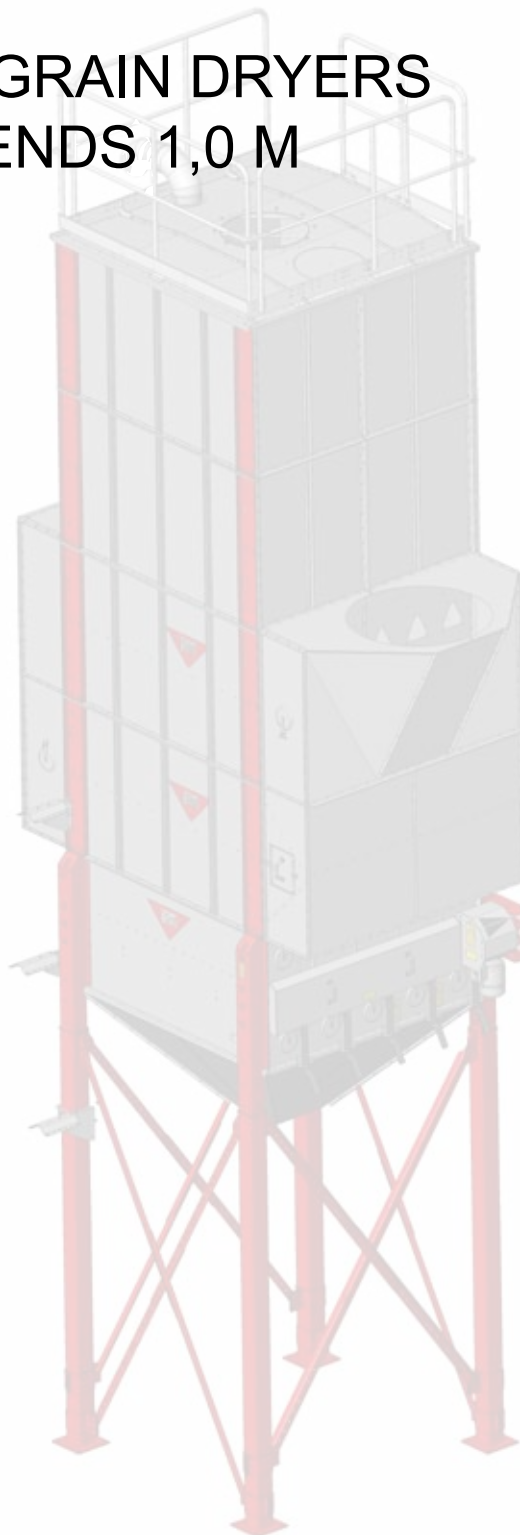


## Assembly Instructions

ANTTI M06 4W GRAIN DRYERS  
AIR CHANNEL ENDS 1,0 M

408095 (en) 02-2022



*You'll see the difference*





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Specifications, air channel ends with openings

D1000 (just an opening to which a suitable air pipe connector for each customer can be attached by bolts).

The air pipe connectors that always fit to the specifications are D630 (A71204), D800 (A71203) and D1000 (A71200).

Octagonal / D1250

Components that can be fitted to specifications:

- In the octagonal opening, the heater A1500 directly and, using the adapter parts D1250, the air pipe connector D1250 (A71201).

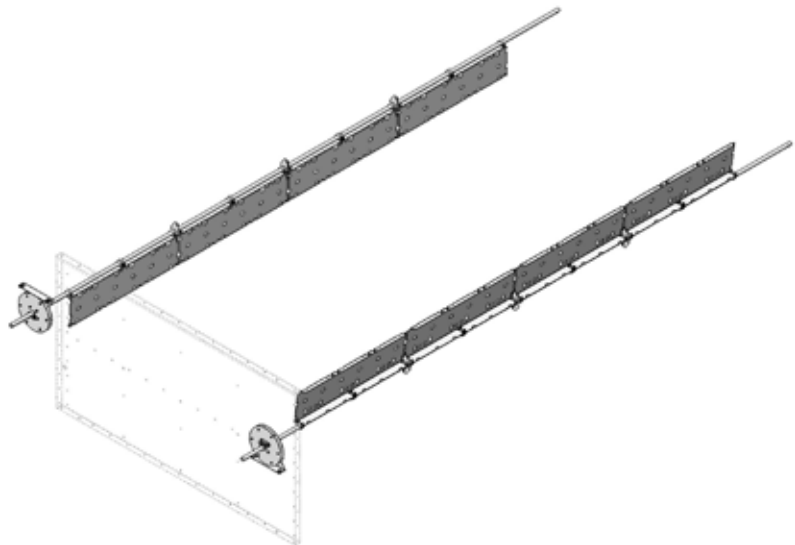
Usually the specifications include the adapter parts D1000, except the specifications 8/D1250 to be installed at the top, which are A71402 for the 2W model, A71403 for the 3W model A71404 for the 4W model.

The air pipe connectors D1000, D800 and D630 do not fit in these parts. There is a special air channel end part for these pipe diameters and, therefore, no adapter part is required for the smaller pipes.



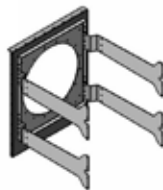
## Optional air channel ends 4W 1,0

Duct row shutters A70988

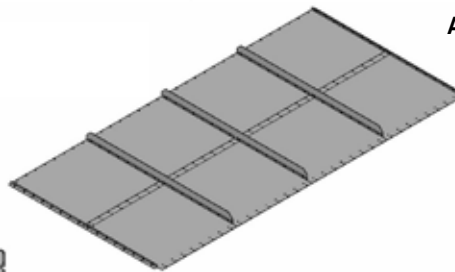


## Air channel ends

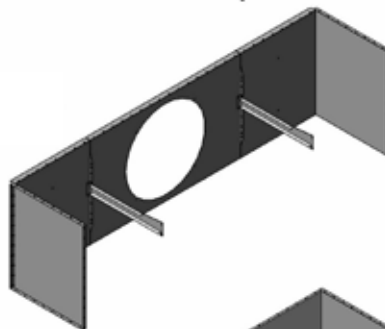
A76264 - fan mounting parts



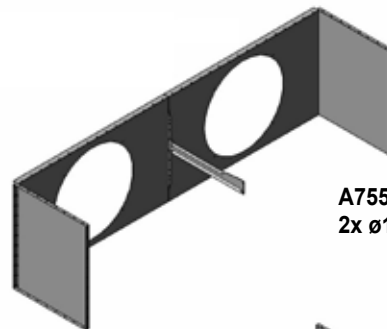
A70974 - 2 x upper shutter B



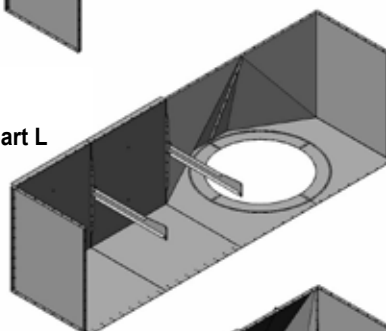
A71210 - centre-part S  
Ø 1000 mm



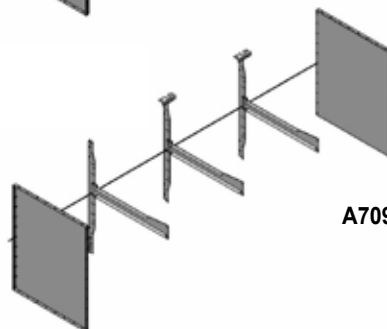
A75592 - centre-part S  
2x Ø1000 mm



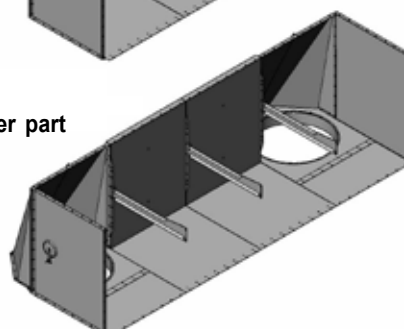
A71222 - lower part / upper part L  
Ø 1250 / 1000 mm



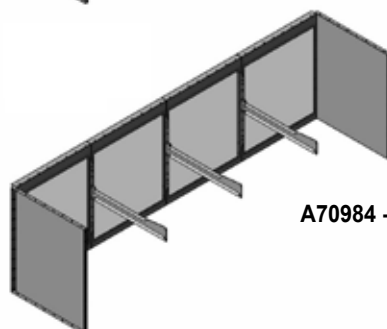
A70976 - intermediate part



A73409 - lower part / upper part  
DGL Ø 2 x 800 mm



A70984 - spark net

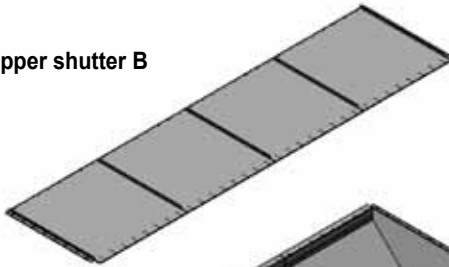




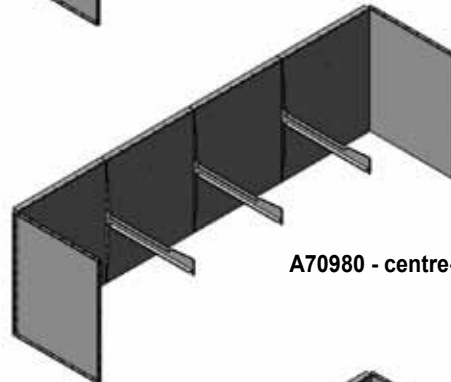
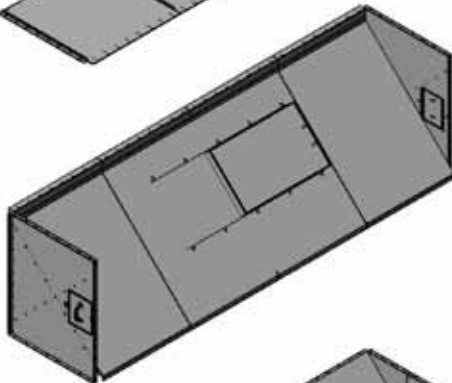
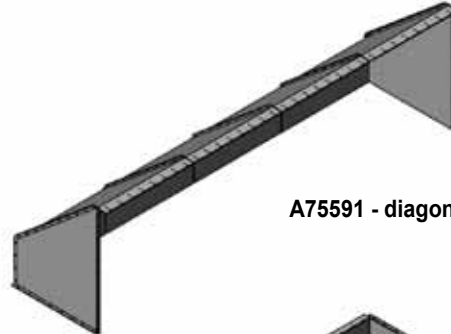


## Air channel ends

A70960 - upper shutter B

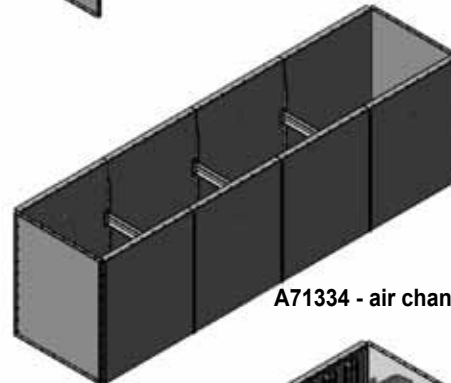
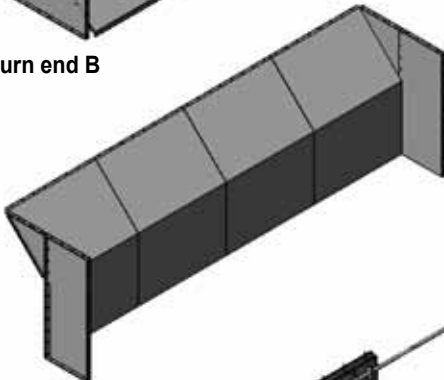


A75591 - diagon roof B



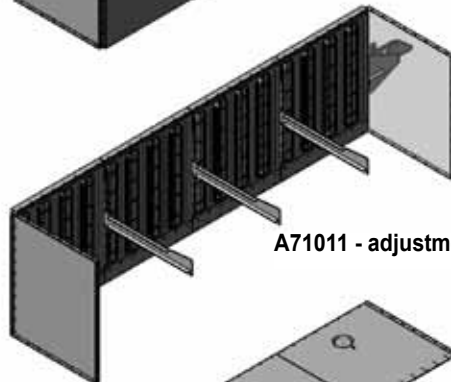
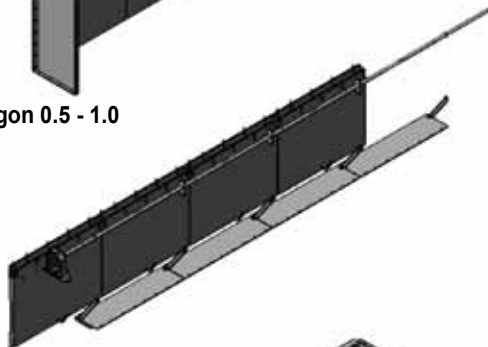
A70748 - return end B

A70980 - centre-part B



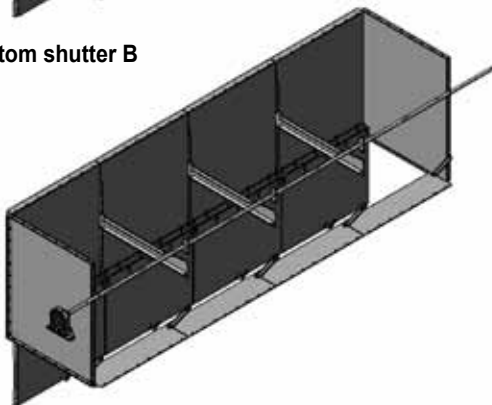
A75961 - diagon 0.5 - 1.0

A71334 - air channel extension

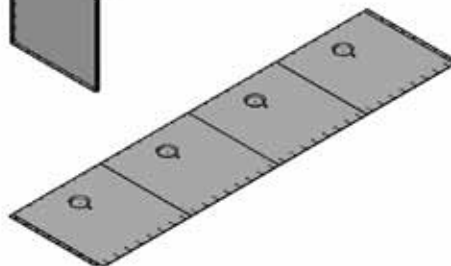


A70966 - bottom shutter B

A71011 - adjustment plates



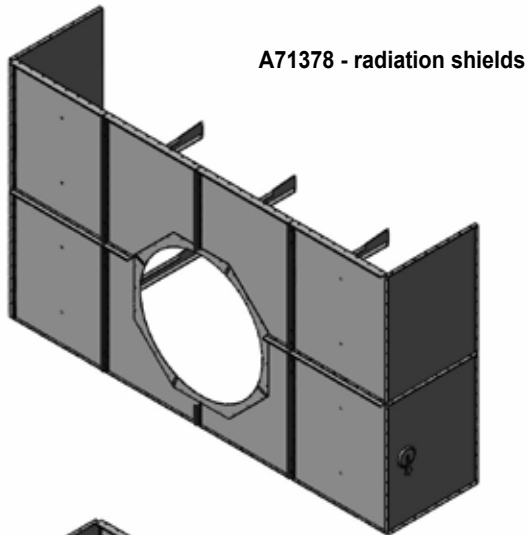
A70825 - channel shutter B



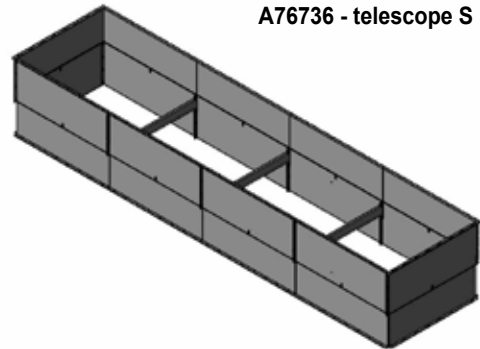
A70957 - lower shutter B



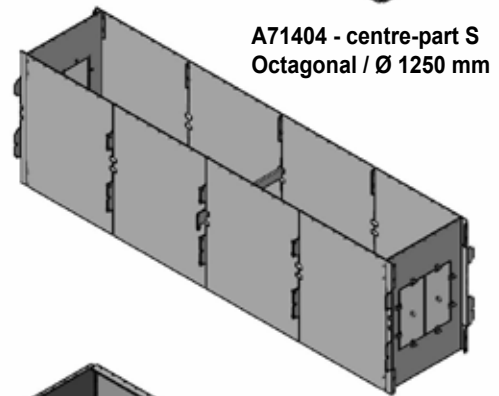
## Air channel ends



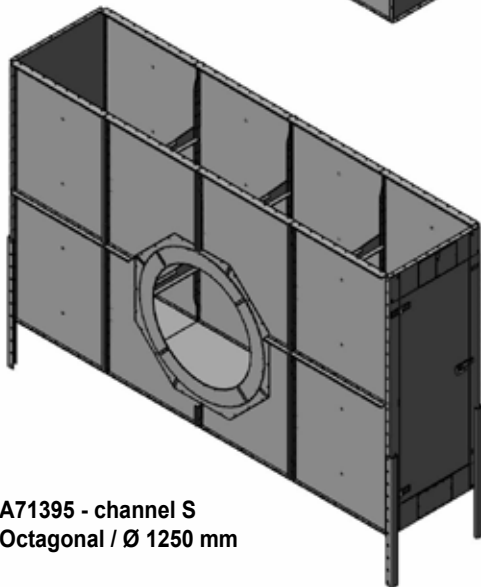
A71378 - radiation shields



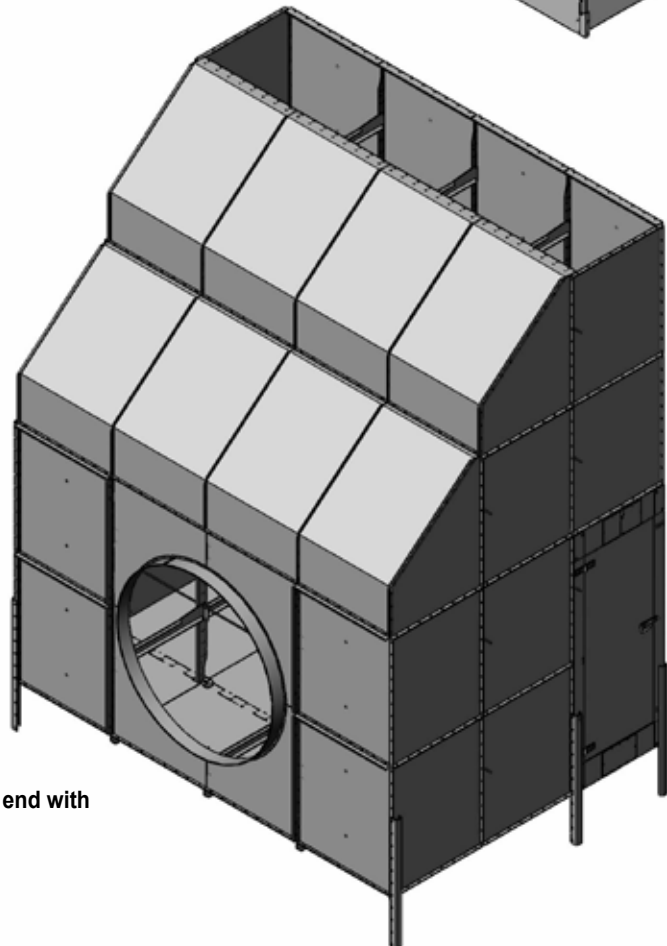
A76736 - telescope S



A71404 - centre-part S  
Octagonal / Ø 1250 mm



A71395 - channel S  
Octagonal / Ø 1250 mm



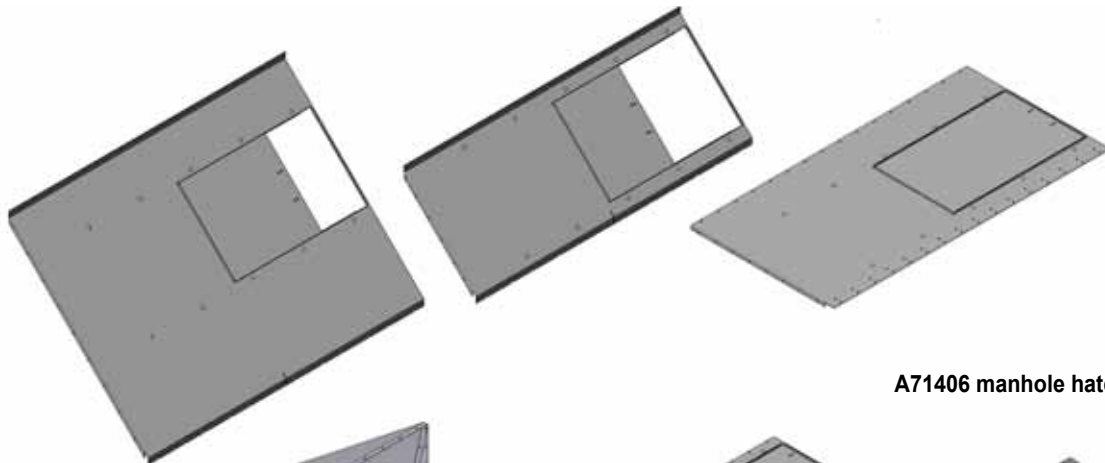
A75593 - air channel end with  
connection S  
Ø 1602 mm



