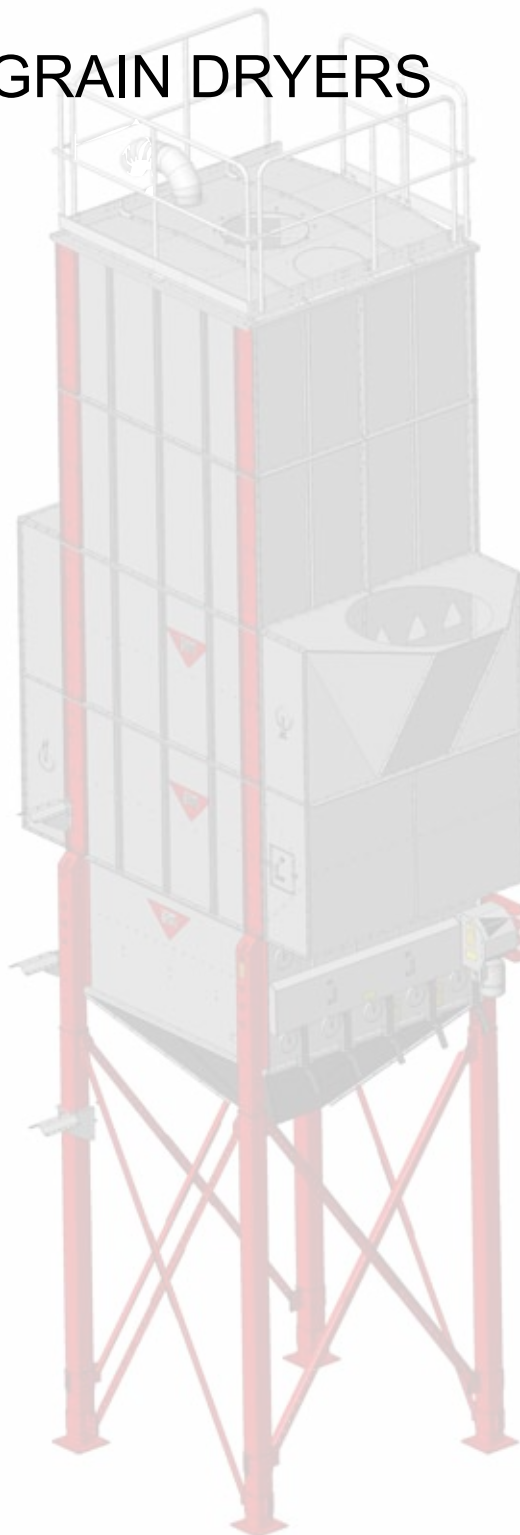


Assembly Instructions

ANTTI M06 2W GRAIN DRYERS BASE

408070 (en) 06-2022



You'll see the difference

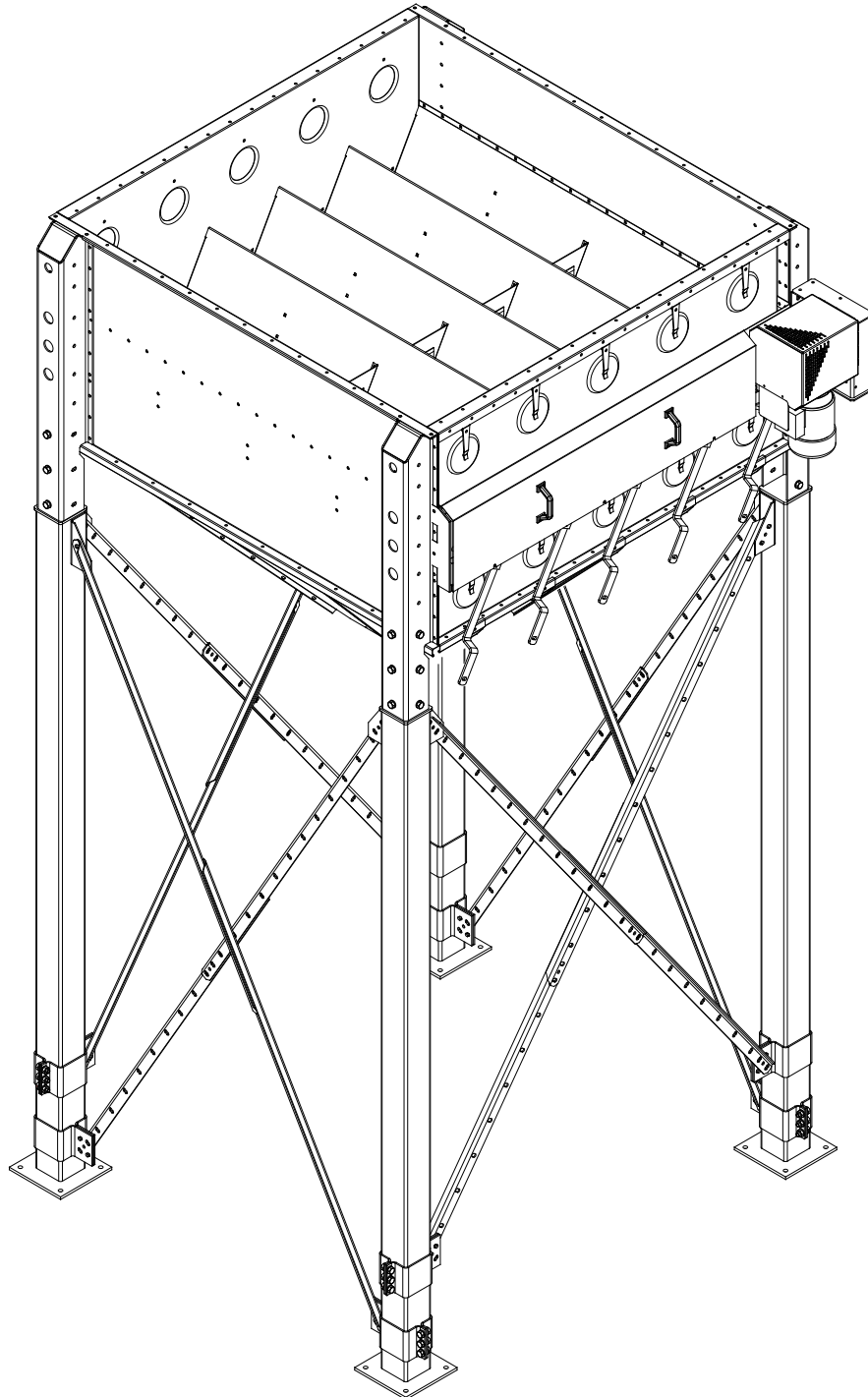
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Base

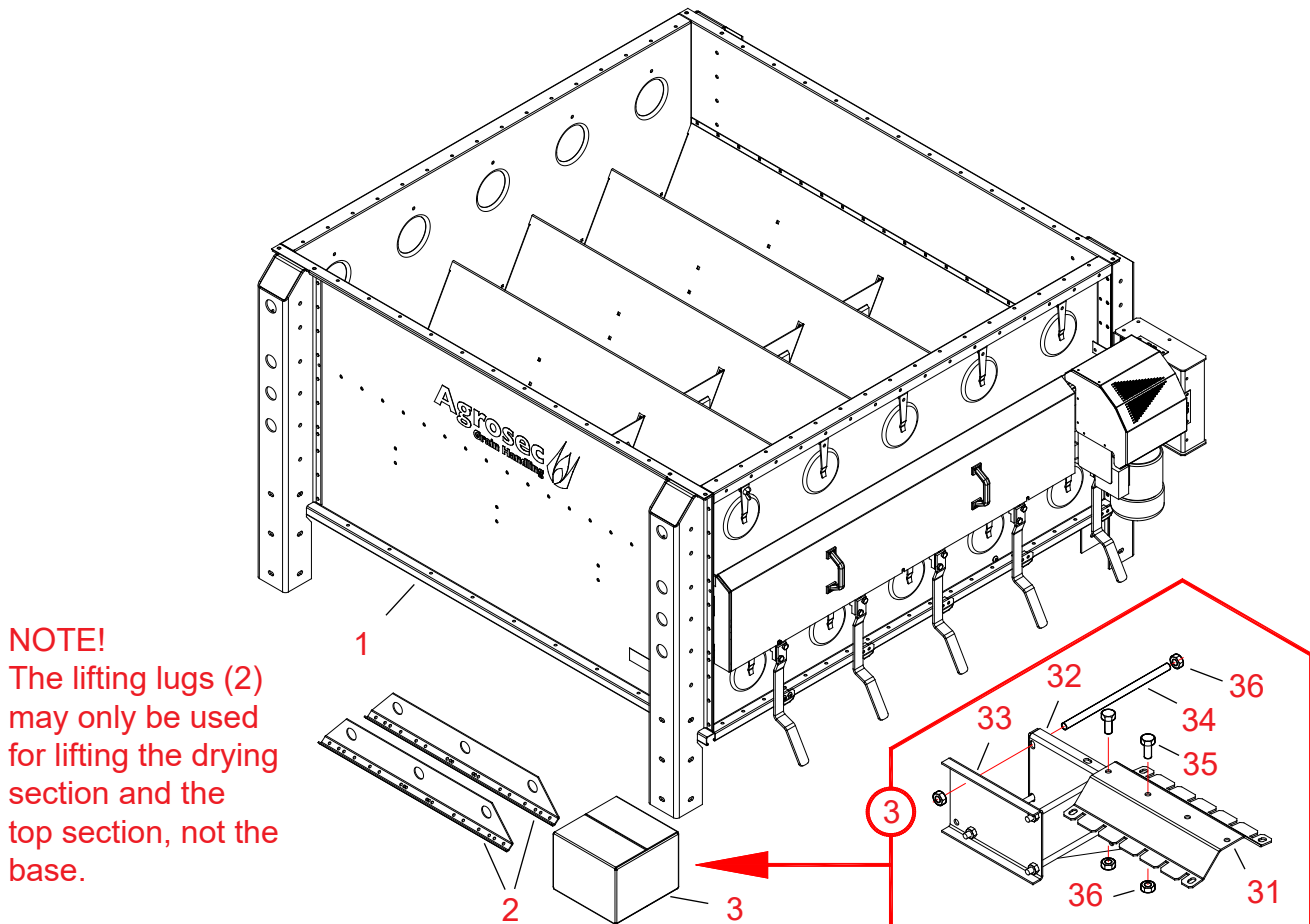
Antti WM06

Base 2W assembled





Base with accessories 2W (A70390), spare parts



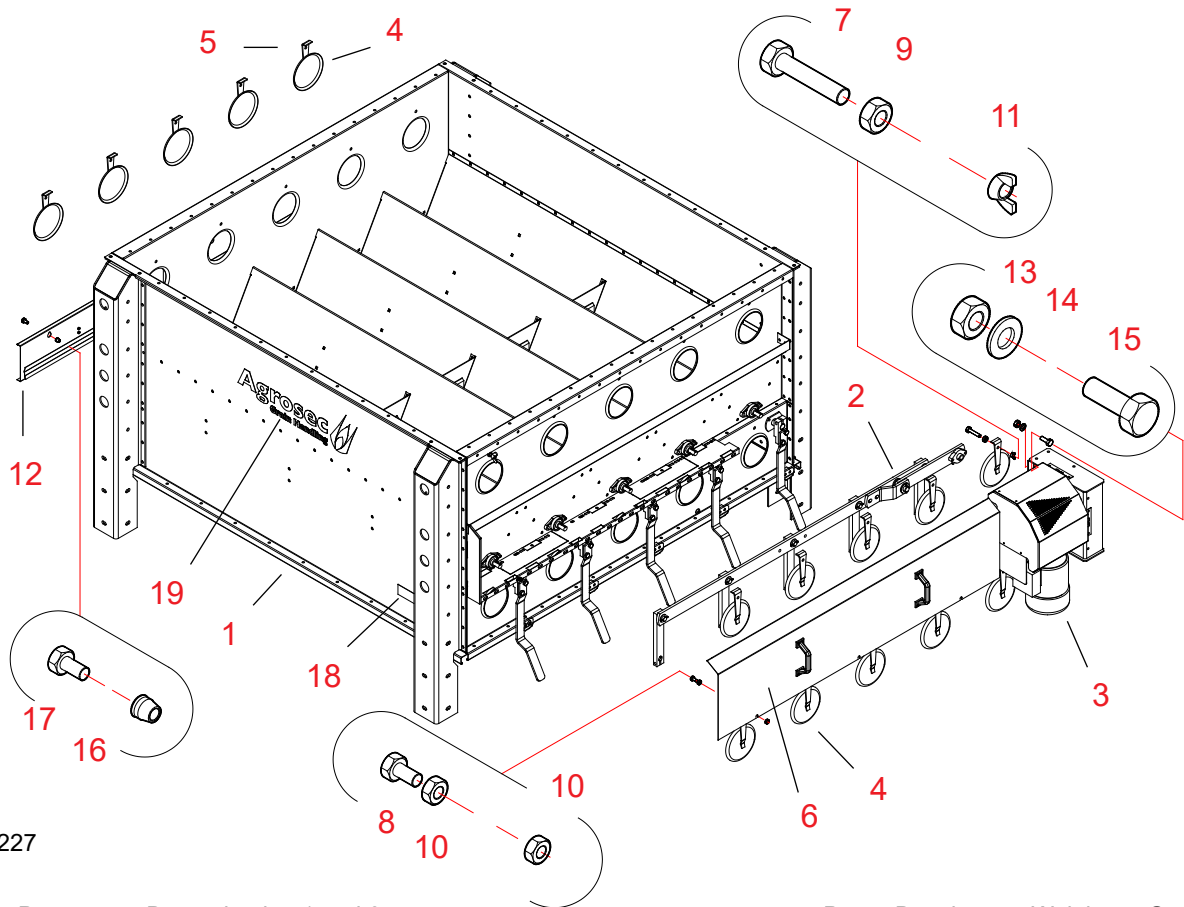
20061227

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	A71516	BASE WM06 2W 1.1 kW	1	A71516	747,32	3000
2	501010	LIFTING LUG, SECTION 4x165x900	2	S32277-D	0	3000
3	A71514	BASE WM06 LOCKING-CHAIN PACK	1	A71514-A	9,87	3000

A71514

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
31	A71513	BASE WM06 2W LOCKING-CHAIN SLOTS	2	A71513-0	1,62	3000
32	A71512	BASE WM06 2W CHAIN ATTACH TRIANGLE	2	A71512-0	1,46	3000
33	A71511	BASE WM06 2W CHAIN ATTACH SUPP	2	A71511-0	0,93	3000
34	A70812	THREADED ROD - M10 L=205	8	A70812-A	0,13	2000
35	102210	BOLT HEX ZN 8.8 10x25 AM DIN933	10		0	2010
36	110560	NUT ZN 8 - M10 DIN934	20		0	2010
37	300502	CARDBOARD BOX LxWxH 300x300x220 No. 5	1		0,38	

Base 2W assembled (A71516), spare parts

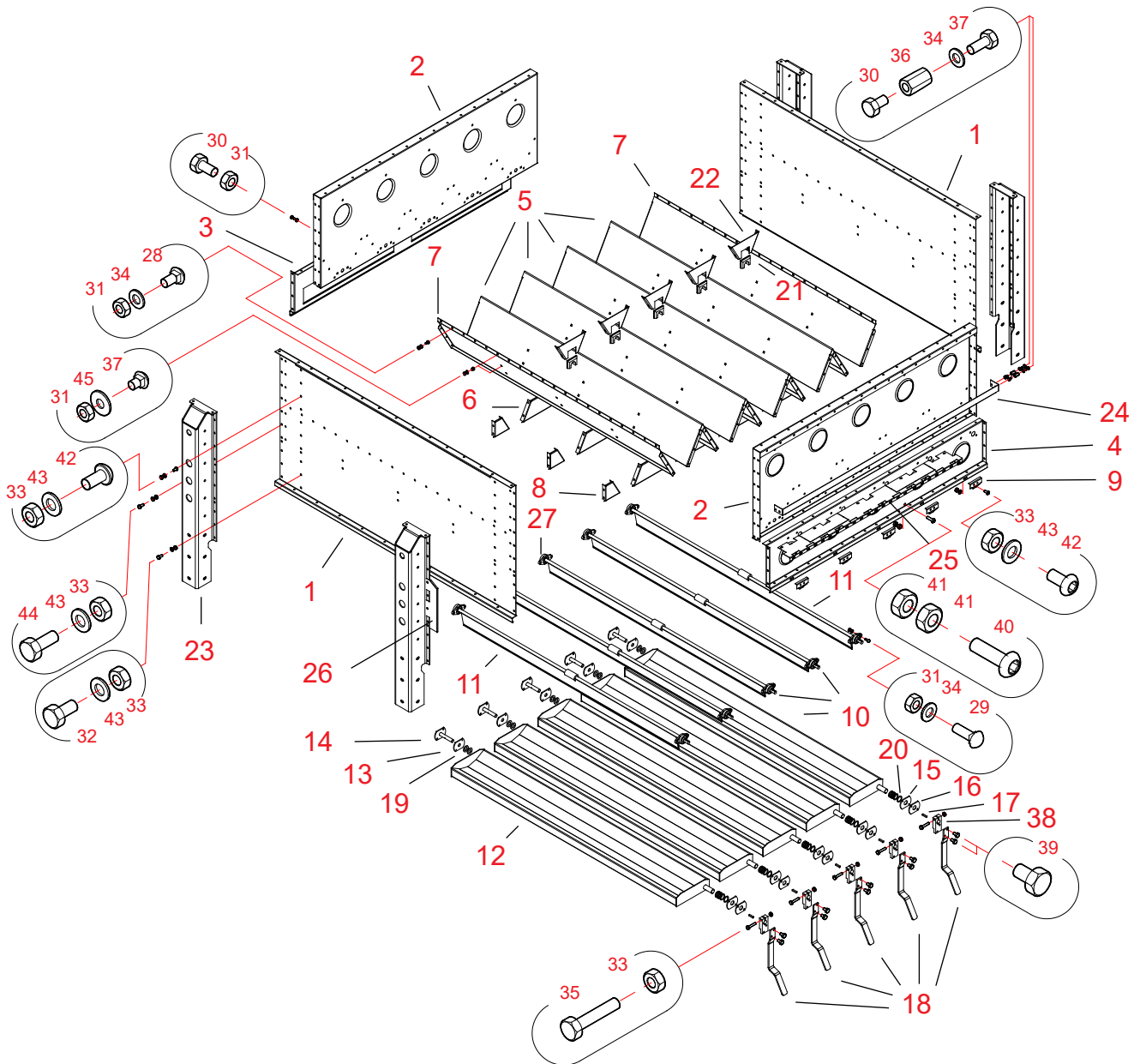


20061227

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	A70342	BASE WM06 2W FRAME	1	A70342	572.19	3000
2	A70398	BASE WM06 2W/4W FEEDER DEVICE ASSEMBLY	1	A70398	21	3000
3	A70416	BASE WM06 MOTOR RACK ASSEMBLY	1	A70416	123.41	3000
4	400140	SHUTTER D173	15	S4293	0	3500
5	400150	HATCH HOLDER	15	4461-B	0	3500
6	A70711	BASE WM06 2W/4W FEEDER COVER	1	A70711	6.68	3000
7	102250	BOLT HEX ZN 8.8 – 10x40 AM DIN933	15		0	2010
8	101810	BOLT HEX ZN 8.8 - 8X16 AM DIN933	3		0	2010
9	110560	NUT ZN 8 - M10 DIN934	15		0	2010
10	110540	NUT ZN 8 – M8 DIN934	6		0	2010
11	111030	NUT WING ZN - M10 DIN315	15		0	2010
12	33043	BASE XL CONTROL HATCH 182x840	2	33043-A	2.46	3000
13	110570	NUT ZN 8 - M12 DIN934	3		0	2010
14	111560	WASHER ZN - M12 DIN125	3		0	2010
15	102520	BOLT HEX ZN 8.8 - 10X25 AM DIN933	3		0	2010
16	110553	STUD NUT - M8 1.5-4.0 MM CTRSUNK	4		0	2010
17	103628	BOLT CTRSUNK SLOT ZN – 8x16 AM	4		0	2010
18	117909	PLATE STICKER 101x50 THT-55-434-1	1	41573-B	0	2900
19	117831	PLATE STICKER 150x500 AGROSEC GRAIN HANDLING	2		0	2900



Base frame 2W (A70342), spare parts





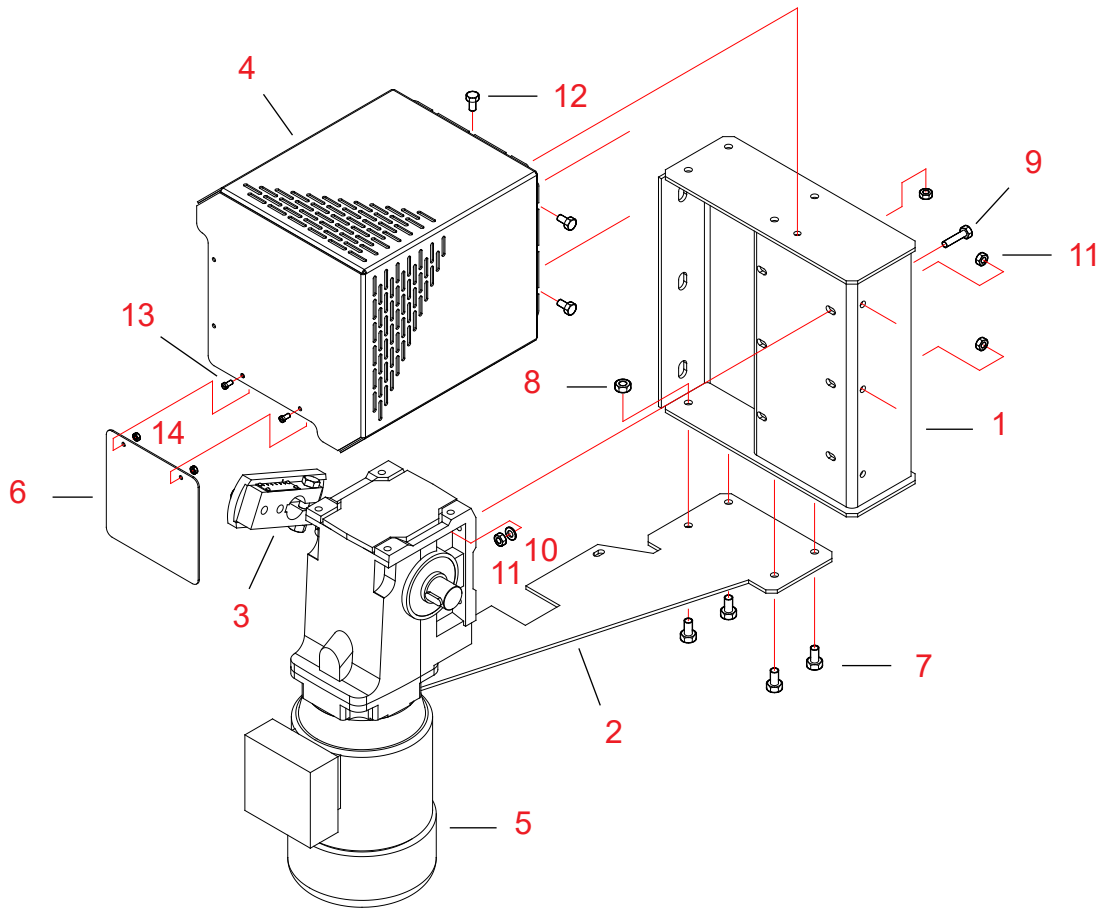
Base

Antti WM06

20061106

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	A70649	BASE WM06 FEEDER SIDE-PLATE	2	A70649	36,69	3000
2	A70701	BASE WM06 2W/4W END-PL TOP PART	2	A70701	24,79	3000
3	A70702	BASE WM06 2W/4W END-PLATE BOTT OPEN	1	A70702	9,73	3000
4	A70510	BASE WM06 2W/4W FEEDER END-PL BOTT OPEN	1	A70510-C	11,72	3000
5	A70381	BASE WM06 2W/4W FEEDER DUCT 1/1	4	A70381-B	19,64	3000
6	A70387	BASE WM06 2W/4W SUPPORT PLATE 1/1	12	A70387-A	0,61	3000
7	A70388	BASE WM06 SUCT FEEDER DUCT 1/2	2	A70388-B	10,55	3000
8	A70389	BASE WM06 SUPPORT PLATE ½ DUCT	6	A70389-A	0,31	3000
9	A70435	BASE WM06 TROUGH ROD STOPPER	5	A70435-C	0,06	3000
10	501704	BASE FEEDER I D20-2050H=85M,XL,EL	3	32226-D	0	3000
11	501705	BASE FEEDER II D20-2050H=105M,XL,EL	2	32227-D	0	3000
12	A70371	BASE WM06 FEED TROUGH	5	A70371	25,91	3000
13	400200	BASE ATTACH PLATE D20.5/M8	5	4606	0	3000
14	A70836	BASE WM06 TROUGH HOLDER	5	A70836	0,48	3000
15	A70385	BASE WM06 ATTACH PLATE D30.5/M8	5	A70385	0,19	3000
16	A70386	BASE WM06 ATTACH PLATE D30.5/D10	5		0,18	3000
17	A70439	KEY DIN 6885B 7x8 - 35	5	A70439	0,02	3000
18	A71320	BASE WM06 TROUGH ROD BAR 8x40	5	A71320	1,24	3000
19	400345	WASHER PL4 D41/D22.5	10		0	4500
20	400348	WASHER ZN PL1.5 D41/31	25		0	4500
21	313303	BEARING PLASTIC 55x80 MEGA 41646-A	5	41646	0	2100
22	A70399	BASE WM06 2W/4W BEARING SUPP PLATE	5	A70399	0,57	3000
23	A70356	BASE WM06 LEG	4	A70356	26,37	3000
24	A70522	BASE WM06 2W FEEDER COVER ATTACH	1	A70522-A	2,92	3000
25	A70524	BASE WM06 FEEDER COVER BOTTOM	1	A70524-A	2,41	3000
26	A70686	BASE WM06 FEEDER COVER END	1	A70686-A	0,26	3000
27	313100	BEARING FLANGE UCFL 204 CAST P	10		0	2100
28	107913	LOCK SCREW ZN - M8x20 DIN603 8.8	4		0	2010
29	107902	LOCK SCREW ZN - M8x25 DIN603	20		0	2010
30	101810	BOLT HEX ZN 8.8 - 8X16 AM DIN933	136		0	2010
31	110540	NUT ZN 8 - M8 DIN934	252		0	2010
32	102200	BOLT HEX ZN 8.8 - 10x20 AM DIN933	28		0	2010
33	110560	NUT ZN 8 - M10 DIN934	98		0	2010
34	111540	WASHER ZN - M8 DIN125	36		0	2010
35	101903	BOLT HEX ZN 8.8 - 10x60 AM DIN933	5		0	2010
36	110626	NUT EXTENSION - M8x24 ZN DIN6334	2		0	2010
37	107910	LOCK SCREW ZN - M8x16 DIN603 8.8	92		0	2010
38	A71321	BASE WM06 TROUGH ROD SHAFT ATTACH	5	A71321	0,75	3000
39	102499	BOLT HEX ZN 8.8 - 12x20 AM DIN933	10		0	2010
40	104263	SOCK SCREW BALL-H - 12x40 AM ISO 7380	1		0	2000
41	110570	NUT ZN 8 - M12 DIN934	2		0	2010
42	104259	SOCK SCREW BALL-H - 10x20 AM ISO 7380	26		0	2010
43	111550	WASHER ZN - M10 DIN125	98		0	2010
44	102210	BOLT HEX ZN 8.8 10x25 AM DIN933	44		0	2010
45	111532	WASHER ZN FENDER - M8 DIN9021	32		0	2010

Motor rack (A70416), spare parts

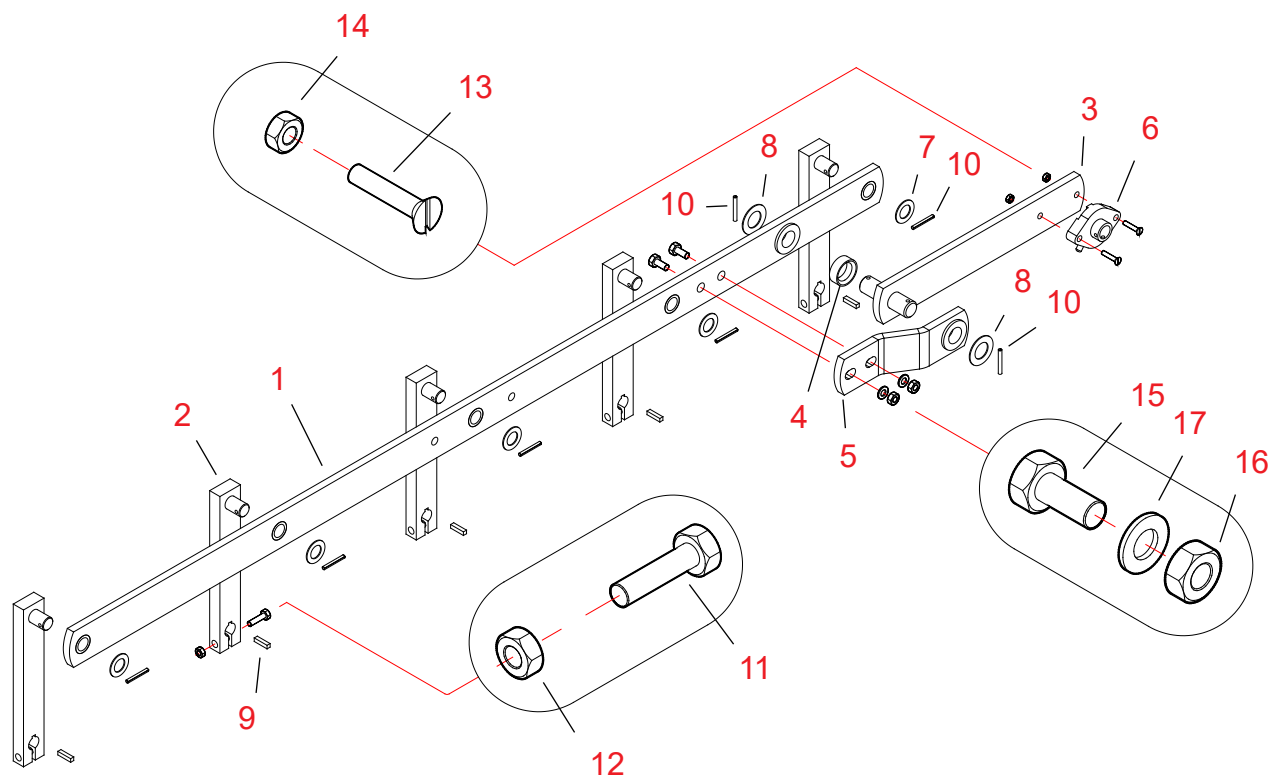


20060921

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	A70411	BASE WM06 MOTOR RACK	1		12.33	3000
2	A70415	BASE WM06 TORQUE ARM MOT RACK	1	A70415	2.85	3000
3	A70520	BASE WM06 DRYER ECC D32/20/0-50	1	A70520-A	1.99	3000
4	A70493	BASE WM06 ECCENTRIC COVER	1	A70493-C	4.33	3000
5	304285	MOTOR CONE 1.1KW 32-30 NORD SK92372LX	1		0	2200
6	A70696	BASE WM06 ECCENTRIC COVER ADD	1	A70696	8.69	3000
7	102200	BOLT HEX ZN 8.8 – 10x25 AM DIN933	4		0	2010
8	110560	NUT ZN 8 - M10 DIN934	4		0	2010
9	101860	BOLT HEX ZN 8.8 – 8x35 AM DIN933	4		0	2010
10	111540	WASHER ZN - M8 DIN125	4		0	2010
11	110540	NUT ZN 8 – M8 DIN934	7		0	2010
12	101810	BOLT HEX ZN 8.8 - 8X16 AM DIN933	3		0	2010
13	100700	BOLT CYL-HEAD SLOT ZN – 5x8 AM DIN84	2		0	2010
14	110520	NUT ZN 8 – M5 DIN934	2		0	2010



