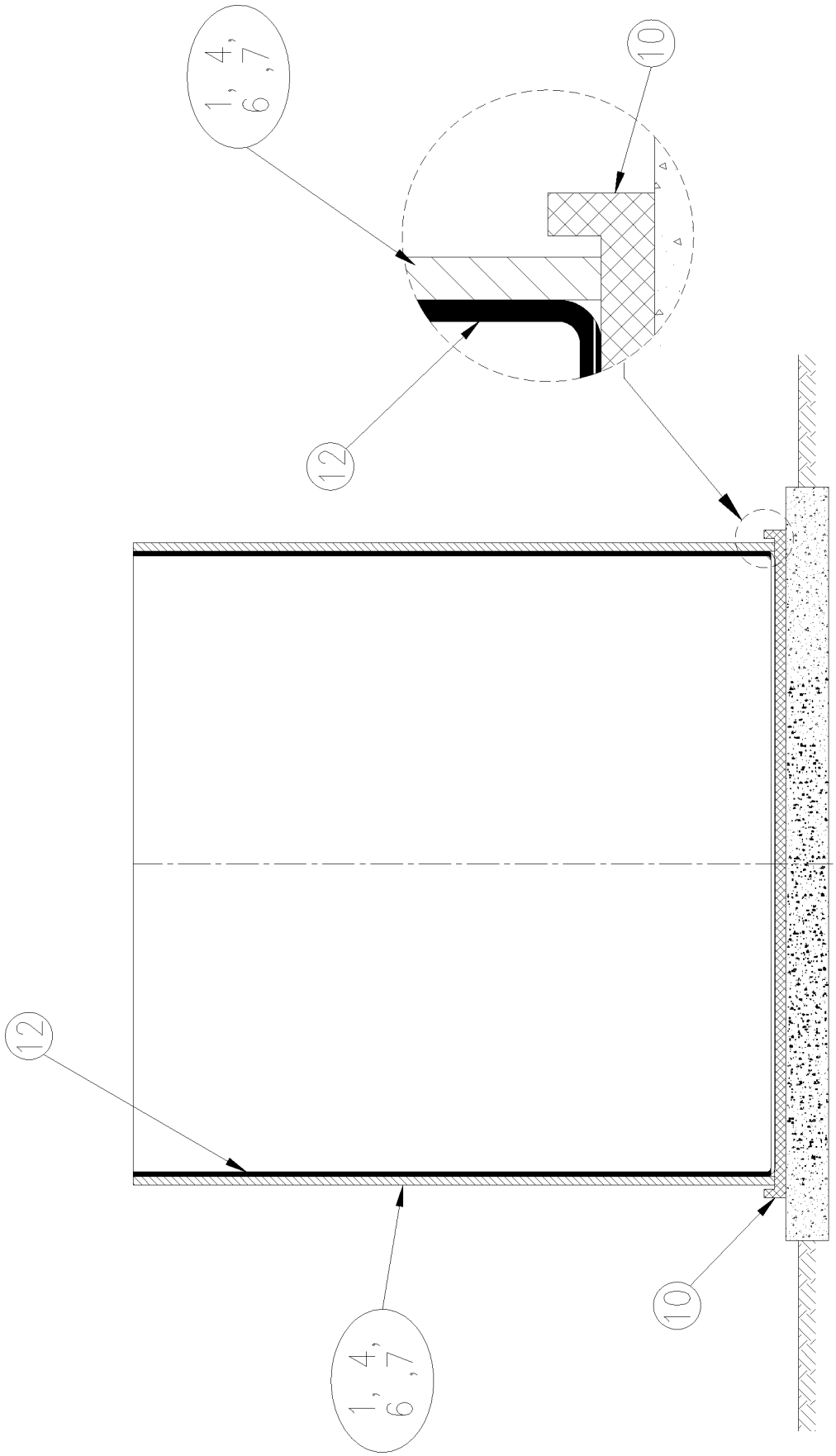

FIGURE 7