## Air channel ends A71090, A71245, A71560, A71562, manhole hatches A71386, A71406

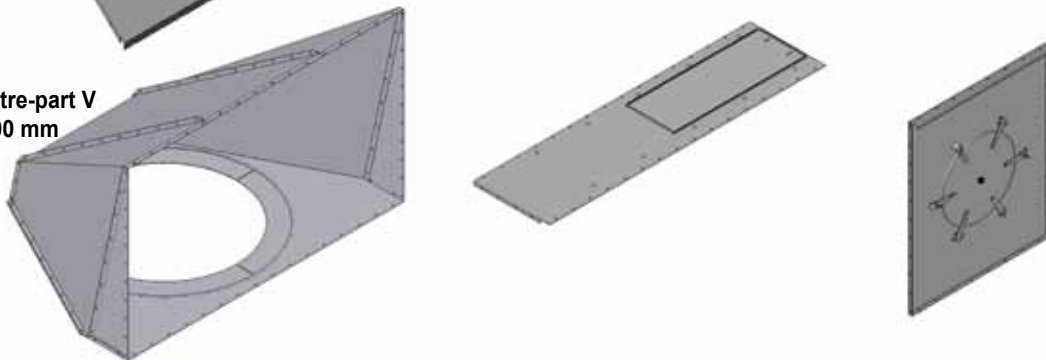
A71560 - return bottom replacement air opening

A71562 - shutter-plate replacement air opening

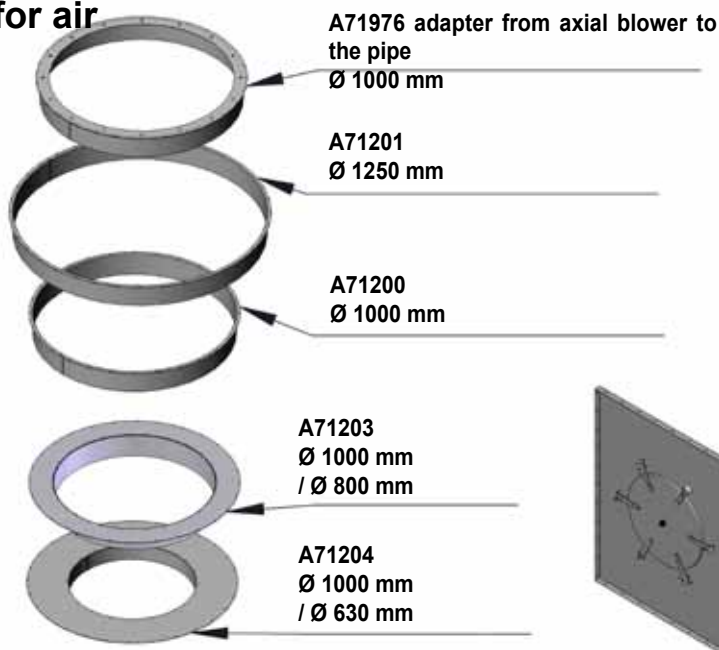


A71406 manhole hatch - end-plate

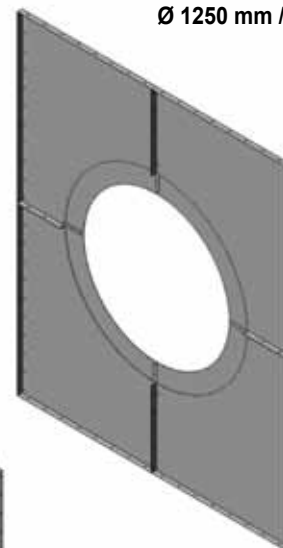
A71090 - centre-part V  
Ø 1250 / Ø1000 mm



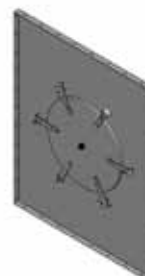
### Connecting parts for air pipe



A71245 - side opening  
Ø 1250 mm / Ø 1000 mm



A71386 manhole hatch - side-plate

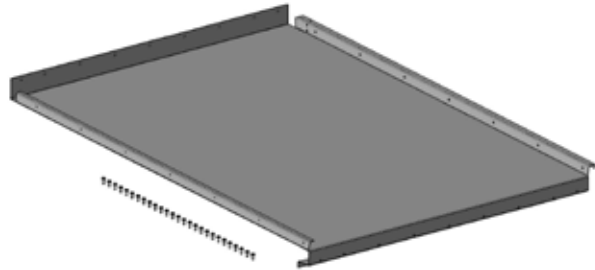




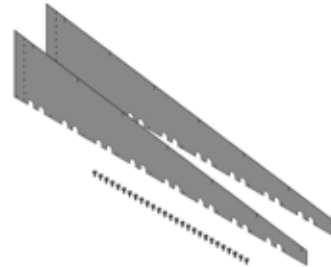
## Optional equipment for air channel end 4W 1,0

Parts A72231, A72232 for the rain roof of 1,0 m air channel end

A72231 - air channel end, slanting roof  
4W: 4 pcs. of plates with bolts / 1,0 m air channel end

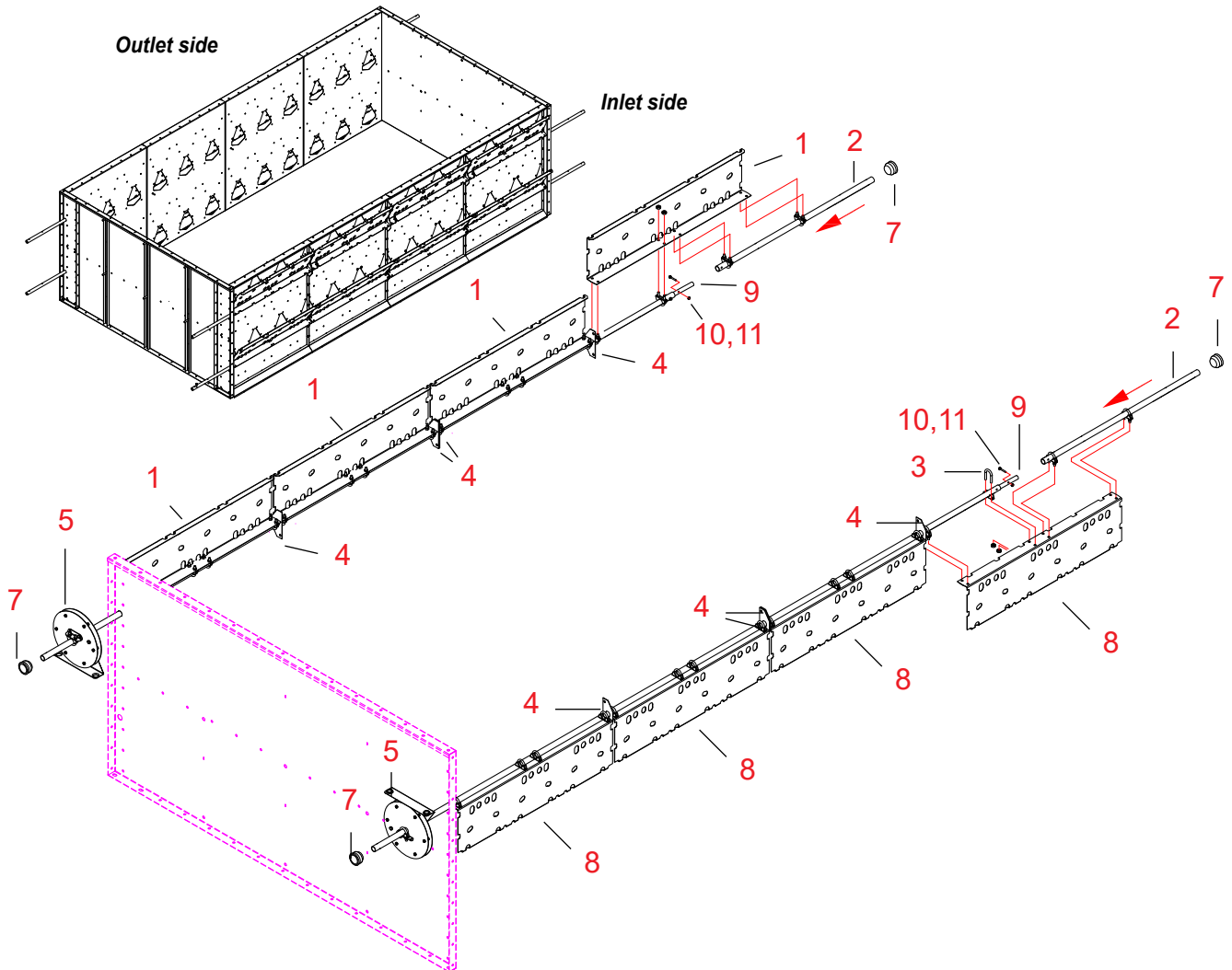


A72232 - air channel end, slanting roof - end cover  
4W: 1 pc. (2 ends with bolts) / 1,0 m air channel end





## Duct row shutters 4W (A70988) Spare parts

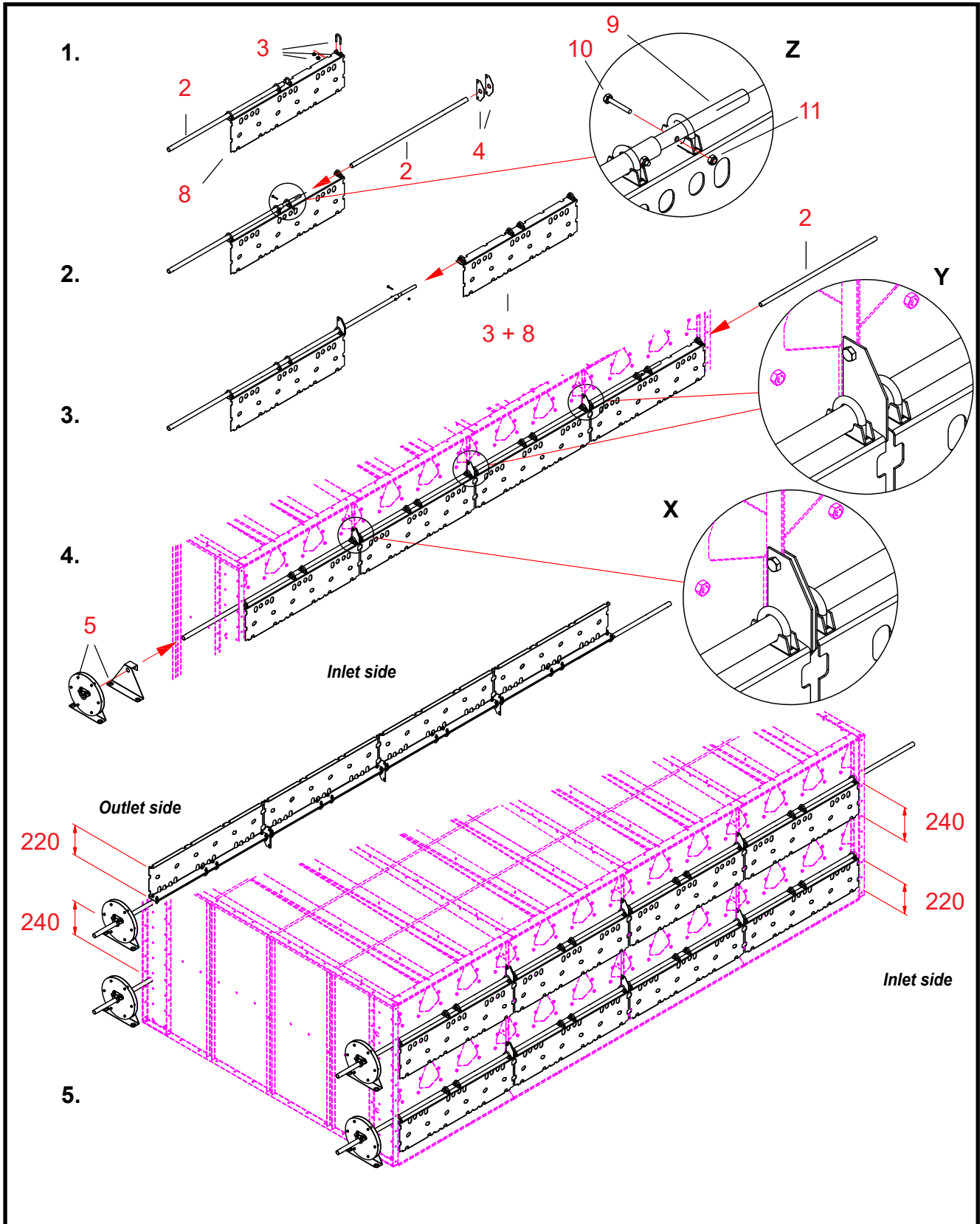


20061123

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Weight
1	A71283	SECTION WM06 SHUTTER	DUCT ROW PL H=220	4	4.48
2	A70548	SECTION WM06 SHUTTER	D25-958 PIPE	10	42.34
3	107930	U-BOLT FLUE PIPE BAND	M8 D=25 1883-25	32	0
4	A70551	SECTION WM06 SHUTTER	GUIDE-LUG	8	42.34
5	A70543	SECTION WM06 SHUTTER	CHAIN-WHEEL PACKAGE	2	19.92
6	114055	WIRE-LOCK	D 5	8	0
7	116065	PLASTIC PLUG	DBI 42	4	0
8	A71294	SECTION WM06 SHUTTER	DUCT ROW PL H=240	4	4.48
9	A70733	SECTION SHUTTER	EXTENSION PIPE D17,2-300	8	0,26
10	101520	BOLT HEX ZN 8.8	6X35 AM DIN933	16	0
11	110789	NUT NYLOC	6 ZN DIN985	16	0



## Installing duct row shutters (A70988)





*Two sets of parts A70988 are required for shutting both air duct rows in the section.*

### 1. Installing the shutter-plates on the inlet side (in both, or sometimes in only one of the duct rows)

Parts The numbering of work stages refers to reference numbers in the spare parts drawing A70988 for the air channel end.

Fig. 1.

**8** Select four shutter-plates, 240 mm in height, for the air duct row on the inlet side.

**3** Fix four U-bolt ties to flanges of all shutter-plates.

Tighten the tie nuts only lightly to enable shifting of the shutter-plate along the shaft-pipe.

**2** Thread one shaft-pipe through the two U-bolt ties in one of the shutter-plates.

Place the pipe so that the pipe end remains visible between the U-bolt ties at the centre of the plate.

Fig. 2.

**2,9,10,11** Attach the extension pipe to the end of the shaft pipe (see detail drawing Z)

Push the other shaft pipe inside the U-bolt ties and the extension pipe from the opposite side.

Press the pipe against the end of the pipe, installed at stage 1.

**4** Thread two guide-lugs onto the pipe.

Fig. 3.

**3, 8** Push the other shutter-plate with its U-bolt ties onto the pipe.

Place the shutter-plate on the pipe so that a free space of at least 5 mm is left between the guide-lugs.

**\*** Repeat the stages in accordance with drawings 2 - 3 until there are four shutter-plates in the set-up.

Note that only one guide-lug should be placed between the other shutter-plates (detail drawing Y).

Fig. 4.

**8** Install the set-up, assembled as shown in the drawings 1 - 3, in the upper duct row on the inlet side of the section.

Thread in the shaft of the set-up through the  $\varnothing$  30 mm holes in the side-plate and the leg.

Remove the two bolts from the centre-seam of the section's end-plates at the guide-lugs.

**Place the pair of guide-lugs on both sides of the seam and re-insert the bolts (detail drawing X).**

**2,9,10,11** Install the fourth extension pipe.

Thread in the fifth shaft-pipe through the side-plate and the leg of the section in the U-bolt ties in the shutter-plate.

Push the pipe from the opposite side of the section against the end of the pipe, already in place.

**\*** Shift the shutter-plates to their correct positions on the shaft.

Ensure, that the slots and holes in the shutter-plate are placed at the bolt-heads.

Turn the shutter-plate between its upper and lower positions.

Ensure, that the shaft-pipe ends remain in contact after the adjustment.

Align the shutter-plates and tighten the U-bolt tie nuts.

**5** Place the chain-wheel unit onto the shutter-plate shaft.

Thread first the chain-guide onto the shaft and, after that, the chain-wheel.

Tighten the nuts of the U-bolt ties only lightly at this stage.

Fig. 5.

**\*** Install the shutter-plates, 220 mm in height, in the lower duct row on the inlet side of the section.

### 2. Installing the shutter-plates on the outlet side (in both, or sometimes, in only one of the duct rows)

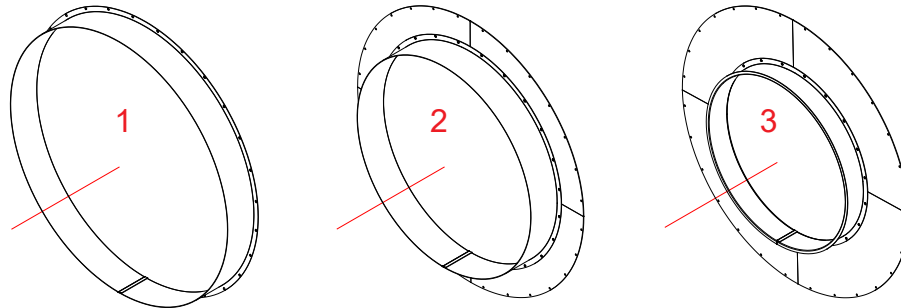
**\*** Install the shutter-plates, 220 mm in height, in the upper duct row on the outlet side.

Install shutter-plates, 240 mm mm in height, in the lower row.