Feeding equipment 2W (A70398), spare parts

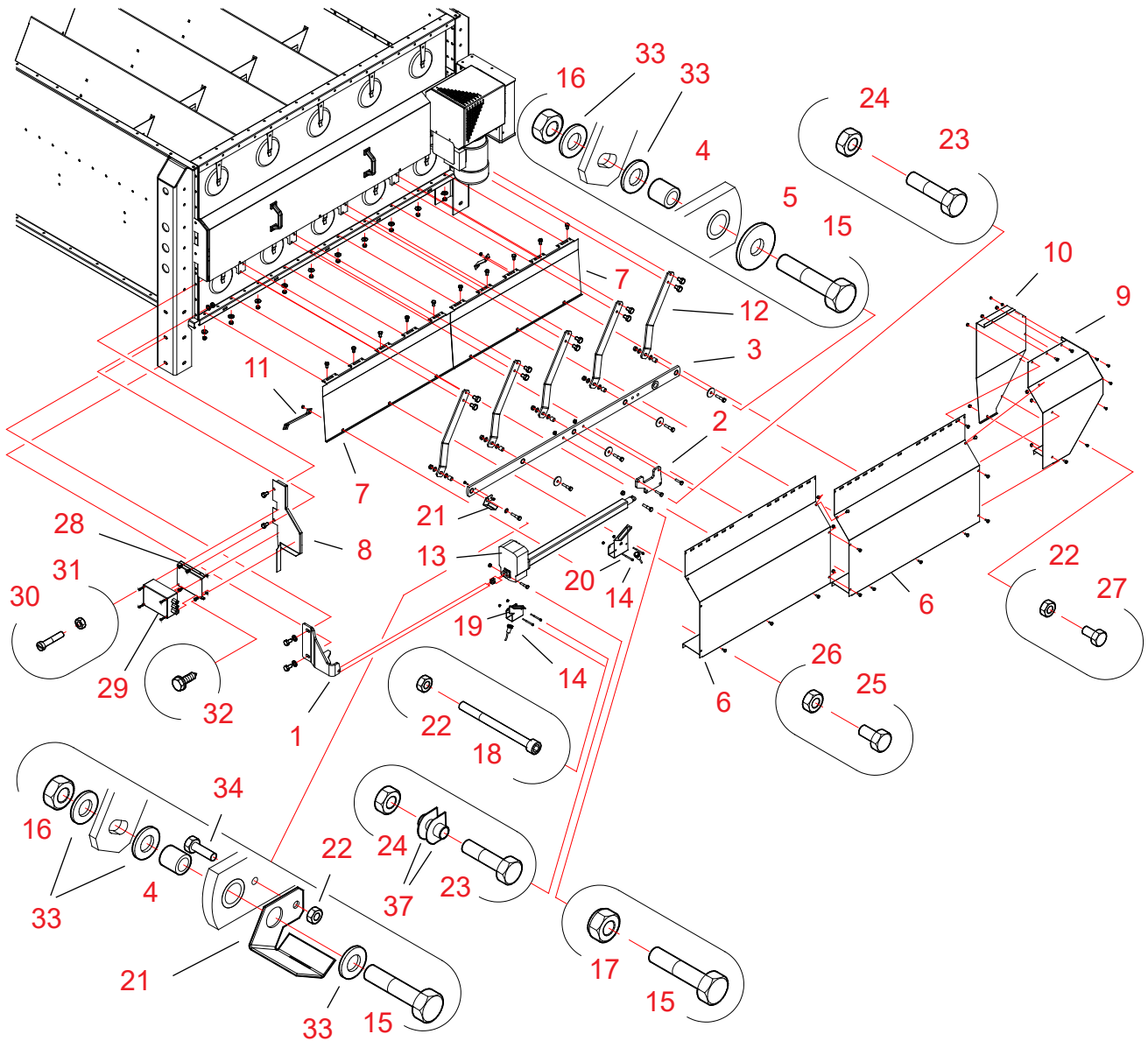


20060601

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	31696	BASE EL,XL,2W,4W CONNECT ROD. 12X60-1588	1	31696-A	8.9	3000
2	501440	BASE PENDEL ARM ELK,20X40-265 D20/20	5	31242-A	0	3000
3	402420	BASE XL,EL TRANSMISSION ROD+SHAFT	1	A70331	0	2900
4	400185	BASE SPACER SLEEVE D40/28 L=14	1	A70332	0	2900
5	402421	BASE XL,EL SUPPORT ROD	1	A70421	0	3000
6	116510	BEARING FLANGE GLCTEY20 CAST P	1		0	2100
7	400347	WASHER AISI PL1.5 D35/20.5	5		0	4500
8	400344	WASHER AISI PL1.5 D45/25,5	2	21175,4	0	4500
9	A70438	KEY 6x6 - 25	5		0.01	3000
10	112540	SPRING PIN D5x40	7		0	2010
11	102282	BOLT HEX ZN 8.8 – 10x50 CM DIN931	5		0	2010
12	110560	NUT ZN 8 - M10 DIN934	5		0	2010
13	103640	BOLT CTRSUNK SLOT ZN – 8x40 AM	2		0	2010
14	110540	NUT ZN 8 – M8 DIN934	2		0	2010
15	102540	BOLT HEX ZN 8.8 – 12x40 AM DIN933	2		0	2010
16	110570	NUT ZN 8 - M12 DIN934	2		0	2010
17	111560	WASHER ZN - M12 DIN125	2		0	2010



Linear actuator drive for the feed troughs 2W (A70492) (optional), spare parts



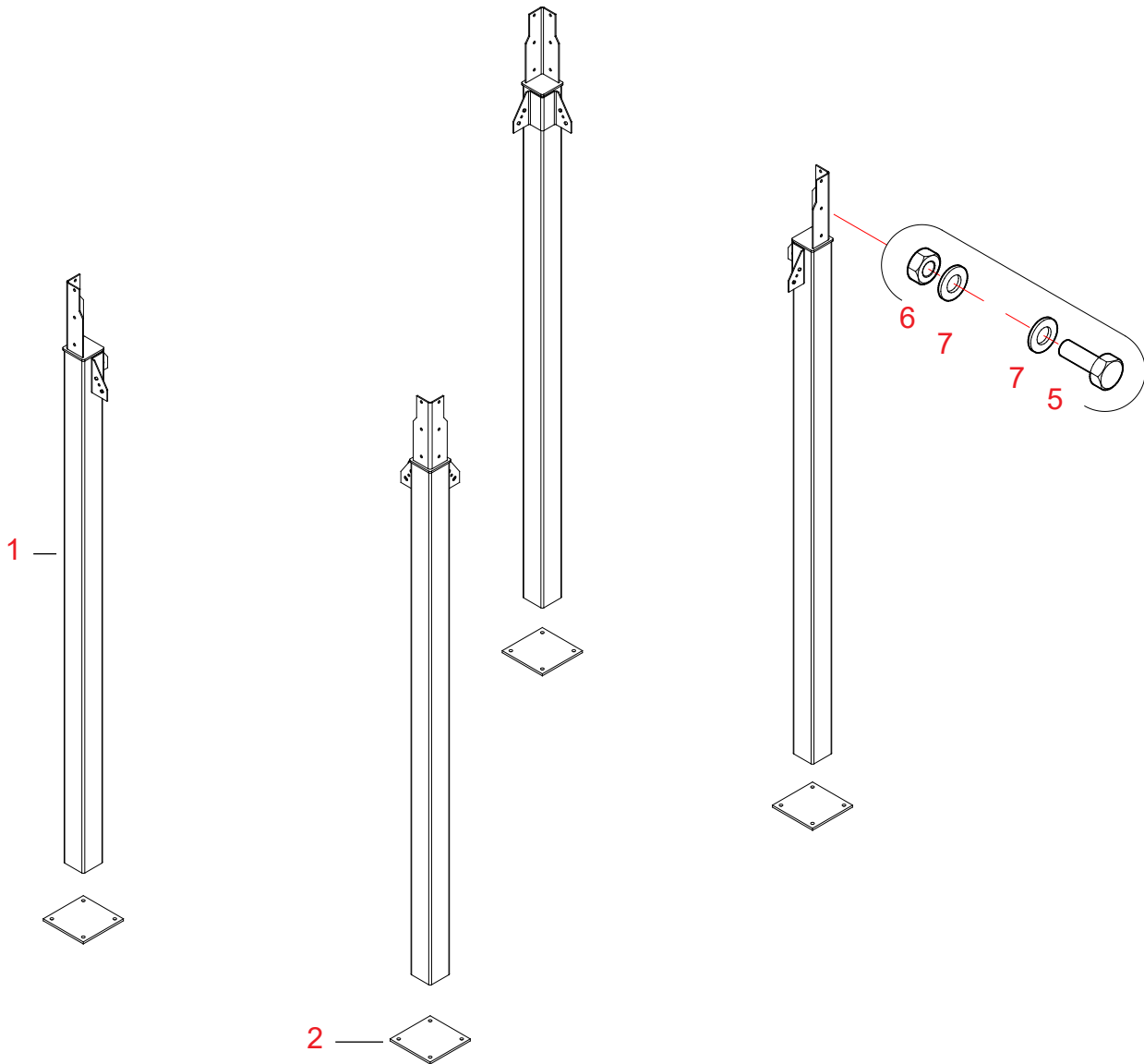


20100201

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	A70491	BASE WM06 LINEAR ACTUAT BRACKET	1	A70491	3,63	3000
2	A70480	BASE WM06 LINEAR ACTUAT INTERM PL	1	A70480	1,12	3000
3	31696	BASE EL,XL,2W,4W CONNECT ROD. 12X60-1588	1	31696	8,84	3000
4	A70444	BASE WM06 SLEEVE 13/19.5 L=20	5	A70444	0,03	3000
5	400342	WASHER - PL5 D52/13	4		0,08	4500
6	A70693	BASE WM06 TROUGH COVER PL	2	A70693	9,79	3000
7	A70695	BASE WM06 LINEAR ACTUAT COV ATTACH PL	2	A70695	2,82	3000
8	A70697	BASE WM06 LINEAR ACT COVER END	1	A70697	0,8	3000
9	A70698	BASE WM06 REAR COVER PL	1	A70698	4,6	3000
10	A70699	BASE WM06 LINEAR ACT COV REAR	1	A70699	1,62	3000
11	A71147	BASE WM06 LINEAR ACT COV SUPP	2	A71147	0,2	3000
12	A71316	BASE WM06 TROUGH ROD LINEAR ACT	5	A71316	1,49	3000
13	300368	LINEAR ACTUATOR MAGNETIC MAX64-C700A01M	1		27,09	2200
14	300312	LIMIT SWITCH INDUCT OM240VAC E2E-X5Y2/NC	2		0,11	2400
15	102580	BOLT HEX ZN 8.8 – 12x55 CM DIN931	6		0	2010
16	110570	NUT ZN 8 - M12 DIN985	5		0	2010
17	110810	NUT NYLOC ZN - M12 DIN933	1		0	2010
19	A71869	BASE WM06 LIN ACTUATOR SENSOR BRACKET CLOSE	1	A71869	0,27	3000
20	A71870	BASE WM06 LIN ACTUATOR SENSOR BRACKET OPEN	1	A71870	0,40	3000
21	A71884	BASE WM06 LIN ACTUATOR SENSOR TUMBLER	1	A71884	0,09	3000
22	110530	NUT – M6 DIN934	10		0	2010
23	102250	BOLT HEX ZN – 10x40 DIN933	3		0,03	2010
24	110560	NUT ZN 8 - M10 DIN934	3		0,01	2010
25	101810	BOLT HEX ZN 8.8 - 8X16 AM DIN933	16		0,01	2010
26	110540	NUT ZN 8 – M8 DIN934	16		0	2010
27	101500	BOLT HEX ZN – 6x14 DIN933	5		0	2010
28	A71885	ATTACHM PL BOX 32824	1	A71885	0,43	3100
29	32824	ELEV SHUTTER-PL LIN ACT CONNECT BOX 60-90 E130	1		14,20	3100
30	100340	BOLT CYL-HEAD SLOT ZN – 4x20 AM DIN84	4		0	2010
31	110510	NUT – M4 DIN934	4		0	2010
32	107720	SCREW SELF-TAP HEX 4.8x13 ZN	4		0	2010
33	111560	WASHER ZN - M12 DIN125 ZN	11		0	2010
34	101510	BOLT HEX ZN – 6x20 DIN933	1		0	2010
35	300371	CONTROL CABLE LIN ACT MAGNETIC 0100294	1		0	2200
36	300372	MAINS CABLE LIN ACT MAGNETIC 0100021	1		0	2200
37	300373	ATTACH SLEEVE LINEAR ACTUATOR MAGNETIC	2		0	2200



Extension leg set 2W (A70525), spare parts; L = 3100 mm

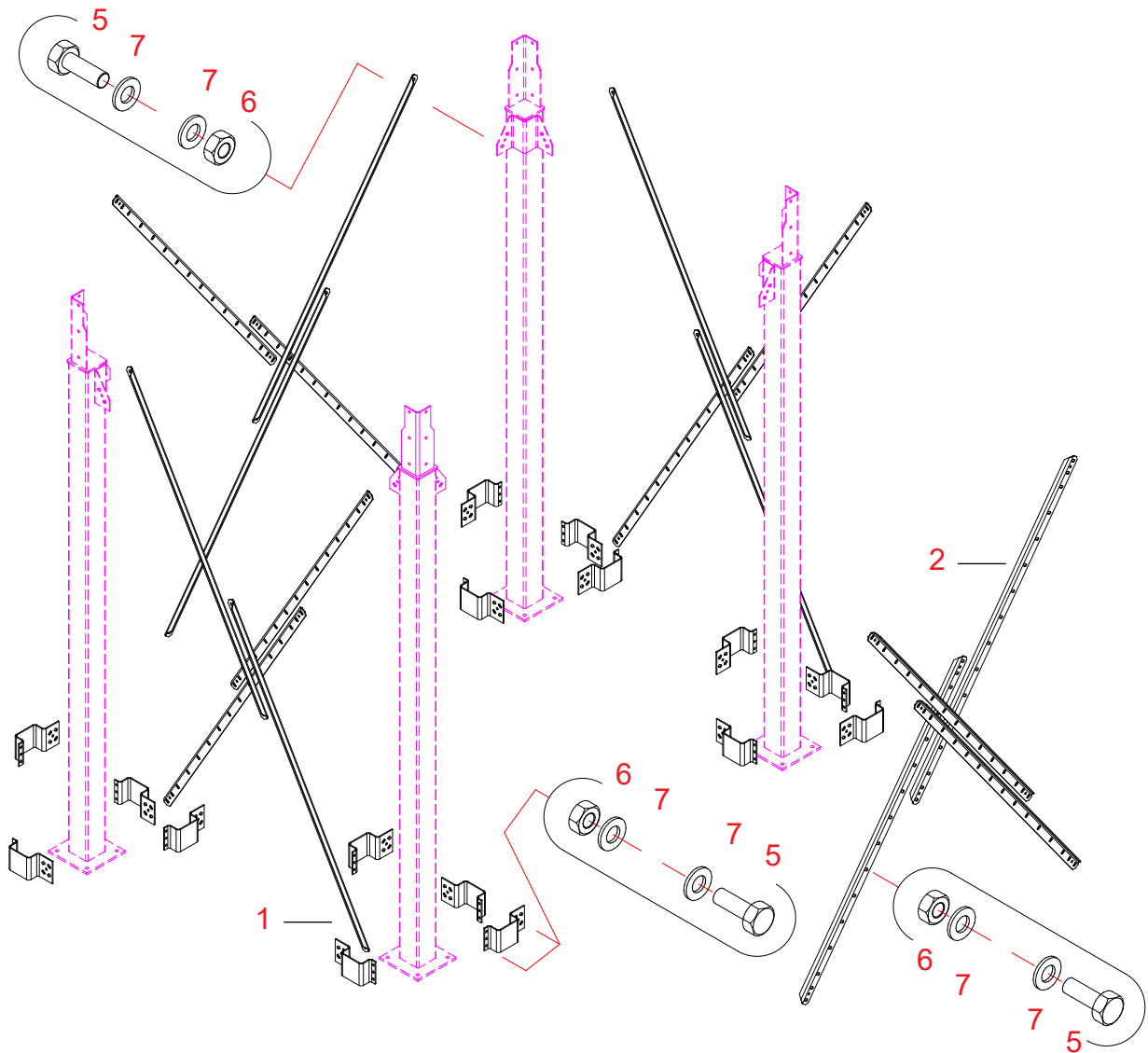


20060601

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
-	A70525	BASE WM06 LEGS 3100 PACK.	1	A70525		3000
THE SET INCLUDES:						
1	A70424	BASE M06W EXTENSION LEG 2W	4	A70424	72.36	3000
2	A70561	LEGS WM06 END-PLATE 12X280X280	4	A70561	7.29	3000
5	102520	BOLT HEX ZN 8.8 - 12X35 AM DIN933	24		0.04	2010
6	110570	NUT ZN 8 - M12 DIN934	24		0.02	2010
7	111560	WASHER ZN - M12 DIN125	48		0	2010



Cross-braces for extension legs 2W (A71522), spare parts; legs L = 3100 mm

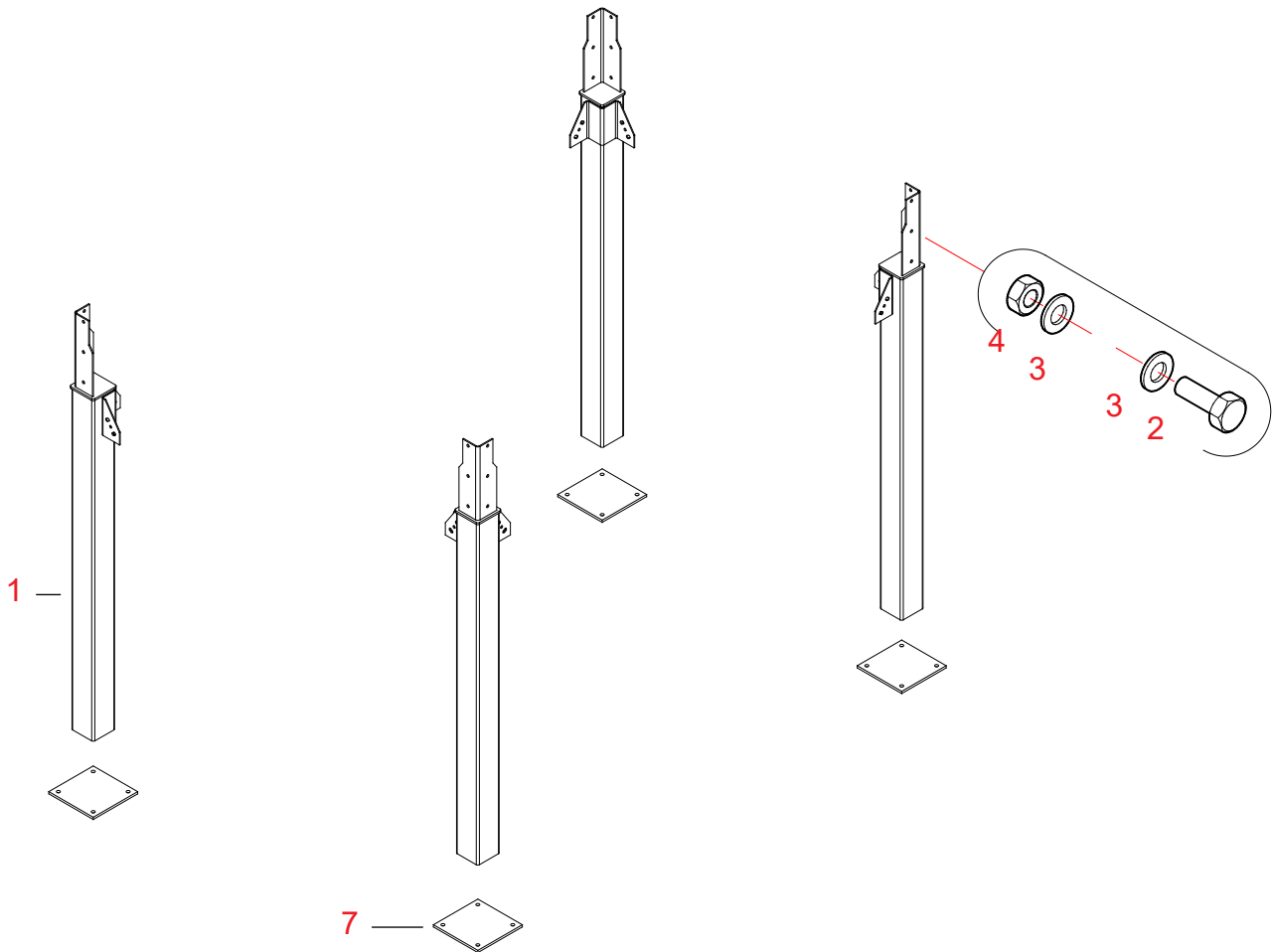


20060601

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	A70527	BASE M06W ADJUST BRACKET 2W	16	A70527-A	2.57	3000
2	A70528	LEGS M06W CROSS-BRACE L = 2000	16	A70528-C	5.92	3000
5	102520	BOLT HEX ZN 8.8 - 12X35 AM DIN933	100		0.04	2010
6	110570	NUT ZN 8 - M12 DIN934	100		0.02	2010
7	111560	WASHER ZN - M12 DIN125	200		0	2010



Extension leg set 2W (A71563), spare parts; L = 1740 mm



20080711

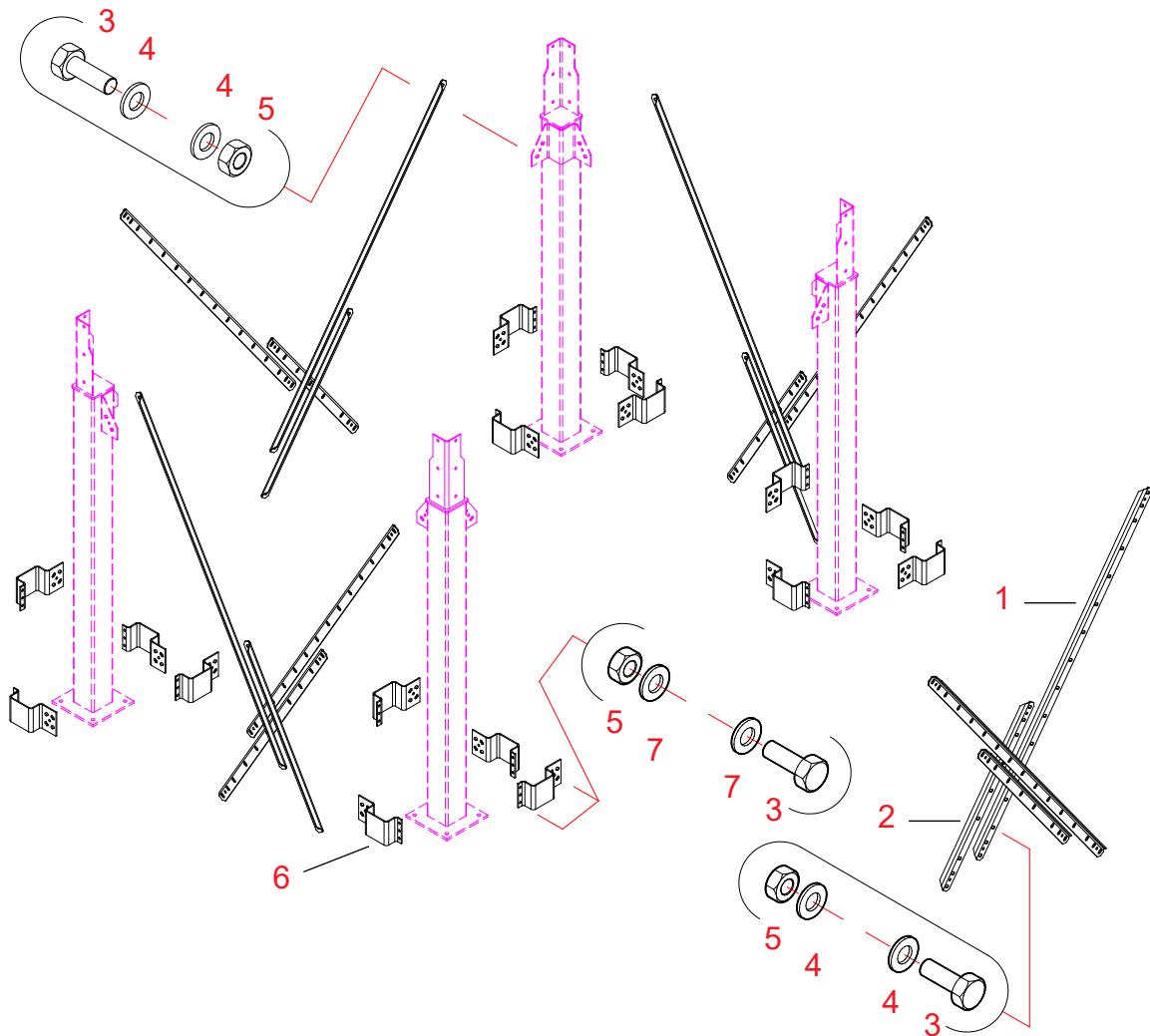
Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
-	A71563	BASE WM06 LEGS 1740 PACK.	1	A71563	207.52	3000

THE SET INCLUDES:

1	A71585	BASE M06W EXTENSION LEG 2W	4	A71585-A	43.98	3000
2	102520	BOLT HEX ZN 8.8 - 10X25 AM DIN933	25		0.04	2010
3	111560	WASHER ZN - M12 DIN125	50		0	2010
4	110570	NUT ZN 8 - M12 DIN934	28		0.02	2010
7	A70561	LEGS WM06 END-PLATE 12X280X280	4	A70561	7.29	3000



Cross-braces for extension legs 2W (A71564), spare parts; legs L = 1740 mm

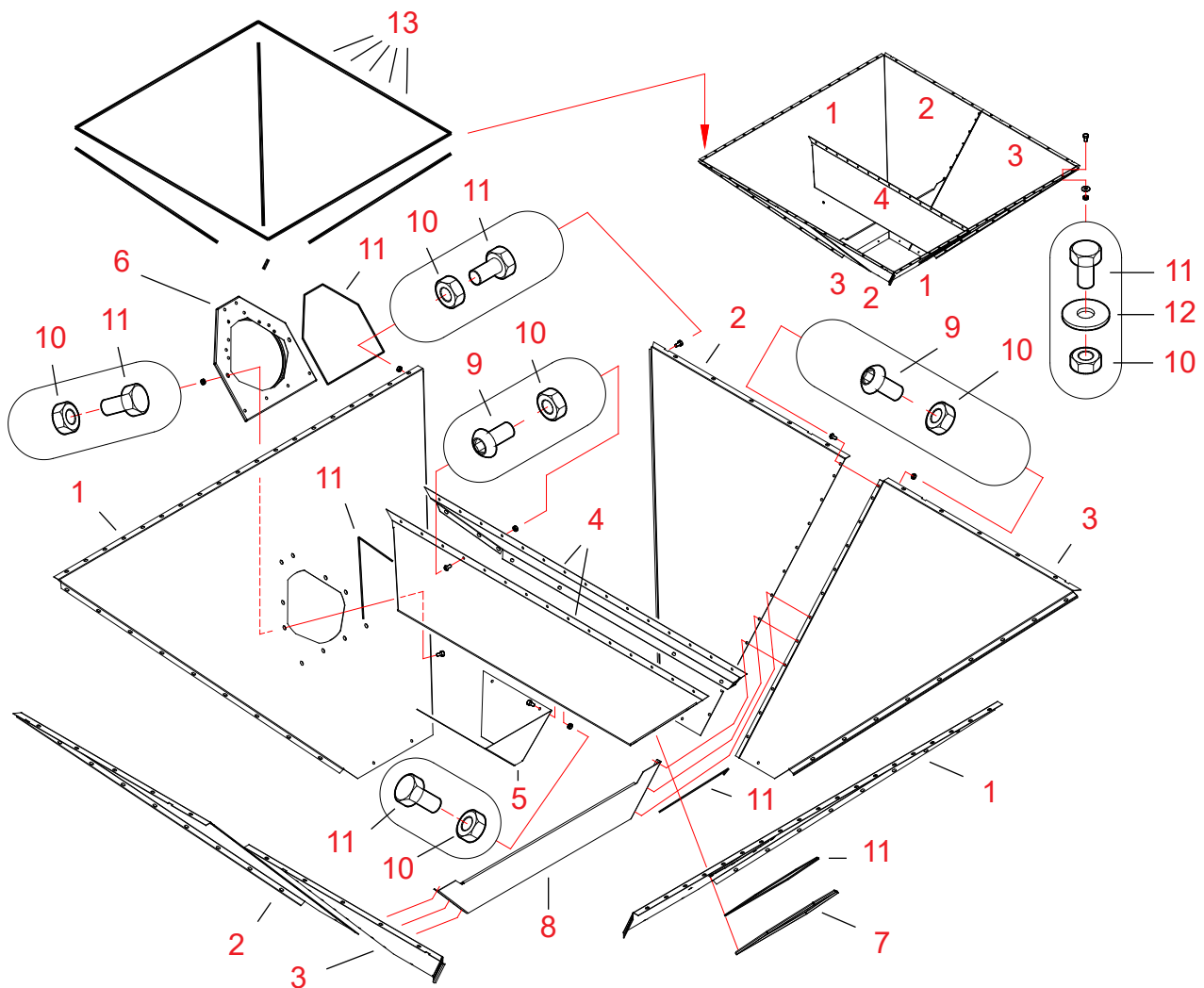


20080711

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	A70528	LEGS M06W CROSS-BRACE L = 2000	8	A70528-C	5.92	3000
2	A70818	LEGS M06W CROSS-BRACE L = 1000	8	A70818-B	2.86	3000
3	102520	BOLT HEX ZN 8.8 - 12X35 AM DIN933	100		0.04	2010
4	111560	WASHER ZN - M12 DIN125	200		0	2010
5	110570	NUT ZN 8 - M12 DIN934	100		0.02	2010
6	A70527	BASE M06W ADJUST BRACKET 2W	16	A70527-A	2.57	3000