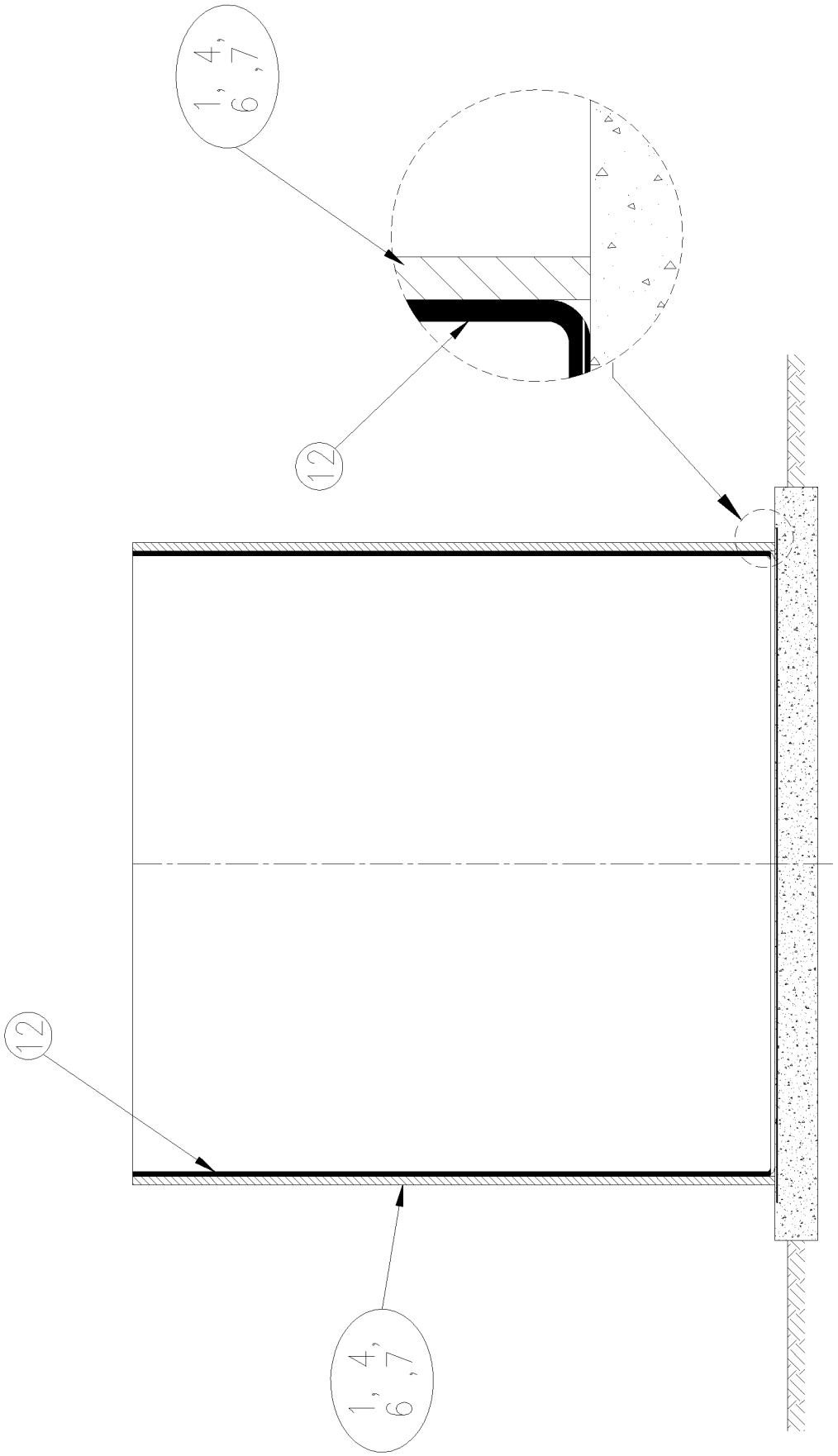

FIGURE 8