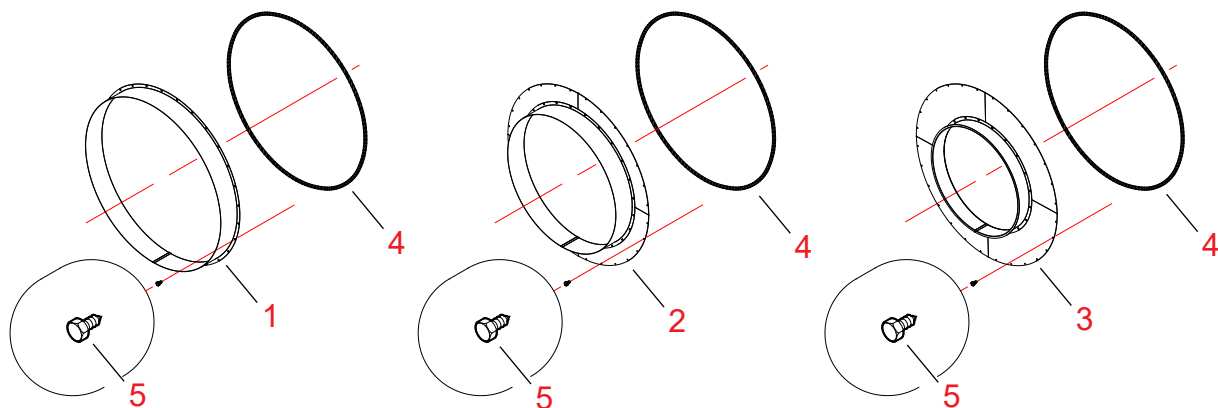


## Air pipe connectors Ø 1000 mm, Ø 800 mm, Ø 630 mm



20061019

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A71200	AIR PIPE SLEEVE	D1000X120	1	A71200	5.18	3500
2	A71203	AIR PIPE WM06	CONV PART D1000/D800	1	A71203	9.40	3000
3	A71204	AIR PIPE WM06	CONV PART D1000/D630	1	A71204	11.49	3000

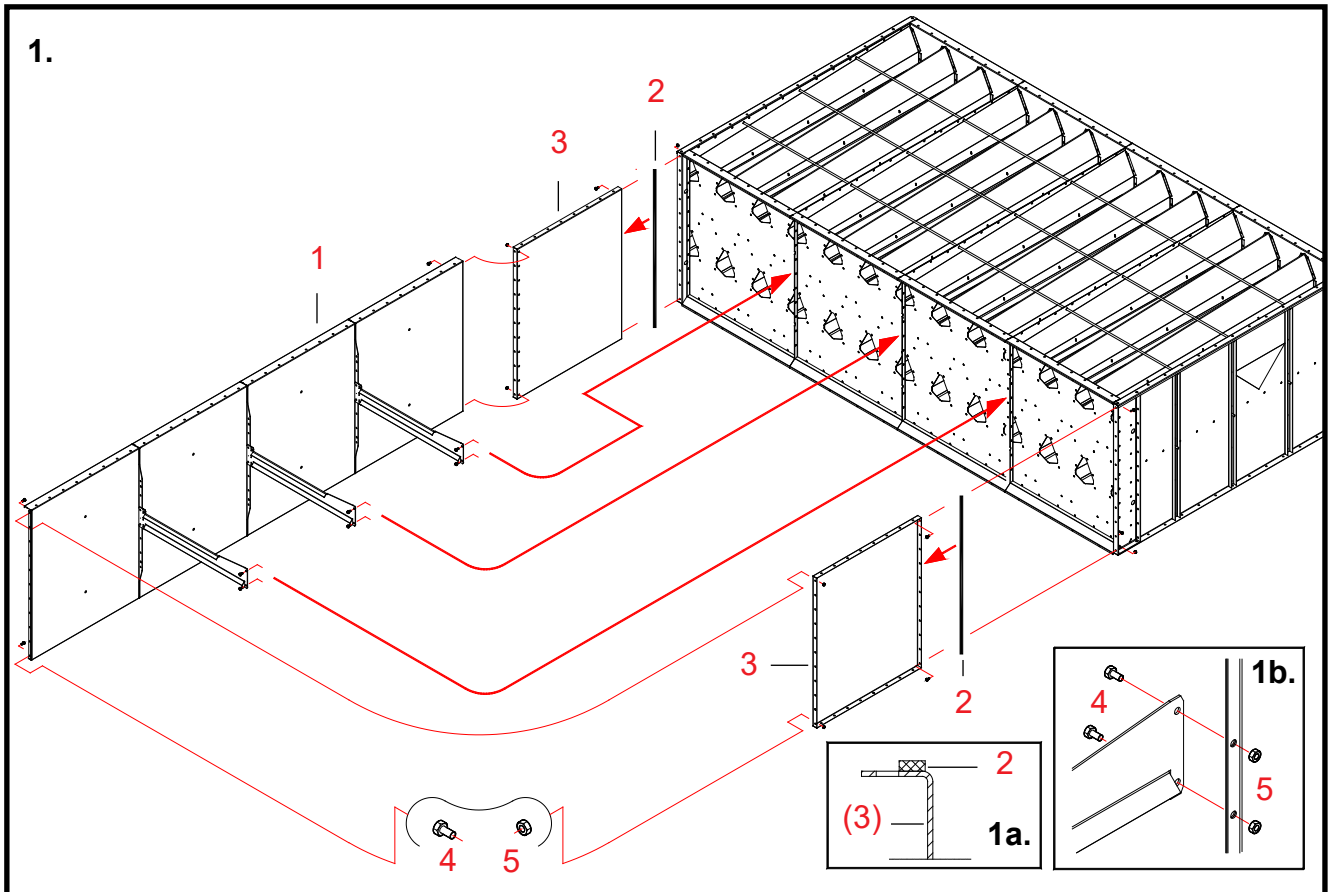


## Installing the air pipe connector in the air channel end

- 1 / 2 / 3 Select the air pipe connector in accordance with the size of the air pipe system (1000 mm / 800 mm / 630 mm).
- 4 Fix a sealing strip to the air pipe connector flange.  
Fix the sealing strip inside the screw hole row in the connector flange.
- 5 Fix the connector to the air channel end using self-tapping screws (4,8 x 13, 28 pcs.).



## Assembling the air channel end



1. Principle drawing on set-up and installation of the air channel end

Parts

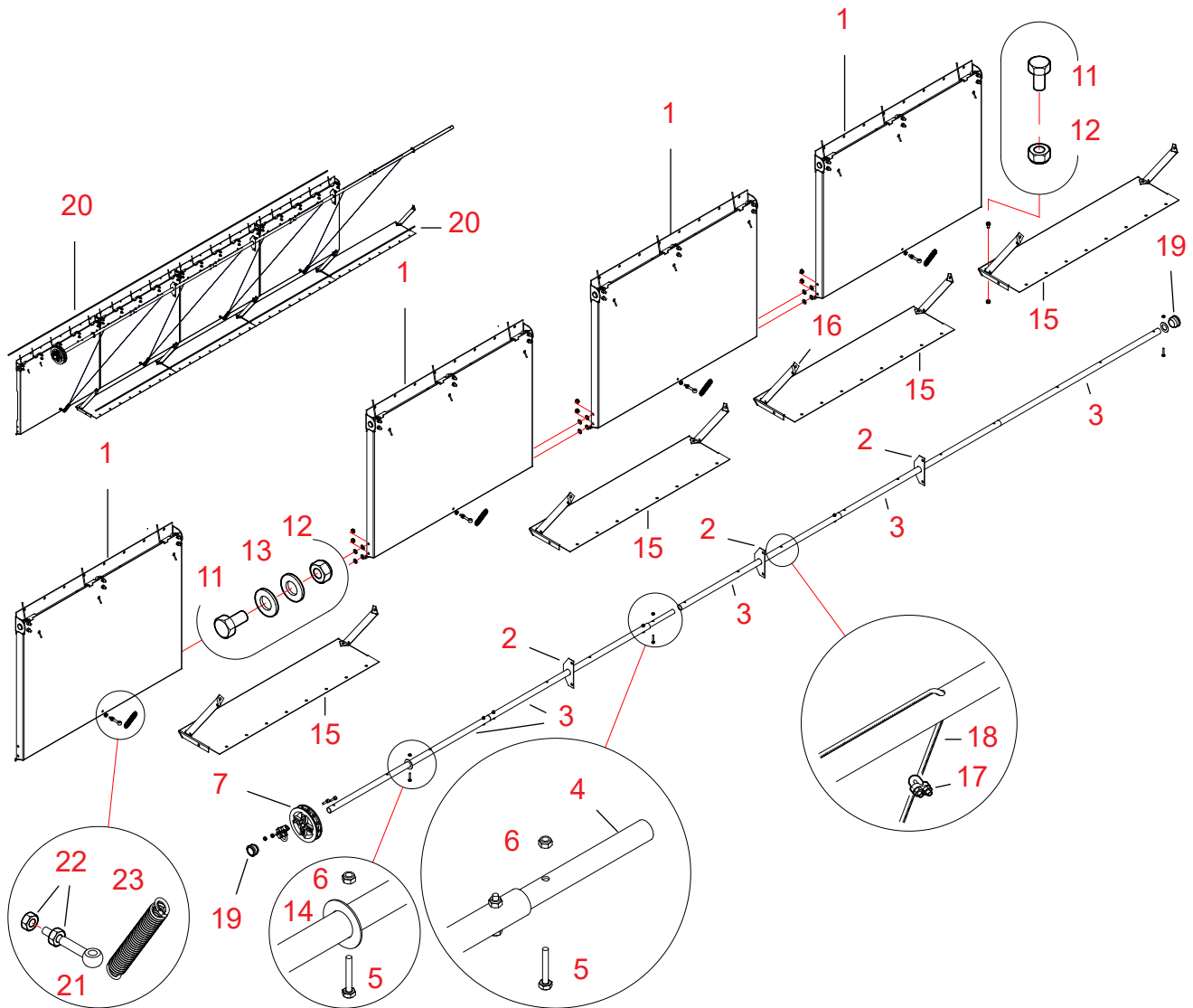
- 1 **Assemble a sub-assembly of the air channel end end-plates in accordance with separate instructions for each air channel end model.**  
If an upper or a lower shutter-plate are included in the set-up, make a separate sub-assembly of them as well.
  
- (4, 5) **Remove the bolts and nuts (2 pcs.) from the section (from the attachment point of the air channel end's straight support).**  
Only in case that the air channel end to be installed has a straight support. Fig. 1b.
  
- 2 **Fix sealing strips to the attachment flanges of the side-plates (parts 3) to be attached to the drying section.**
  
- 3 **Move the side-plates tight against the ends of the section.**
  
- 4, 5 **Fix the side-plates using bolts and nuts (M8 x 16, 11 pcs. /side-plate).**
  
- 1 **Move the shutter-plate or the end-plate sub-assembly, if any, against the side-plates.**  
**Position the air channel end support on the same side of the drying section's centre seam as it is at the end.**  
  
**Attach the set-up(s), assembled at stage 1 to (the section and) the side-plates.**  
**Fix the straight supports for the air channel end to the section.**
  
- \* **Check the joints and rectangular shape of the air channel end. Tighten all bolts.**



## Air channel end 1,0 3W (A70966) - bottom shutter B

## An accessory for air channel end A71331 (fan end PFS)

## Spare parts



As required, plug the unused shaft holes in the drying section with parts 19.

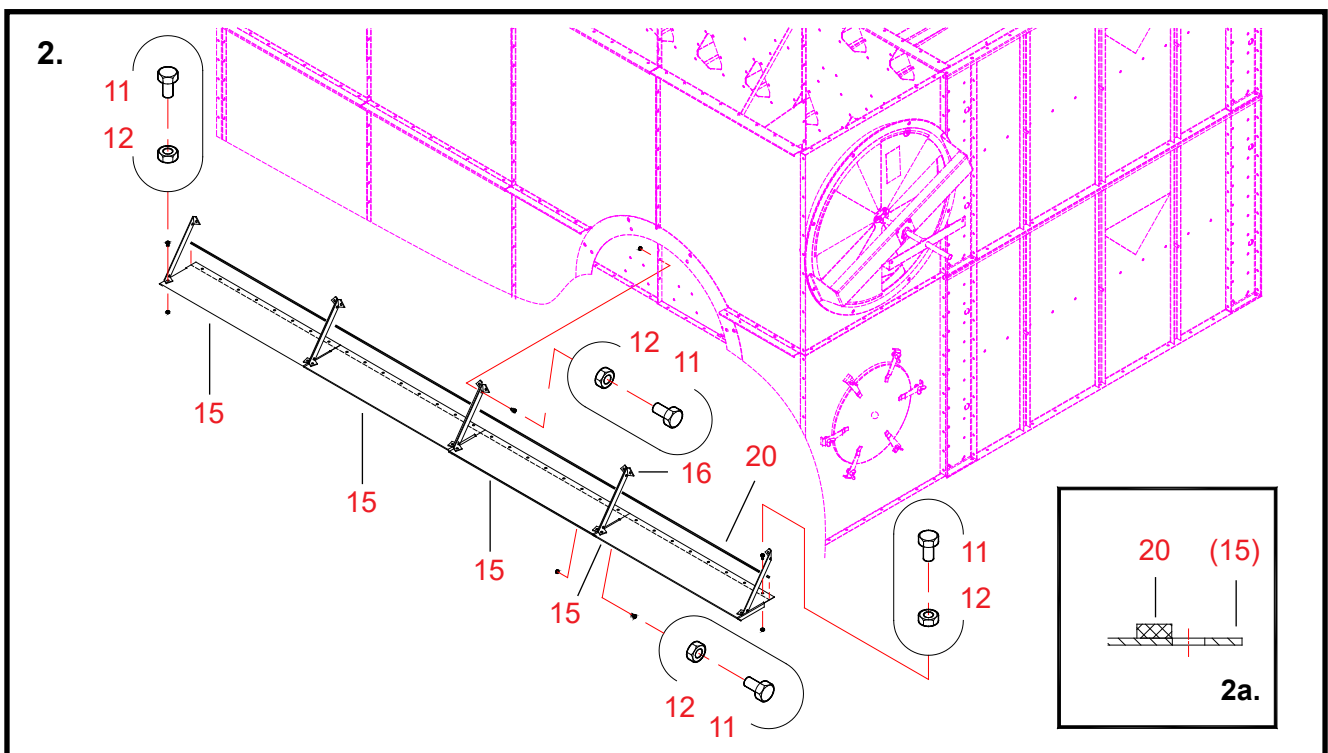
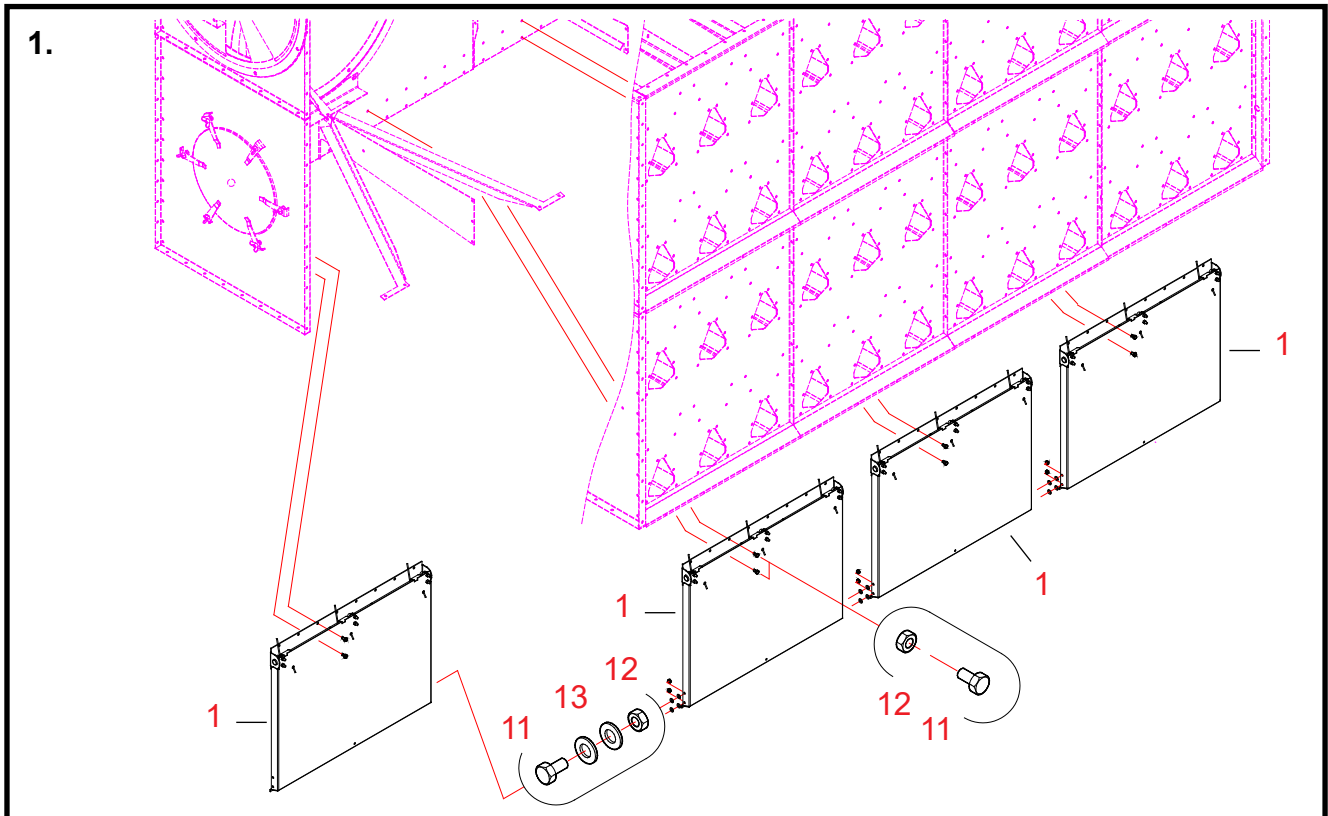


20061106

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A70668	AIR CHANN END WM06	TURN SHUTT PL 1M ASSY	4	A70668	15.08	3000
2	A70551	SECTION WM06 SHUTTER	GUIDE-LUG	3	A70551	42.34	3000
3	A70548	SECTION WM06 SHUTTER	D25-958 PIPE	5	A70548-A	42.34	3000
4	A70733	SECTION WM06 SHUTTER	D19-300 EXTENS PIPE	4	A70733	0.25	3000
5	101520	HEX BOLT ZN 8.8	6X35 AM DIN933	10		0	2010
6	110789	NUT NYLOC ZN M 6	DIN985	10		0	2010
7	A71223	AIR PIPE WM06	PLAST CHAIN-WHE PACK	1	A71223-A	0.9	3000
11	101810	HEX BOLT ZN 8.8	8X16 AM DIN933	14		0	2010
12	110790	NUT NYLOC ZN M 8	DIN985	14		0	2010
13	111550	WASHER ZN	M 10 DIN125	12		0	2010
14	400344	WASHER AISI	PL1,5 D45/25,5	2	21175.4	0	4500
15	A71156	AIR CHANN END WM06	COUNT PL FOR HATCH	4	A71156	15.08	3000
16	A71157	AIR CHANN END WM06	HATCH SUPP	8	A71157	15.08	3000
17	114055	WIRE-LOCK	D 5	8		0	2900
18	114067	WIRE-ROPE	D3/D5 MM PLAST P	16		0	2900
19	116065	PLASTIC PLUG	DBI 42	2		0	2600
20	115570	SEALING STRIP	4X10 MAPA	8		0	2600
21	107821	EYE-BOLT	M8X60	4		0	2000
22	110540	NUT ZN 8 M 8	DIN934	8		0	2010
23	120014	DRAW-SPRING	3,0X17 140	4	41529	0	2900

## Assembling air channel end A70966

We recommend carrying out assembly of the air channel end on an even plane.  
This ensures the ready-assembled air channel end is straight.





## 1. Installing shutter-plate set-ups in the air channel end (A71331), ready-assembled inside the section

Parts            The numbering of work stages refers to reference numbers in the spare parts drawing A70966 for the air channel end.

**1                    Attach the shutter-plate set-ups (parts 1) to the holes in the end-plate set-up.**

**11, 12            Fix the shutter-plates using bolts and nuts (M 8 x 16, 16 pcs. / shutter-plate).**

**11, 12, 13        Join the shutter-plates together using bolts, washers and nuts (M 8 x 16).**  
Install two M10 washers on both bolts, between the shutter-plates.

## 2. Installing the counter-plates for the shutter-plate in the section

**15                    Join the four counter-plates (parts 15) together.**

**11, 12            Fix the joint using bolt and nuts (M 8 x 16).**

**16                    Install the counter-plate supports (8 pcs. of parts 16) in the counter-plates in position, shown in the picture.**

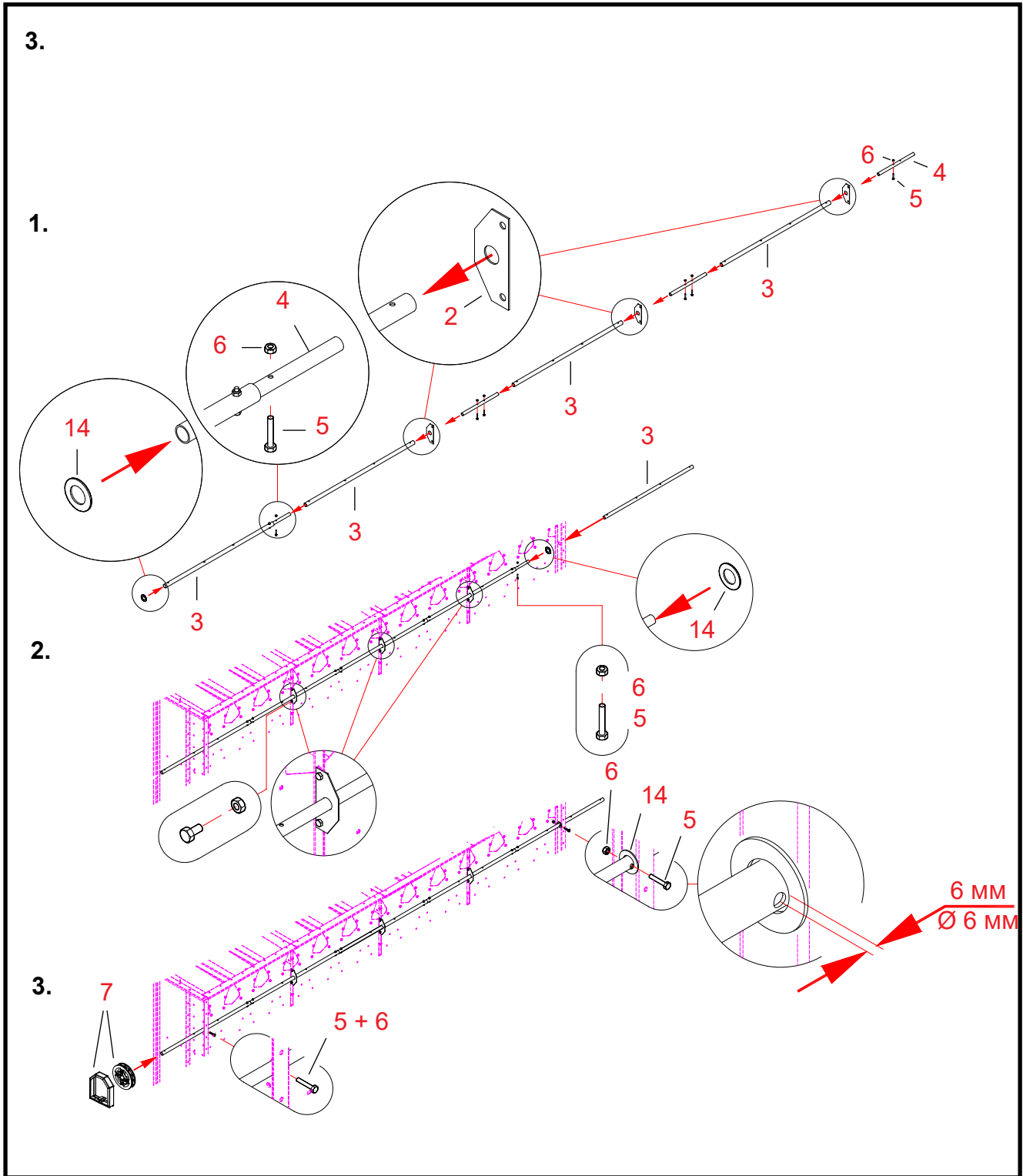
**11, 12            Fix the supports using bolt and nuts (M8 x 16, 1 pcs./support).**

**20                    Fix a sealing strip to the upper surface of the counter-plate set-up (parts 15).**  
Fix the sealing strip inside the screw hole row (see Fig. 2a).