Base cone (A70374), spare parts



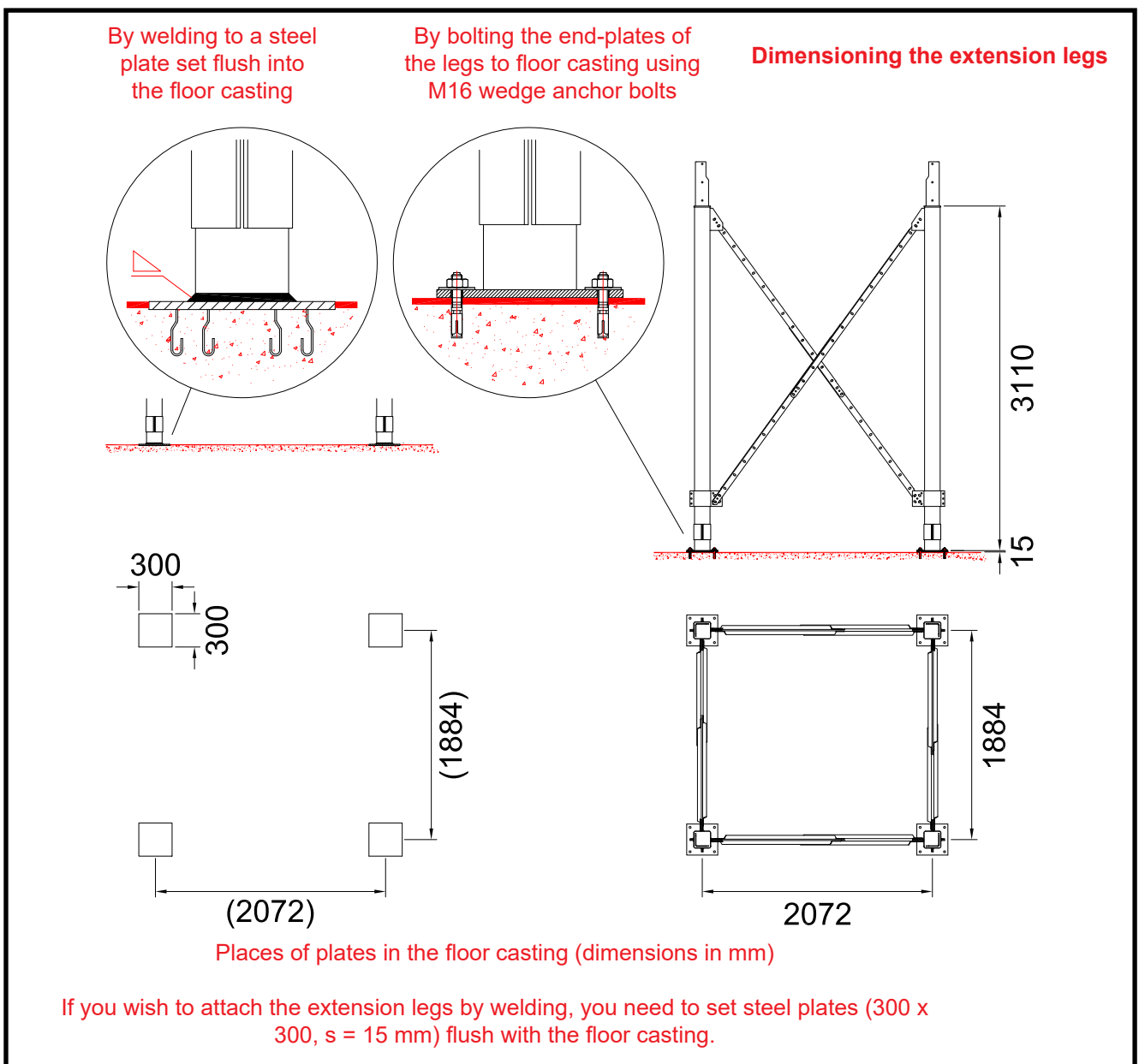
20060601

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	33085	BASE CONE SIDE-PLATE XL OPEN SIDE-PL BOLT	2	33085-C	120	3000
2	33086	BASE CONE SIDE-PLATE XL BOLT LEFT	2	33086-A	120	3000
3	33087	BASE CONE SIDE-PL XL BOLT RIGHT	2	33087-A	120	3000
4	A70377	BASE WM06 SUCT AIR CHANNEL 1/2	2	A70377-A	10.59	3000
5	A70410	BASE WM06 SUCT AIR CHANN STOP PL	1	A70410-B	1.81	3000
6	33384	BASE CONE SIDE-PLATE XL, MEGA COVER PL D280	1	33384	120	3000
7	33383	BASE CONE SIDE-PLATE XL, MEGA COVER PL	1	33383	120	3000
8	A70948	BASE WM06 ADDITIONAL CONE SUPPORT 2W	1	A70948	3	3000
9	104261	SOCK SCREW BALL-H - 8x16AM ISO 7380	39		0	2010
10	110540	NUT ZN 8 - M8 DIN934	157		0	2010
11	101810	BOLT HEX ZN 8.8 - 8X16 AM DIN933	118		0	2010
12	111562	WASHER ZN - 9/28x3 DIN440R	58		0	2010
13	115570	SEALING STRIP 4X10 MAPA	11		0	2600

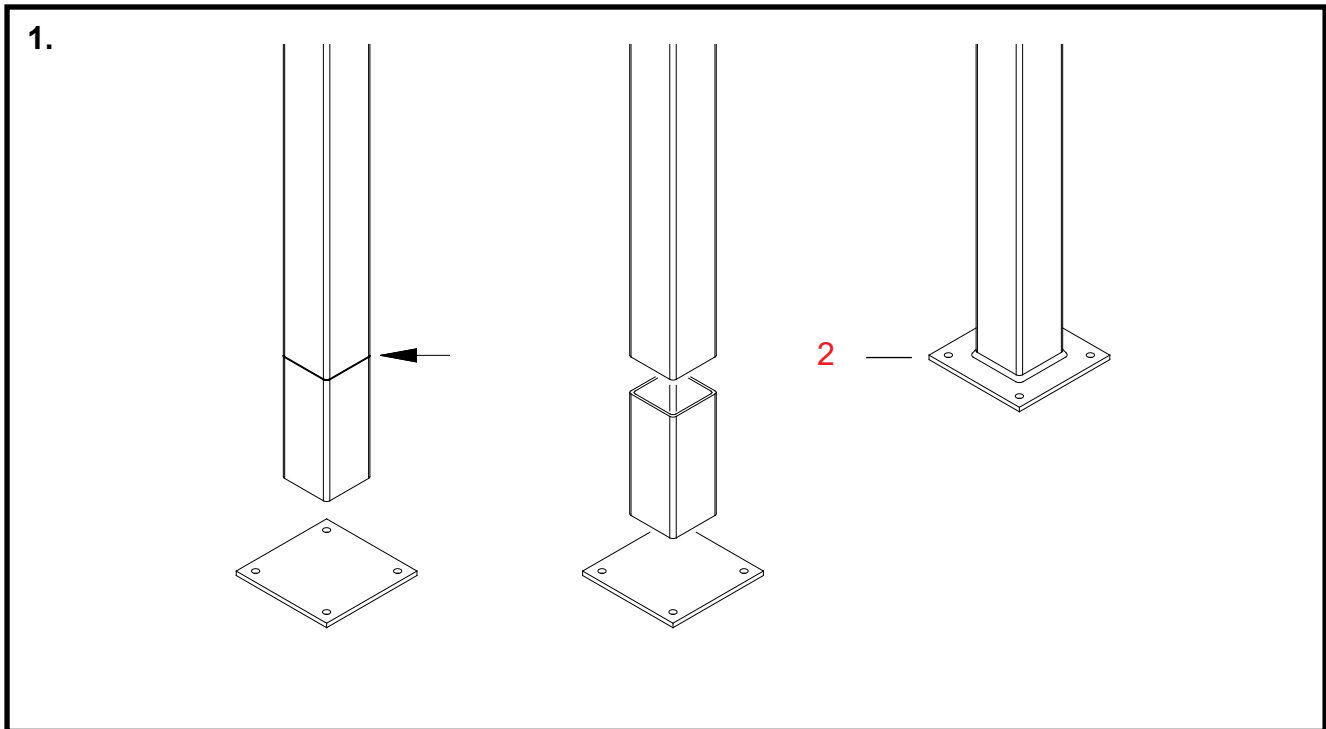
ASSEMBLING THE DRYER BASE

Optional ways to attach the lower ends of the extension legs

The maximum height of the machinery, to be installed outdoors using expansion anchors, is (because of the wind load) 8 rows. A machinery higher than this must be attached by welding to the bond plates embedded in the concrete. Attach the foot plates to the concrete foundation using M16x140 expansion anchors, 4 anchors/plate. Drill a D16 hole, 140 mm deep, for the expansion anchors. Clean the drilled hole before installing the anchor. (Ensure that the concrete foundation has hardened sufficiently after the casting to provide firm attachment of the anchors). The foot plate can also be attached using a M16 chemical anchor. Note! Each anchor must be able to withstand a pull of 16 kN.



Attaching the extension legs to the base



1. Shortening the extension legs

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the extension legs.

* **At first, determine the length required for the extension legs.**

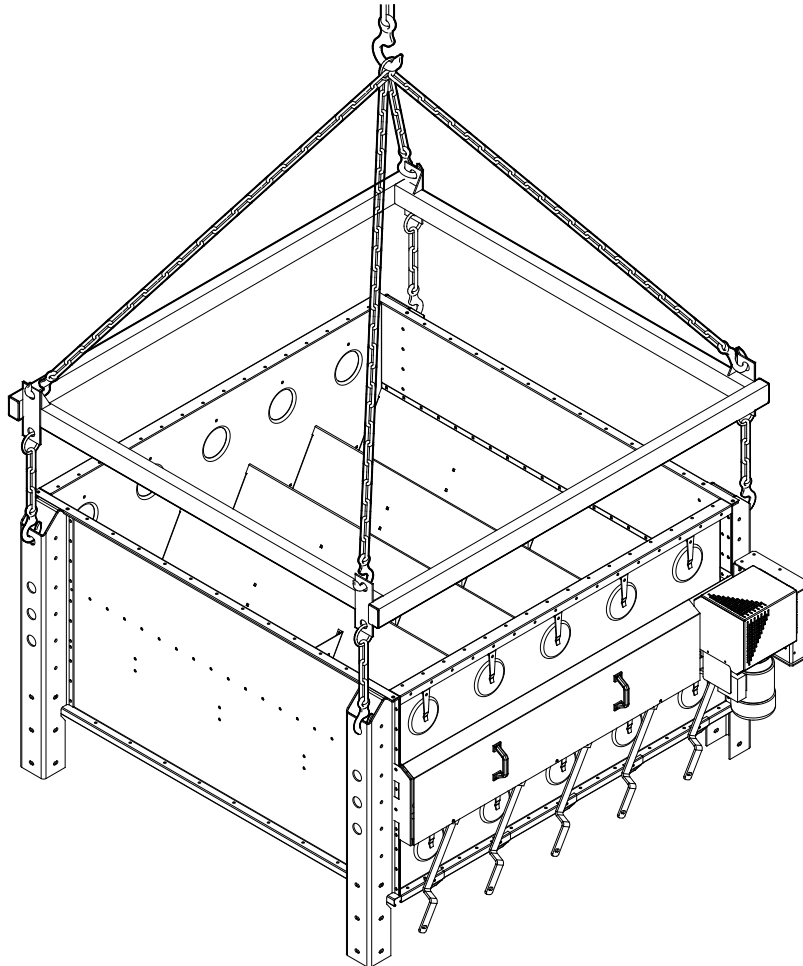
If you attach the extension legs to the floor casting using wedge anchors, note the thickness of the extension leg end-plates (12 mm) when determining the length to be cut off.

The main rule is that the angle of the pipe leading from the base cone to the elevator should be a minimum of 45 degrees to horizontal.

* **Cut the lower ends of the extension legs to the appropriate length.**

2 **As required, attach the end-plates included in the delivery by welding to the lower ends of the legs.**

2.



2. Lifting the base frame 2W

- * **Remove the protective plastic cover of the gear motor for the feeding equipment before lifting the base frame.**

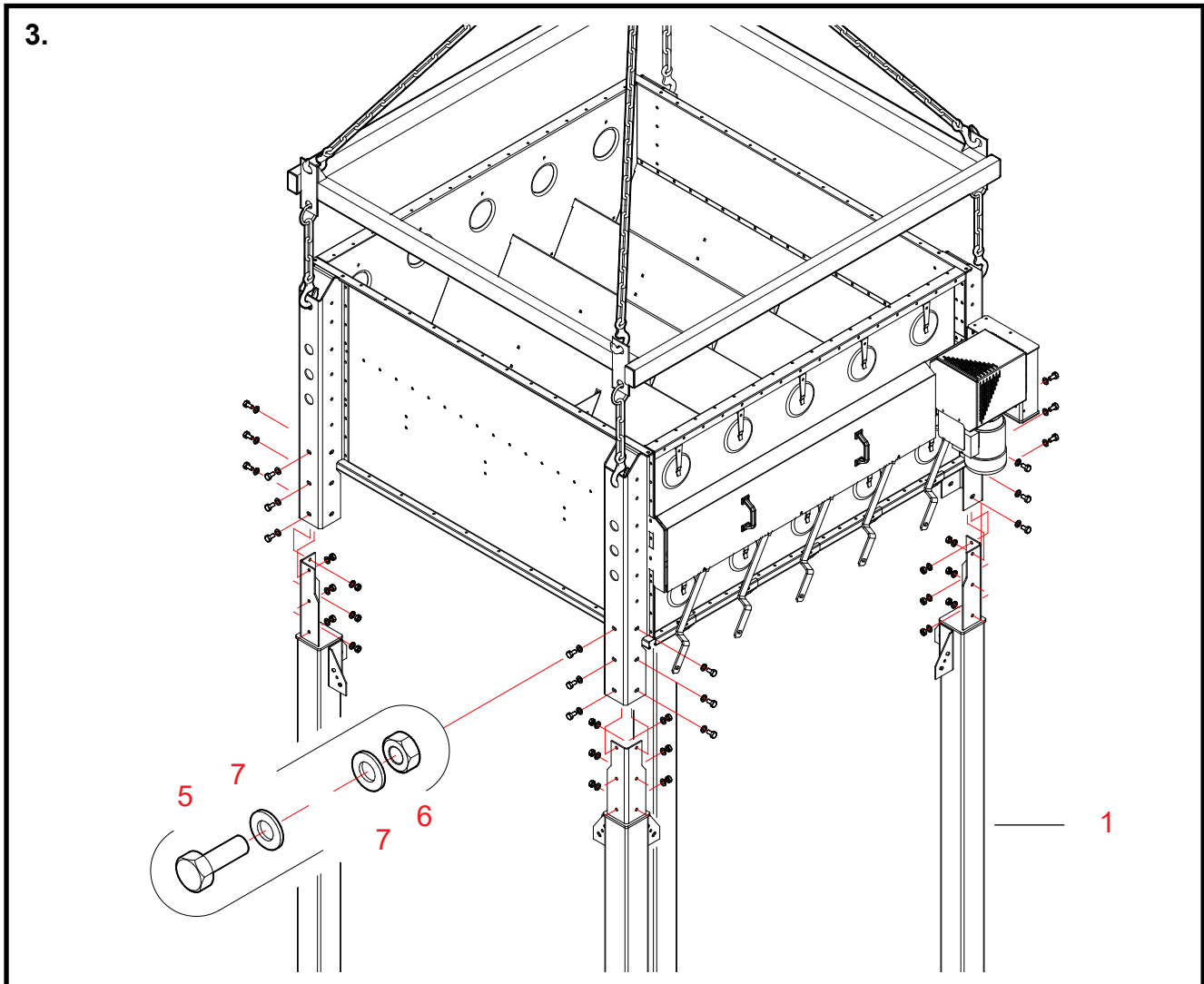
Simply tear off the plastic. Use knife, as necessary.

Raise the ready-assembled base frame using the lifting frame built on site (construction material, for example, RHS 100 x 60 mm).

Connect up the lifting frame using the hooks of the 4-part lifting chain. Continue by connecting up the chains of the lifting frame by the holes at the upper ends of the base legs.

- * **Lift the base frame from the floor using the lift.**

The weight of the base frame of 2 W is about 750 kg.



3. Installing the extension legs on 2W

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the extension legs.

1 **Insert the extension legs in the base frame legs.**
The upper part of the leg comes inside the base leg.

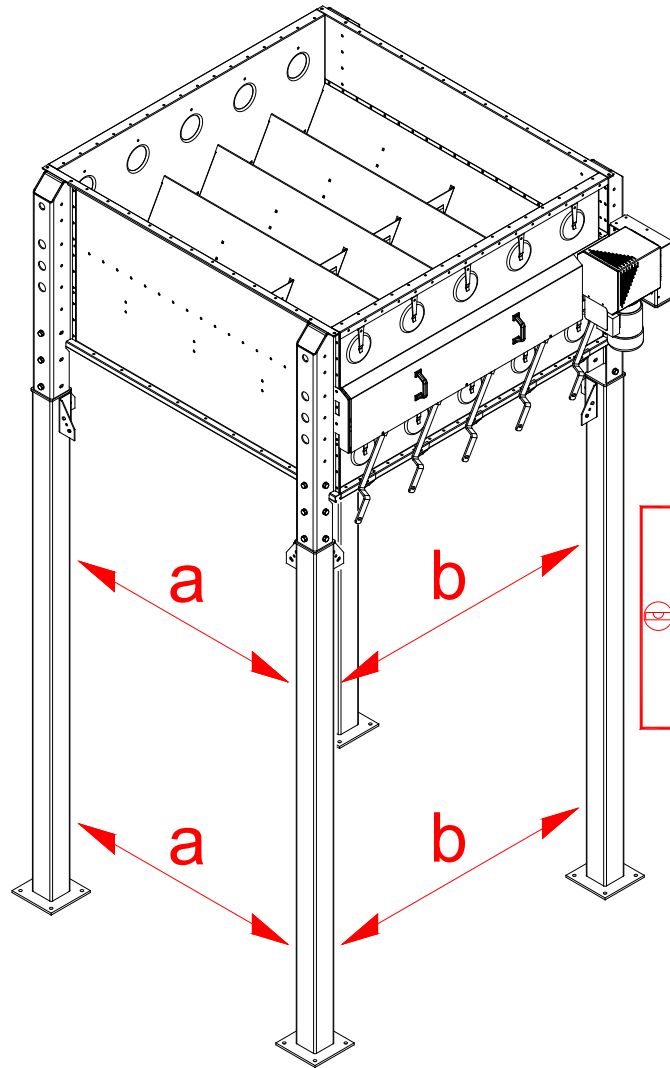
5, 6, 7 **Attach the extension legs to the base legs (bolts M12 x 35).**

Note!

Provide each leg with 6 bolts, washers and nuts!

* **Lower the dryer base onto the extension legs.**

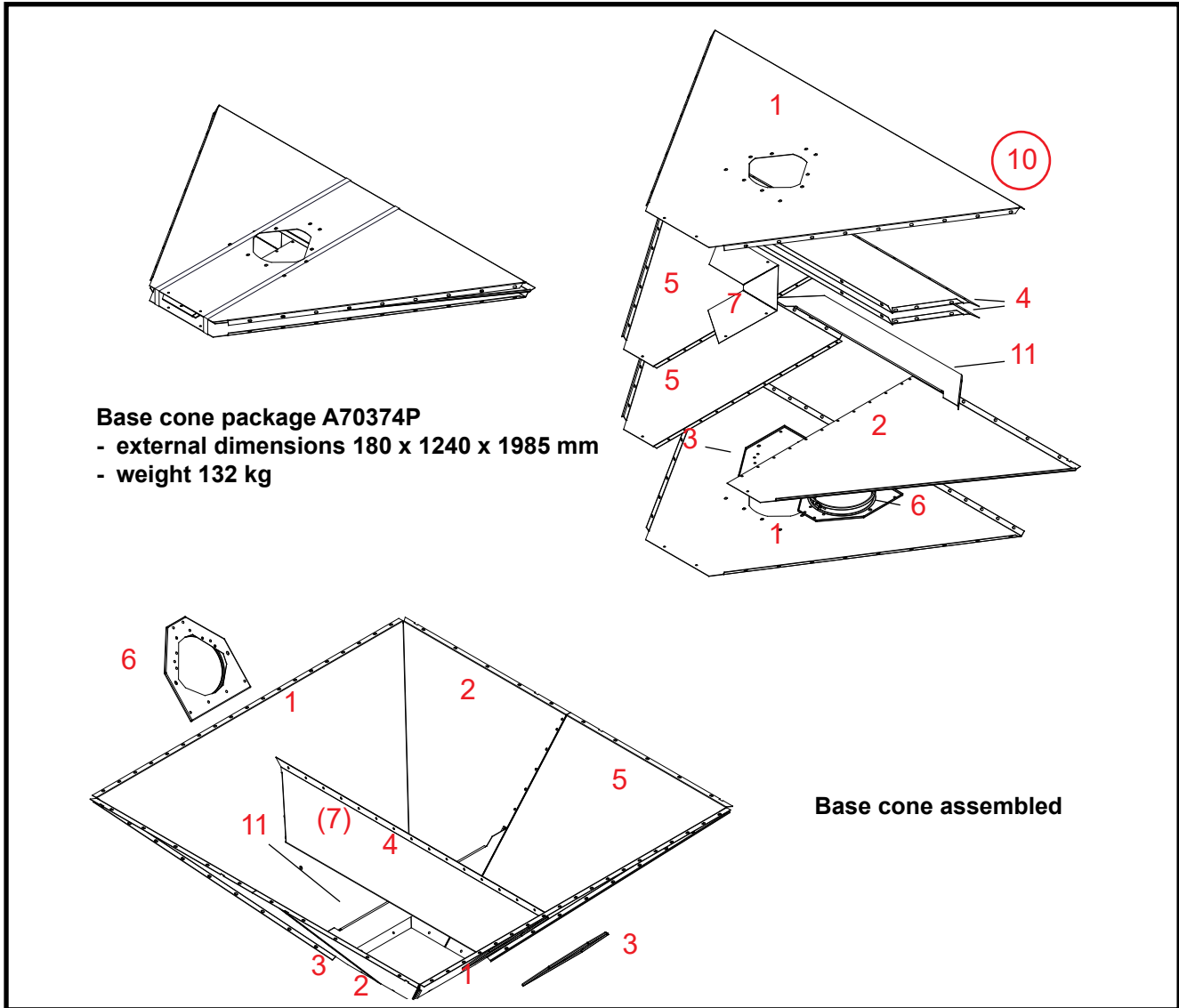
4.



4. Checking alignment of the extension legs

- * **Check that the extension legs are in an upright position and parallel to each other.**
Carry out the measurement and perform the required corrections before attaching the legs to the floor.
- * **Attach the legs to the floor either by welding or using wedge anchors.**
Attachment by welding is possible only if metal plates have been set into the floor during casting.

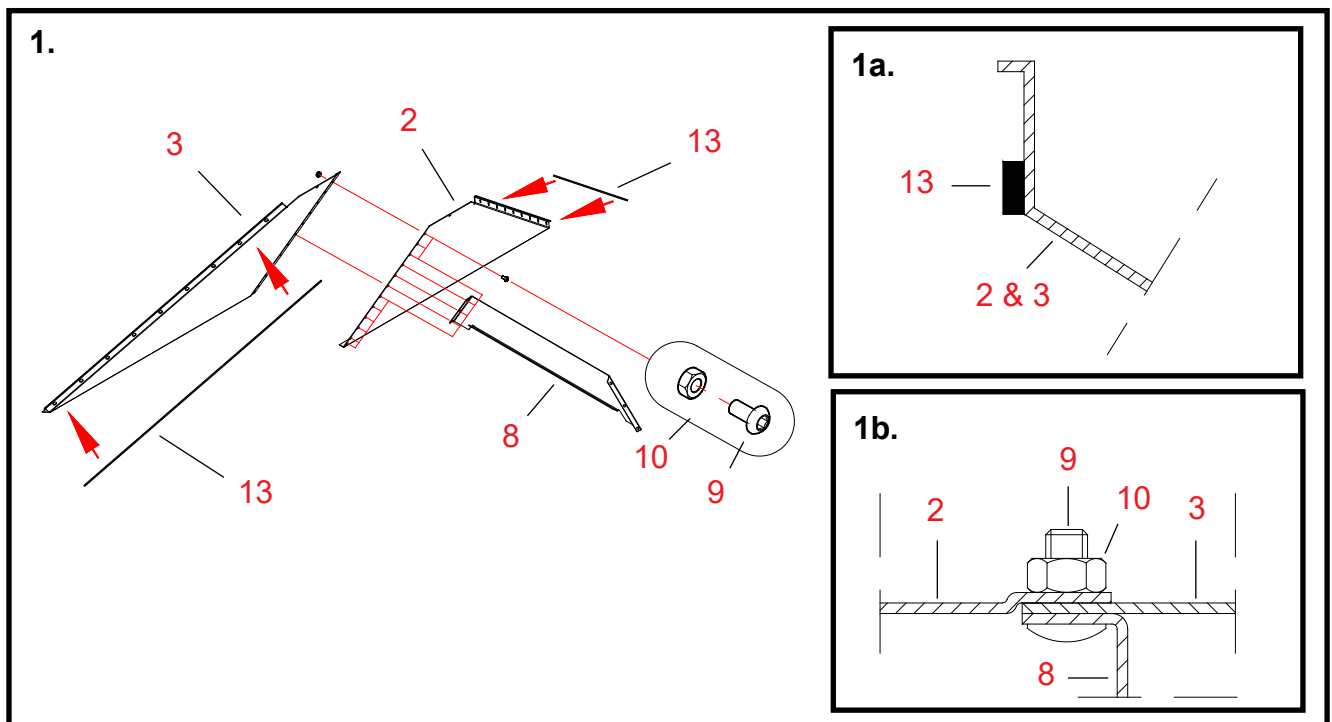
Structure of the base cone 2W



20060601

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	33085	BASE CONE SIDE-PLATE XL OPEN SIDE-PL BOLT	2	33085-C	120	3000
2	33086	BASE CONE SIDE-PLATE XL BOLT LEFT	2	33086-A	120	3000
3	33383	BASE CONE SIDE-PLATE XL, MEGA COVER PL	1	33383	120	3000
4	A70377	BASE WM06 SUCT AIR CHANNEL 1/2	2	A70377-A	10.59	3000
5	33087	BASE CONE SIDE-PL XL BOLT RIGHT	2	33087-A	120	3000
6	33384	BASE CONE SIDE-PLATE XL, MEGA COVER PL D280	1	33384	120	3000
7	A70410	BASE WM06 SUCT AIR CHANN STOP PL	1	A70410-B	1.81	3000
10	A70919	BASE CONE 2W BOLT PACK 9994200045	1	A70919-A	1.96	2010
11	A70948	BASE WM06 ADDITIONAL CONE SUPPORT 2W	1	A70948	3	3000

Assembling the base cone 2W



1. Joining together the base cone side-plates consisting of two halves

Parts The numbering of work stages refers to reference numbers in the spare parts drawing of the base cone.

We recommend joining the base cone parts together on a suitable level plane, on which the cone can be assembled upside down with respect to its final position.

13 Fix sealing strip to the corner flange of the plate with straight edge (part 2).

Fix the sealing strip inside the bolthole row in the plate (see drawing 1a).

13 Fix a sealing strip to the corner flange of the shouldered side-plate (part 3).

Fix the sealing strip inside the bolthole row in the plate (see drawing 1a).

Note: no sealing strip is required at the centre seam of the base cone.

Be careful not to damage the sealing strips while joining the plates.

2 + 3 Place the shouldered side-plate tight against the side-plate with straight edge.

The shouldered edge of plate 3 shall remain outside plate 2.

8 Place the additional support for the cone inside the side-plates.

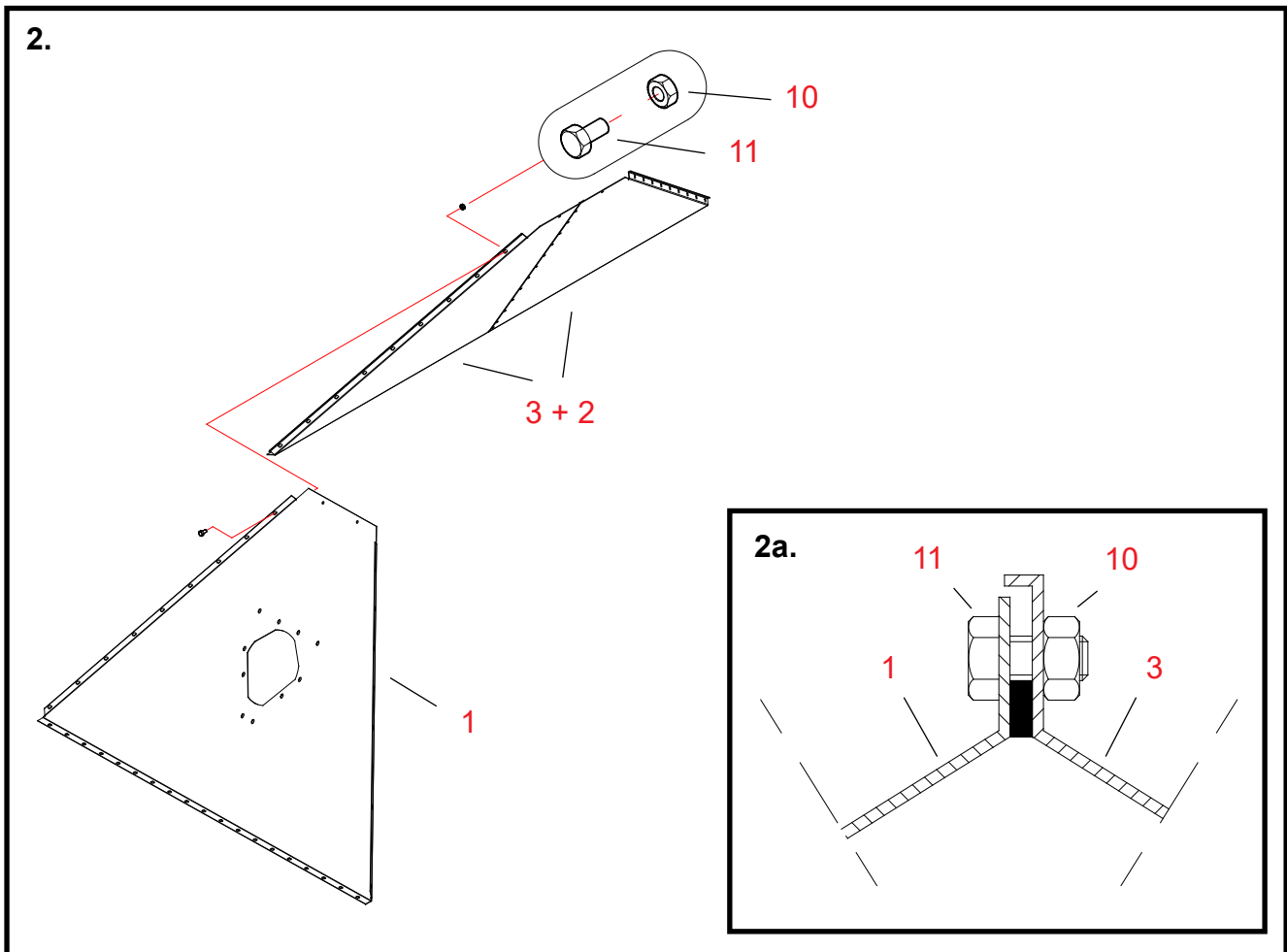
Look up the correct position and attachment point for the support in the drawing.

9, 10 Fix the seam using ball-headed nuts and bolts (M8 x 16, 12 pcs.).

Place the bolt heads on the grain space side (see Fig. 1b).

2 + 3 Assemble another similar side-plate without additional support (part 8) of parts 2 and 3.

Do not put bolts into the three holes in the additional support at this stage.



2. Fixing the third side-plate for the base cone

Parts The numbering of work stages refers to reference numbers in the spare parts drawing of the base cone.

1 Lift the side-plate with opening for the base cone onto the assembly plane.

Place the flange of the plate with 19 holes against the plane.

2 + 3 Lift one of the recently assembled side-plates, the one without additional support, against the side-plate with opening.

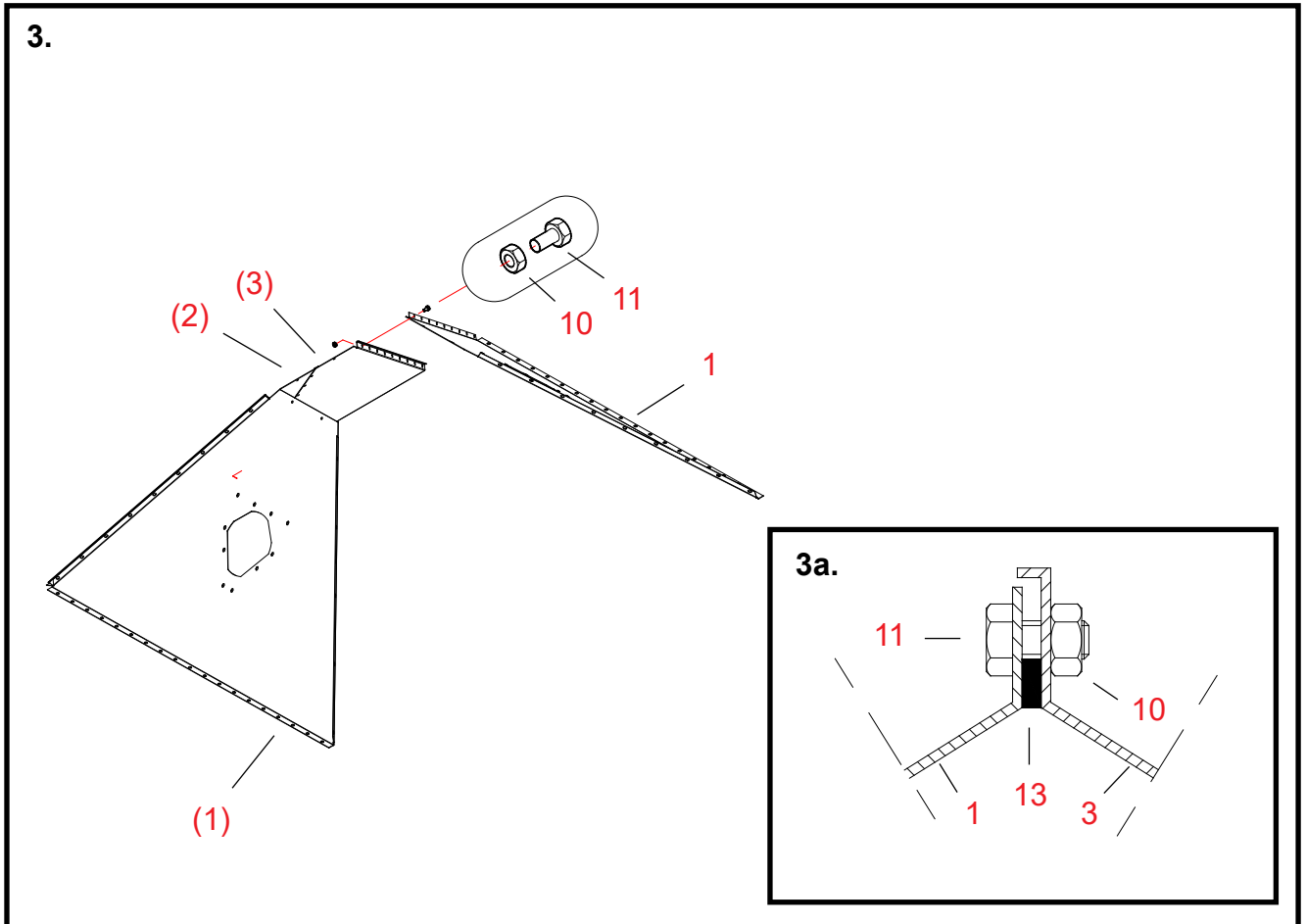
Carefully align the corner joint between the plates.

Check that the flanges of the plates are lying tight against the assembly plane.

10, 11 Fix the seam using nuts and bolts (M8 x 16, 9 pcs.).

See dwg. 1a.

Do not tighten the bolts yet.



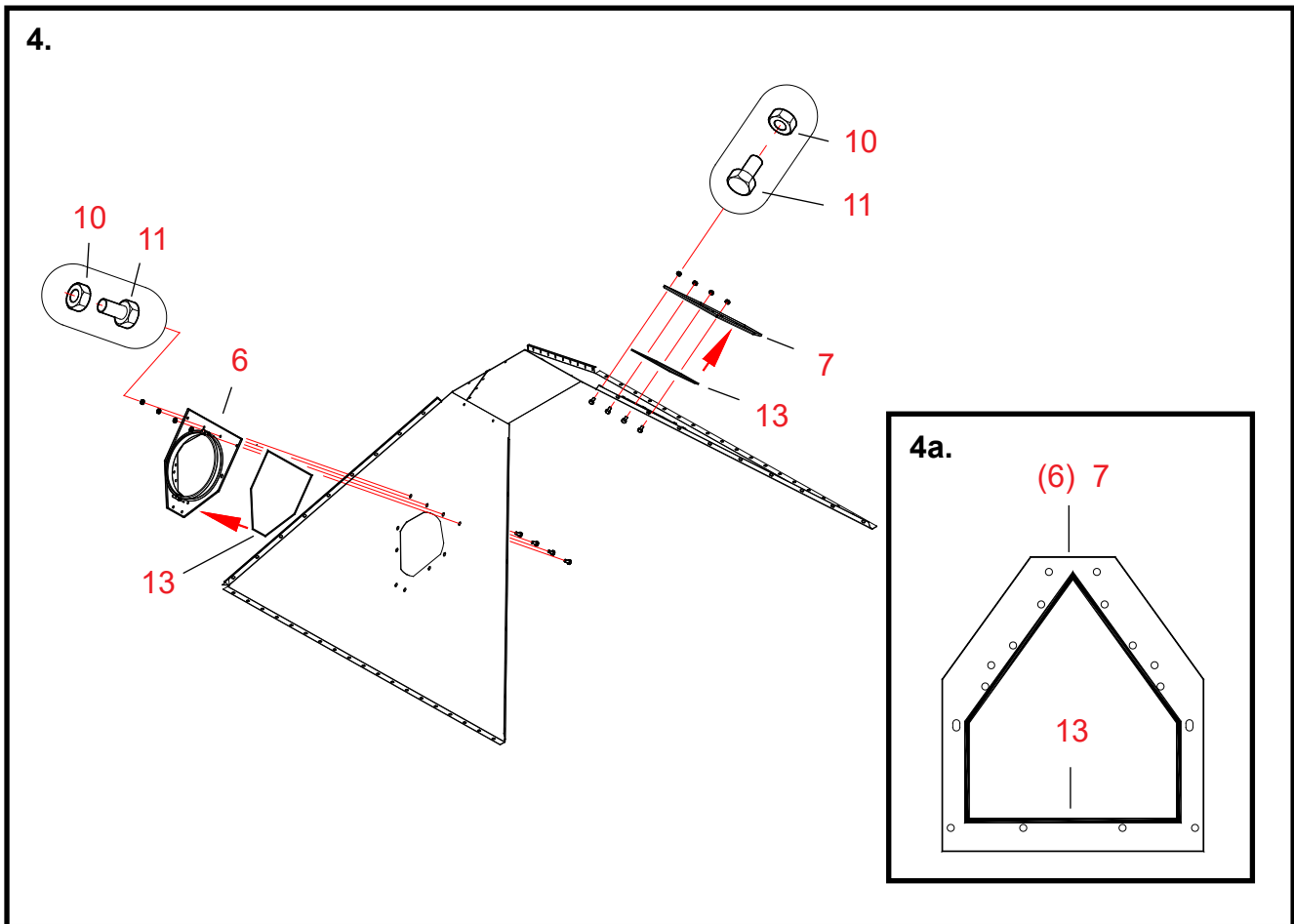
3. Fixing the fourth side-plate for the base cone

Parts The numbering of work stages refers to reference numbers in the spare parts drawing of the base cone.

1 Lift the other side-plate with opening for the base cone onto the assembly plane.

1, 3 Carefully align the corner joint between the plates.
Check that the flanges of the plates are lying tight against the assembly plane.

10, 11 Fix the seam using nuts and bolts (M8 x 16, 9 pcs.).
Fig. 3a. Do not tighten the bolts yet.



4. Attaching the connecting part and the cover-plate to the base cone

Parts The numbering of work stages refers to reference numbers in the spare parts drawing of the base cone.

13 **Fix a sealing strip onto the inner surface of the connecting part with opening (part 6).**

13 **Fix a sealing strip onto the inner surface of the cover plate (part 7).**

Fix the sealing strips inside the bolthole row in the plates (see drawing 4a).

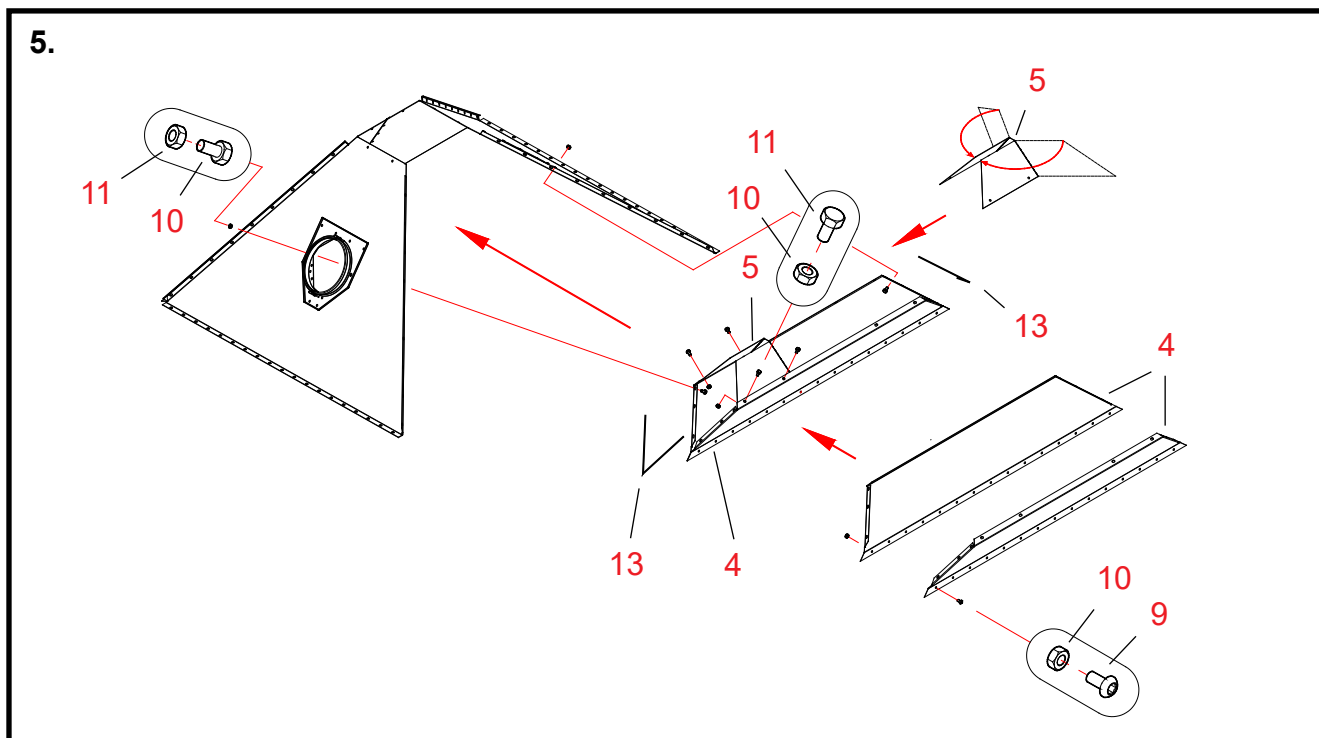
6 **Install the connecting part with opening to the base cone on the bottom suction fan side.**

Make yourself clear about on which side the bottom suction fan is to be installed.

7 **Install the cover plate on the opposite side.**

10, 11 **Fix the connecting part and the cover plate to the base cone using nuts and bolts (M8 x 16).**

Place hexagon nuts and bolts (4 + 4 pcs) at this stage only in holes in straight line at the lower edge of the connecting part and cover plate.



5. Installing the suction air duct in the base cone

Parts The numbering of work stages refers to reference numbers in the spare parts drawing of the base cone.

4 Place the suction air duct halves face to face.

Make sure that the end flanges of the air duct do not "indent".

9, 10 Join the halves together using ball-headed nuts and bolts (M8 x 16, 15 pcs.).

5 Attach the stop plate to the lower edge of the suction air duct (i.e. to the upper edge while the cone lies upside down during assembly).

The stop plate is straight when delivered.

Bend the plate along the row of holes to the shape illustrated in the drawing.

Place the stop plate in the duct at the end where the bottom suction fan is to be installed.

The open end of the plate comes against the cone wall.

Place its edges inside the flanges of the suction air duct.

10, 11 Fix the stop plate using hexagon bolts and nuts (M8 x 16, 4 pcs.).

13 Fix sealing strips to the end flanges of the suction air duct.

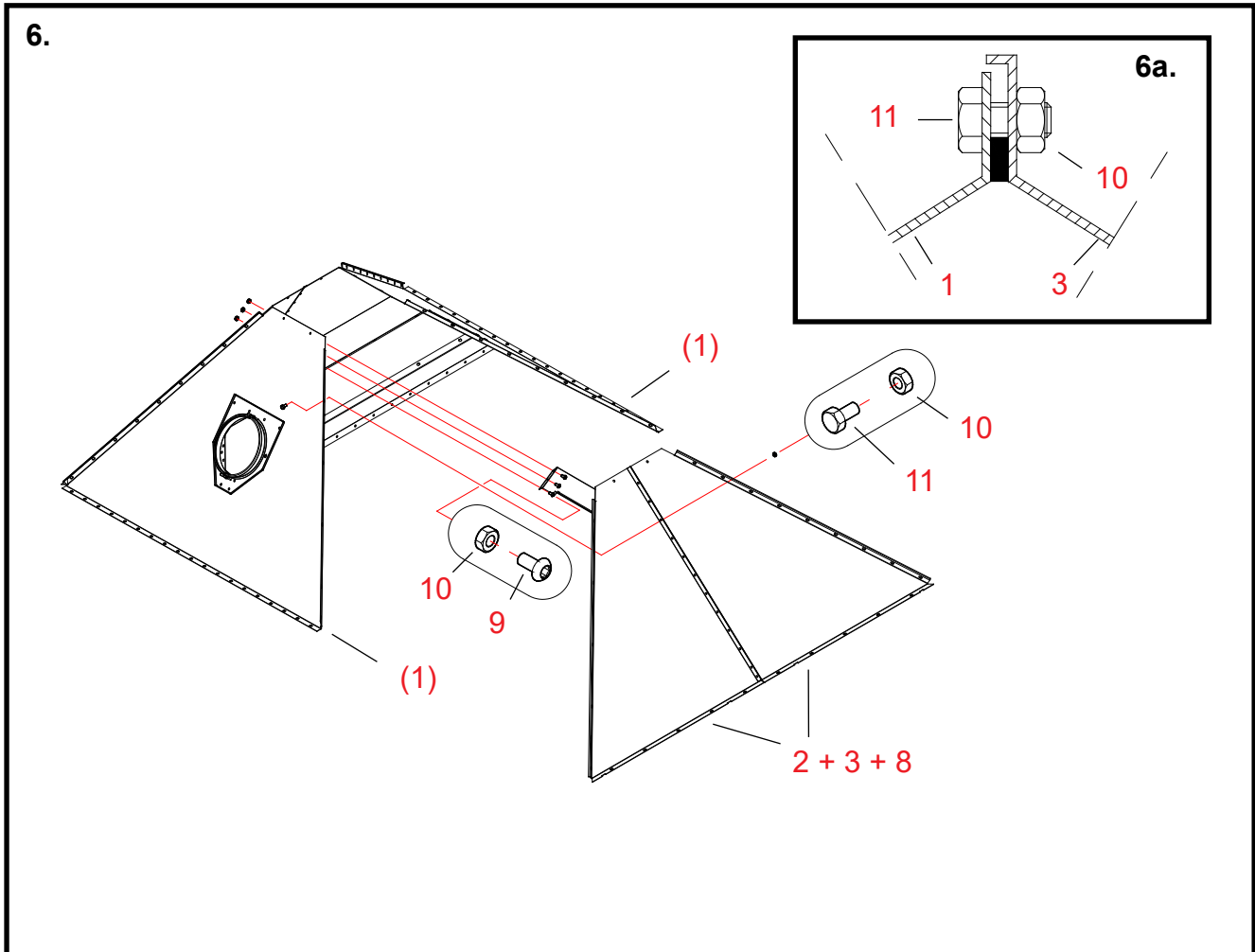
4 Place the suction air channel with the stop plate attached inside the base cone.

10, 11 Fix the air channel by its end-flanges using bolts and nuts (M8 x 16, 6 + 6 pcs.).

These bolts are also used for fixing the connecting part and the cover plate in their final positions.

Ensure that the joint between the stop plate and the base cone wall is tight.

If necessary, seal with butyl compound (the compound and the press are included in the delivery).



6. Installing the fifth and sixth side-plates for the base cone, which are joined together

Parts The numbering of work stages refers to reference numbers in the spare parts drawing of the base cone.

2 + 3 + 8 Close the ready-assembled base cone using the joined-together fifth and sixth side-plates.

1, 2, 3 Carefully align the corner joints between the plates.
 Check that the flanges of the plates are lying tight against the assembly plane.
 Align the bolt holes in the additional support with the three unused holes in the opposite side-plate.

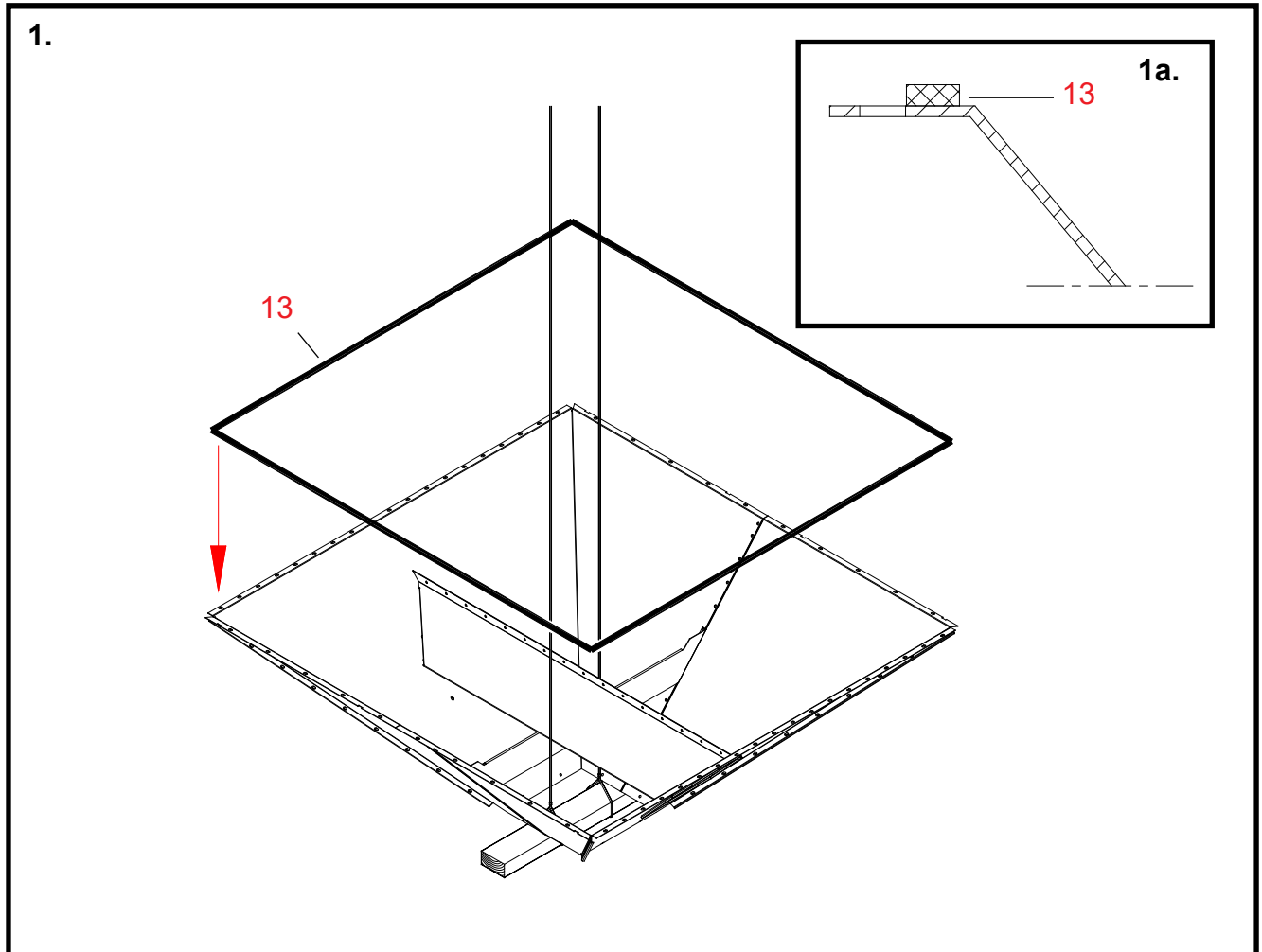
10, 11 Fix the corner joints using nuts and bolts (M8 x 16, 9 + 9 pcs.).

9, 10 Fix the intermediate support using ball-headed nuts and bolts (M8 x 16, 3 pcs.).

Finally, ensure that the whole cone is lying tight against the assembly plane.

* **Tighten all bolts in the corner joints.**

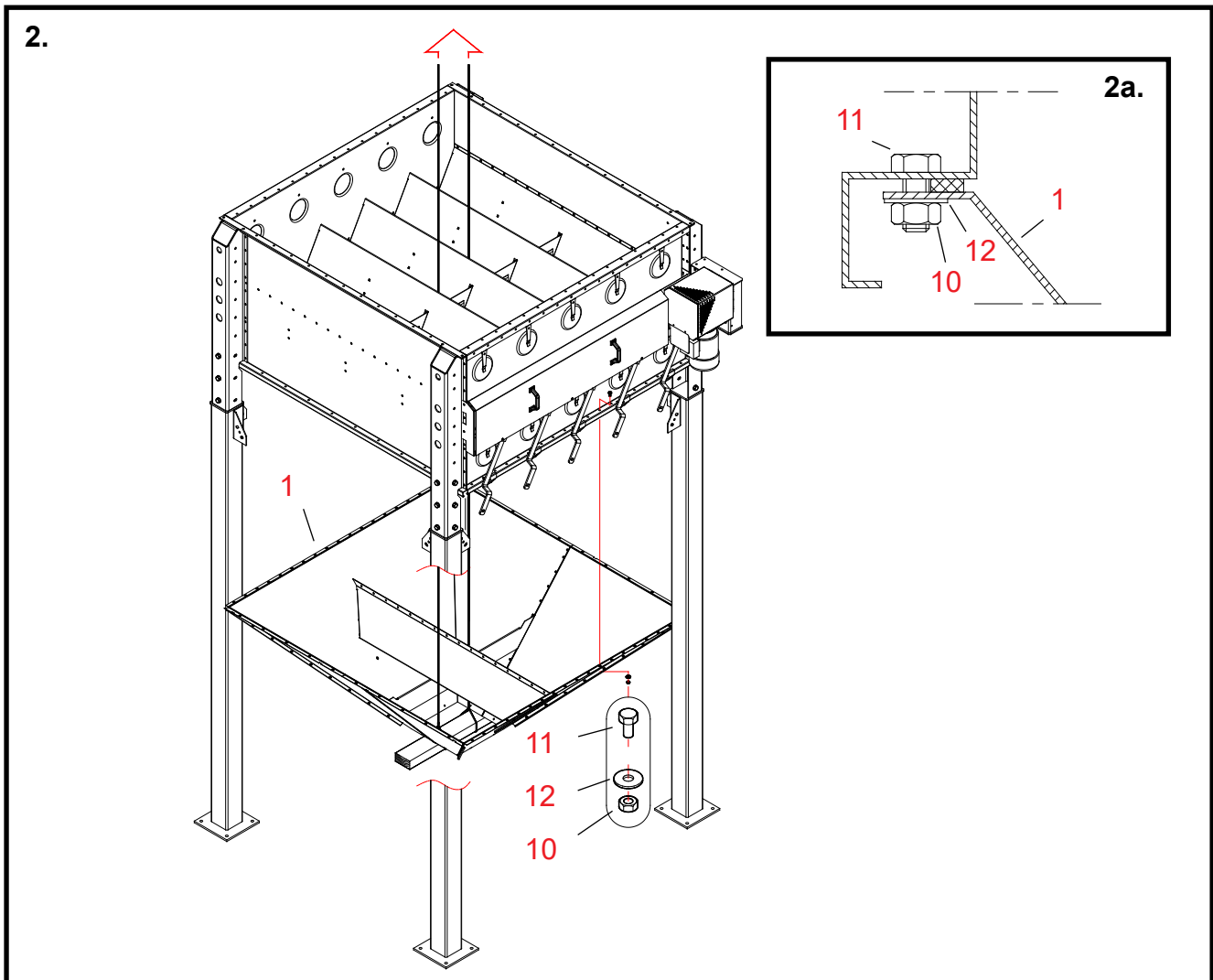
Installing the base cone



1. Preparing the base cone for lifting and fixing the sealing

Parts The numbering of work stages refers to reference numbers in the spare parts drawing of the base cone.

- * **Turn the base cone to a position where the attachment flange comes on the upside.**
 - * **Place a batten, e.g. 50 x 100 mm of about 1 metre in length, under the cone.**
 - * **Attach the wire ropes for lifting the cone to the batten on both sides of the suction air duct.**
- 13** **Fix sealing strips to the flanges on the upper surface of the cone.**
Fix the sealing strip inside the bolthole row in the flange (see drawing 1a).



2. Lifting and fixing the base cone

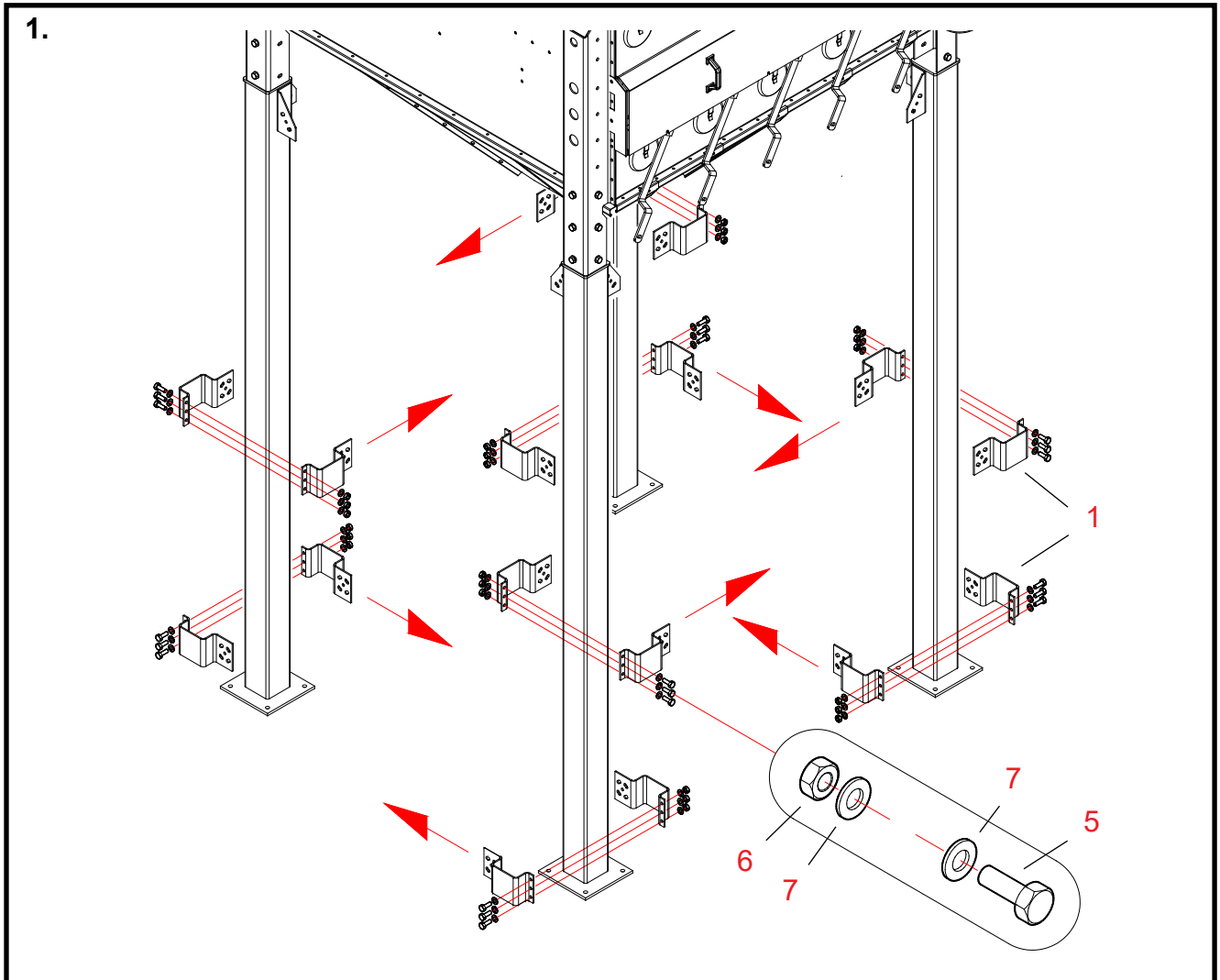
Parts The numbering of work stages refers to reference numbers in the spare parts drawing of the base cone.

Be careful not to damage the sealing strips when lifting the cone.