**(11, 12)            Remove from the section the fixing bolts and nuts from the fixing point of the counter-plate supports.**  
Fix the counter-plate supports using the second bolt from the bottom in the centre-seam and side-seams of the section.

**\***                    **Move the ready-assembled counter-plate set-up against the end of the drying section.**  
***Be careful not to damage the sealing strip while installing the plate.***

**11, 12            Fix the counter-plate supports using the removed bolts and nuts (M 8 x 16).**  
The edge of the counter-plate comes under the side of the section and is fixed in place with it.





### 3. Installing the actuator-shaft for the shutter-plates

Fig. 1.

- 4 **Join together two shaft-pipes (parts 3) using the extension pipe.**
- 5, 6 **Fix the joint using two bolts and Nyloc-nuts (M 6 x 35).**
- 2 **Push the guide-lug for the shaft on the pipe.**
- 4 **Attach another extension pipe to the same end of the shaft-pipe, on which you threaded the guide-lug.**
- 5, 6 **Fix the extension pipe using bolt and Nyloc-nuts (M 6 x 35).**
- \* **Repeat the three preceding stages twice.**  
**After that the shaft comprises four pipes and three guide-lugs.**
- 14 **Thread washer (D45/25,5) onto the pipe from the opposite end of the pipe.**

Fig. 2.

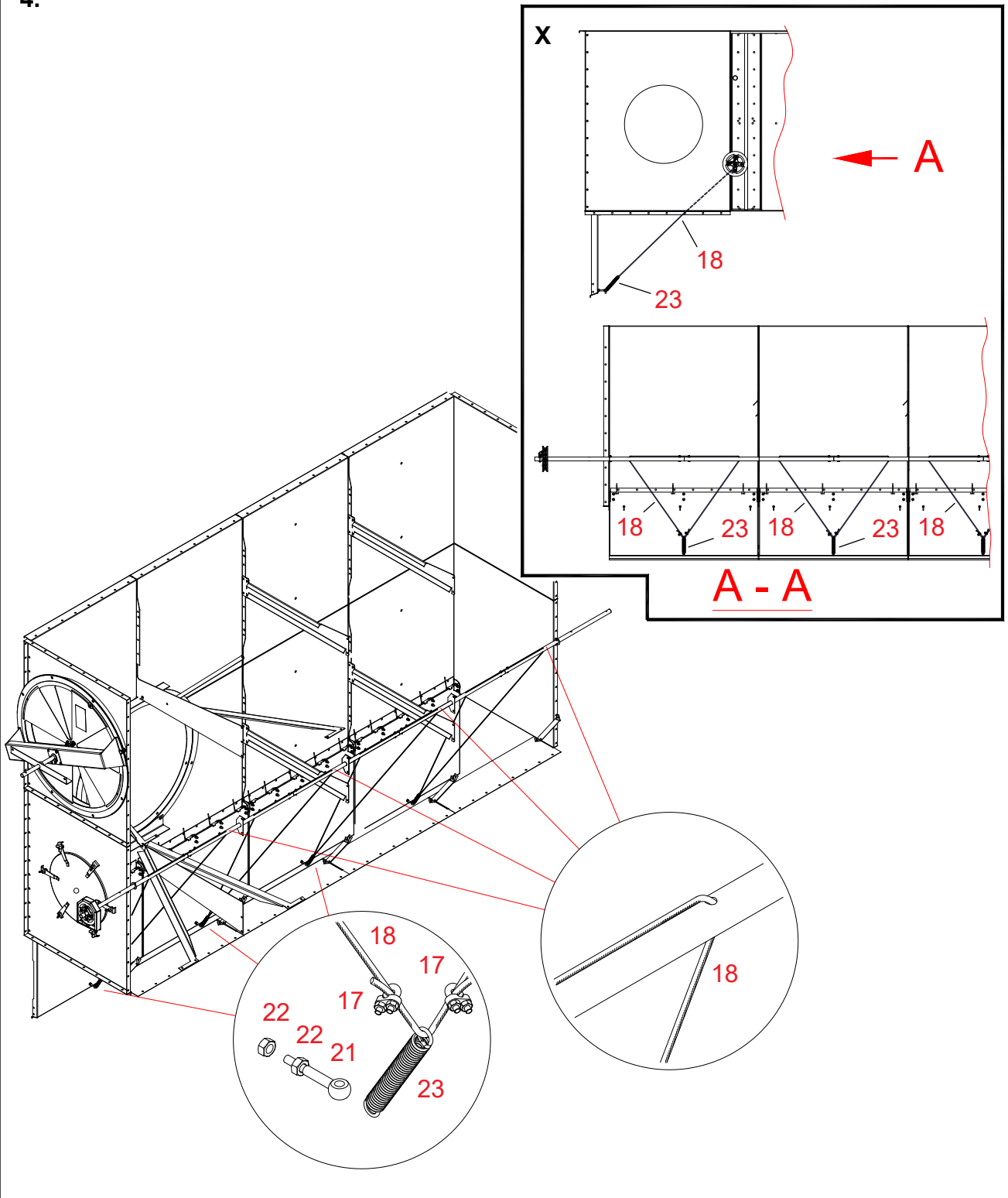
- (1) **Insert the shaft, assembled in accordance with Fig. 1, in the upper  $\varnothing$  25,5 mm holes in the section's side-plates.**  
Remove two bolts from the centre-seams of the section's end-plates, at the guide-lugs.  
Place the guide-lugs against the flanges of the end-plates and re-insert the bolts.
- 14 **Thread another washer (D45/25,5) onto the shaft-pipe.**
- 3 **Push the fifth shaft-pipe through the side-plate and the leg of the section onto the extension pipe for the ready-assembled shaft.**
- 5, 6 **Fix the shaft-pipe joint using bolt and Nyloc-nut (M 6 x 35).**

Fig. 3.

- \* **Centre the shaft-pipe with respect to the side-flanges of the section.**
- \* **Shift washers (parts 14) against the side-flanges of the section.**
- \* **Drill a  $\varnothing$  6 mm hole through the shaft-pipe, at a distance of 6 mm from the face of each washer.**
- 5, 6 **Insert bolts in the drilled holes and fix them using Nyloc-nuts (M 6 x 35).**
- 7 **Place the chain-wheel unit onto the actuator-shaft for the shutter-plates.**  
Tighten the nuts of the U-bolt ties only lightly at this stage.



4.







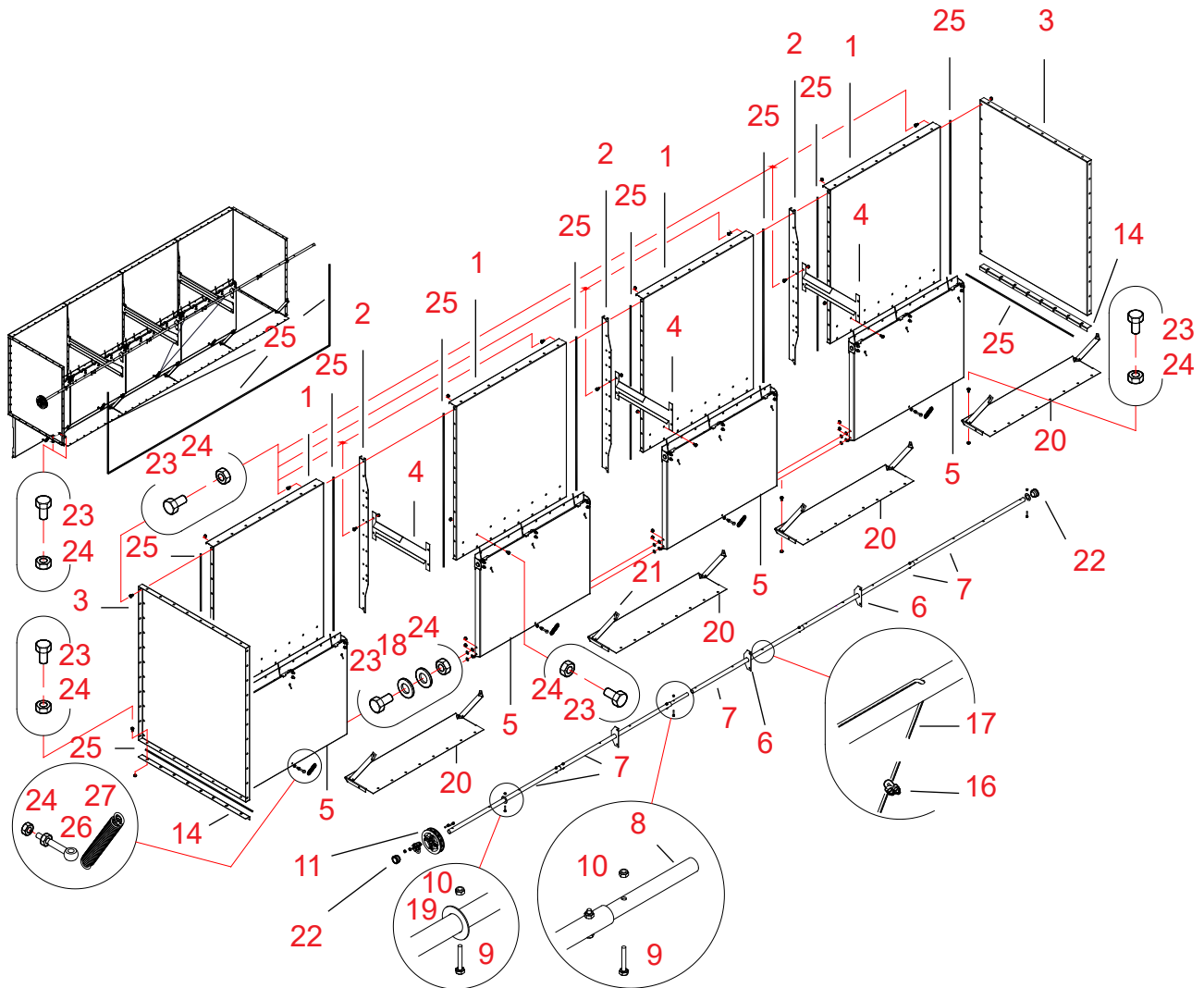
#### 4. Installing the actuator wires for the plates

- 21, 22      **Provide all shutter-plates with an eye-bolt. Fix them using two nuts (M8).**
- 23          **Thread in a draw-spring through all eye-bolts.**
- 18          **Install the actuator wires for the shutter-plates.**  
Thread the wire through the two holes in the shaft and the draw-spring eye to make a triangle-shaped loop. (Picture X)
- 17          **Place wire-locks on both sides of the draw-spring eye.**
- \*            **Cut off the wire at a distance of about 30 mm from the wire-lock.**



## Air channel end 1,0 4W (A70825) - channel shutter B

### Spare parts



Parts 14 and their sealings are installed only if this assembly is the lowest part of the air channel end in the dryer.

As required, plug the unused shaft holes in the drying section with parts 22.



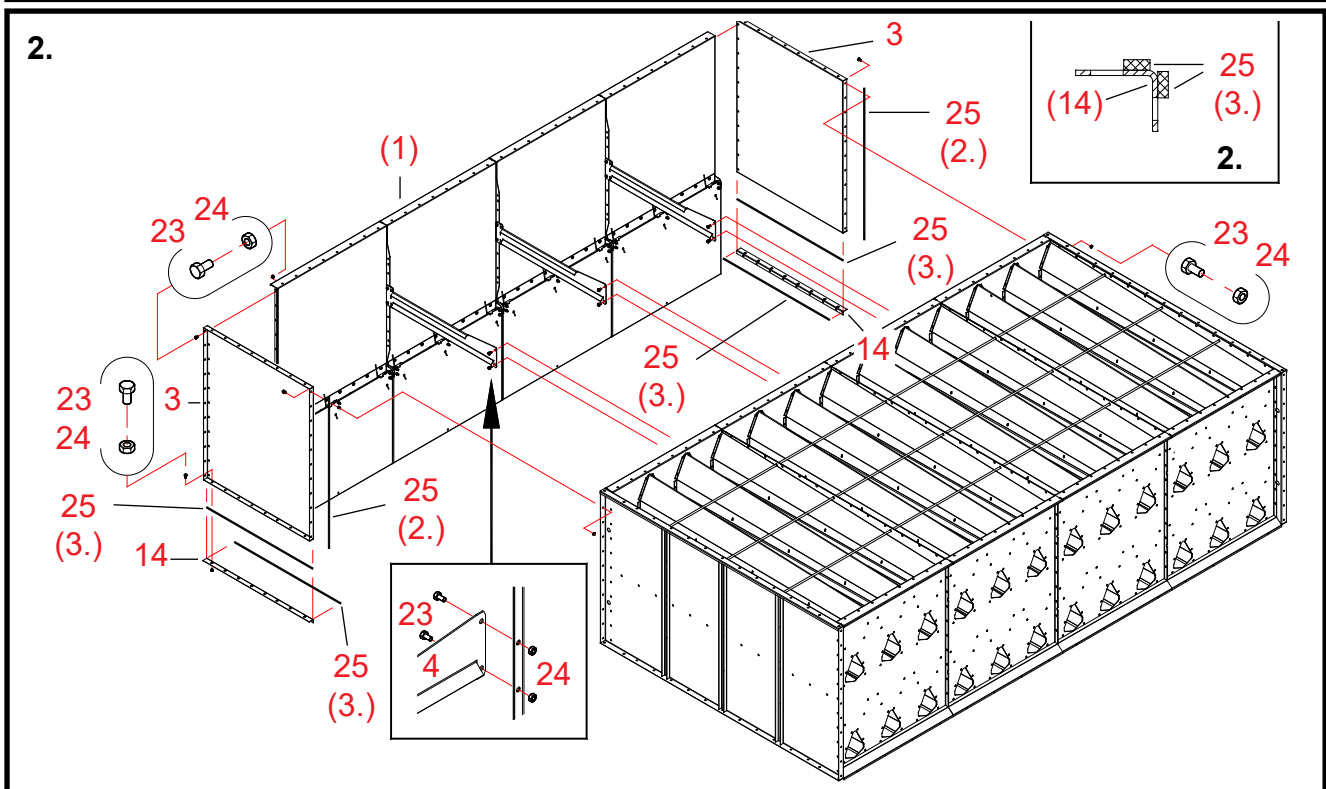
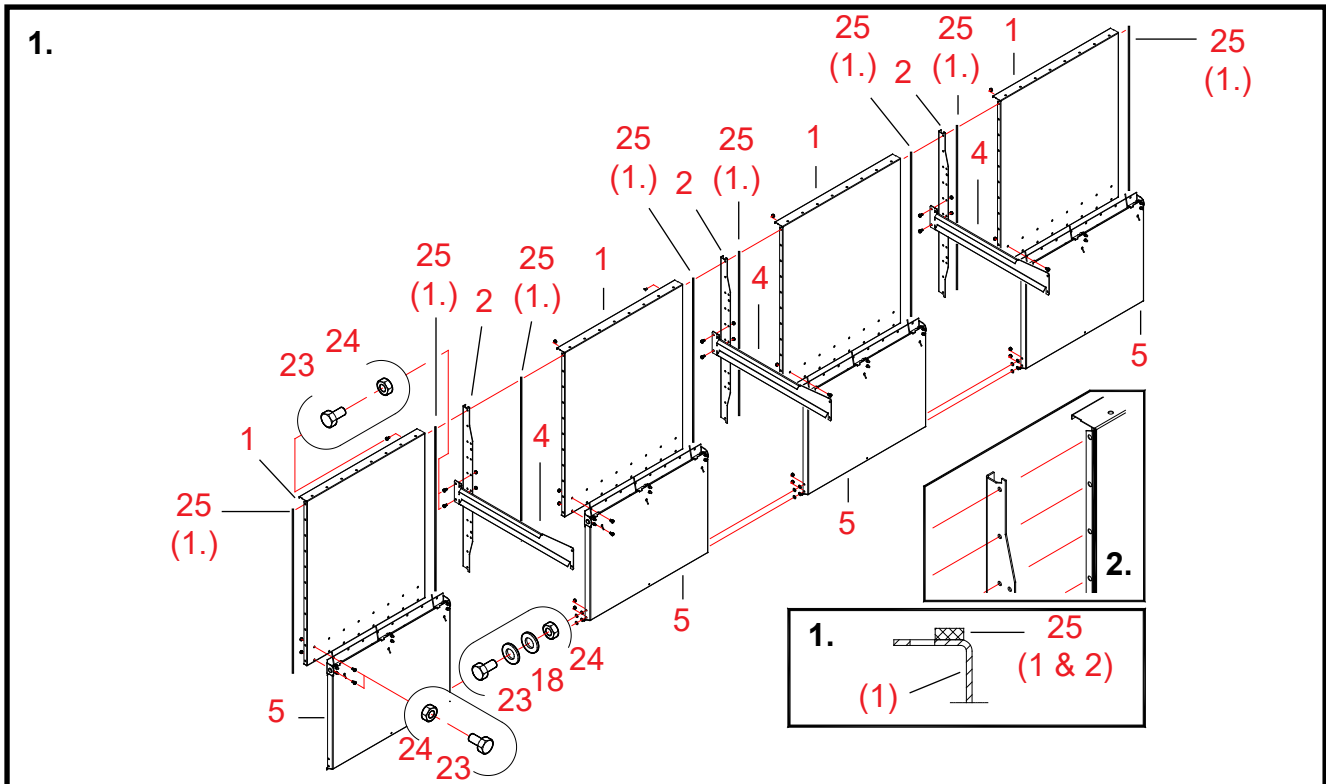
20080901

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A70682	AIR CHANN END WM06	END-PLATE W SHUTTER	4	A70682	14.64	3000
2	A70810	TOP SECTION WM06	VERTICAL SUPPORT PL3	3	A70810-C	2.34	3000
3	A70640	AIR CHANN END WM06 1.0	SIDE-PLATE	2	A70640	14.18	3000
4	A70678	AIR CHANN END WM06 1.0	STRAIGHT SUPPORT	3	A70678-B	1.79	3000
5	A70668	AIR CHANN END WM06	TURN SHUTT PL 1M ASSY	4	A70668	15.08	3000
6	A70551	SECTION WM06 SHUTTER	GUIDE-LUG	3	A70551	42.34	3000
7	A70548	SECTION WM06 SHUTTER	D25-958 PIPE	5	A70548-C	42.34	3000
8	A70733	SECTION WM06 SHUTTER	D19-300 EXTENS PIPE	4	A70733	0.25	3000
9	101520	HEX BOLT ZN 8.8	6X35 AM DIN933	10		0	2010
10	110789	NUT NYLOC ZN M 6	DIN985	10		0	2010
11	A71223	AIR PIPE WM06	PLAST CHAIN-WHE PACK	1	A71223-A	0.9	3000
14	A70570	AIR CHANN END WM06 1.0	CORNER-STRIP	2	A70570-A	0.94	3000
16	114055	WIRE-LOCK	D 5	8		0	2900
17	114067	WIRE-ROPE	D3/D5 MM PLAST P	16		0	2900
18	111550	WASHER ZN	M 10 DIN125	12		0	2010
19	400344	WASHER AISI	PL1,5 D45/25,5	2	21175.4	0	4500
20	A71156	AIR CHANN END WM06	COUNT PL FOR HATCH	4	A71156	15.08	3000
21	A71157	AIR CHANN END WM06	HATCH SUPP	8	A71157	15.08	3000
22	116065	PLASTIC PLUG	DBI 42	2		0	2600
23	101810	HEX BOLT ZN 8.8	8X16 AM DIN933	201		0	2010
24	110540	NUT ZN 8 M 8	DIN934	209		0	2010
25	115570	SEALING STRIP	4X10 MAPA	39		0	2600
26	107821	EYE-BOLT	M8X60	4		0	2000
27	120014	DRAW-SPRING	3,0X17 140	4	41529	0	2900



## Assembling air channel end A70825

We recommend carrying out assembly of the air channel end on an even plane.  
This ensures the ready-assembled air channel end is straight.