- * **Move the base cone under the base.**
- * **Lift the cone using the wire rope threaded in between the air ducts in the base.**
- * **Thread in the cone carefully between the lugs in the extension legs.**
- 1 Lift the base cone tight against the bottom surface of the base.**

10, 11, 12 Attach it using bolts, washers and nuts (M8 x 16, 58 pcs.).
See dwg. 2a.

Installing the cross-braces for the extension leg on 2W

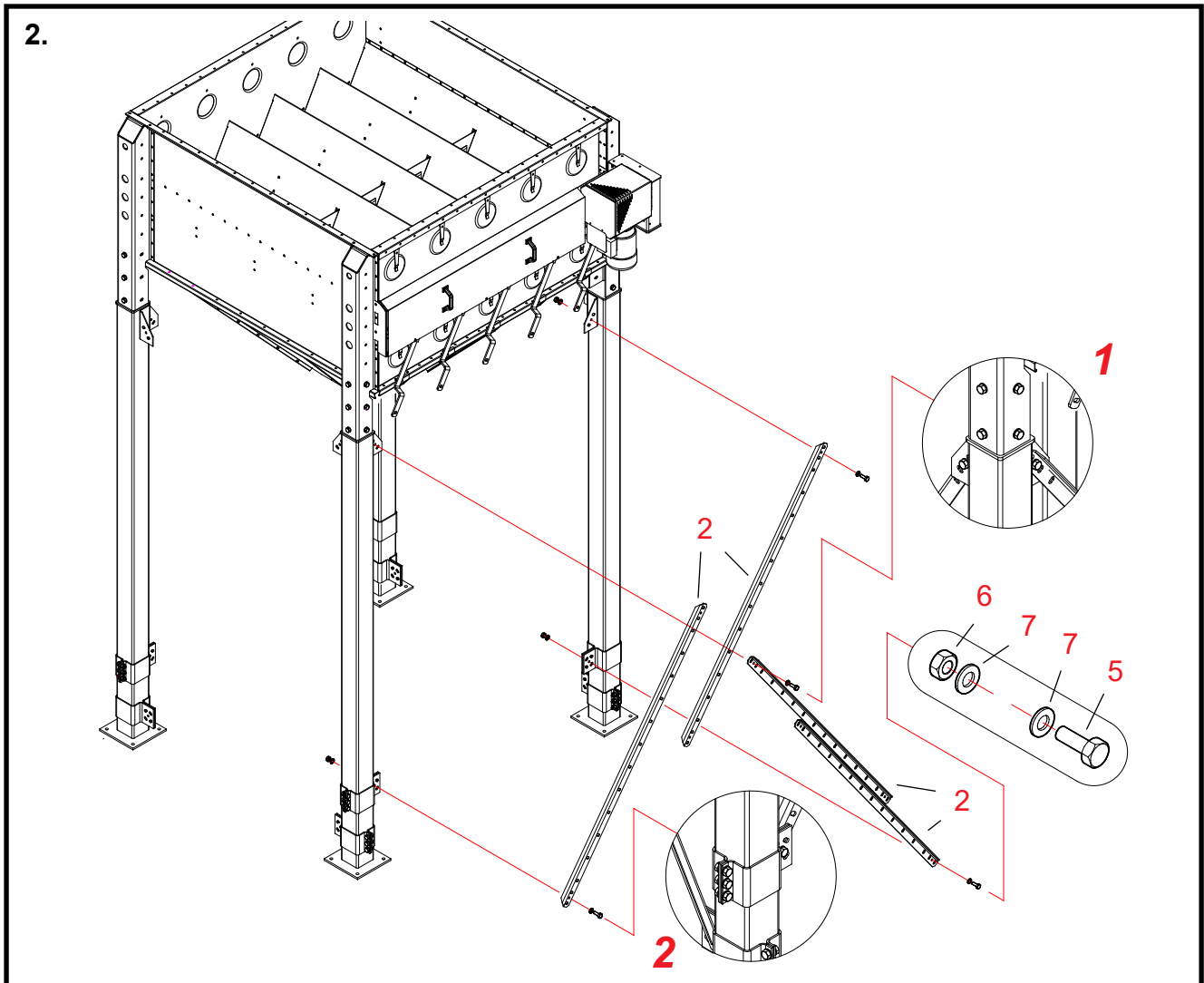


1. Installing the adjustable cross-brace brackets on the extension legs

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for cross-braces for the extension legs.

1 Put the halves of the adjustable brackets on the extension legs.
Install two pieces of brackets, consisting of two halves each, on each leg.
Check the correct direction for the bracket flange with 5 holes in the drawing.

5, 6, 7 Attach the brackets to the extension legs (bolts M12 x 35).
Look up the correct position for the bolts in the drawing.
At this stage, attach the brackets only by their flanges with 3 holes.
Leave the bolt attachments loose in order to be able to move the brackets without damaging the surface treatment of the legs.



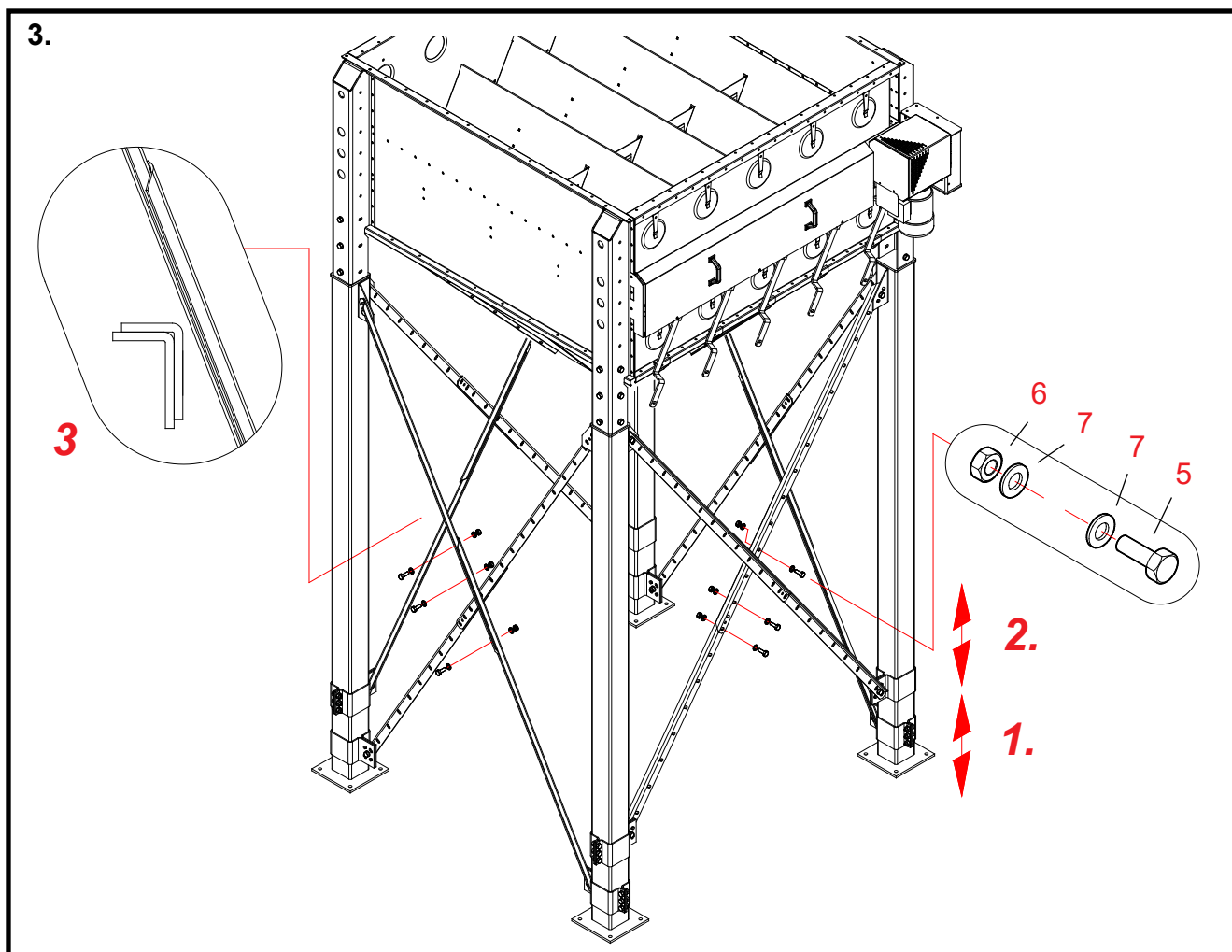
2. Fixing the cross-brace ends to the extension legs

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for cross-braces for the extension legs.

2 **Put in place the cross-brace parts in the upper and lower brackets on one side of the base.**
Select the direction and position for the cross-braces at the side of the bracket, as illustrated in drawings 1 and 2.

5, 6, 7 **Fix the ends of the cross-braces to the brackets in the extension legs (bolts M12 x 35).**
Look up the correct position for the bolts in the drawing.
Fix the cross-braces at both their ends at this stage only with one bolt.
Put the bolt, the washers and the nut in place in the round hole in the brace and the bracket.
Do not wrench the bolts to their final tightness yet.

* **Install the upper and lower parts of the cross-braces in the same way on the other three sides of the base.**



3. Installing the bolts in the cross-brace joints of the extension legs

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for cross-braces for the extension legs.

Start by joining together the braces attached to the lower adjustable brackets on the extension legs.

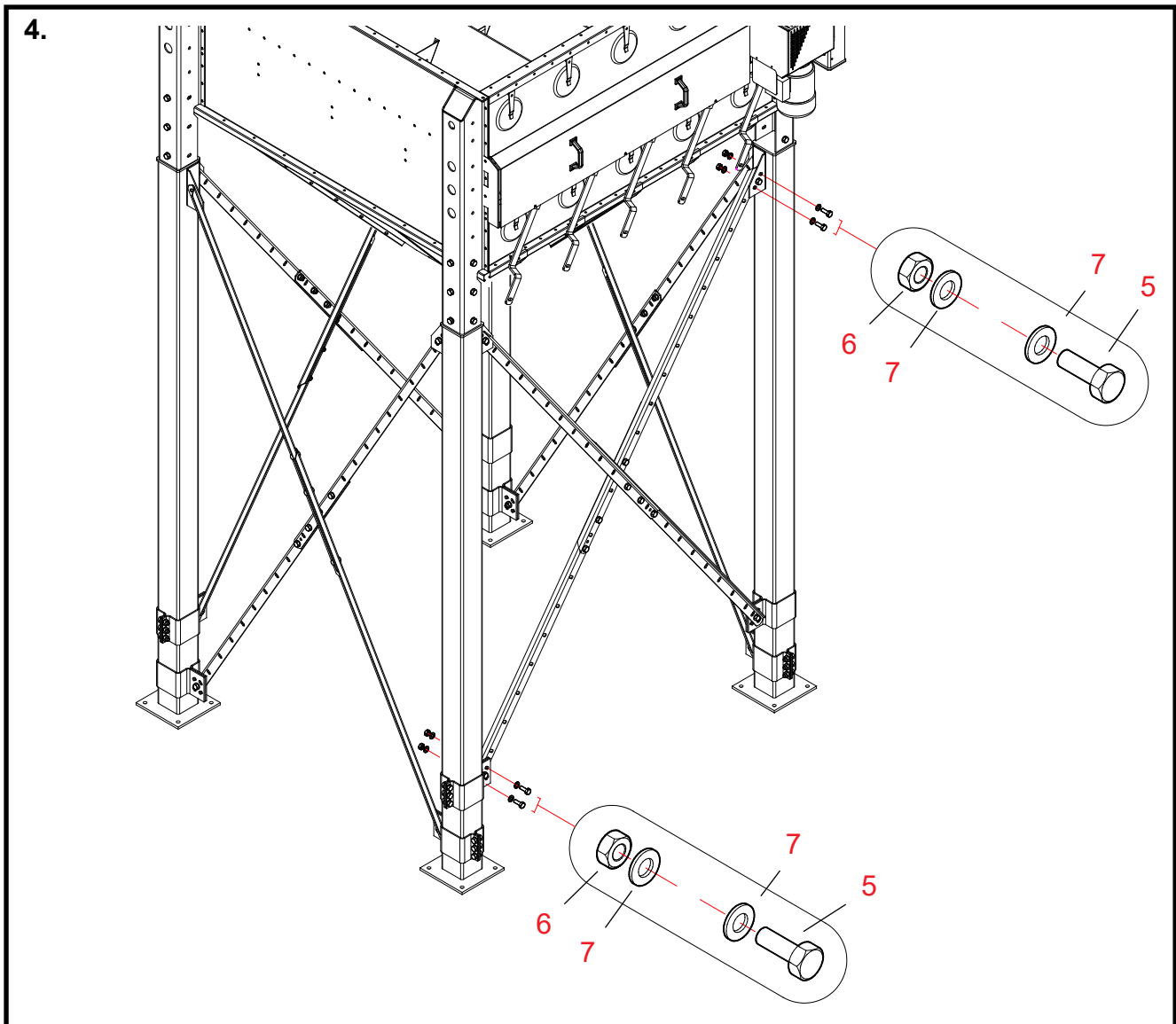
Place the parts one inside the other, as shown in detail drawing 3.

- * **Move the lower cross-brace bracket along the extension leg.**
Select the position so that you can install a bolt in each of the three holes at the cross-brace joint. Extend the cross-brace as much as possible (move the lower bracket to as low as it goes).

5, 6, 7 Put in place and tighten the bolts at the cross-brace joints (3 pcs. M12 x 35).
Look up the correct position for the bolts in the drawing.

- * **Attach the rest of the cross-braces to the lower adjustable brackets.**

Continue by joining together the support rods to be attached to the upper adjustable brackets on the extension legs.



4. Fixing the upper and lower ends of the cross-braces for the extension legs in their final positions

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for cross-braces for the extension legs.

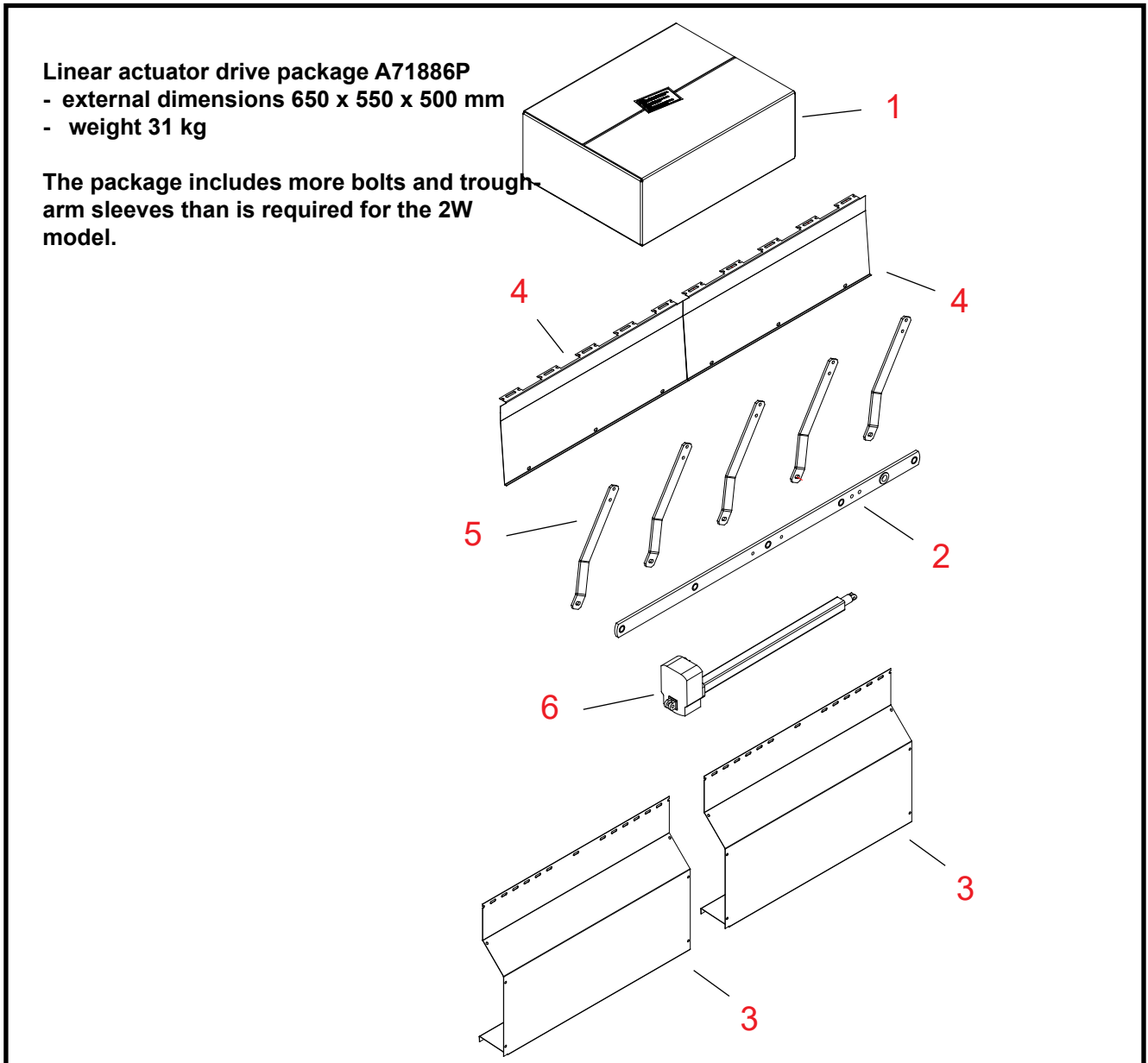
5, 6, 7 Put in place the missing bolts (M12 x 35) in the upper and lower ends of each cross-brace.

Every cross-brace must be attached to the bracket on the extension leg by three bolts, washers and nuts at its lower and upper ends.

* Tighten all bolt attachments at the upper and lower ends of the cross-braces.

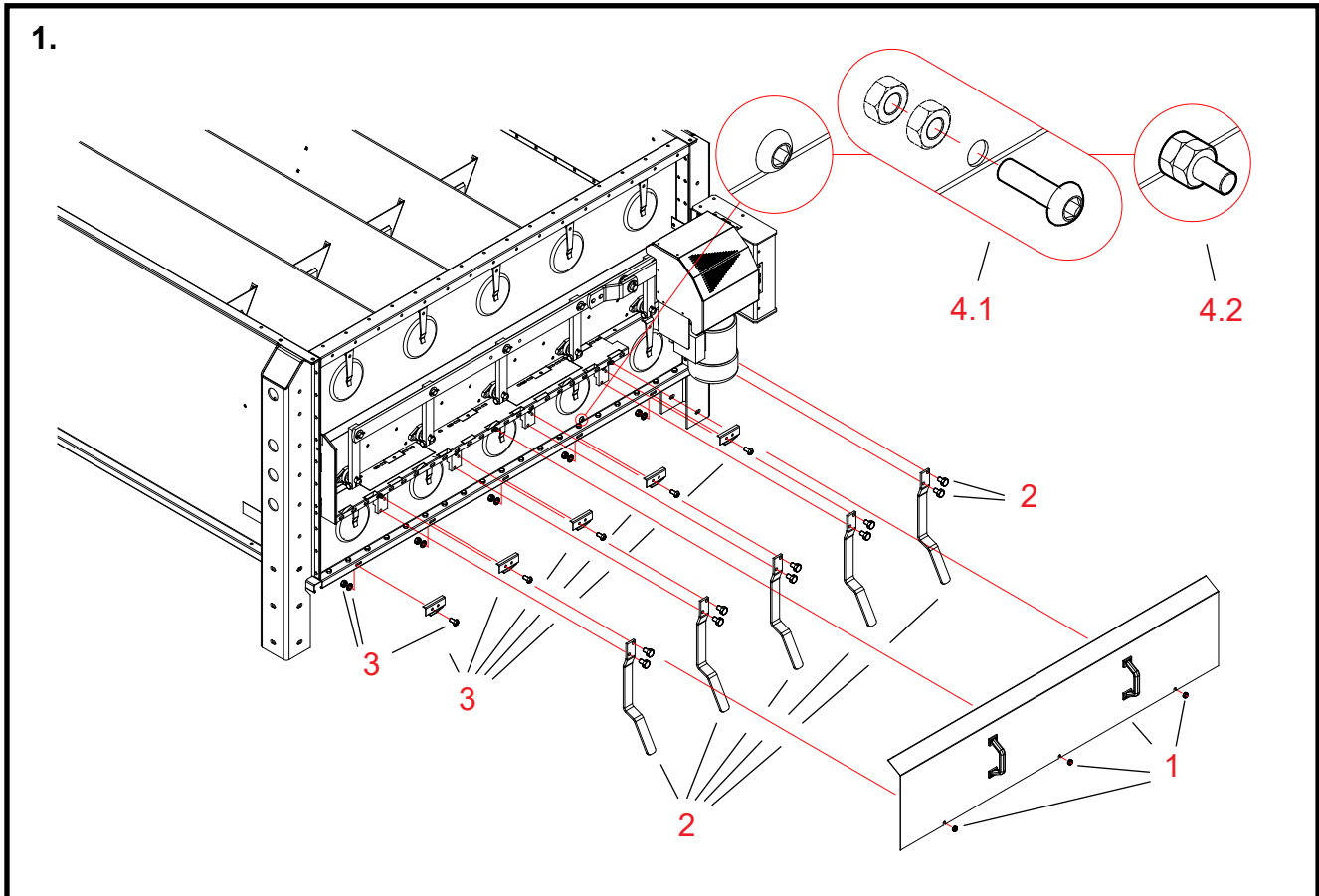


Structure of the linear actuator drive (A70492T) for the feed troughs on 2W (optional)



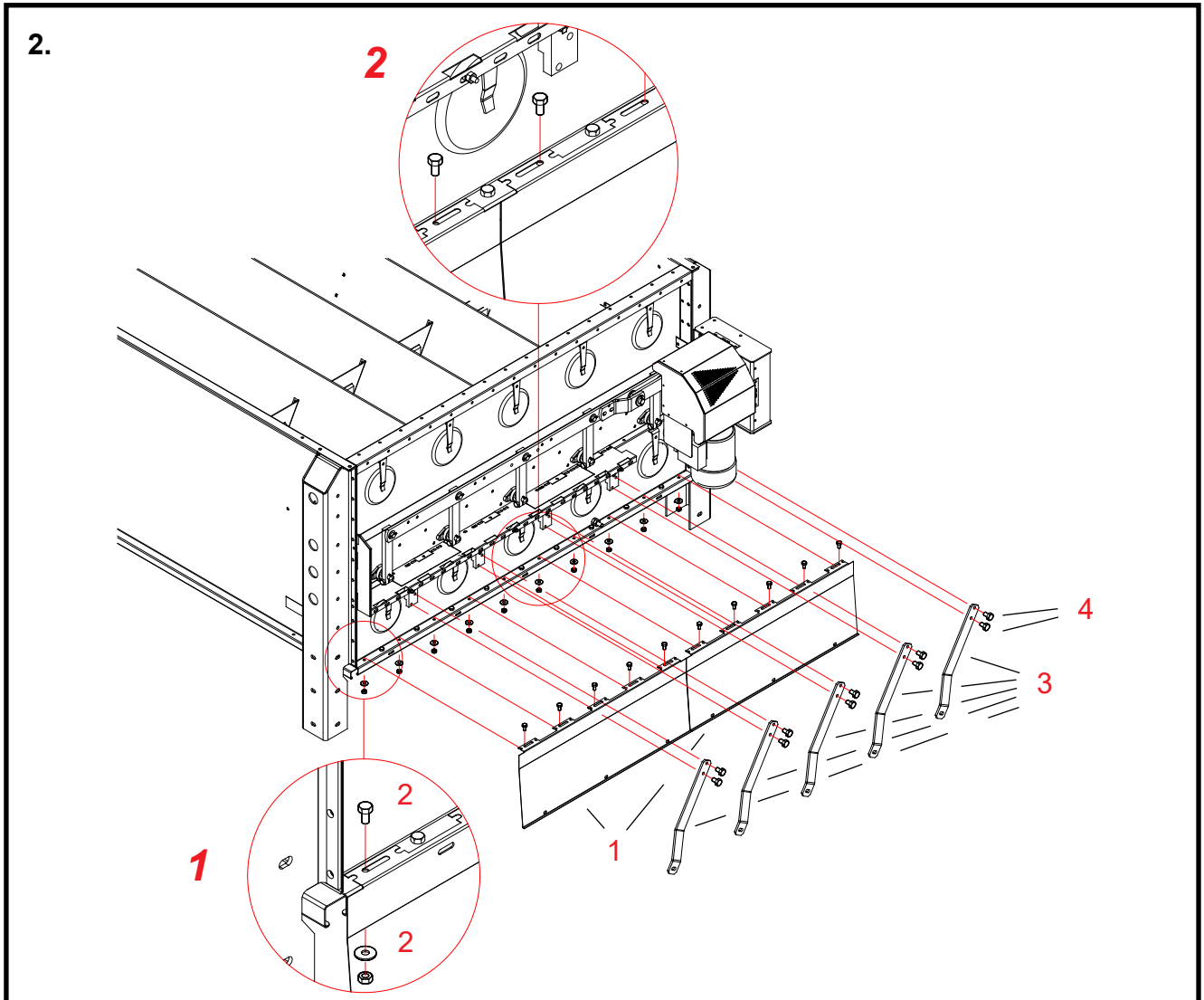
20071106

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	A71886P	BASE WM06 LINEAR ACT DRIVE	1	A71886P	31,01	3000
2	31696	BASE EL,XL,2W,4W CONNECT ROD. 12X60-1588	1	31696	8,84	3000
3	A70693	BASE WM06 TROUGH COVER PL	2	A70693	9,79	3000
4	A70695	BASE WM06 LINEAR ACTUAT COV ATTACH PL	2	A70695	2,82	3000
5	A71316	BASE WM06 TROUGH ROD LINEAR ACT	5	A71316	1,49	3000
6	300368	LINEAR ACTUATOR MAGNETIC MAX64-C700A01M	1		27,09	2200

Installing the linear actuator drive for the feed troughs on 2W (optional)**1. Removing the manually operated trough-arms and their counter-parts, wrenching the limiter bolt**

Stage

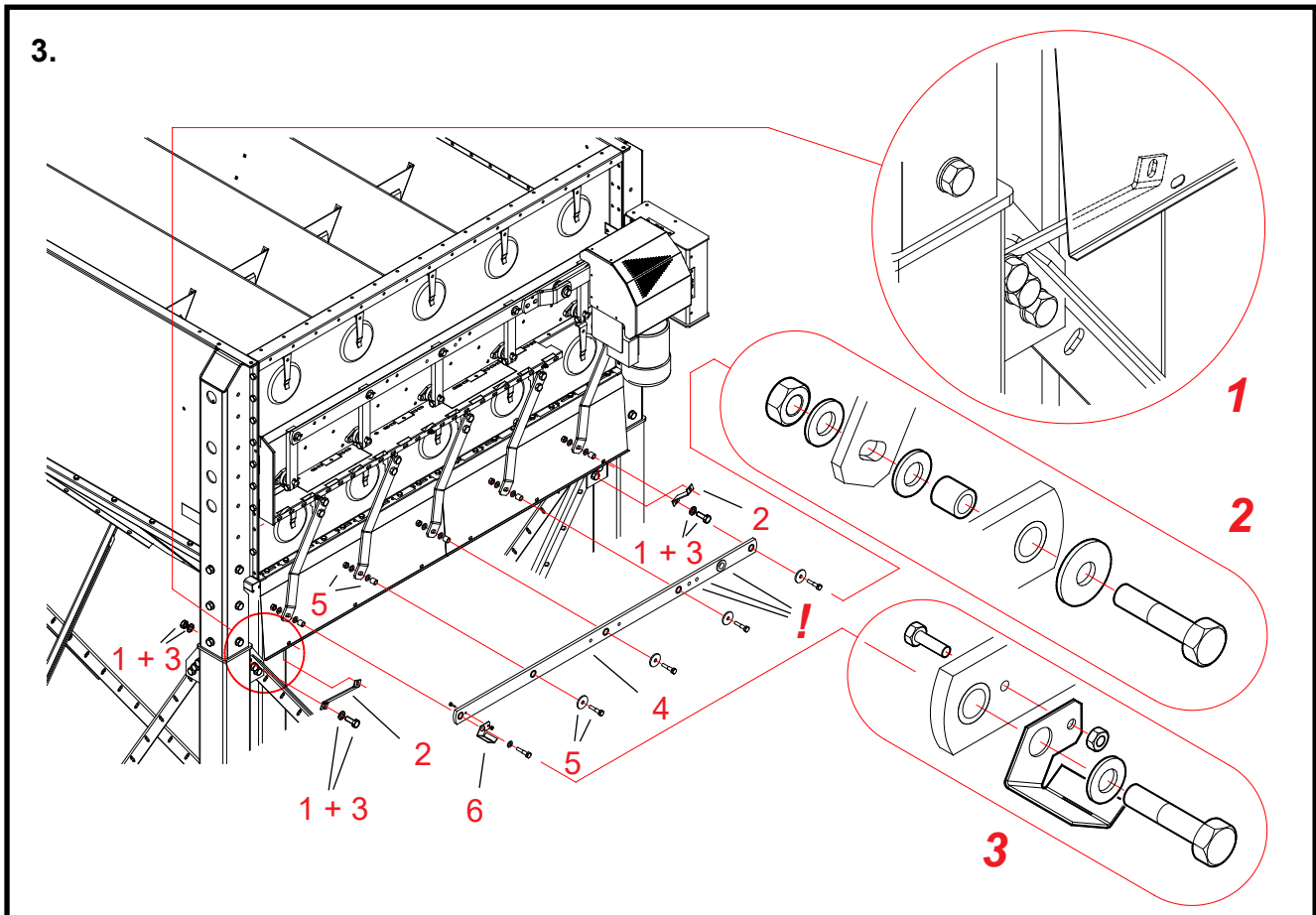
- 1** Remove the nuts for the feeding equipment cover and the cover.
- 2** Remove the hexagon bolts for the manually operated trough-arms and the through-arms.
- 3** Remove the hexagon socket bolts for the trough-arm counter-parts, the washers and nuts as well as the trough-arm counter-parts.
- 4** **Wrench the limiter bolt for the trough movement.**
 - 4.1** Remove the ball-headed hexagon socket bolt and its two nuts from the end-plate of the base.
 - 4.2** Install the parts back in the same hole so, that the nuts come on the outside.