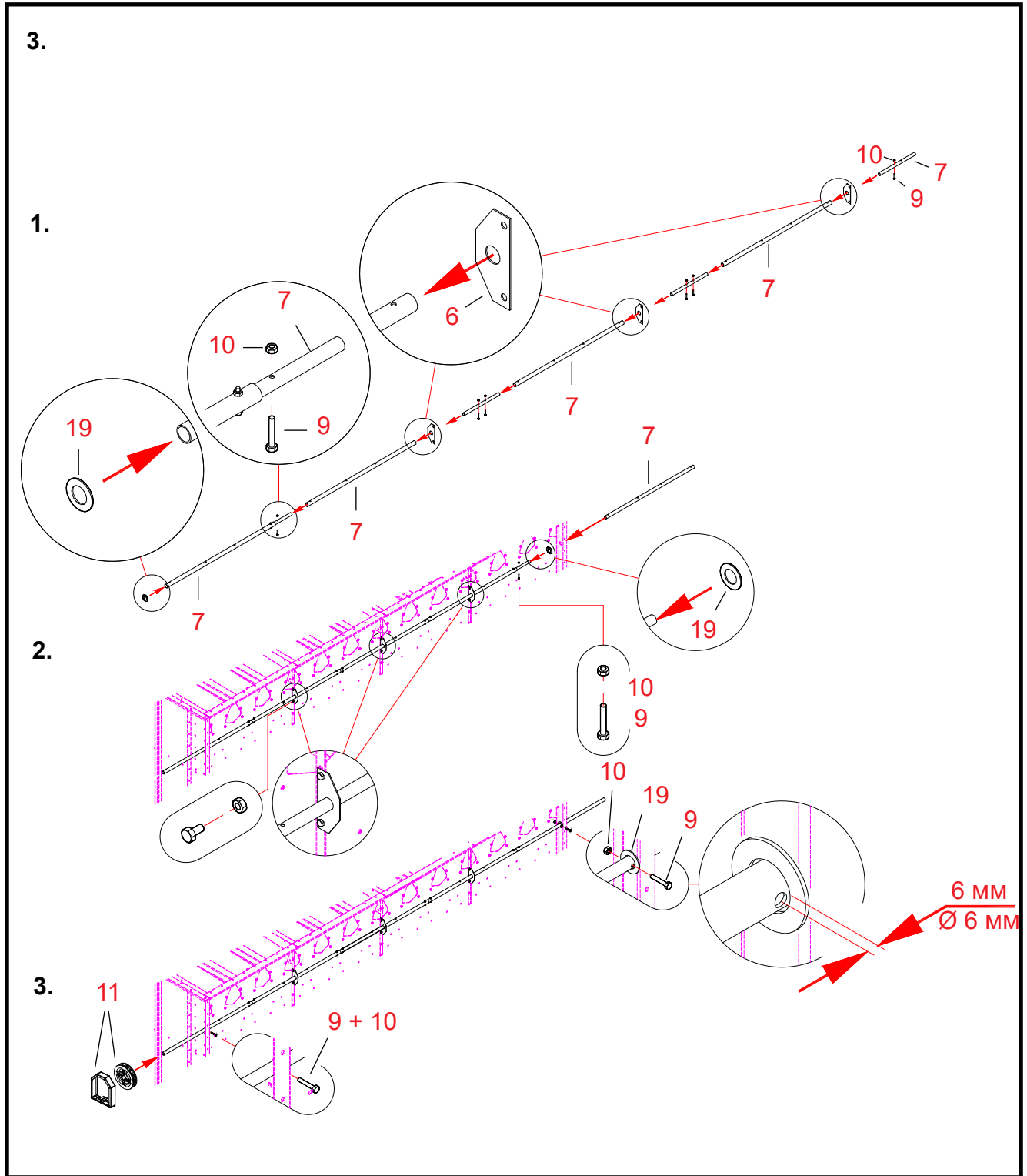
## 1. Assembling the end-plate set-up for the air channel end

- Parts            The numbering of work stages refers to reference numbers in the spare parts drawing A70825 for the air channel end.
- 25 (1.)            Fix sealing strips to the end-flanges of the four end-plates (parts 1).**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).
- 2                    Place the vertical supports between the end-plates.**  
*Be careful not to damage the sealing strips while installing the vertical support.*  
Install the flange of the vertical support to be left outside the air channel end in the direction illustrated in drawing 2.  
*The flange must be as illustrated in the drawing 2 if a rain roof will be attached to the air channel end.*
- 23, 24            Fix the end-plates and the vertical supports using bolts and nuts (M8 x 16, 11 + 11 + 11 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 4                    Install the straight supports for the air channel end in the vertical supports (parts 2).**  
Look up correct position for the supports in the drawing.
- 23, 24            Fix the supports using bolts and nuts (M8 x 16, 2 pcs./support).**
- 5                    Attach the shutter-plate set-ups (parts 5) to the holes in the end-plate set-ups.**
- 23, 24            Fix the shutter-plates using bolts and nuts (M 8 x 16, 16 pcs. / shutter-plate).**
- 18, 23, 24        Join the shutter-plates together using bolts, washers and nuts (M 8 x 16).**  
Install two M10 washers on both bolts, between the shutter-plates.

## 2. Assembling the air channel end

- 25 (2.)            Fix sealing strips to the attachment flanges of the side-plates (parts 3) to be attached to the drying section.**  
Fix the sealing strips inside the bolthole rows (see detail drawing 1 of stage 1).
- 3                    Move the side-plates tight against the ends of the section.**  
*Be careful not to damage the sealing strips while installing the side-plates.*
- 23, 24            Fix the side-plates to the section using bolts and nuts (M8 x 16, 11 pcs. /side-plate).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- (1)                Move the set-up, assembled at stage 1 between the side-plates.**  
*Be careful not to damage the sealing strips while moving the set-ups.*
- 23, 24            Fix the set-up, assembled at stage 1, using bolts and nuts (M8 x 16, 11 + 11 pcs.).**
- 23, 24            Attach the straight supports for the air channel end to the section using bolts and nuts (M 8 x 16, 2 pcs.).**  
See detail drawing 2. Tighten the bolts only lightly so that you can straighten the air channel end later.

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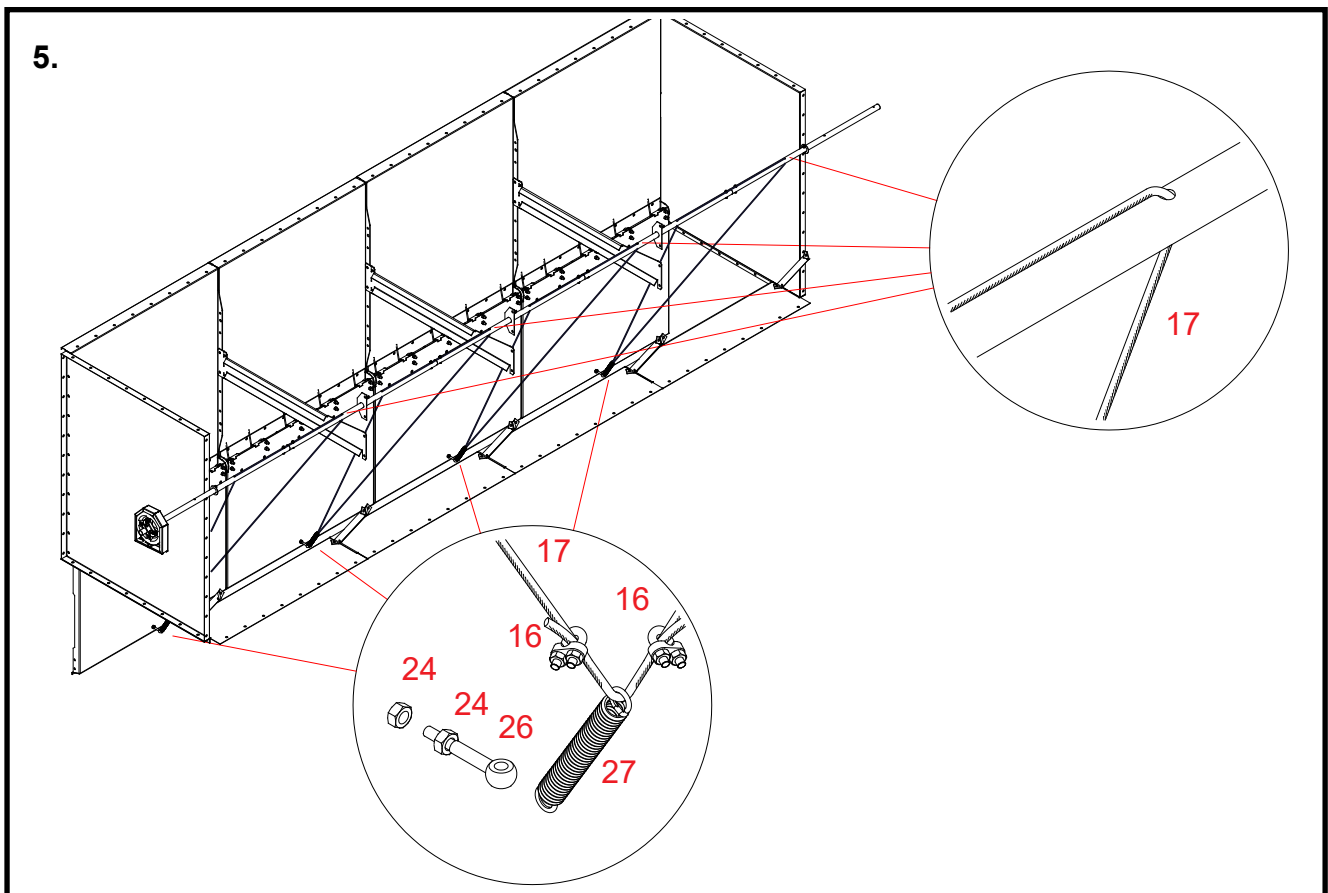
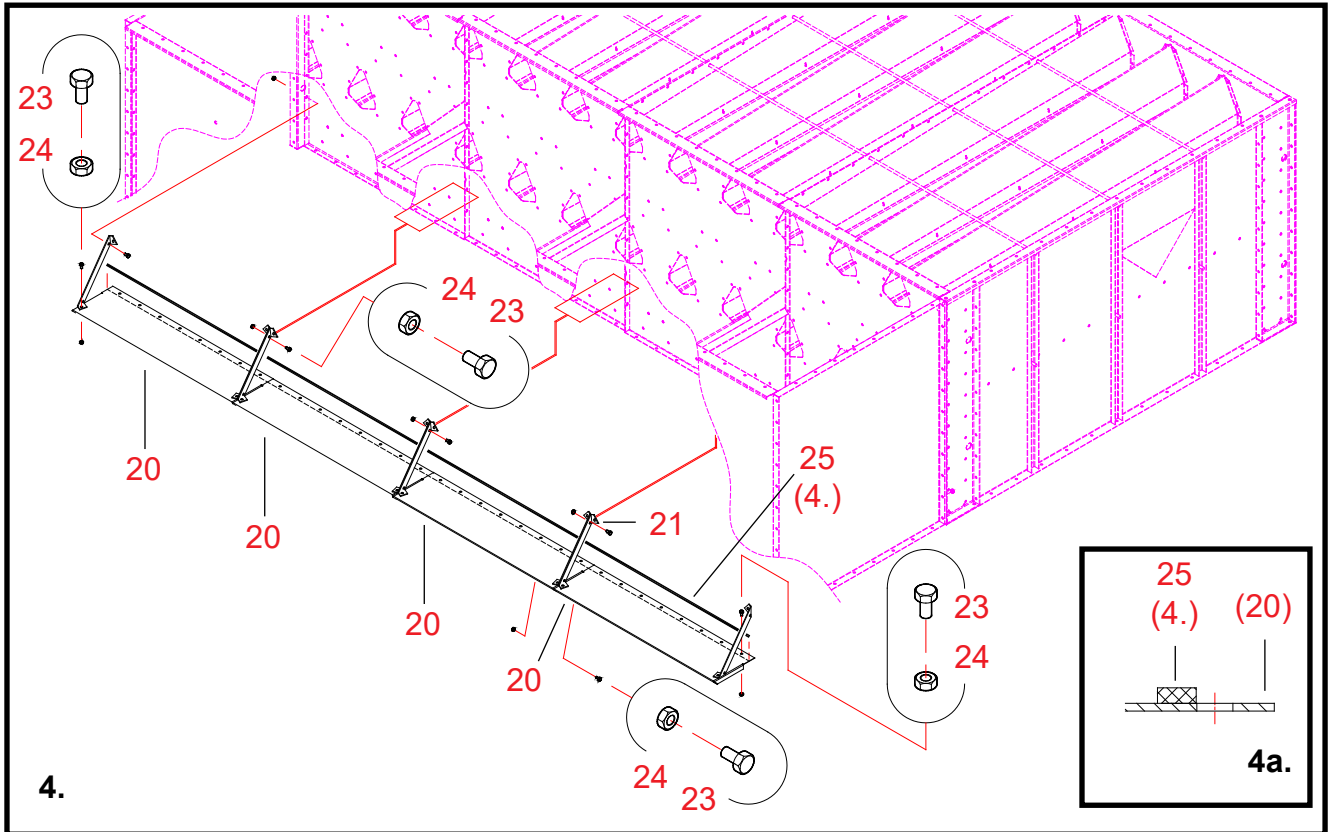


*Install the corner-strips (parts 14) only if this set-up is the lowest part of the air channel end in the dryer.*

- 25 (3.) **Fix sealing strips to the flanges of the corner-strips (parts 14).**  
Fix the sealing strips inside the bolthole rows (see detail drawing 2).
- 14 **Fix corner-strips to the lower flanges of both side-plates.**
- 23, 24 **Fix the corner-strips using bolts and nuts (M8 x 16, 4 + 4 pcs.).**
- \* **Check the joints and rectangular shape of the air channel end. Tighten all bolts.**

### 3. Installing the actuator-shaft for the shutter-plates

- Fig. 1.
- 8 **Join together two shaft-pipes (parts 7) using the extension pipe.**
- 9, 10 **Fix the joint using two bolts and Nyloc-nuts (M 6 x 35).**
- 6 **Push the guide-lug for the shaft on the pipe.**
- 8 **Attach another extension pipe to the same end of the shaft-pipe, on which you threaded the guide-lug.**
- 9, 10 **Fix the extension pipe using bolt and Nyloc-nuts (M 6 x 35).**
- \* **Repeat the three preceding stages twice.**  
**After that the shaft comprises four pipes and three guide-lugs.**
- 19 **Thread washer (D45/25,5) onto the pipe from the opposite end of the pipe.**
- Fig. 2.
- (1) **Insert the shaft, assembled in accordance with Fig. 1, in the upper Ø 25,5 mm holes in the section's side-plates.**  
Remove two bolts from the centre-seams of the section's end-plates, at the guide-lugs.  
Place the guide-lugs against the flanges of the end-plates and re-insert the bolts.
- 19 **Thread another washer (D45/25,5) onto the shaft-pipe.**
- 7 **Push the fifth shaft-pipe through the side-plate and the leg of the section onto the extension pipe for the ready-assembled shaft.**
- 9, 10 **Fix the shaft-pipe joint using bolt and Nyloc-nut (M 6 x 35).**
- Fig. 3.
- \* **Centre the shaft-pipe with respect to the side-flanges of the section.**
- \* **Shift washers (parts 19) against the side-flanges of the section.**
- \* **Drill a Ø 6 mm hole through the shaft-pipe, at a distance of 6 mm from the face of each washer.**
- 9, 10 **Insert bolts in the drilled holes and fix them using Nyloc-nuts (M 6 x 35).**
- 11 **Place the chain-wheel unit onto the actuator-shaft for the shutter-plates.**  
Tighten the nuts of the U-bolt ties only lightly at this stage.







#### 4. Installing the counter-plates for the shutter-plate in the section

- 20            **Join the four counter-plates (parts 20) together.**
- 23, 24        **Fix the seams using bolts and nuts (M8 x 16).**
- 21            **Install the counter-plate supports (8 pcs. of parts 21) in the counter-plates in position, shown in the picture.**
- 23, 24        **Fix the supports using bolt and nuts (M8 x 16, 1 pcs./support).**
- 25 (4.)       **Fix a sealing strip to the upper surface of the counter-plate set-up (parts 21).**  
Fix the sealing strip inside the screw hole row (see Fig. 4a).
- (23, 24)      **Remove from the section the fixing bolts and nuts from the fixing point of the counter-plate support.**  
Fix the counter-plate supports using the second bolt from the bottom in the centre-seam and side-seams of the section.
- (20, 4 pcs.) **Attach the ready-assembled counter-plate to the corner-strips of the air channel end side-plates.**  
Place the counter-plate in the outermost holes of the corner-strip, on the same side with the section.
- 23, 24        **Fix the counter-plate by its both ends using bolt and nut (M 8 x 16).**  
The edge of the counter-plate comes under the side of the section and is fixed in place with it.  
***If the air channel ends are left without corner-lists, attach the counter-plate only to the section.***
- 23, 24        **Fix the counter-plate supports using the removed bolts and nuts (M 8 x 16).**

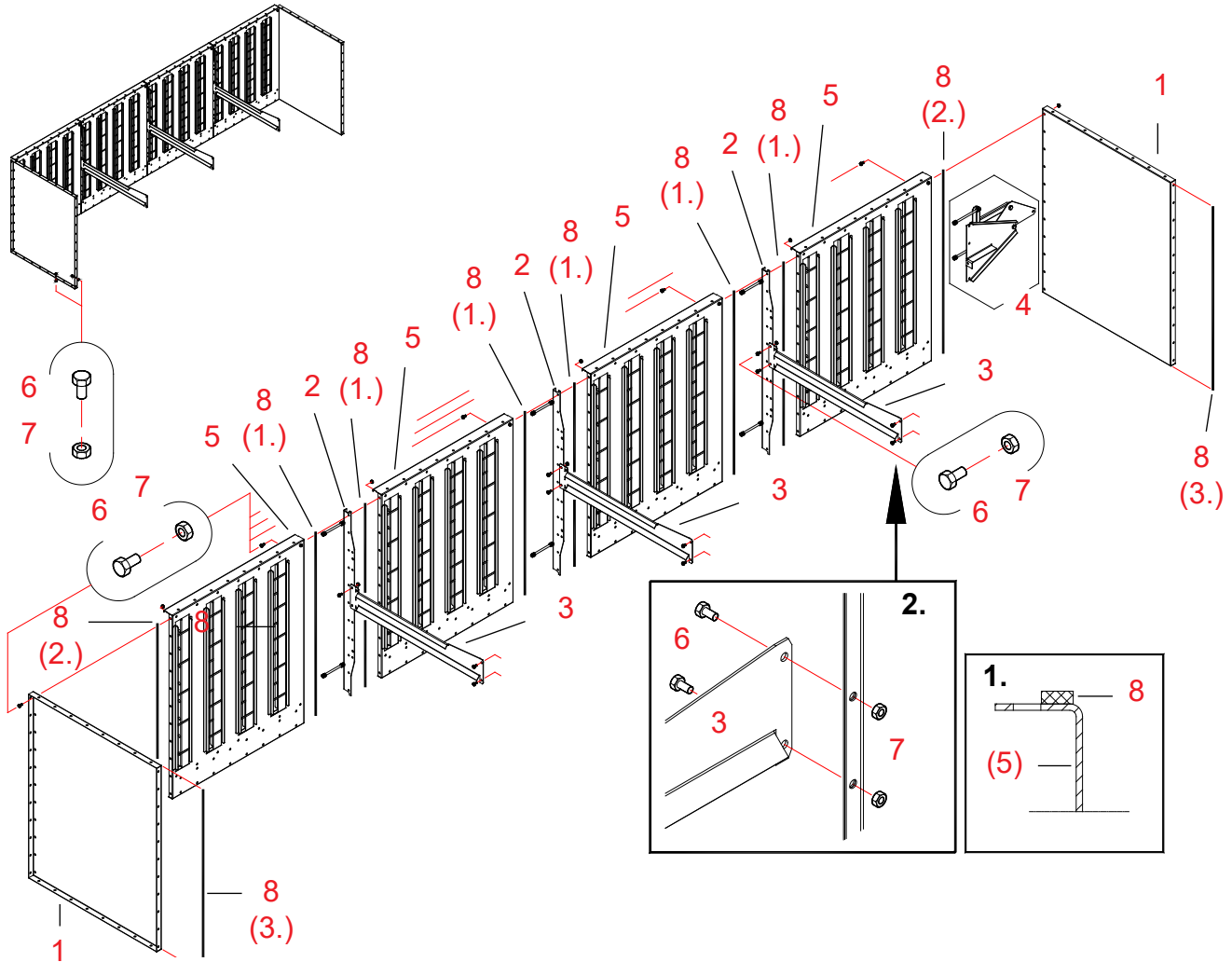
#### 5. Installing the actuator wires for the plates

- 24, 26        **Provide all shutter-plates with an eye-bolt. Fix them using two nuts (M8).**
- 27            **Thread in a draw-spring through all eye-bolts.**
- 17            **Install the actuator wires for the shutter-plates.**  
Thread the wire through the two holes in the shaft and the draw-spring eye to make a triangle-shaped loop.  
Also see the picture X in the assembly instructions drawing 4 for the air channel end A70966 above.
- 16            **Place wire-locks on both sides of the draw-spring eye.**
- \*             **Cut off the wire at a distance of about 30 mm from the wire-lock.**



## Air channel end 1,0 4W (A71011) - adjustment plates

## Spare parts



20080901

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A70640	AIR CHANN END WM06 1.0	SIDE-PLATE	2	A70640	14.18	3000
2	A70810	TOP SECTION WM06	VERTICAL SUPPORT PL3	3	A70810-C	2.34	3000
3	A70678	AIR CHANN END WM06 1.0	STRAIGHT SUPPORT	3	A70678-B	1.79	3000
4	A71367	AIR CHANN END WM06	PACK OF ADJ PARTS	1	A71367	5.46	3000
5	A71351	AIR CHANN END WM06	ADJUST ASSEMBLY	4	A71351	32.1	3000
6	101810	HEX BOLT ZN 8.8	8X16 AM DIN933	195		0	2010
7	110540	NUT ZN 8 M 8	DIN934	195		0	2010
8	115570	SEALING STRIP	4X10 MAPA	29		0	2600



## Assembling air channel end A71011

### 1. Assembling the end-plate set-up for the air channel end

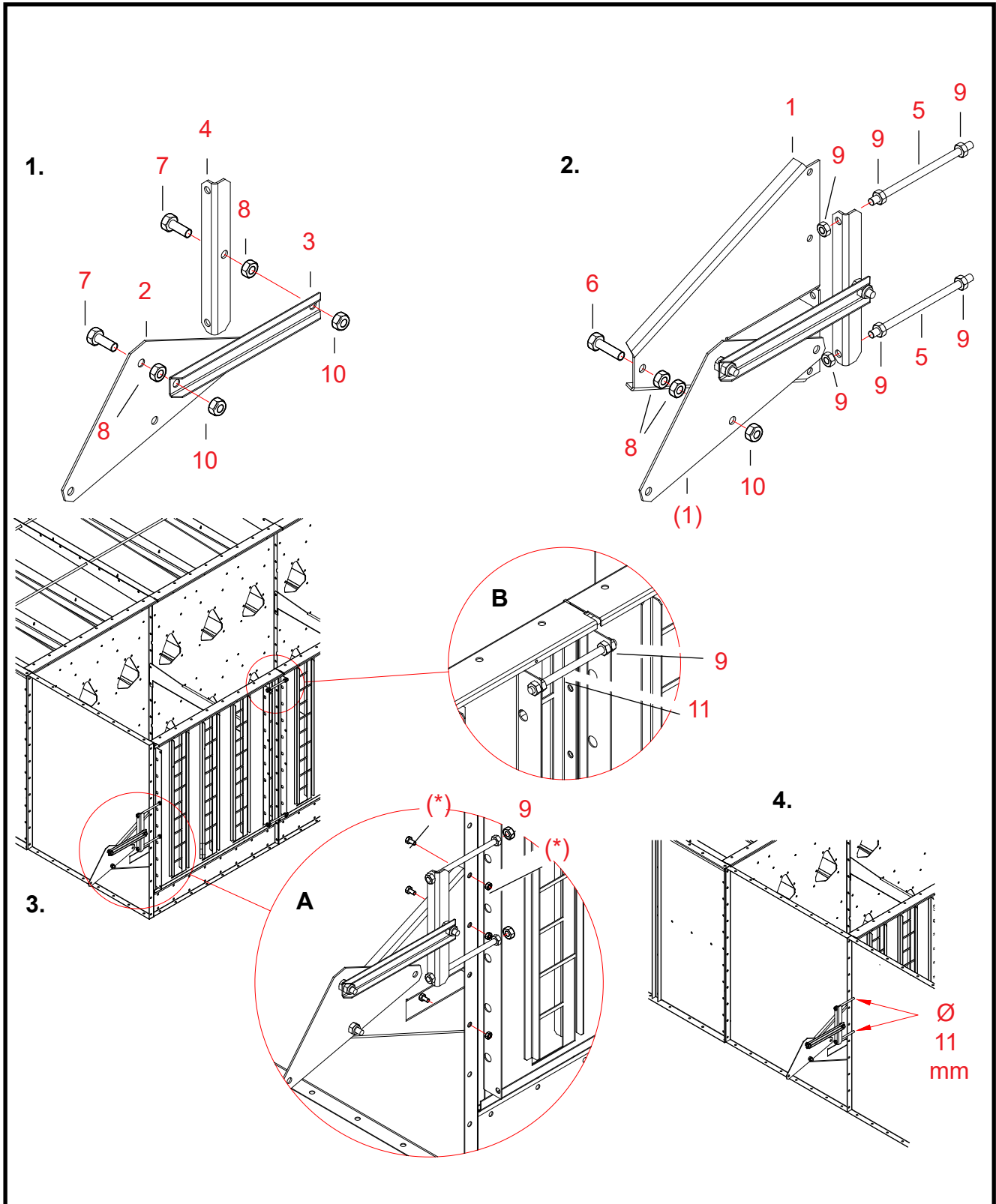
Parts            The numbering of work stages refers to reference numbers in the spare parts drawing A71011 for the air channel end.

*We recommend carrying out assembly of the air channel end on an even plane.  
This ensures the ready-assembled air channel end is straight.*

- 8 (1.)        **Fix sealing strips to the flanges of the four end-plates (parts 5) to be joined together.**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing).
  
- 2             **Place vertical supports between the panels of the adjustment plates.**  
*Be careful not to damage the sealing strips while installing the vertical support.*
  
- 6, 7         **Fix the adjustment plate panels and the vertical supports using bolts and nuts (M8 x 16, 11 pcs./seam).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
  
- 3             **Install the straight supports for the air channel end in the vertical supports (parts 2).**  
Look up correct position for the support in the drawing.
  
- 6, 7         **Fix the supports using bolts and nuts (M8 x 16, 2 pcs./support).**

### 2. Assembling the air channel end

- 8 (3.)        **Fix sealing strips to the attachment flanges of the side-plates (parts 1) to be attached to the drying section.**  
Fix the sealing strips inside the bolthole rows.
  
- 1             **Move the side-plates tight against the ends of the section.**  
*Be careful not to damage the sealing strips while installing the side-plates.*
  
- 6, 7         **Fix the side-plates using bolts and nuts (M8 x 16, 11 pcs. /side-plate).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
  
- (1)           **Move the set-up, assembled at stage 1 between the side-plates.**  
*Be careful not to damage the sealing strips while moving the set-ups.*
  
- 6, 7         **Fix the set-up, assembled at stage 1, using bolts and nuts (M8 x 16, 11 + 11 pcs.).**
- 6, 7         **Attach the straight supports for the air channel end to the section using bolts and nuts (M 8 x 16, 2 pcs.).**  
See detail drawing 2. Tighten the bolts only lightly so that you can straighten the air channel end later.
  
- \*             **Check the joints of the air channel end, its rectangular shape and alignment of the side-plates.**  
**Tighten all bolts.**





## Assembling and installing adjustment part package A71367

### 1. Assembling the adjustment parts

- Parts            The numbering of work stages refers to reference numbers in the spare parts drawing A71367 for the air channel end.
- Fig. 1.
- 7, 8            **Fix a bolt and a nut (M 12 x 35) to the lever (part 2) and adjustment bracket (part 4).**
- 3                **Join the parts together using the intermediate rod. Insert the bolts, you just installed, in the holes in the intermediate rod.**  
Check in the drawing that the parts are correctly positioned with respect to one another.
- 10              **Fix the intermediate rod using nuts (M 12 nyloc, 2 pcs.).**
- Fig. 2.
- 6, 8            **Fix one bolt and two nuts (M 12 x 50) to the adjuster support (part 1).**
- (1)             **Put the set-up, assembled in accordance with Fig. 1, on the bolt, you just installed.**  
Check in the drawing that the parts are correctly positioned with respect to one another.
- 10              **Fix the set-up using nut (M 12 nyloc, 1 pc.).**
- 9                **Turn two nuts (M10) on both transmission rods.**  
Turn the nuts to end of the thread.
- 5                **Fix the transmission rods to the adjustment bracket.**
- 9                **Fix the transmission rods using nut (M 10 nyloc, 1 pcs./rod).**

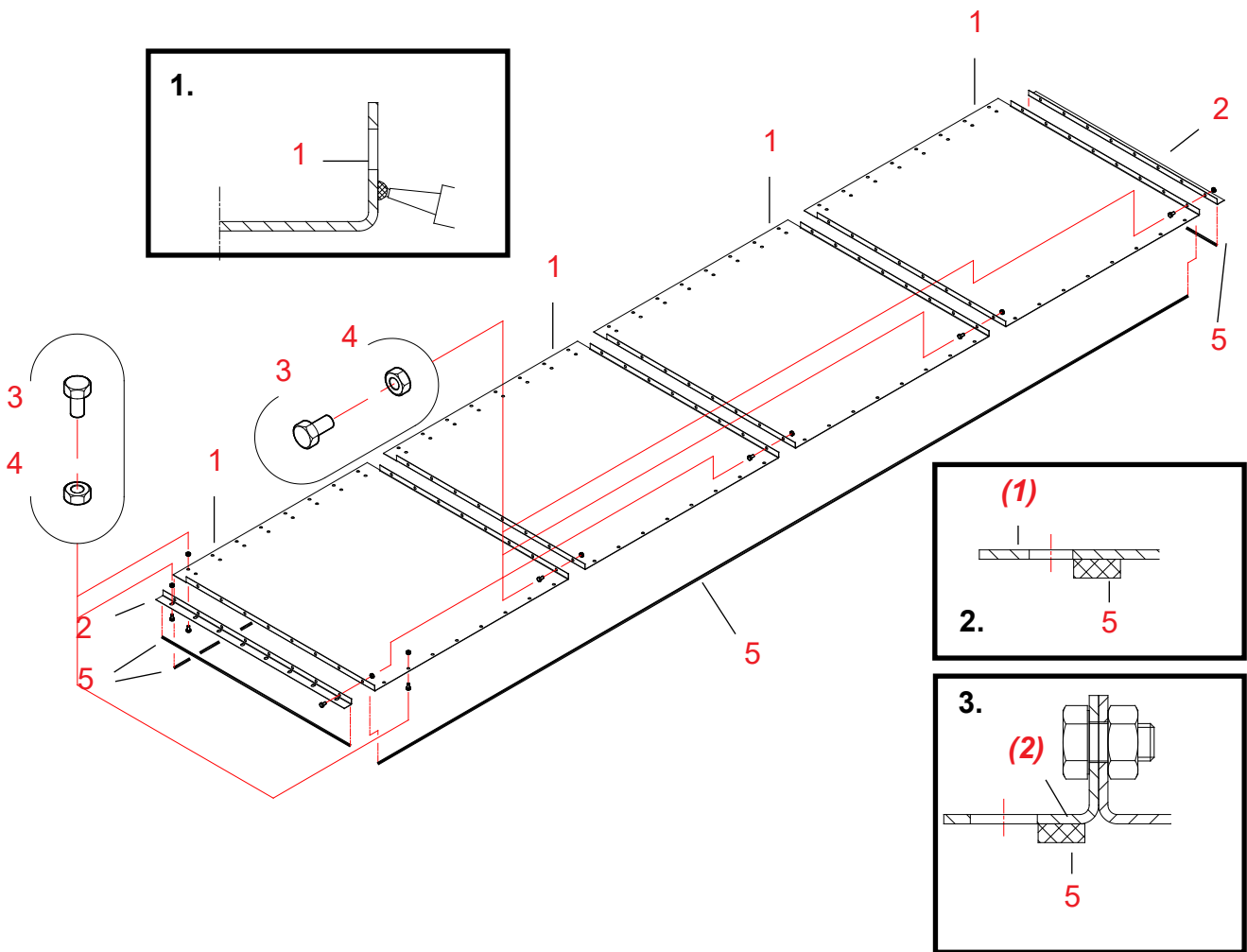
### 2. Installing the adjuster set-up

- Fig. 3, detail A  
Look up in Fig. 3 the correct location for the adjuster at the side of the air channel end.
- \*                **Remove three bolts from the air channel end for installation of the adjuster set-up.**
- (1 - 2)         **Attach the set-up, assembled at stages 1 - 2, to the side of the air channel end.**
- \*                **Fix the set-up in place using the bolts and nuts you just removed.**
- 9                **Fix the transmission rods to the adjustment plate using nuts (M 10 nyloc, 1 pcs./rod).**
- Fig. 3, detail B
- 9, 11         **Join the adjustment plates together using the two threaded rods and the four nuts. (M 10, L = 160 mm).**
- Fig. 4.
- \*                **If the adjustment plates are placed inside the air channel end, holes need to be drilled for the transmission rods.**  
Drill Ø 11 mm holes in the side-plate of the air channel end for the transmission rods.



## Air channel end 1,0 4W (A70960) - upper shutter B

### Spare parts



20080715

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A70642	AIR CHANN END WM06 1.0	SHUTTER-PLATE	4	A70642	11.67	3000
2	A70570	AIR CHANN END WM06 1.0	CORNER-STRIP	2	A70570-A	0.94	3000
3	101810	HEX BOLT ZN 8.8	8X16 AM DIN933	88		0	2010
4	110540	NUT ZN 8 M 8	DIN934	88		0	2010
5	115570	SEALING STRIP	4X10 MAPA	6		0	2600
6	800271	MASTIC SEALING/GLUE	GREY 310 ML	1			2600

## Installing upper shutter A70960 in the air channel end

### 1. Joining together the shutter-plates and the corner-strips

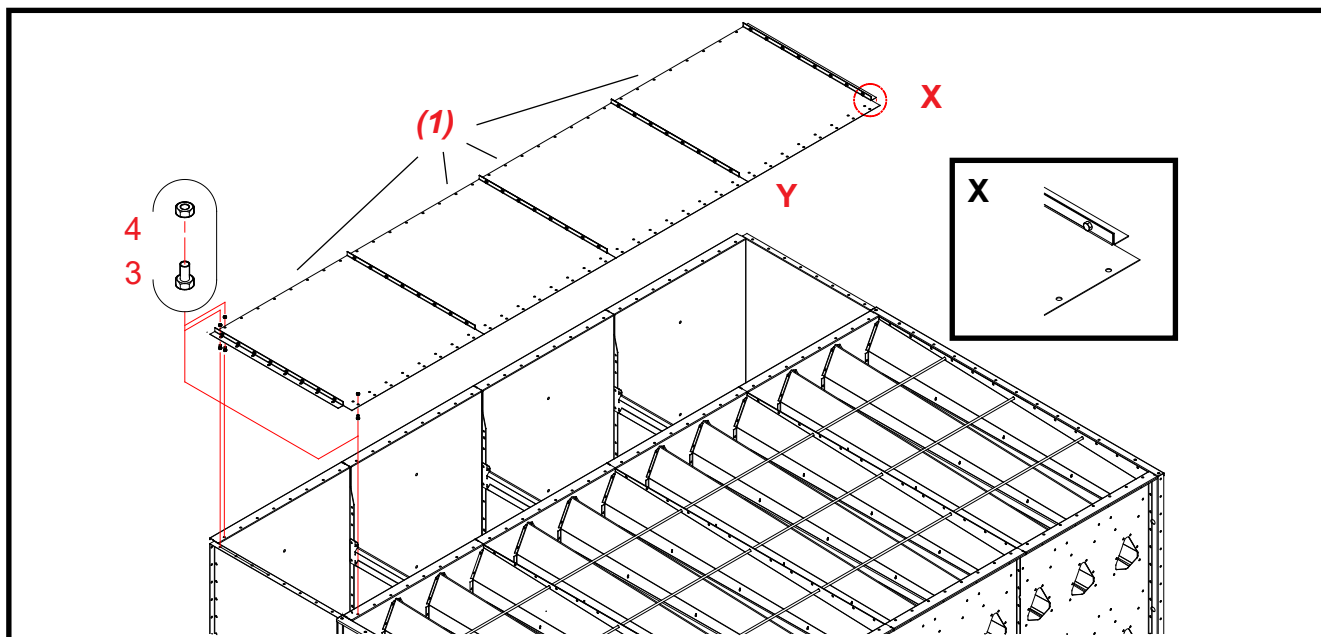
Parts The numbering of work stages refers to reference numbers in the spare parts drawing A70960 for the upper shutter.

- \* **Apply sealing mastic on the outside of both end flanges (parts 1).**  
Apply sealing mastic outside the bolthole rows in the supports (see detail drawing 1).  
Try to keep the mastic strip as even and continuous as possible.
- 3, 4 **Join the shutter-plates together using bolts and nuts (M8 x 16, 8 pcs./joint).**  
**Be careful not to damage the sealing mastic strip while joining the plates.**
- 2 **Fix the corner-strips against the flanges at the outer ends of the shutter-plate set-up.**  
**Be careful not to damage the sealing mastic strip while installing the corner-strips.**
- 3, 4 **Fix them in place using bolts and nuts (M 8 x 16, 8 pcs./corner-strip).**
- 5 **Fix sealing strips to the lower surfaces of the shutter-plate/corner-strip assembly (assembled at stage 1).**  
Fix the sealing strips inside the bolthole rows in the shutter-plates (see detail drawing 2).  
Fix the sealing strips inside the bolthole rows in the corner-strips (see detail drawing 3).

### 2. Fixing the shutter-plate to the upper end of the air channel end

Parts Refer to installation drawing for the upper shutter A70960 of the air channel end below.