2. Installing the attachment plates for the linear actuator cover and the trough-arms

Stage

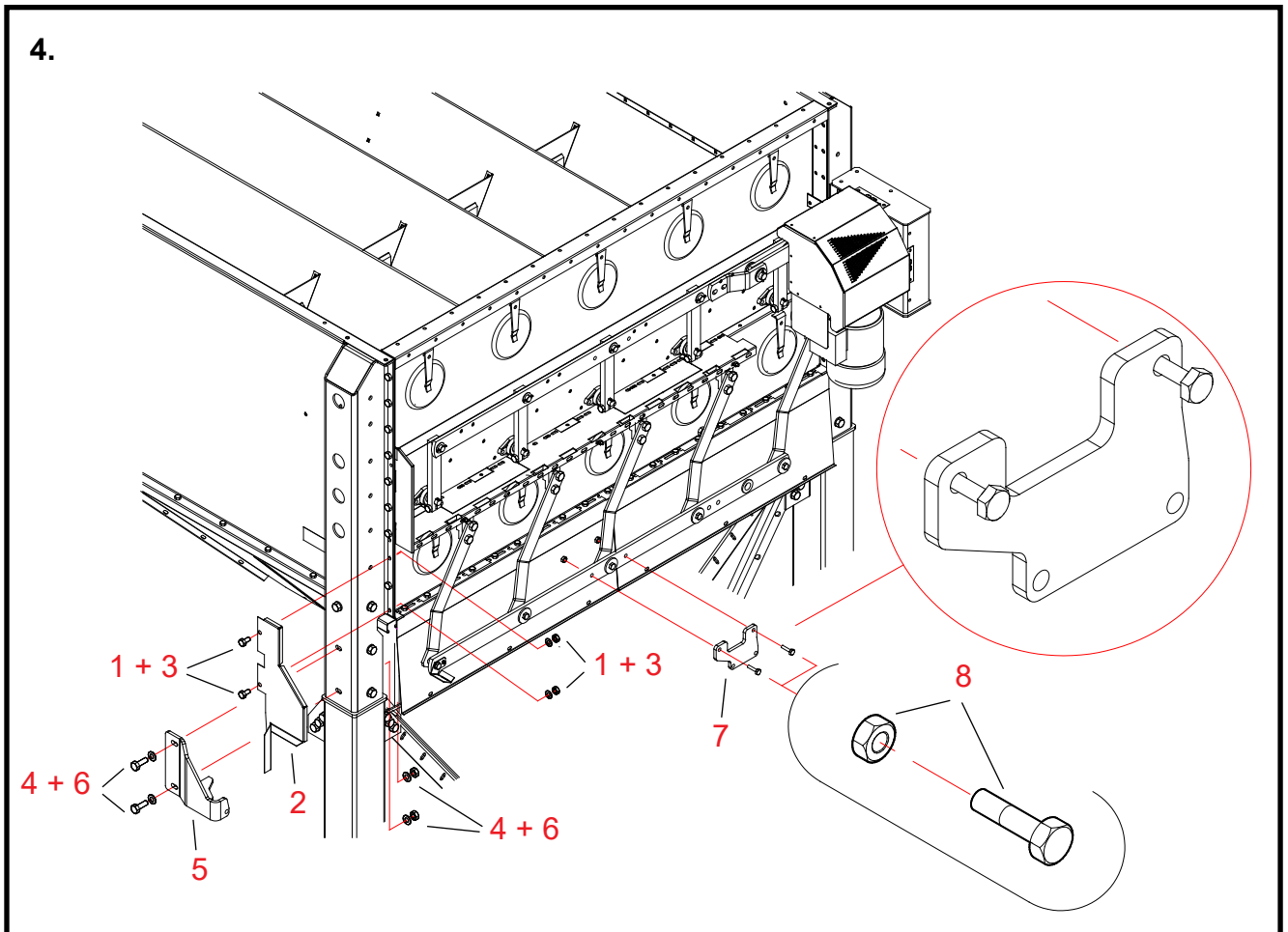
- 1 Install the attachment plates for the linear actuator cover.**
 - 1.1 Remove every other attachment bolt for the base cone with washer and nut from the side of the base with the feeding equipment as illustrated in the drawing.
 - 1.2 Place the perforated edges of the attachment plates for the linear actuator cover on top of the shoulder at the lower edge of the base.
See detail drawings 1 and 2.
- 2 Fix the attachment plates using the bolts, washers and nuts you just removed.**
- 3 Aim the trough-arms towards the holes in the shaft brackets.**
- 4 Fix the trough-arms using the bolts removed at the previous stage.**



3. Installing the attachment plate supports for the linear actuator cover and the connecting rod for the trough-arms

Stage

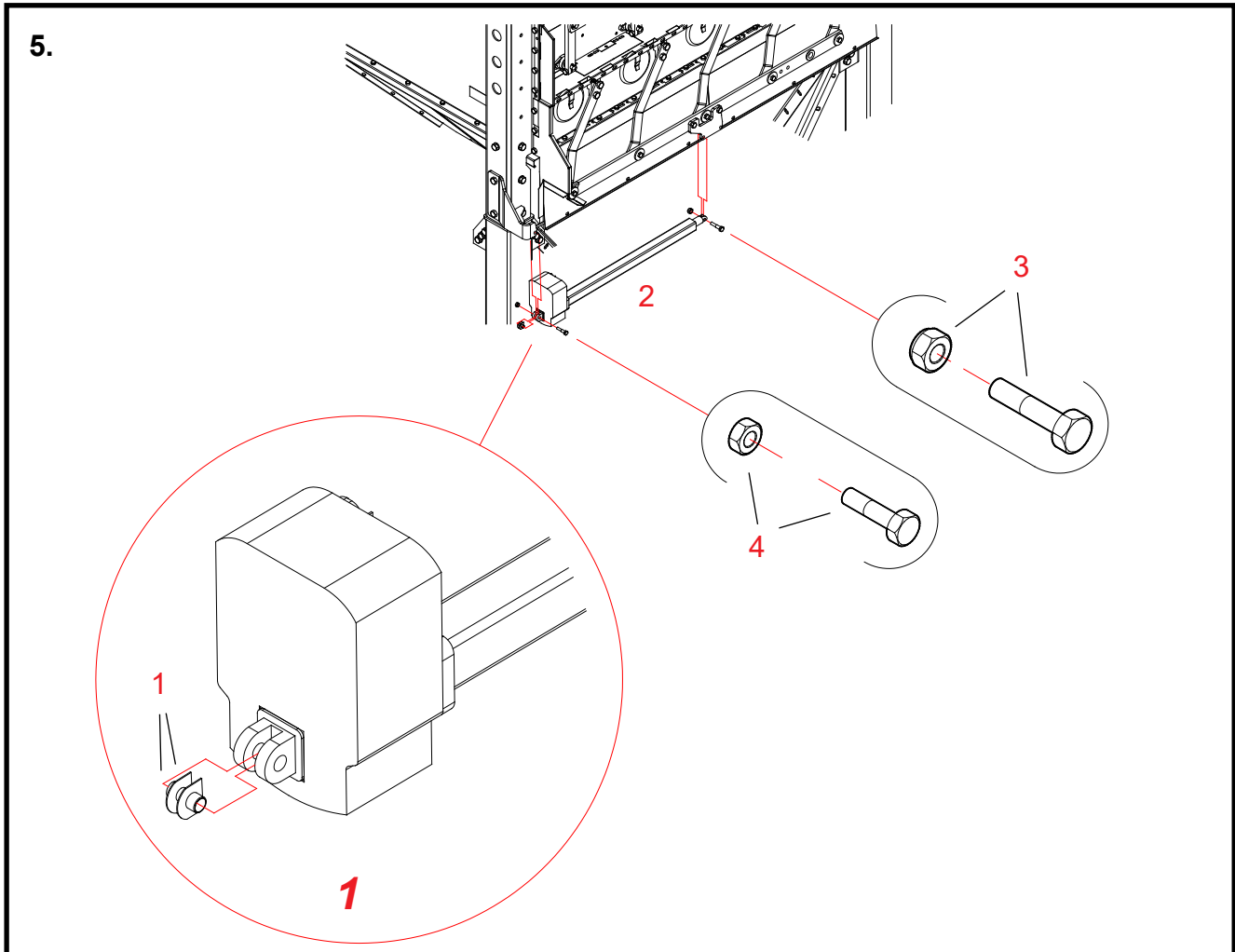
- 1 **Remove the bolts, washers and nuts from the upper ends of the cross-braces for the extension legs**
Remove these two bolts only from the feeding equipment side of the base.
- 2 **Put the attachment plate supports for the linear actuator in place.**
The upper end of the support comes behind the cover and its lower end comes against the upper end of the cross-brace. See detail drawing 1.
- 3 **Fix the attachment plate supports using bolts, washers and nuts.**
The upper end of the support will be fixed by the two bolts at the lower edge of the linear actuator cover.
- 4 **Aim the connecting rod of the trough-arms towards the holes at the lower ends of the trough-arms.**
Observe the direction of the connecting rod (the holes marked ! to the right).
- 5 **Fix the connecting rod to the trough-arms using bolts, washers, sleeves and nuts.**
The assembly order is illustrated in the detail drawing 2. Observe the larger washer under the bolt cap. Tighten the bolts.
- 6 **Do not forget to install the tumbler for the sensor in the left shaft bolt of the trough-arm.**
Place the tumbler between the intermediate plate and the connecting rod. The washer to be placed under the cap of this bolt is of equal size as the other washers on this bolt. Install the tumbler on the connecting rod using M6 x 20 nuts and bolts.
See detail drawing 3.



4. Installing the end of the linear actuator cover, attachment bracket for the linear actuator and the intermediate plate

Stage

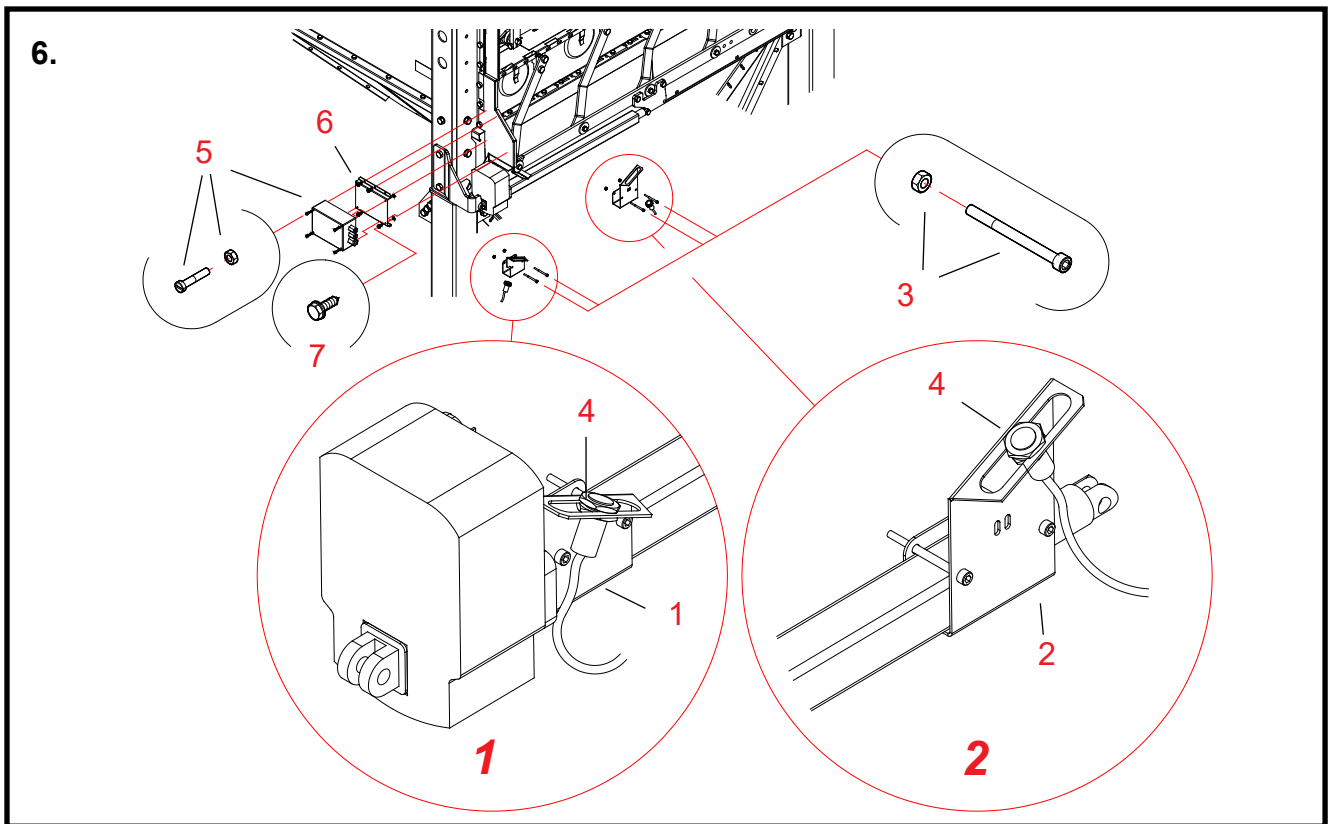
- 1 **Remove the two bolts, washers and nuts from the base leg and the end-plate.**
See drawing
- 2 **Put the end of the linear actuator cover in place.**
The end of the cover comes outside the flange.
- 3 **Fix the end of the linear actuator cover using the bolts, washers and nuts you just removed.**
- 4 **Remove the two lowest extension leg bolts with washers and nuts from the base leg.**
- 5 **Place the attachment bracket for the linear actuator on the outside of the base leg.**
- 6 **Fix the attachment bracket for the linear actuator using the bolts, washers and nuts you just removed.**
- 7 **Position the intermediate plate for the linear actuator in the connecting rod as illustrated in the drawing.**
- 8 **Fix the intermediate plate for the linear actuator using two hexagon nuts and bolts (M10x40).**



5. Installing the linear actuator

Stage

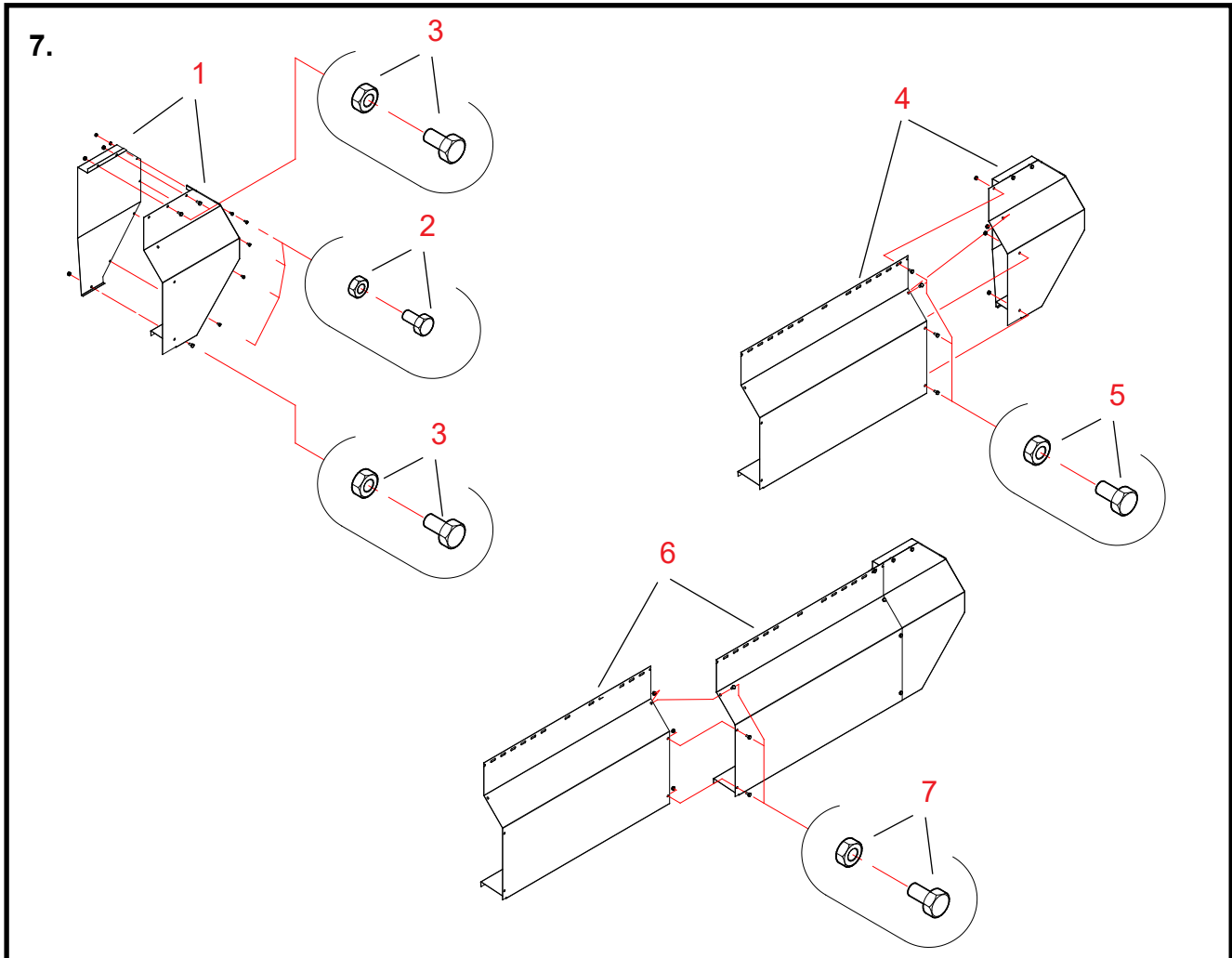
- 1 **Thread the attachment sleeves into the brackets on the left end (in the picture) of the linear actuator.**
Look up the position of the linear actuator and threading of the sleeves in detail drawing 1.
- 2 **Align the linear actuator with the holes in the attachment bracket and the intermediate plate.**
Look up the correct position for the linear actuator in the drawing.
- 3 **Fix the linear actuator to the intermediate plate using a hexagon bolt and Nyloc nuts (M12x55).**
- 4 **Fix the linear actuator to the attachment bracket using a hexagon bolt nuts (M10x40).**
Make sure, that the attachment sleeves remain in position in the brackets during the installation.



6. Installing the sensor brackets, the sensor and the connecting box

Stage

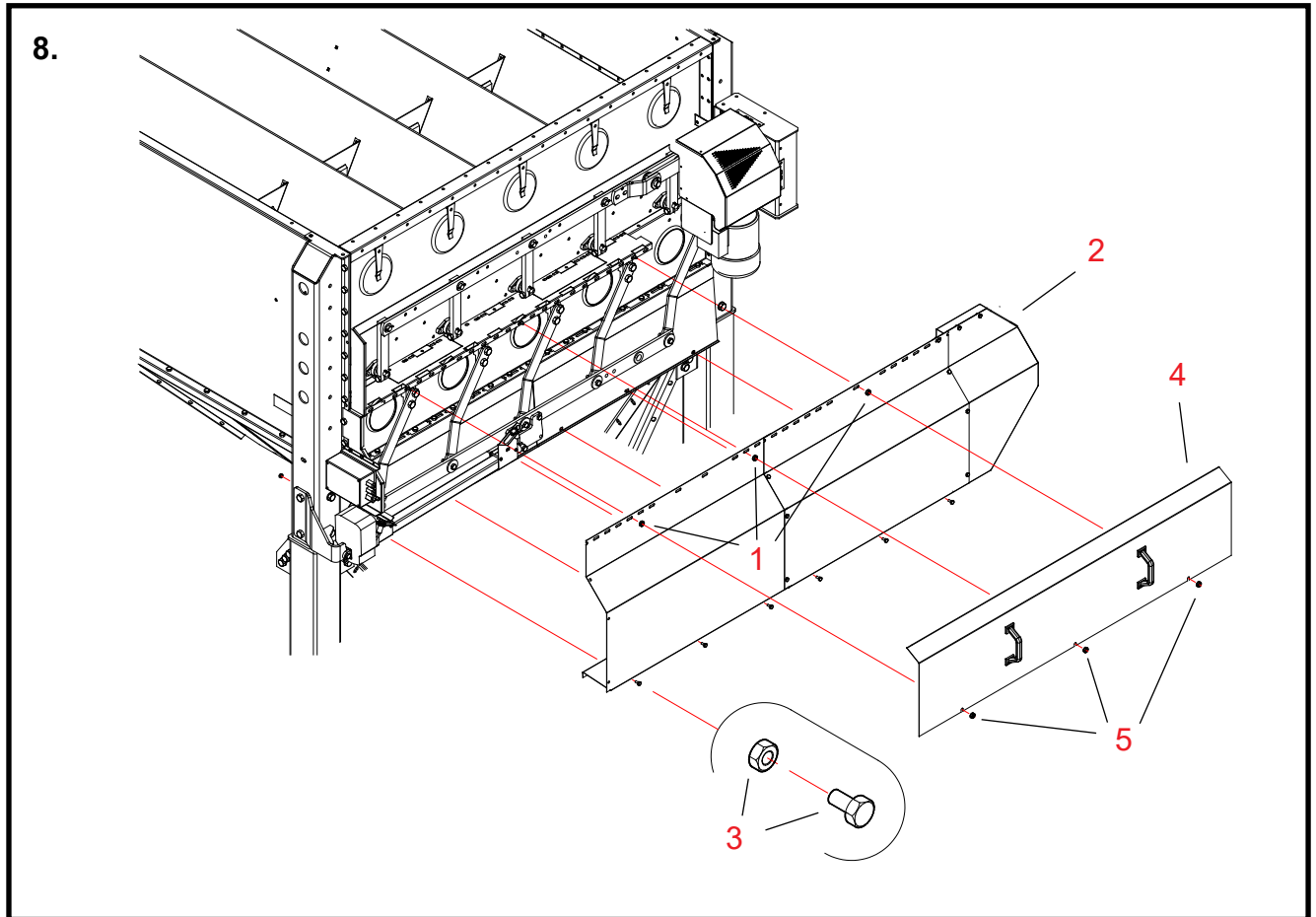
- 1 **Position the sensor bracket for the closed position on the frame of the linear actuator.**
The correct location for the bracket is against the shoulder at the end of the frame, on the same side as the motor (detail drawing 1).
- 2 **Position the sensor bracket for the open position on the frame of the linear actuator.**
The correct location for the bracket is level with the end of the frame, on the same side as the spindle (detail drawing 2).
- 3 **Fix both sensor brackets using two hexagon socket nuts and bolts (M6x70).**
- 4 **Attach the sensor using its nuts to both sensor brackets.**
- 5 **Place the connecting box onto the attachment plate and fix it using four slot-headed screws and nuts (M4x20).**
- 6 **Position the attachment plate for the connecting box in the end of the linear actuator cover.**
- 7 **Attach the plate using four self-tapping hexagon screws (4,8 x 13).**



7. Assembling the cover-plates for the linear actuator

Stage

- 1 Place the rear cover-plates for the linear actuator one against the other and align the boltholes.
- 2 Fix the plates by their end-flanges using five hexagon nuts and bolts (M6x14).
- 3 Fix the plates by their upper and lower flanges using three hexagon nuts and bolts (M8x16).
- 4 Place the rear cover-plates in the end of the cover-plate for the trough-arms and align the boltholes.
The cover-plate for the trough arms comes in the front of the rear cover-plate set-up.
- 5 Fix the parts using four hexagon nuts and bolts (M8x16).
- 6 Place the set-up, assembled at stage 4, in the end of the cover-plate for one of the trough-arms.
The set-up, assembled at stage 4, comes on top of the cover-plate for the trough-arms.
- 7 Fix the parts using three hexagon nuts and bolts (M8x16).



8. Installing the cover-plate set-up for the linear actuator and the cover for the feeding equipment

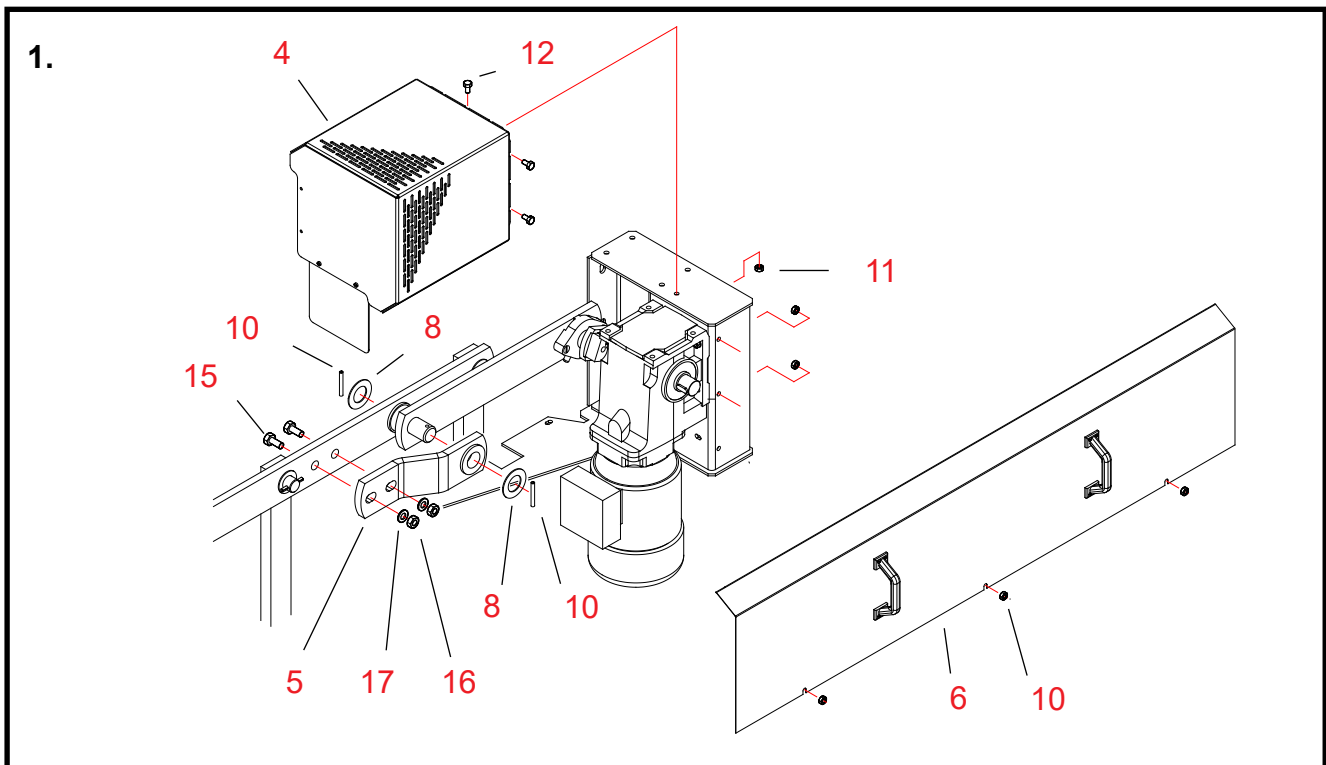
Stage

- 1 **Remove nuts from the three attachment bolts for the feeding equipment cover.**
- 2 **Put the cover-plate set-up for the linear actuator in place.**
Align the boltholes at the lower edge and thread the upper edge onto the bolts of the feeding equipment cover.
Fix the upper edge of the set-up using the nuts that you just removed. Tighten the nuts.
- 3 **Fix the set-up by its lower edge using six hexagon nuts and bolts (M8 x 16).**
Observe, that the bolts, closest to the edge, at the same time fix the upper ends of the supports for the linear actuator cover.
- 4 **Put the cover for the feeding equipment in place.**
- 5 **Fix the cover using three nuts (M8).**
The upper edge of the cover-plate set-up for the linear actuator will be fixed at the same time.

Transferring the feeding equipment motor to another position

The shape of the dryer building or some other space-related issue may sometimes require transferring the motor to the opposite side of the dryer base.

At the factory, the motors are always placed on the right-hand side of the dryer base.



1. Dismantling the eccentric piece cover and the transmission rod

Parts The numbering of work stages refers to reference numbers in the spare parts drawings of the motor rack, feeding equipment and base assembly.

10 Remove the three attachment nuts for the protective cover of the feeding equipment.

6 Remove the protective cover for the feeding equipment.

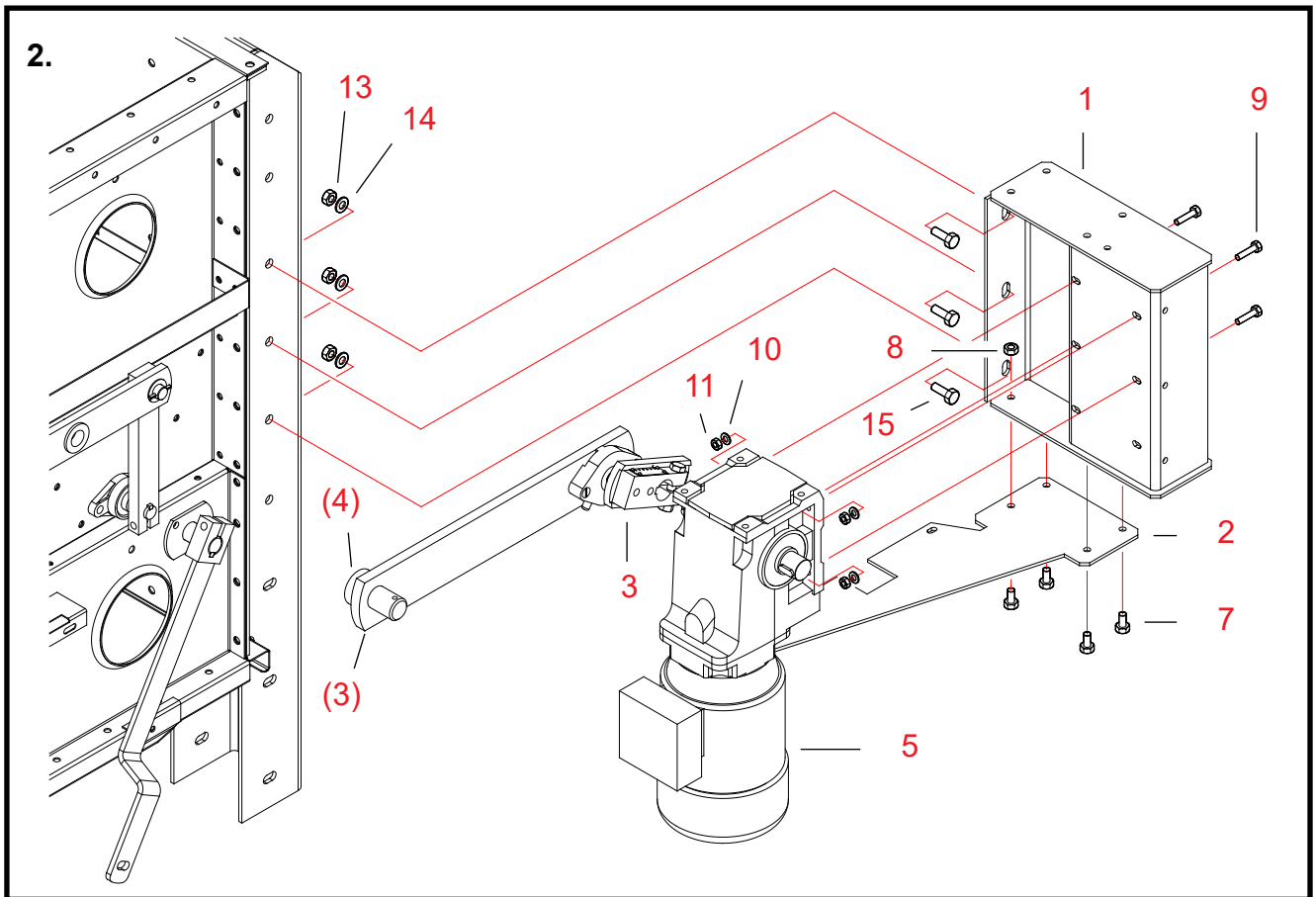
11, 12 Remove the three attachment nuts and bolts for the eccentric piece cover.