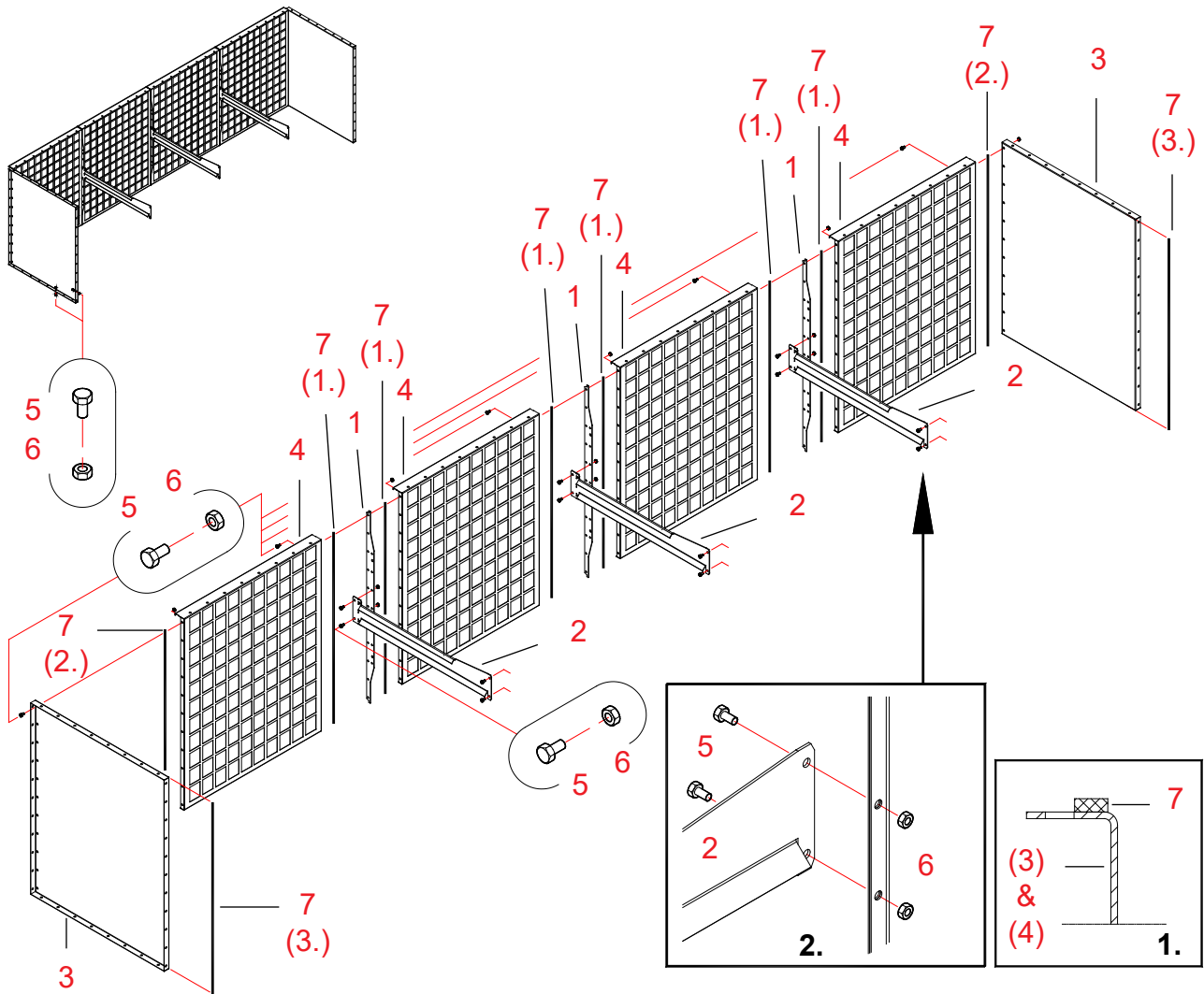
- (1) **Move the assembly against the flanges at the upper end of the air channel end.**  
**Be careful not to damage the sealing strips while installing the plate.**  
Check correct position for the assembly in detail drawing X.
- 3, 4 **Fix the shutter-plate using bolts and nuts (M 8 x 16, 80 pcs.).**  
**Note! Do not install the bolts on the other long side (Y) until the dryer is being assembled.**





## Air channel end 1,0 4W (A70984) - spark net

### Spare parts



20080901

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A70810	TOP SECTION WM06	VERTICAL SUPPORT PL3	3	A70810-C	2.34	3000
2	A70678	AIR CHANN END WM06 1.0	STRAIGHT SUPPORT	3	A70678-B	1.79	3000
3	A70640	AIR CHANN END WM06 1.0	SIDE-PLATE	2	A70640	14.18	3000
4	A70978	AIR CHANN END WM06	SPARK NET	4	A70978	6.45	3000
5	101810	HEX BOLT ZN 8.8	8X16 AM DIN933	131		0	2010
6	110540	NUT ZN 8 M 8	DIN934	131		0	2010
7	115570	SEALING STRIP	4X10 MAPA	29		0	2600





## Assembling air channel end A70984

### 1. Assembling the end-plate set-up (spark nets) for the air channel end

Parts The numbering of work stages refers to reference numbers in the spare parts drawing A70984 for the air channel end.

*We recommend carrying out assembly of the air channel end on an even plane.  
This ensures the ready-assembled air channel end is straight.*

7 (1.) **Fix sealing strips to the end flanges of the four spark nets (parts 4) to be joined together.**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).

1 **Place vertical supports between the spark nets.**  
*Be careful not to damage the sealing strips while installing the vertical support.*

5, 6 **Fix the spark nets and the vertical support using bolts and nuts (M8 x 16, 11 + 11 + 11 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.

2 **Install the straight supports for the air channel end in the vertical supports (parts 1).**  
Look up correct position for the support in the drawing.

5, 6 **Fix the supports using bolts and nuts (M8 x 16, 2 pcs./support).**

7 (2.) **Fix sealing strips to the end-flanges of the ready-assembled end-plate set-up.**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).

### 2. Assembling the air channel end

7 (3.) **Fix sealing strips to the attachment flanges of the side-plates (parts 3) to be attached to the drying section.**  
Fix the sealing strips inside the bolthole rows.

3 **Move the side-plates tight against the ends of the section.**  
*Be careful not to damage the sealing strips while installing the side-plates.*

5, 6 **Fix the side-plates using bolts and nuts (M8 x 16, 11 pcs. /side-plate).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.

(1) **Move the set-up, assembled at stage 1 between the side-plates.**  
*Be careful not to damage the sealing strips while moving the set-ups.*

5, 6 **Fix the set-up, assembled at stage 1, using bolts and nuts (M8 x 16, 11 + 11 pcs.).**

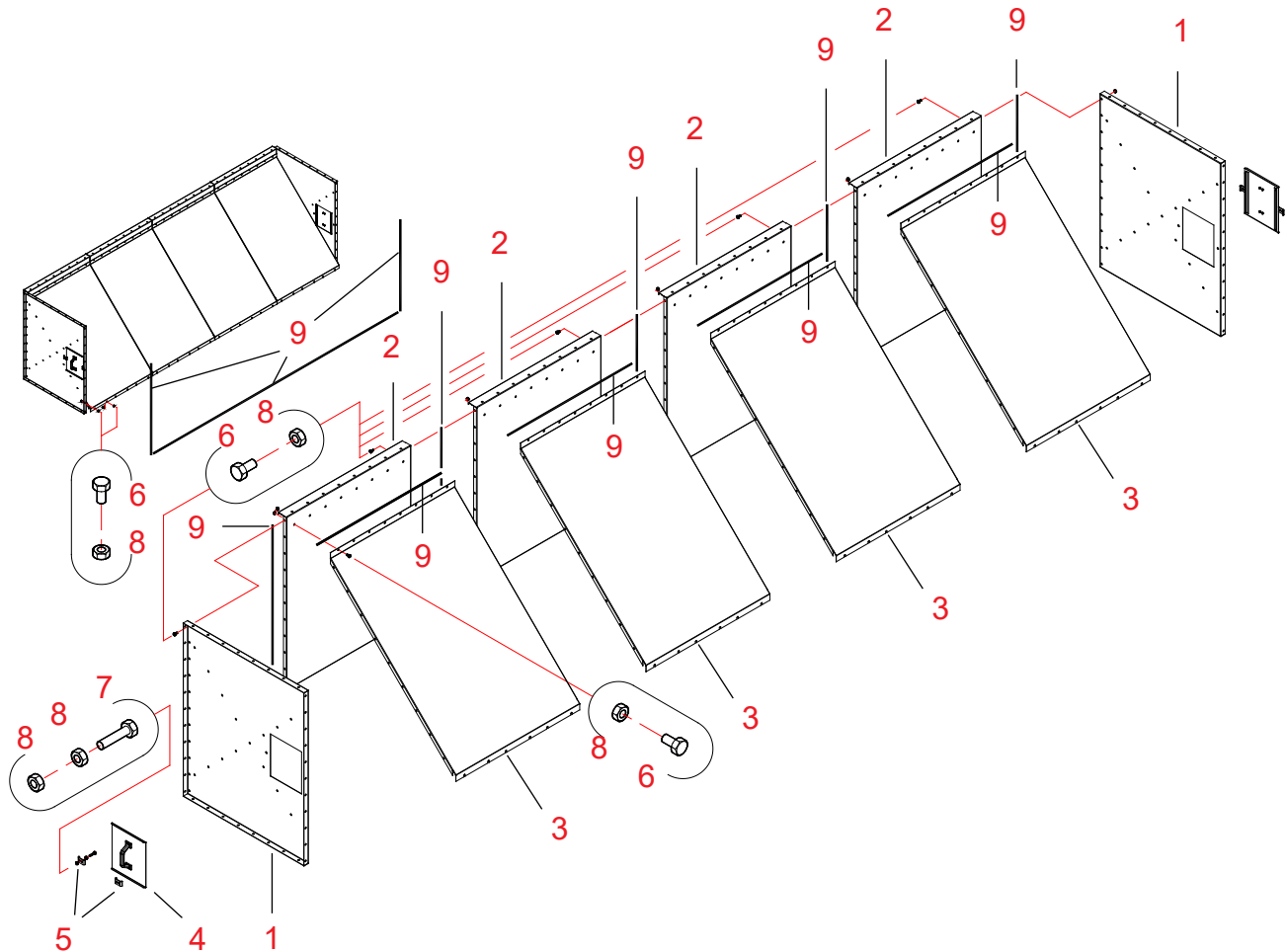
5, 6 **Fix the straight supports for the air channel end to the section using bolts and nuts (M 8 x 16, 2 + 2 + 2 pcs.).**  
See detail drawing 2. Tighten the bolts only lightly so that you can straighten the air channel end later.

\* **Check the joints of the air channel end, its rectangular shape and alignment of the side-plates.**  
**Tighten all bolts.**



## Air channel end 1,0 4W (A70748) - return end B

### Spare parts



20061106

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A70679	AIR CHANN END WM06 1.0	SIDE-PL RETURN END	2	A70679	13.37	3000
2	A70680	AIR CHANN END WM06 1.0	END-PLATE RETURN END	4	A70680-A	14.66	3000
3	A70681	AIR CHANN END WM06 1.0	RETURN BOTTOM	4	A70681-A	16.91	3000
4	501763	SECTION AIR CH SIDE-PL	HATCH MEGA	2	32214-A	0	3000
5	400280	TOP SECTION COV	HOLDER	4	S4668-A	0	3000
6	101810	HEX BOLT ZN 8.8	8X16 AM DIN933	218		0	2010
7	101860	HEX BOLT ZN 8.8	8X35 AM DIN933	4		0	2010
8	110540	NUT ZN 8 M 8	DIN934	226		0	2010
9	115570	SEALING STRIP	4X10 MAPA	33		0	2600



## Assembling air channel end A70748

### 1. Assembling the end-plate set-up for the air channel end

Parts            The numbering of work stages refers to reference numbers in the spare parts drawing A70748 for the air channel end.

*We recommend carrying out assembly of the air channel end on an even plane.  
This ensures the ready-assembled air channel end is straight.*

9 (1.)            **Fix sealing strips to both end-flanges of one of the end-plates (part 2).**

9 (2.)            **Fix a sealing strip to the other end-flange of three of the end-plates (part 2).**

Fix the sealing strip inside the screw hole row in the flange (see detail drawing 1).

2                **Place the end-flanges of the end-plates face to face.**

Observe, that there will be only one sealing strip between the flanges.

*Be careful not to damage the sealing strip while installing the end-plate.*

6, 8            **Fix the end-plates using bolts and nuts (M8 x 16, 11 + 11 + 11 pcs.).**

Tighten the bolts only lightly so that you can straighten the air channel end later.

9 (3.)            **Fix sealing strips to the upper flanges of all return bottoms (parts 3).**

Fix the sealing strip inside the screw hole row in the flange (see detail drawing 2).

9 (4.)            **Fix sealing strips to both end-flanges of one of the return bottoms (part 3).**

9 (5.)            **Fix sealing strips to the other end-flange of three of the return bottoms (part 3).**

Fix the sealing strips inside the screw hole row in the flange (see detail drawing 2).

3                **Fix the return bottoms to the hole rows near the upper edge of the end-plates (parts 2).**

6, 8            **Fix the return bottoms using bolts and nuts (M 8 x 16, 8 pcs./bottom).**

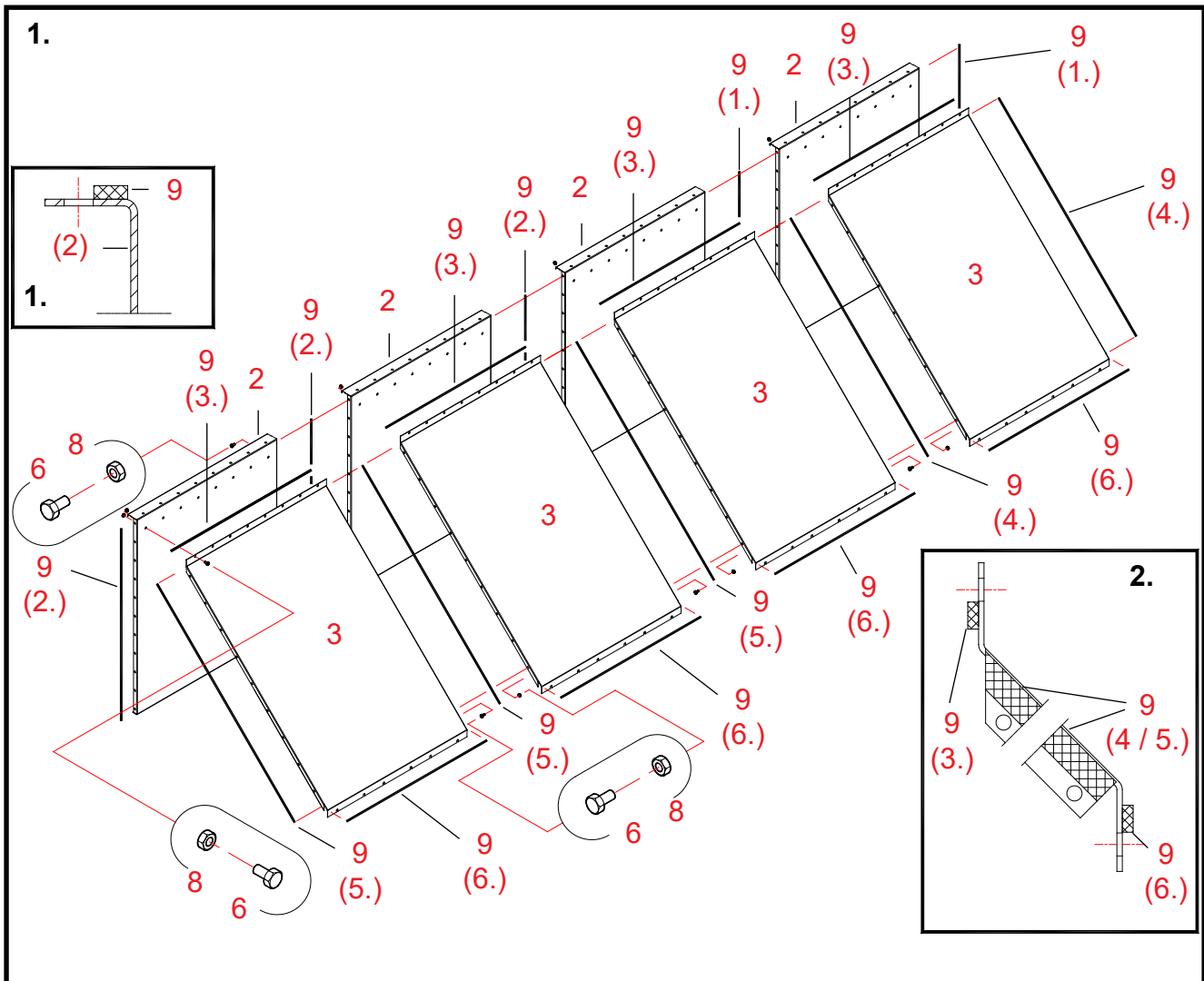
Place the bolt caps on the return bottom side.

6, 8            **Fix the return bottoms together using bolts and nuts (M8 x 16, 7 + 7 + 7 pcs.).**

9 (6.)            **Fix sealing strips to the lower flanges of all return bottoms (parts 3).**

Fix the sealing strips inside the screw hole row in the flange (see detail drawing 2).

See illustration of this stage on next page.

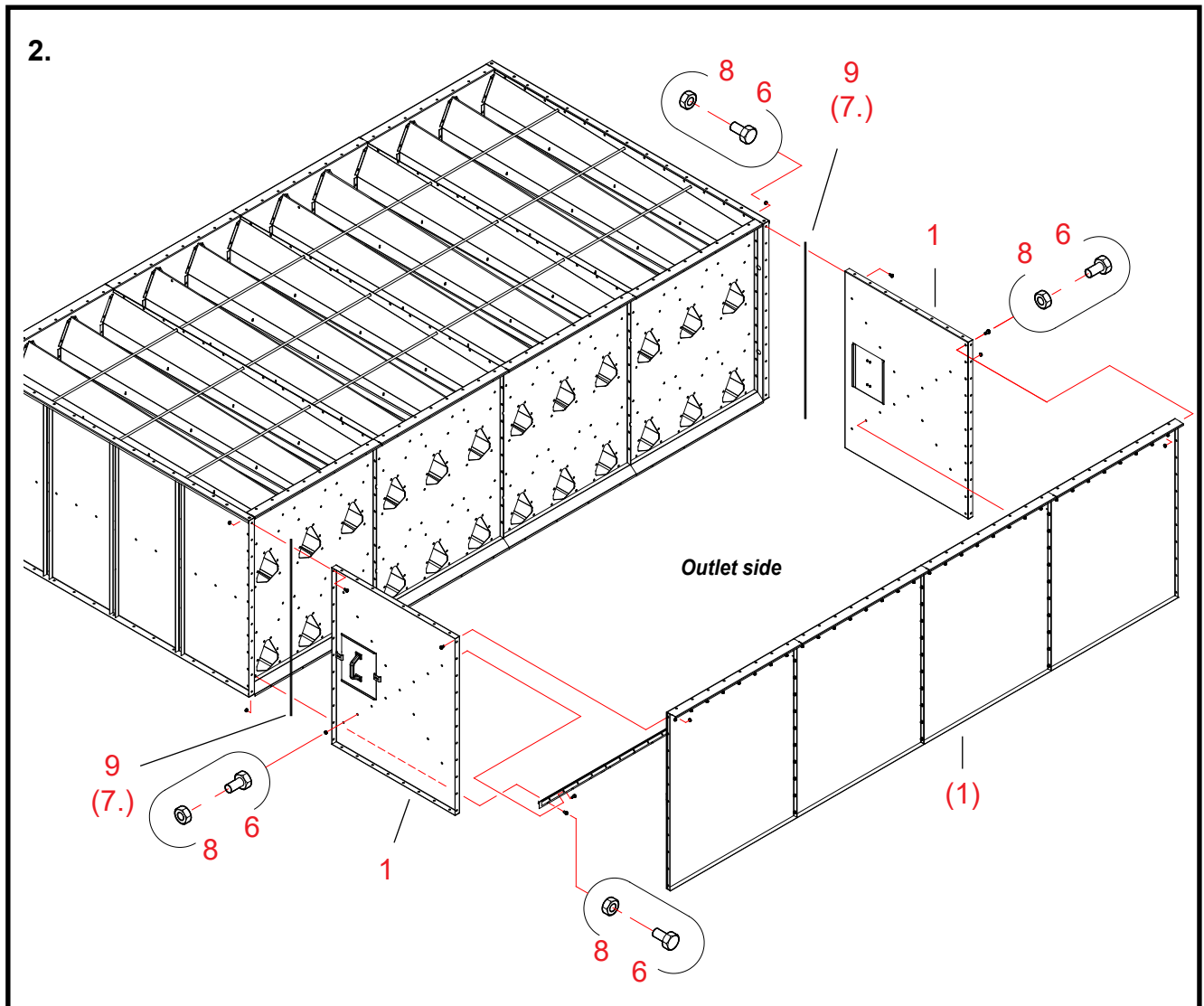


Assembling air channel end A70748, continues

## 2. Assembling the air channel end

- 9 (7.) **Fix sealing strips to the attachment flanges of the side-plates (parts 1) to be attached to the drying section.**  
Fix the sealing strips inside the bolthole rows.
  
- 1 **Move the side-plates tight against the ends of the section.**  
*Be careful not to damage the sealing strips while installing the side-plates.*
  
- 6, 8 **Fix the side-plates using bolts and nuts (M8 x 16, 11 pcs. /side-plate).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
  
- (1) **Move the set-up, assembled at stage 1 between the side-plates.**  
*Be careful not to damage the sealing strips while moving the set-ups.*
  
- 6, 8 **Fix the set-up, assembled at stage 1, to the side-plates using bolts and nuts (M8 x 16, 11 + 11 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.

>>>



6, 8      **Fix the return bottoms to the side-plates using bolts and nuts (M8 x 16, 9 pcs. /side-plate).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.

6, 8      **Fix the return bottoms to the section using bolts and nuts (M8 x 16, 6 + 6 + 6 + 6 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.