4 Dismantle the eccentric piece cover with its additional cover from the motor rack.

8, 10 Remove the spring cotters and washers from both ends of the transmission of the feeding equipment.

15, 16, 17 Remove the two bolts and washers from the connecting rod support.

5 Dismantle the connecting rod support from the connecting rod and the transmission rod.



2. Dismantling the motor and the motor rack

Parts The numbering of work stages refers to reference numbers in the spare parts drawings of the motor rack, feeding equipment and base assembly.

9, 10, 11 Remove the four attachment bolts and washers for the motor.

5 Dismantle the motor, the eccentric piece and the transmission rod from the rack.

As required, use a pry-bar for removal of the transmission rod shaft (part 3).

Leave the spacer (part 4) on the transmission rod shaft.

Lift the dismantled unit onto a suitable work plane.

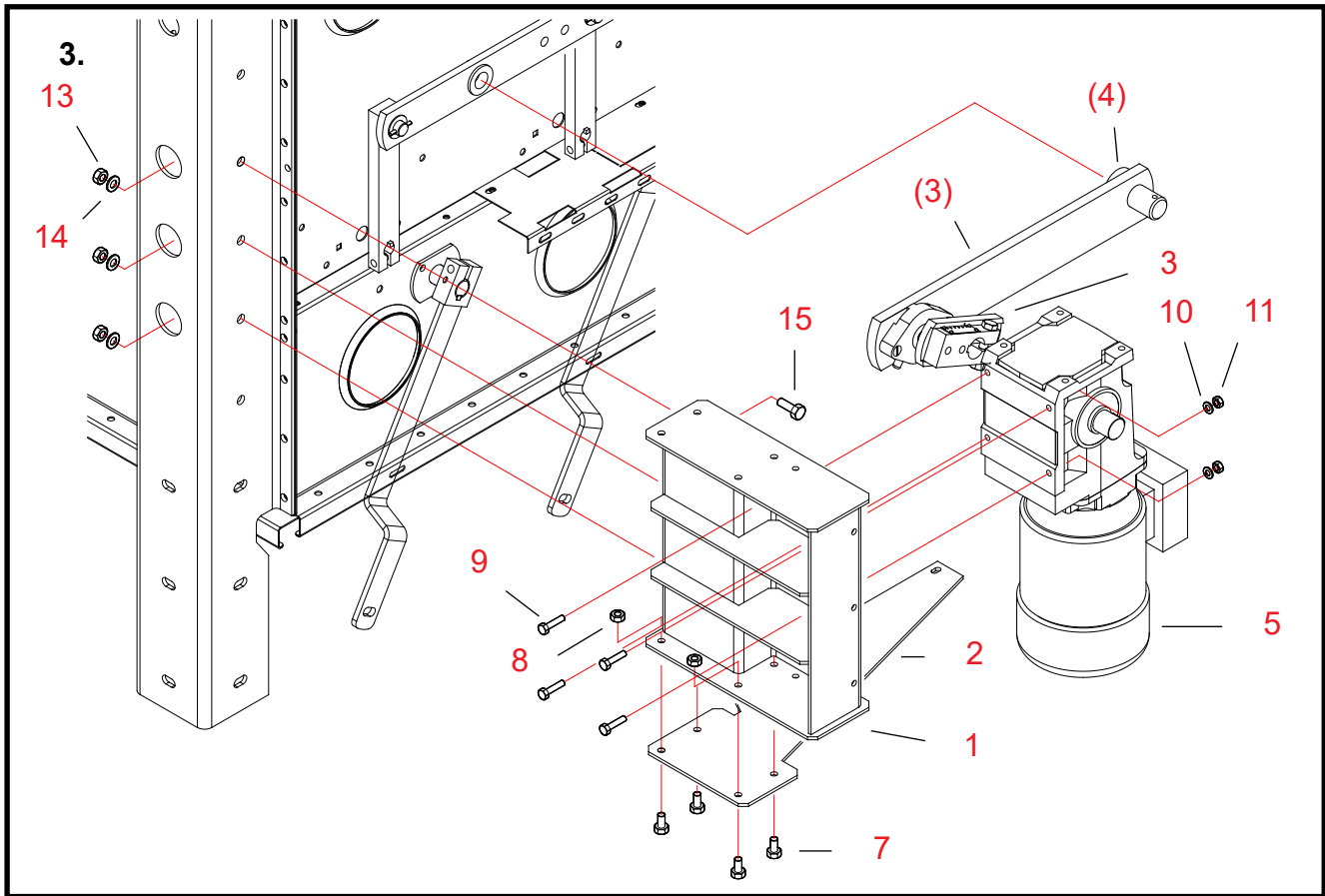
13, 14, 15 Remove the three attachment bolts, nuts and washers for the motor rack.

1 Remove the motor rack and the torque arm from the dryer base leg.

7, 8 Remove the four attachment screws and nuts for the torque arm.

2 Disconnect the torque arm from the motor rack.

3 Unscrew the eccentric piece bolt and draw out the eccentric piece and the transmission rod.



3. Re-installing the motor and the motor rack

Parts The numbering of work stages refers to reference numbers in the spare parts drawings of the motor rack, feeding equipment and base assembly.

2 Put the torque arm in place in the motor rack.

7, 8 Attach the torque arm using nuts and bolts (M10 x 20, 4 pcs.).

1 Attach the motor rack and the torque arm to the dryer base leg.

13, 14, 15 Attach the motor rack using bolts, washers and nuts (M12 x 35, 3 pcs.).

Check that the relevant end of the motor shaft is equipped with a key.

3 Place the eccentric piece onto the motor shaft.

Push the eccentric piece on the shaft to as far it as goes.

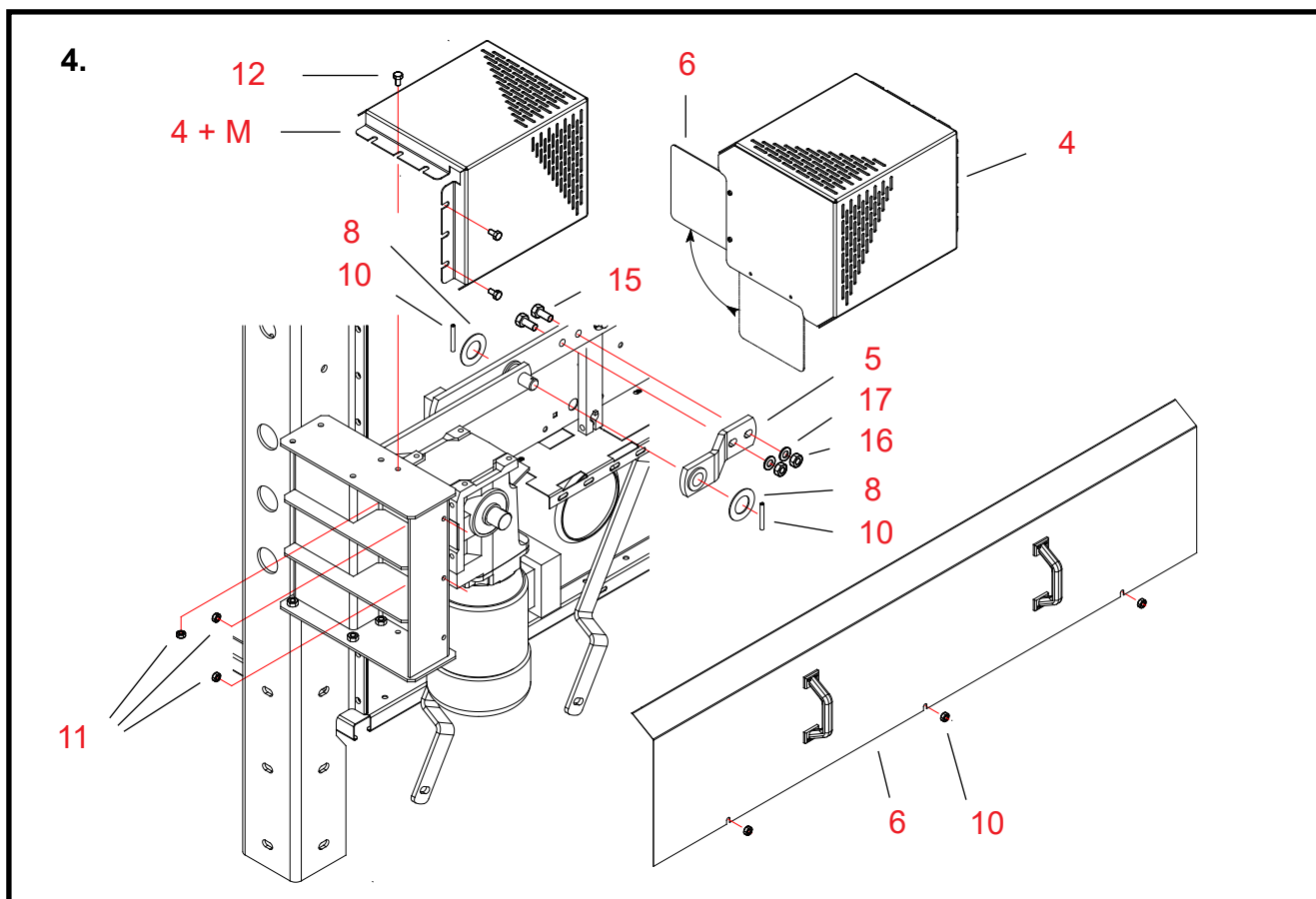
Tighten the bolt for the eccentric piece.

5 Put the motor with the eccentric piece and transmission rod back on the rack.

Check that the spacer (part 4) is still in place on the transmission rod shaft.

Align the transmission rod shaft (part 3) with the bearing sleeve for the connecting rod.

9, 10, 11 Attach the motor to the rack using bolts, washers and nuts (M8 x 35, 4 pcs.).

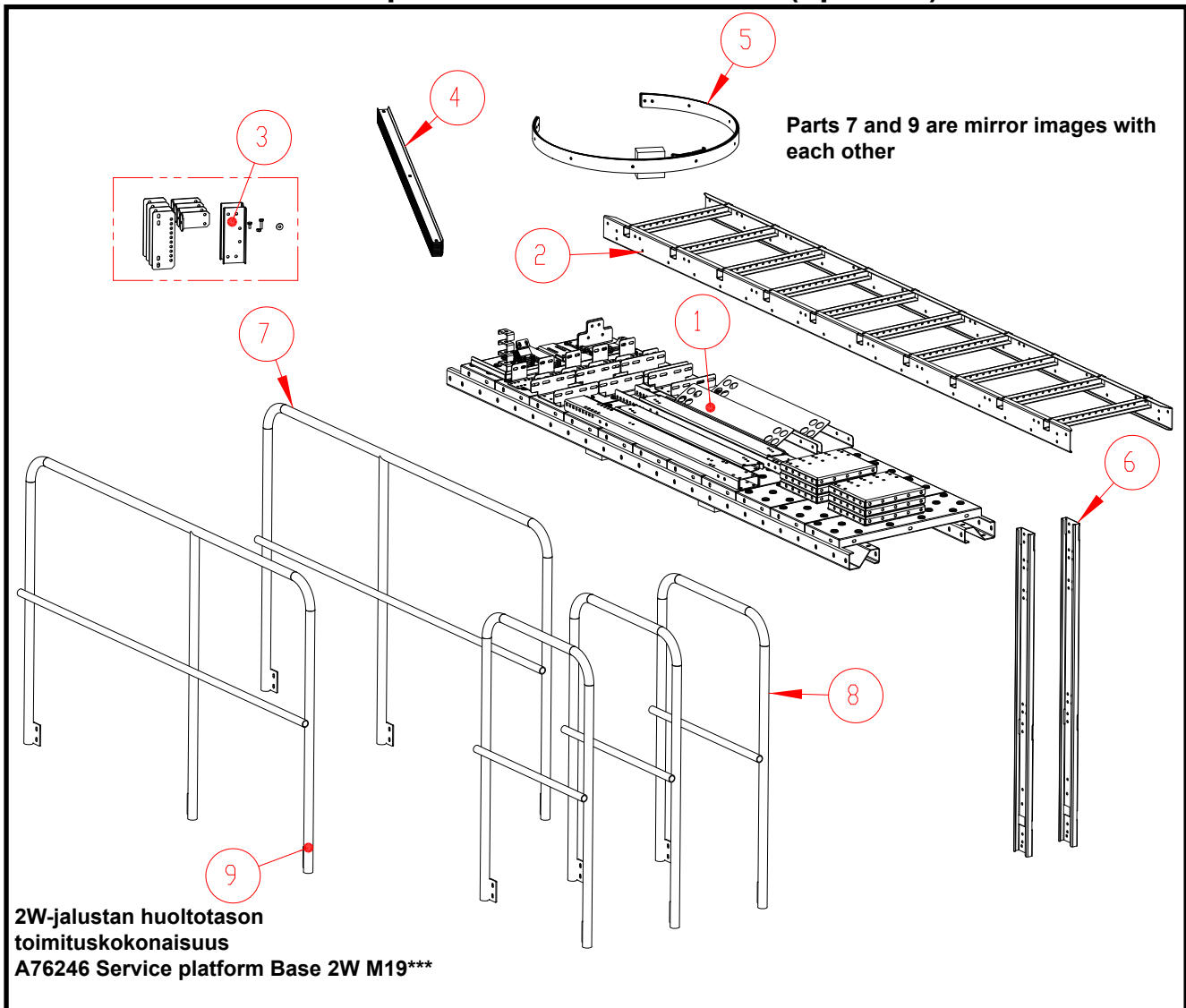


4. Installing the eccentric piece cover and the transmission rod

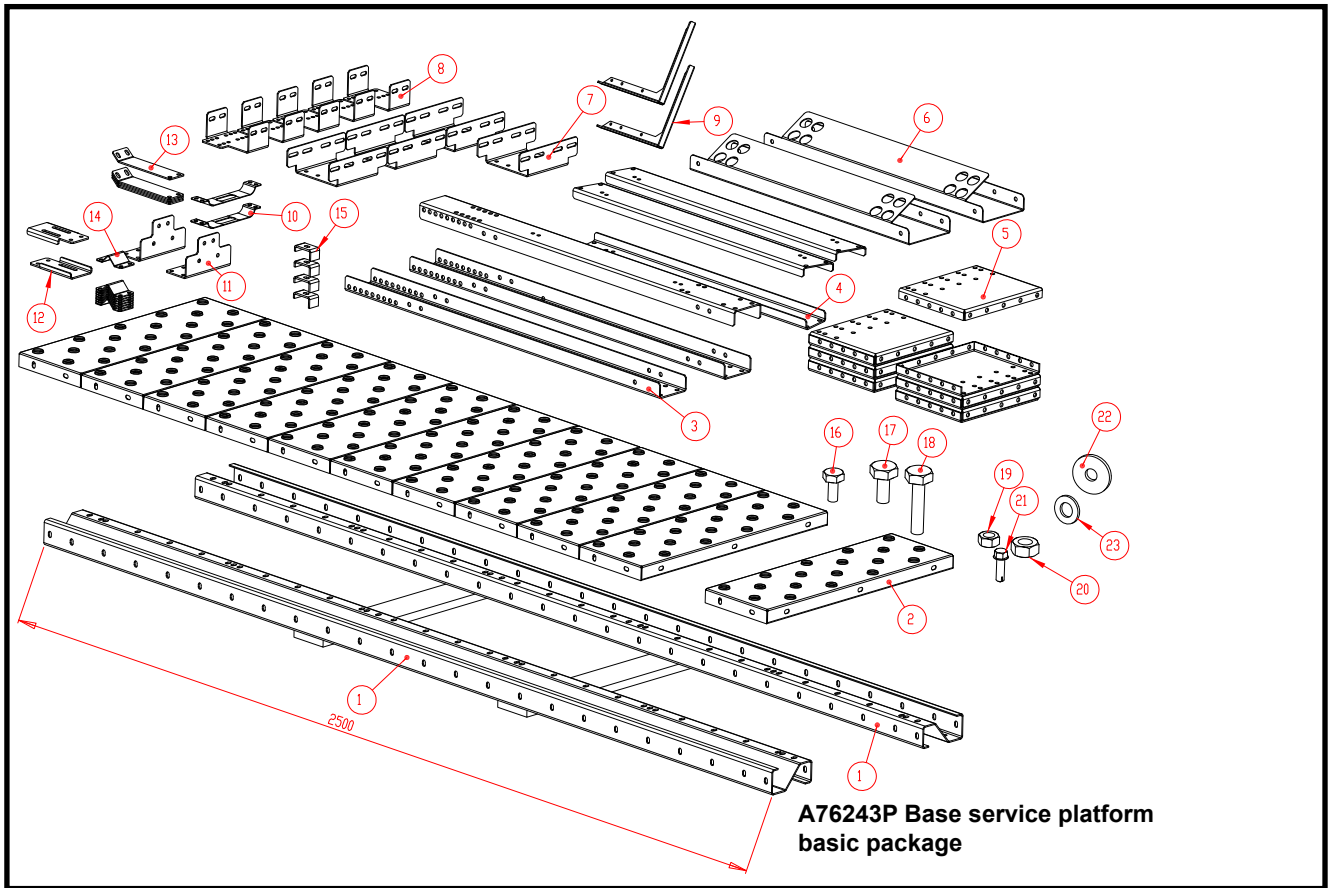
Parts The numbering of work stages refers to reference numbers in the spare parts drawings of the motor rack, feeding equipment and base assembly.

- 5** Install the connecting rod support on the connecting rod and the transmission rod.
- 15, 16, 17** Fix the connecting rod support in place using bolts, washers and nuts (M12 x 40, 2 pcs.).
- 8, 10** Put spring cotters and washers on both ends of the transmission rod shaft of the feeding equipment.
- 6** Transfer the additional protective cover for the eccentric piece to its optional position in the eccentric piece cover.
Look up the new position for the additional cover in the drawing.
- 4** Attach the eccentric piece cover with its additional cover to the motor rack.
- 11, 12** Attach the eccentric piece cover using bolts, washers and nuts (M8 x 16, 3 pcs.).
- 6** Put the protective cover for the feeding equipment in place.
- 10** Attach the protective cover for the feeding equipment using nuts (M8, 3 pcs.).

Structure of the service platform for the base 2W (optional)



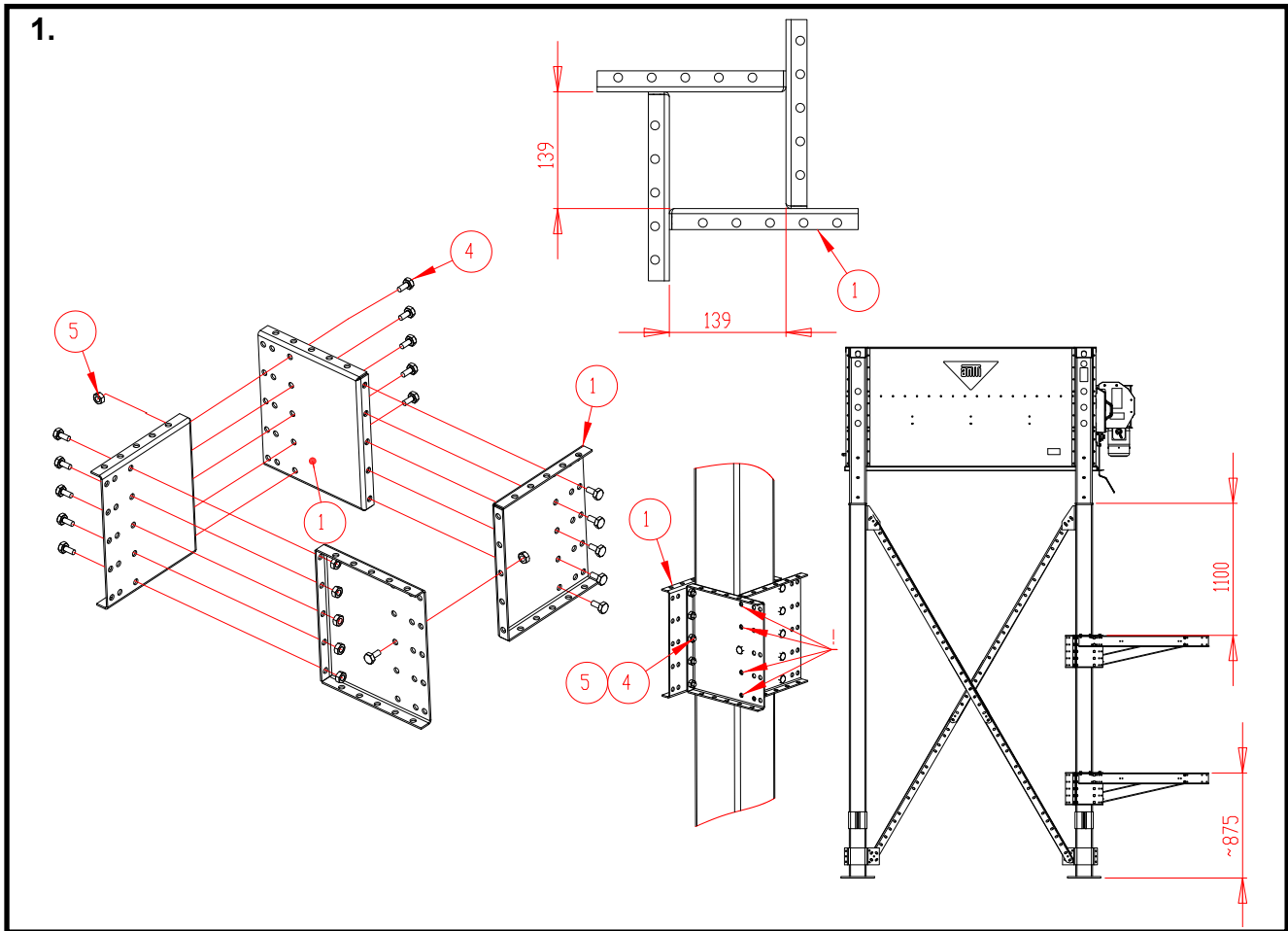
Ref.	Part no.	Denomination	Pcs.	Weight
1	A76243P	SERVICE PLATFORM BASE BASIC PACKAGE M19	1	119,11
2	A76224	PAK LADDER L=2900 M19	1	16,94
3	A76251	PAK LADDER TARVIKELAATIKKO M19	1	3,38
4	A76250	PAK LADDER SELKÄJOHDE PAKKAUS M19	1	13,92
5	A76249	PAK LADDER SUOJAKAARIPAKKAUS M19	1	9,36
6	A76253	PAK LADDER UPPER EXIT RAIL M19	2	2,71
7	A76206	RAILING ELEMENTS L 1773 A M19	1	12,46
8	A76208	RAILING ELEMENTS L 671 M19	3	6,49
9	A76207	RAILING ELEMENTS L 1773 B M19	1	12,46



Ref.	Part no.	Denomination	Pcs.	Weight
1	A71919	Z-BEAM L=2500 WM06	2	17,58
2	A71545	PLATFORM ELEMENT FOR ELEVATOR 215 X 635 X 35	11	2,35
3	A71962	SERVICE PLATFORM BASE CROSSBAR L=1070 WM06	3	3,97
4	A76244	SERVICE PLATFORM BASE SUPPORT M19	3	2,31
5	A71963	SERVICE PLATFORM BASE BAND 225X268 WM06	12	1,69
6	A71949	SERVICE PLATFORM BASE END-BEAM L=750 WM06	2	3,37
7	A76220	SERVICE PLATFORM FASTENER PLATE M19	4	0,94
8	A76221	SERVICE PLATFORM FASTENER PLATE M19	5	0,47
9	A76214	RAILING SUPPORT PART M19	2	0,38
10	A76216	RAILING FASTENING PART M19	3	0,09
11	A76239	SERVICE PLATFORM BASE LADDER CLAMP	2	0,48
12	A76240	SERVICE PLATFORM BASE LADDER CLAMP	2	0,29
13	A76241	SERVICE PLATFORM BASE LADDER CLAMP	4	0,24
14	A76242	KIINNIKELEVY KAIDEPUTKEEN M19	8	0,08
15	400282	SUPPORT CLAMP TO COVER, UPPER LAYER	4	0,08
16	101810	BOLT HEX ZN 8.8 8X16 DIN933	74	0,01
17	102200	BOLT HEX ZN 8.8 10X20 DIN933	175	0,02
18	102250	BOLT HEX ZN 8.8 10X40 DIN933	5	0,01
19	110540	NUT M8 ZN 8 DIN934	74	0,01
20	110560	NUT M10 ZN 8 DIN934	179	0,01
21	107523	DRILL SCREW 6HEX 5,5X19 ZN DIN7504-K	12	0,01
22	111563	WASHER M10 D34/D11X3 DIN440R ZN	23	0,01
23	111550	WASHER ZN M10 DIN 125	46	0,01

Installing the service platform for the base 2W (optional)

"Ohjekuvista on piilotettu jalustan pohjakartio, jotta kuvien luettavuus on selkeämpi



Kokoa hoitotason kannattimen pannat (osista 1) jalustan kahden jatkojalan ympärille.

Assemble one band on both extension legs on the side of the base with the feeding equipment. (Ylempänä olevat pannat). Kokoa yksi panta myös alemmas jalkaan joka on lähellä huoltotason tikkaiden puoleista päätä.

Sijoita ylempänä olevien pantojen yläreunat 1100 mm:n etäisyydelle jalustan jalan alapäästä.

Sijoita alempana olevan pannan yläreuna n. 875 mm:n etäisyydelle jalustan jatkojalan alapäästä.

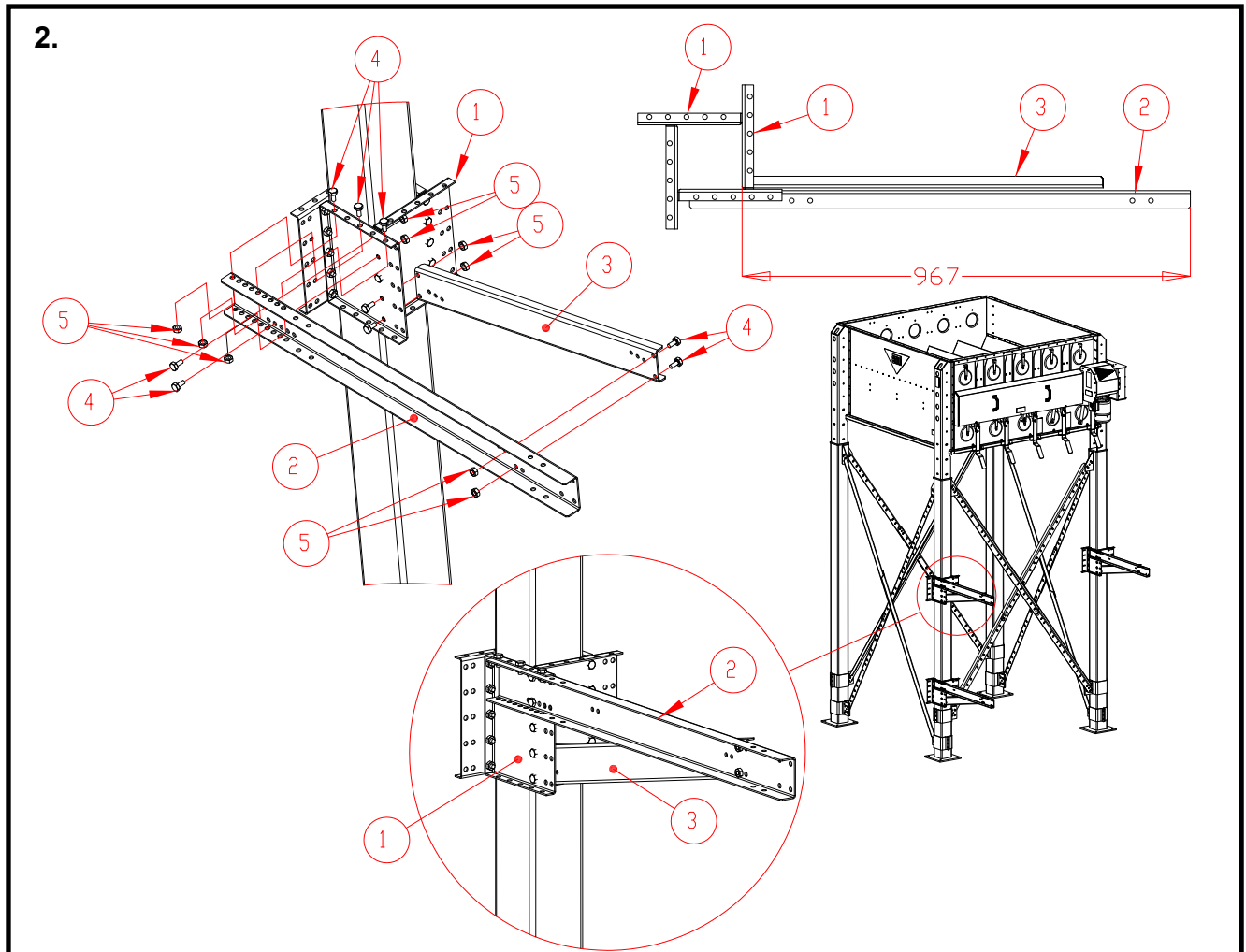
Fix the parts of the bands using nuts and bolts (M10x20, 16 pcs./set-up).

Assemble the bands for the 2W dryer using the inner bolthole rows (opening in the band 139x139 mm).

Huomaa, että tässä työvaiheessa pannoista jätetään yhdeltä sivulta neljä ruuvia asentamatta (Kohdat merkitty kuvaan huutomerkillä).

Em. ruuvien alle kiinnittyvät myös orsi ja vinotukiosat (osat 2 ja 3). Em. ruuvit asennetaan vasta seuraavassa työvaiheessa. (kts.seuraava sivu)

Ref.	Part no.	Denomination
1	A71963	SERVICE PLATFORM BASE BAND 225X268 WM06
2	A71962	SERVICE PLATFORM BASE CROSSBAR L=1070 WM06
3	A76244	SERVICE PLATFORM BASE SUPPORT M19
4	102200	BOLT HEX ZN 8.8 10X20 DIN933
5	110560	NUT M10 ZN 8 DIN934



Installing the crossbar on the service platform bearers and its support 2W

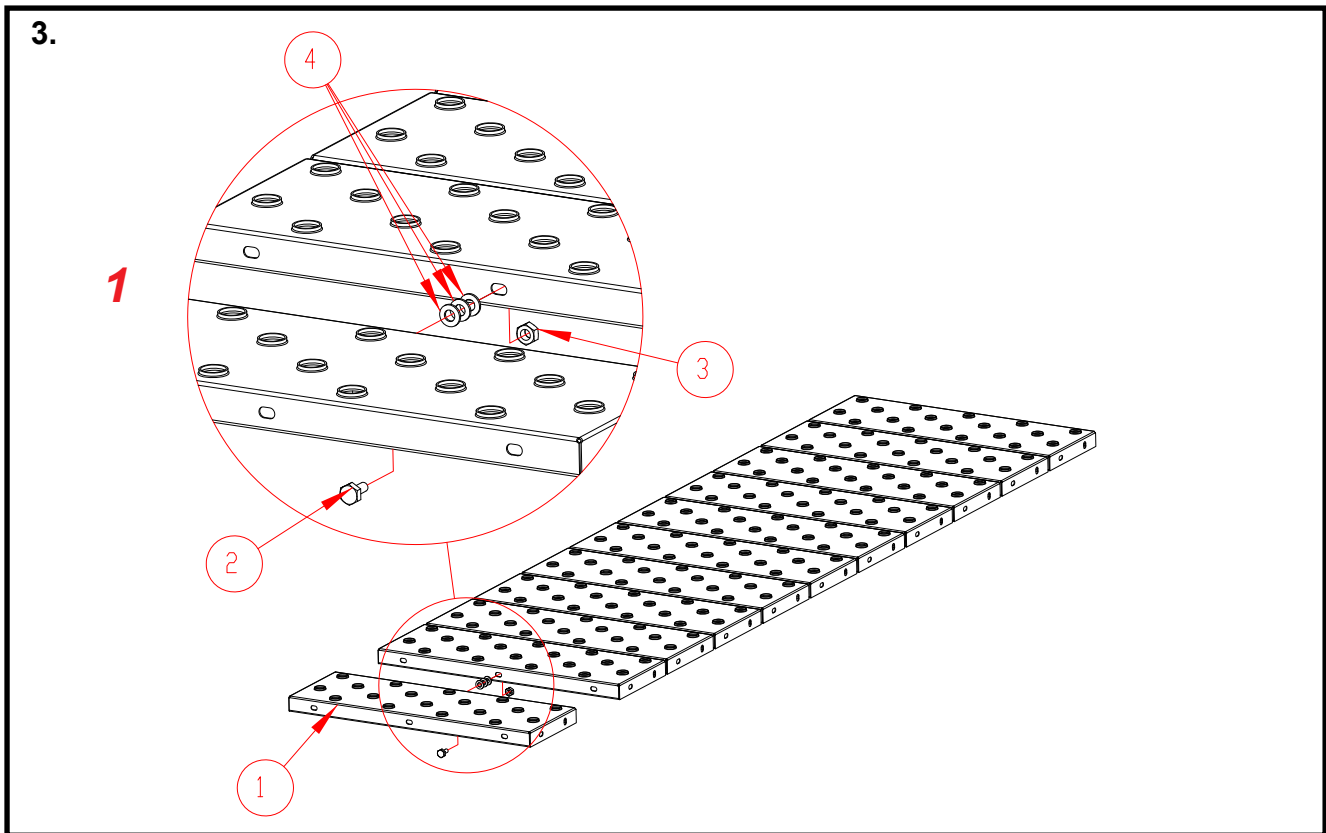
Sijoita hoitotason kannattimen orret (parts 2) kannattimien pantoihin.

Position the crossbars so that the distance from the end of the crossbar to the tube of the extension leg will be 947 mm.

Fix the crossbars to the bands using nuts and bolts (M10x20, 5 pcs./crossbar).

Position the supports for the service platform bearers (parts 3) as illustrated in the drawing.

Fix the supports to the bands and crossbars using nuts and bolts (M10x20, 4 pcs./support).



Ref.	Part no.	Denomination
1	A71545	PLATFORM ELEMENT FOR ELEVATOR 215 X 635 X 35
2	102200	BOLT HEX ZN 8.8 10X20 DIN933
3	110560	NUT M10 ZN 8 DIN934
4	111550	WASHER M 10 DIN125 ZN

Joining the platform elements 2W

Start by joining all the 11 platform elements (A71545) together.

Jalustan huoltotasopakkaus A76243P sisältää 11 kpl tasoelementtejä.

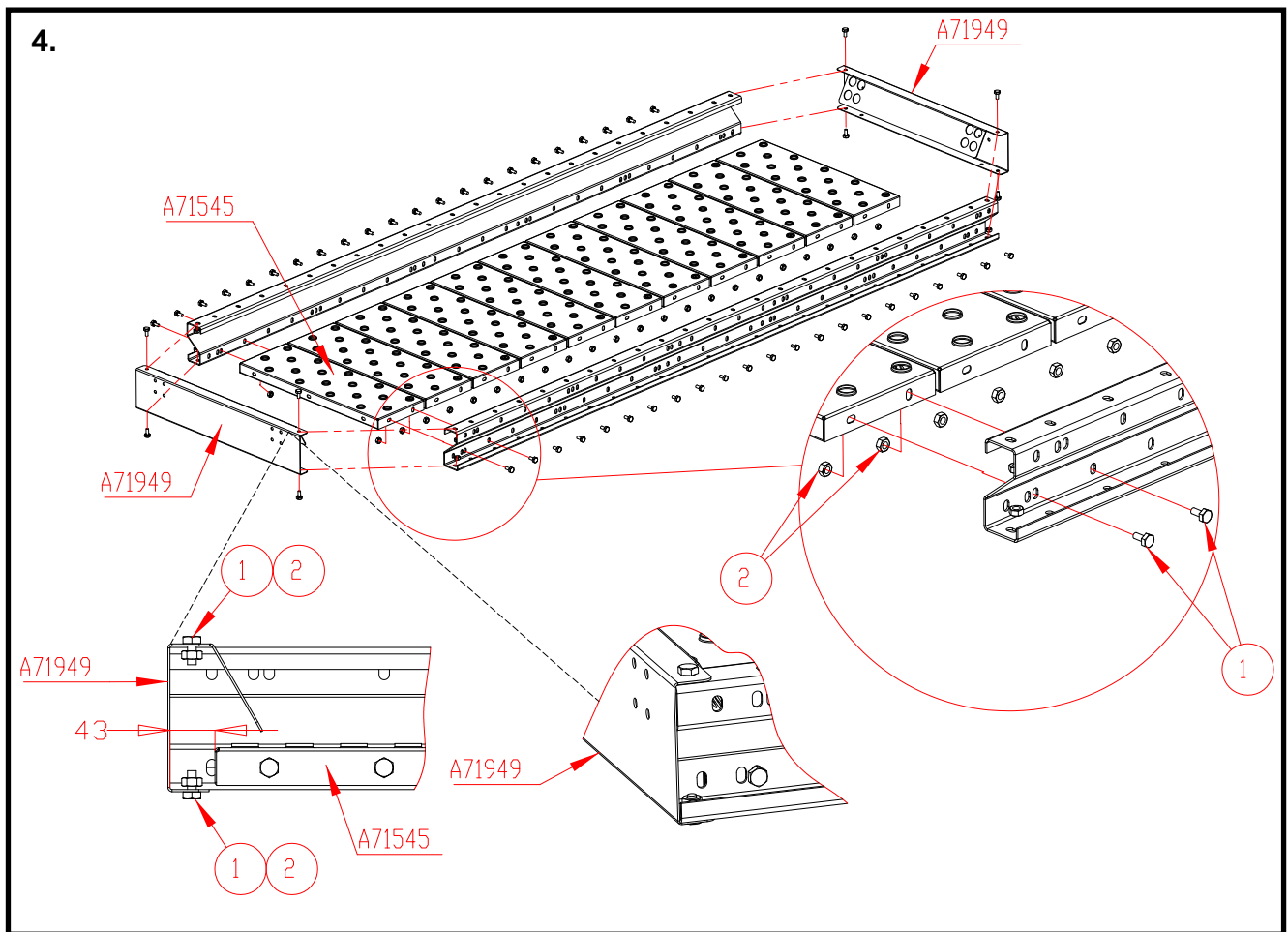
Join the platform elements together using nuts and bolts (M10x20, 1 pcs./element joint).

Put an M10x20 bolt and an M10 nut in the midmost boltholes in the longer edges of the elements.

Asenna elementtien saumaan lisäksi 3kpl M 10 aluslevyjä elementtien väliin jotta saadaan elementtien jako sopivaksi

See detail drawing 1.

Tasoelementtien kiinnitysruuvien lopullinen kiristys kannattaa suorittaa vasta sen jälkeen kun tasoelementit on liitetty Z-palkkeihin. (kts. vaihe "Z-palkkien ja päätypalkkien asentaminen huoltotasoon 2W") s.53



Ref.	Part no.	Denomination
1	102200	BOLT HEX ZN 8.8 10X20 DIN933
2	110560	NUT M10 ZN 8 DIN934

Installing the Z-beams and the end-beams of the service platform 2W

Asenna Z-palkki (A71919) huoltotason kumpaankin sivuun.

Check the position of the platform elements and the Z-beams with respect to one another in the detail drawings 1 and 2.

Fix the Z-beams to the sides of the platform element set-ups.

Suorita kiinnitys kahdella ruuvilla ja mutterilla (M 10 x 20) jokaisen tasoelementin kummastakin päästä.

Install an end-beam (A71949) in both ends of the service platform.

Check the position of the end-beam and the Z-beam with respect to one another in the detail drawings 2 and 3.

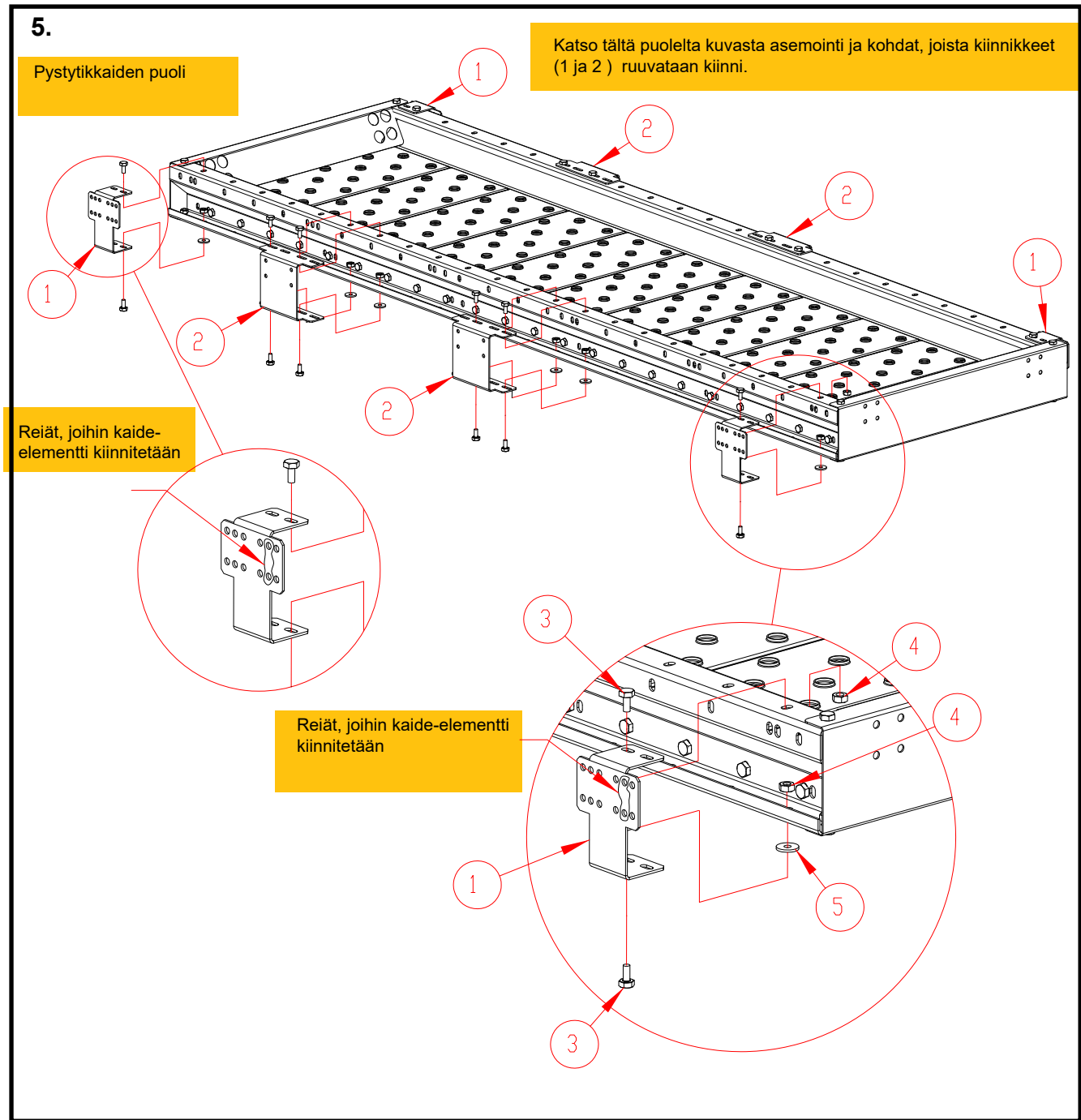
Fix the end-beams to the ends of the Z-beams.

Fix each end-beam by its both ends using two nuts and bolts (M10x20).

5.

Pystytikkaiden puoli

Katso tältä puolelta kuvasta aseointi ja kohdat, joista kiinnikkeet (1 ja 2) ruuvataan kiinni.



Ref.	Part no.	Denomination
1	A76221	SERVICE PLATFORM FASTENER PLATE M19
2	A76220	SERVICE PLATFORM FASTENER PLATE M19
3	102200	BOLT HEX ZN 8.8 10X20 DIN933
4	110560	NUT M10 ZN 8 DIN934
5	111563	WASHER M10 D34/D11X3 DIN440R ZN



Kaide-elementtien kiinnityslevyjen asennus

Asenna kiinnikelevyt (osat 1 ja 2) tarkasti kuvan mukaisille paikoilleen.

Katso oikeat paikat kuvasta laskemalla Z-palkin reiät, jotka jäävät kiinnikeiden väleihin.

Laita kiinnikelevyn ja Z-palkin alareunan väliin korialuslevy (osa 5) jokaiseen ruuviliitokseen.

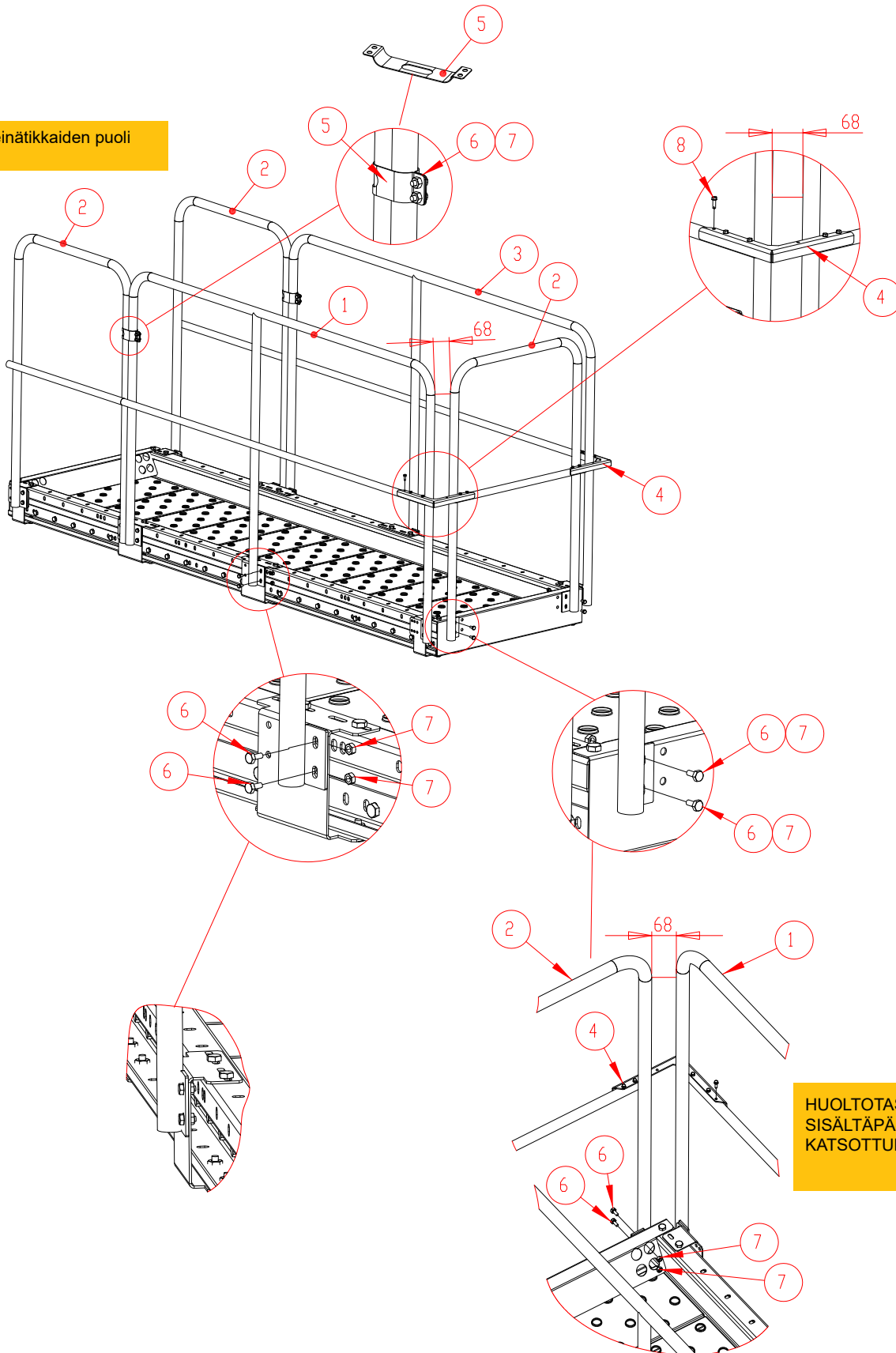
Kiinnitä kiinnikelevyt M10x25 ruuvein ja M10 mutterein.

Leveämpiin kiinnikkeisiin tulee yhteensä 4kpl ruuveja/kiinnike ja kapeampiin 2kpl ruuveja/kiinnike. Kapeammassa kiinnikkeessä toiset kiinnitysreiät jäävät siis tyhjäksi.

Kiinnikelevyjen kiinnitysruuvien lopullinen kiristys kannattaa tehdä vasta sen jälkeen kun olet kiinnittänyt kaiteet kiinnikkeisiin. (kts. seuraava työvaihe) koska silloin kiinnikelevyjä voi vetää Z-profiilista hieman ulospäin (niin paljon kuin pitkät reiät antavat liikkumavaraa). Kiinnikelevyjen vetäminen tilapäisesti kauemmas Z-profiilista antaa enemmän tilaa asentaa kaiteiden kiinnitysruuveja.

6.

Seinätkkaiden puoli



HUOLTOTASO
SISÄLTÄPÄIN
KATSOTTUNA



Ref.	Part no.	Denomination
1	A76206	RAILING ELEMENTS L 1773 A M19
2	A76208	RAILING ELEMENTS L 671 M19
3	A76207	RAILING ELEMENTS L 1773 B M19
4	A76214	RAILING SUPPORT PART M19
5	A76216	RAILING FASTENING PART M19
6	101810	BOLT HEX ZN 8.8 8X16 DIN933
7	110540	NUT M8 ZN 8 DIN934
8	107523	DRILL SCREW 6HEX 5,5X19 ZN DIN7504-K

Huoltotason kaiteiden asennus

Tässä ohjeessa on esitetty asennus järjestys siten että ensin asennetaan kaiteet huoltotasoon ja vasta sen jälkeen huoltotaso nostetaan paikoilleen kannatusorsille. Jos asennuskohde on ahdas niin saattaa olla tarpeellista kiinnittää huoltotaso kannatusorsilleen ja asentaa vasta sitten kaiteet paikoilleen.

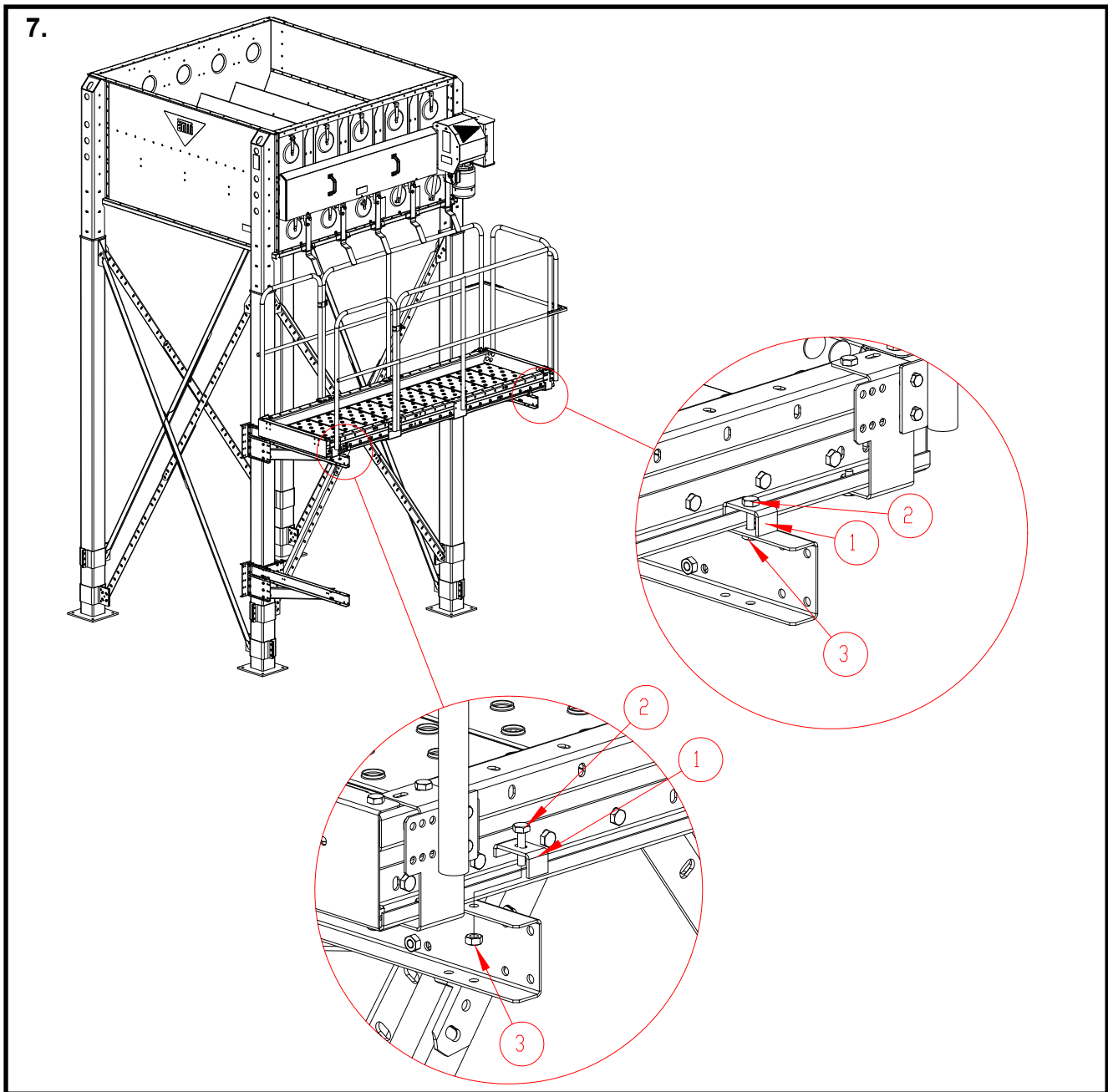
Kokoonpane kaideosat kuvan mukaisesti. Tarkista että kaide-elementit ovat keskenään linjassa. Päädyn ja pitkän sivun kaide-elementteihin kuuluu jäädä n. 68mm väli kaideputkien väliin.

Pantakiinnikkeet (osa 5) taitellaan kaideputken ympäri ja kiinnitetään M8x16 ruuvein.

Osa 4 kiinnitetään poraruuveilla kaideputkiin. Osassa 4 on reitykset poraruuveille. Kaideputkissa ei ole reitystä vaan poraruuvi porautuu kaideputkeen tehden siihen kiinnitysreiän. Nurkkatuki (osa 4) kiinnitetään viidellä (5kpl) poraruuvilla kaideputkiin, yksi nurkkatuen kiinnitysreikä jää tyhjäksi.

Kiinnitä osat 4 poraruuveilla vasta sitten, kun olet aivan varma, että kaikki osat ovat asennettu oikein ja oikeilla paikoillaan, jotta kaideputkiin ei tulisi ylimääräisiä reikiä.

NOTE! Osat 1 ja 3 ovat keskenään peilikuvia.



Installing the service platform on the bearers 2W

Sijoita kokoonpantu huoltotaso kannattimilleen.

Katso tason oikea asema suhteessa kannatinorsiin kohtakuvista.

Fix the service platform to the bearers using clamps (400282), nuts and bolts (M10x40).

Fix the shorter end of the clamp on top of the Z-beam of the service platform.

Fix the service platform at four points (jokaisesta nurkasta), see detail drawings.



Ref.	Part no.	Denomination
1	400282	SUPPORT CLAMP TO COVER, UPPER LAYER
2	102250	BOLT HEX ZN 8.8 10X40 DIN933
3	110560	NUT M10 ZN 8 DIN934

Huoltotason tikkaiden asentaminen

Asenna tikkaat kuvien mukaisesti (kts. sivut 60-61)

Asenna kaikki liitokset kuvien mukaisesti, työjärjestys kannattaa valita tapauskohtaisesti huomioiden asennusolosuhteet. On mahdollista kasata tikkaat ja suojakaariosat maassa täysin valmiiksi ja kiinnittää tikaskokoonpano vasta sitten huoltotasoon tai sitten voidaan kiinnittää tikasosia huoltotasoon ja alempaan tukiortteen pienempinä kokonaisuuksina.

Kiinnitä tikaselementin ylemmät kiinnikkeet (osat 2, ja yläpoistumisjohteet etukäteen tikaselementin ylimmän puolan alapuolelle ennen tikkaan kiinnittämistä huoltotasoon.

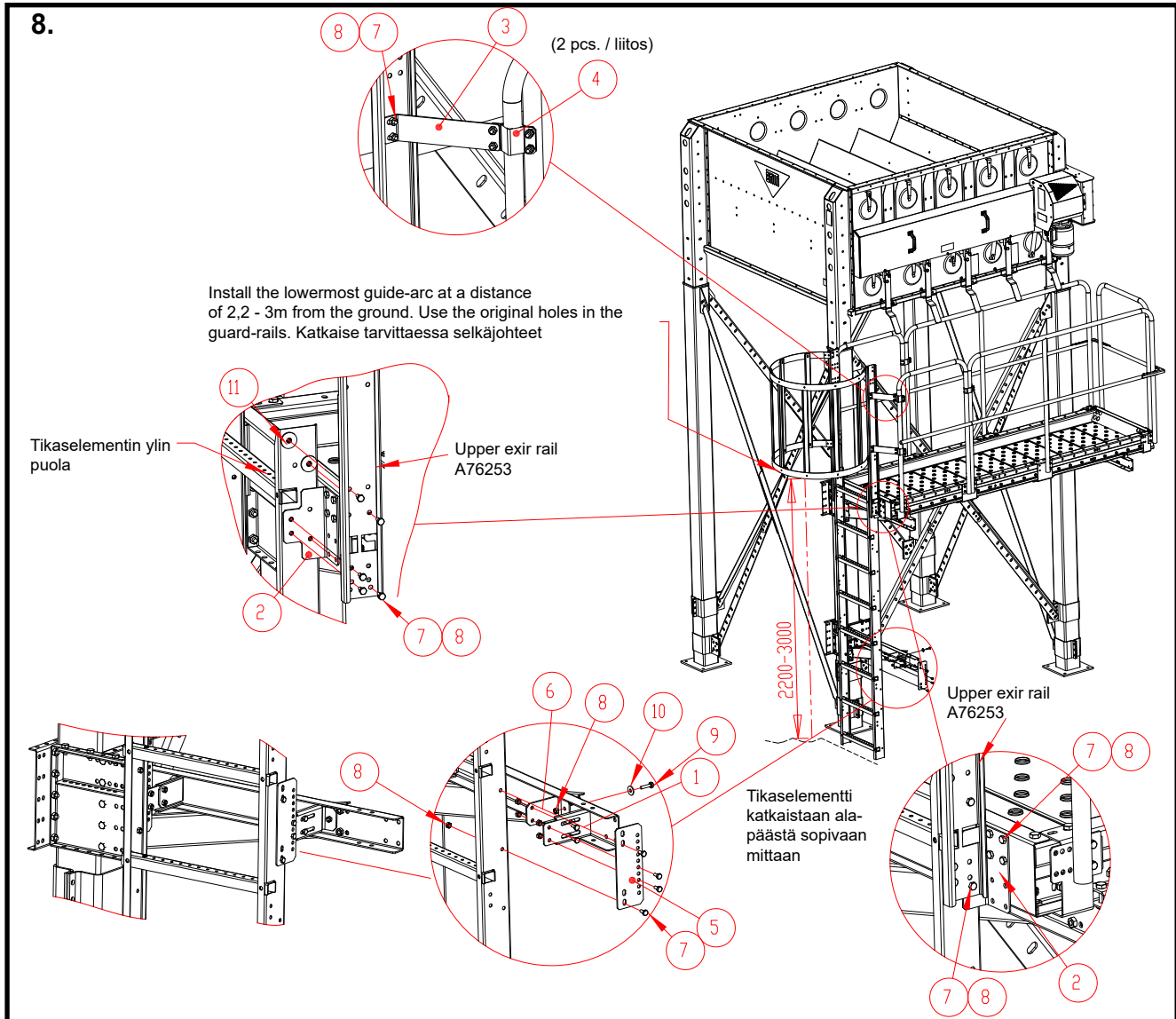
Kiinnitys M8x16 ruuvein. Yläpoistumisjohteen ja tikaselementin väliseen liitokseen tulee laittaa myös 2kpl korialuslevyjä (osa 11) . Katso kohtakuva. Asenna kiinnike ja yläjohde tikaselementin toiselle puolelle samalla tapaa kun on kohtakuvassa esitetty.

Ylempien tikaskiinnikkeiden (osa 2) ruuviliitokset tasoon saadaan tehtyä hylsyavaimessa käytettävällä lisäjatkovarrella tason päätypalkissa olevista isoista asennusreistä käsin (katso kohtakuva).

Katkaise tikaselementti alapäästä sopivasta kohtaa poikki.

Tikaselementin alapään tulee olla n. 35mm lattiatasosta irti. Tämä on erityisen tärkeää varsinkin silloin, jos kuivurikoneisto on varustettu vaaka-antureilla.

Tikkaiden asentaminen 2W huoltotasoon



Ref.	Part no.	Denomination	
1	A76240	SERVICE PLATFORM BASE LADDER CLAMP	()
2	A76239	SERVICE PLATFORM BASE LADDER CLAMP	()
3	A76241	SERVICE PLATFORM BASE LADDER CLAMP	()
4	A76242	ATTACH PLATE KAIDEPUTKEEN M19	()
5	A76234	PAK LADDER ATTACH PLATE A M19	*
6	A76235	PAK LADDERATTACH PLATE B M19	*
7	101810	BOLT HEX ZN 8.8 8X16 DIN933	* ()
8	110540	NUT M8 ZN 8 DIN934	* ()
9	101850	BOLT HEX ZN 8.8 8X30 AM DIN933	*
10	111532	WASHER ZN M 8 DIN9021	*
11	111563	WASHER M10 D34/D11X3 DIN440R ZN	()

() Osat huoltotason peruspakkauksessa A76243P

* Osat seinätikas tarvikepakauksessa A76251

Tikkaiden kokoonpano; yleiskuva