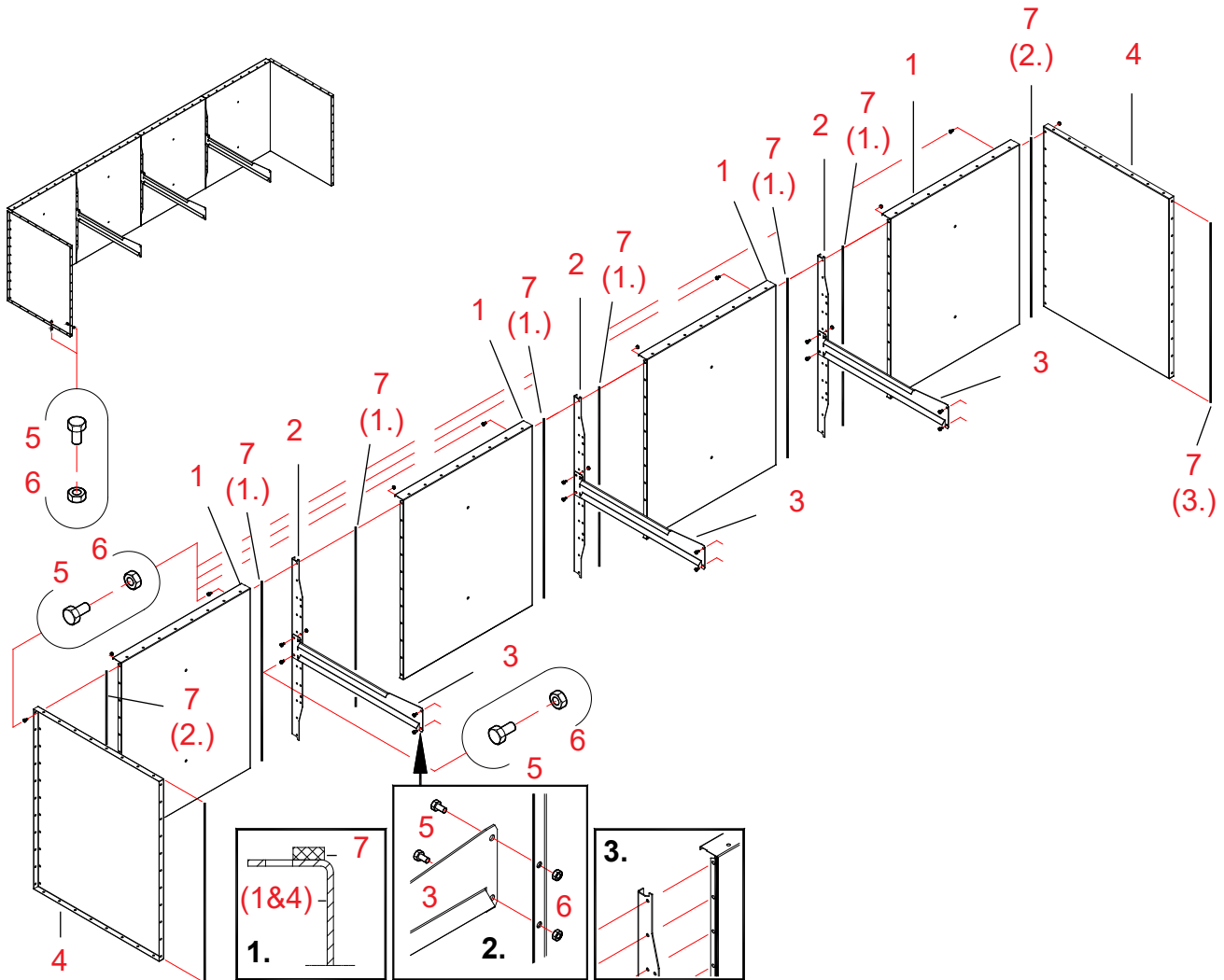
\*      **Check the joints and rectangular shape of the air channel end. Tighten all bolts.**

**Note, that parts 4 and 5 are ready-attached to parts 1.**



## Air channel end 1,0 4W (A70980) - centre-part B

### Spare parts



20080901

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A70563	TOP SECTION/AIR CH END	END-PLATE	4	A70563-B	14.65	3000
2	A70810	TOP SECTION WM06	VERTICAL SUPPORT PL3	3	A70810-C	2.34	3000
3	A70678	AIR CHANN END WM06 1.0	STRAIGHT SUPPORT	3	A70678-B	1.79	3000
4	A70640	AIR CHANN END WM06 1.0	SIDE-PLATE	2	A70640	14.18	3000
5	101810	HEX BOLT ZN 8.8	8X16 AM DIN933	138		0	2010
6	110540	NUT ZN 8 M 8	DIN934	138		0	2010
7	115570	SEALING STRIP	4X10 MAPA	29		0	2600



## Assembling air channel end A70980

### 1. Assembling the end-plate set-up for the air channel end

Parts            The numbering of work stages refers to reference numbers in the spare parts drawing A70980 for the air channel end.

*We recommend carrying out assembly of the air channel end on an even plane.  
This ensures the ready-assembled air channel end is straight.*

7 (1.)            **Fix sealing strips to the flanges of the four end-plates (parts 1) to be joined together.**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).

2                 **Place the vertical supports between the end-plates.**  
***Be careful not to damage the sealing strips while installing the vertical support.***  
Install the flange of the vertical support to be left outside the air channel end in the direction illustrated in drawing 3.  
***The flange must be as illustrated in the drawing 3 if a rain roof will be attached to the air channel end.***

5, 6              **Fix the end-plates and the vertical supports using bolts and nuts (M8 x 16, 11 + 11 + 11 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.

3                 **Install the straight supports for the air channel end in the vertical supports (parts 2).**  
Look up correct position for the support in the drawing.

5, 6              **Fix the supports using bolts and nuts (M8 x 16, 2 pcs./support).**

7 (2.)            **Fix sealing strips to the end-flanges of the ready-assembled end-plate set-up.**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).

### 2. Assembling the air channel end

7 (3.)            **Fix sealing strips to the attachment flanges of the side-plates (parts 4) to be attached to the drying section.**  
Fix the sealing strips inside the bolthole rows.

4                 **Move the side-plates tight against the ends of the section.**  
***Be careful not to damage the sealing strips while installing the side-plates.***

5, 6              **Fix the side-plates using bolts and nuts (M8 x 16, 11 pcs. /side-plate).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.

(1)               **Move the set-up, assembled at stage 1 between the side-plates.**  
***Be careful not to damage the sealing strips while moving the set-ups.***

5, 6              **Fix the set-up, assembled at stage 1, using bolts and nuts (M8 x 16, 11 + 11 pcs.).**

5, 6              **Fix the straight supports for the air channel end to the section using bolts and nuts (M 8 x 16, 2 pcs./support).**  
See detail drawing 2. Tighten the bolts only lightly so that you can straighten the air channel end later.

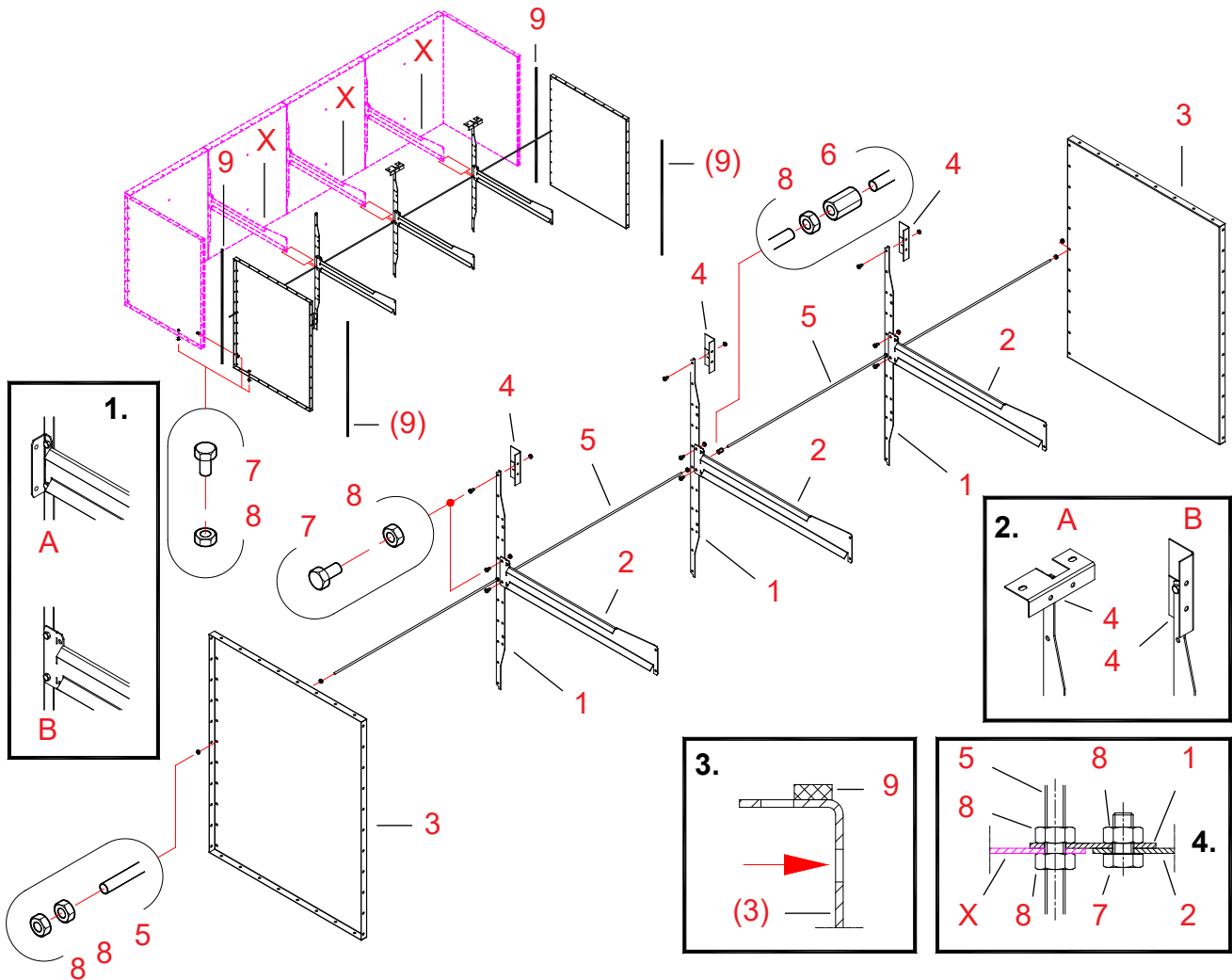
\*                 **Check the joints and rectangular shape of the air channel end. Tighten all bolts.**



## Air channel end 1,0 3W (A70976) - intermediate part

### Spare parts

### An accessory for air channel end A70980 (centre-part B)



20080901

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A70810	TOP SECTION WM06	VERTICAL SUPPORT PL3	3	A70810-C	2.34	3000
2	A70678	AIR CHANN END WM06 1.0	STRAIGHT SUPPORT	3	A70678-B	1.79	3000
3	A70640	AIR CHANN END WM06 1.0	SIDE-PLATE	2	A70640	14.18	3000
4	A70977	AIR CHANN END WM06	VERT SUPP ATTACHM	3	A70977	0.22	3000
5	119006	THREADED ROD ZN	M 8X2000 MM 8.8	2		0	2000
6	110626	NUT EXTENSION M8x24	ZN DIN6334	1		0	2010
7	101810	HEX BOLT ZN 8.8	8X16 AM DIN933	70		0	2010
8	110540	NUT ZN 8 M 8	DIN934	79		0	2010
9	115570	SEALING STRIP	4X10 MAPA	16.5		0	2600





## Assembling air channel end A70976

### 1. Assembling threaded rod/support set-up

Parts The numbering of work stages refers to reference numbers in the spare parts drawing A70976 for the air channel end.

*Assemble the air channel end on a level plane to ensure it is straight.*

**!!!** *Note the way, the straight support (part X) is attached to the vertical support at the air channel end A70980 (see detail dwg. 1).*

Alternative A, if air channel end A70976 is used - (otherwise alternative B).

Alternative A: fold the straight support along the bending line.

- 8 Turn one M8 nut to the centre-point of both threaded rods (parts 5).
- 1 Place a vertical support against both nuts turned on the threaded rod.
- 5 Insert the threaded rods with their vertical supports in the lower holes in the straight supports (parts X) for the air channel end A70980.
- 8 Turn two more M8 nuts on the threaded rods against the parts X.
- 6, 8 Join up the threaded rods to one single rod using the extension nut and an ordinary nut.  
Tighten the nuts at the joint against one another.
- \* Adjust the distances between the vertical supports and the straight supports and tighten the nuts lightly.
- 4 Fix the brackets for the vertical support to the vertical supports (parts 1) (detail dwg. 2).  
If you fix the bracket to the shutter-plate for the air channel end (detail A), bend it first to an angle of 90 degrees.  
If you fix the bracket to the straight support for the upper air channel end, leave it straight (detail B).
- 7, 8 Fix the support using bolt and nuts (M 8 x 16).

### 2. Fixing the side-plates of the air channel end to the air channel end A70980

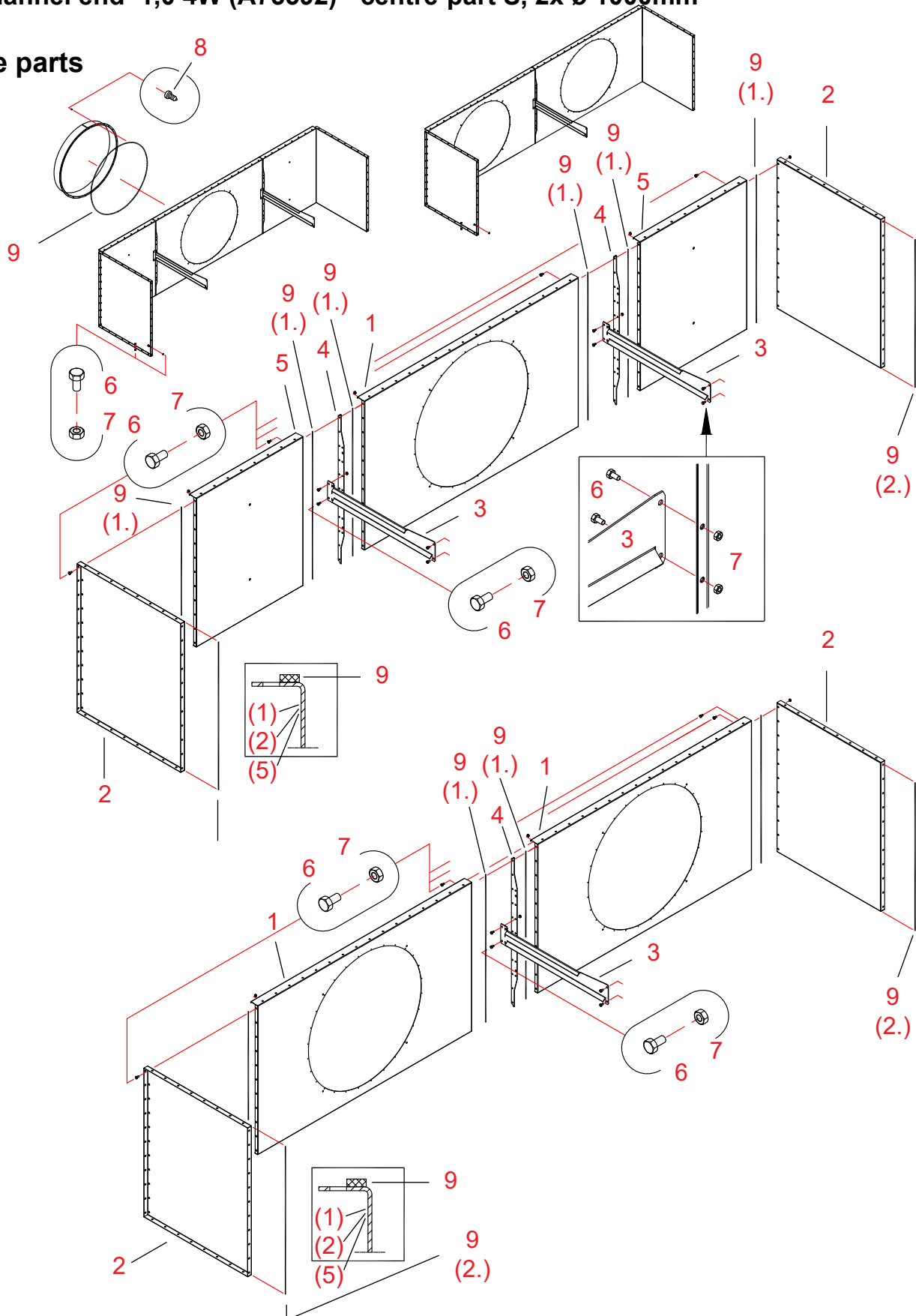
- 9 Fix sealing strips to one of the vertical flanges of both side-plates (parts 3).  
Fix the sealing strips inside the screw hole rows in the flanges.  
Detail drawing 3, observe the hole row indicated by the arrow.
- 8 Turn a M8 nut on both ends of the threaded rod, to a distance of about 40 mm from end of the rod.
- 3 Install the side-plates in the threaded rod set-up against the flanges of the air channel end A70980.  
Insert the ends of the threaded rod in the centre hole of both side-plates.  
As required, align the side-plates using the nuts on the threaded rod.  
**Be careful not to damage the sealing strips while installing the side-plates.**
- 8 Fix the side-plates to the threaded rod using M8 nuts.  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 7, 8 Fix the side-plates using bolts and nuts (M8 x 16, 11 pcs. /side-plate).  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 2 Install the straight supports for the air channel end in the vertical supports (parts 1).  
Look up correct position for the supports in the drawing and in the detail drawing 1, alt. B.
- 7, 8 Fix the supports using bolts and nuts (M8 x 16, 2 pcs./support).  
Installing the straight supports, threaded rod and nuts (detail drawing 4).
- \* Check the joints of the air channel end, its rectangular shape and alignment of the side-plates.
- \* Install the ready-assembled air channel end set-up inside the section according to instructions for the air channel end A70980.  
Tighten all bolts and nuts.



Air channel end 1,0 4W (A71210) - centre-part S, Ø 1000 mm

Air channel end 1,0 4W (A75592) - centre-part S, 2x Ø 1000mm

### Spare parts





Ref.	Part no.	Denomination	A71210	A75592	Drawing No.	Weight	Group
			Pcs.	Pcs.			
1	A71207	AIR CHANN END WM06 END D1000 SCREW ATT	1	2	A71207	19,3	3000
2	A70640	AIR CHANN END WM06 1.0 SIDE-PLATE	2	2	A70640	14,2	3000
3	A70678	AIR CHANN END WM06 1.0 STRAIGHT SUPPORT	2	1	A70678	3,1	3000
4	A70810	TOP SECTION WM06 VERTICAL SUPPORT PL3	2	1	A70810	2,3	3000
5	A70563	TOP SECTION/AIR CH END WM06 END-PLATE	2	-	A70563	14,7	3000
6	101810	HEX BOLT ZN 8.8 AM DIN933	122	109			2010
7	110540	NUT M8 ZN 8 DIN934	122	109			2010
8	107720	SELF-TAP HEX SCREW 4,8X13 ZN	28	59			2010
9	115570	SEALING STRIP 4X8 EKO-40	31	30			2600

## Assembling air channel end A71210 and A75592

Parts The numbering of work stages refers to reference numbers in the spare parts drawing A71210 and A75592 for the air channel end.

***Assemble the air channel end on a level plane to ensure it is straight.***

- 9 (1.) Fix sealing strips to the end-flanges of the end-plates (parts 1 and 5).**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).
- 4 Place the vertical supports between the end-plates.**  
***Be careful not to damage the sealing strips while installing the vertical support.***
- 6, 7 Fix the end-plates and the vertical supports using bolts and nuts (M8 x 16, 11 + 11 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 3 Install the straight supports for the air channel end in the vertical supports (parts 4).**  
Look up correct position for the supports in the drawing.
- 6, 7 Fix the supports using bolts and nuts (M8 x 16, 2 pcs./support).**
- 9 (2.) Fix sealing strips to the attachment flanges of the side-plates (parts 2) to be attached to the drying section.**  
Fix the sealing strips inside the bolthole rows (see detail drawing 1).
- 2 Move the side-plates tight against the ends of the section.**  
***Be careful not to damage the sealing strips while installing the side-plates.***
- 6, 7 Fix the side-plates using bolts and nuts (M8 x 16, 11 pcs. /side-plate).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 5 + 1 + 5 Move the end-plate between the side-plates.**  
***Be careful not to damage the sealing strips while installing the side-plates.***
- 6, 7 Fix the end-plate using bolts and nuts (M8 x 16, 11 + 11 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.

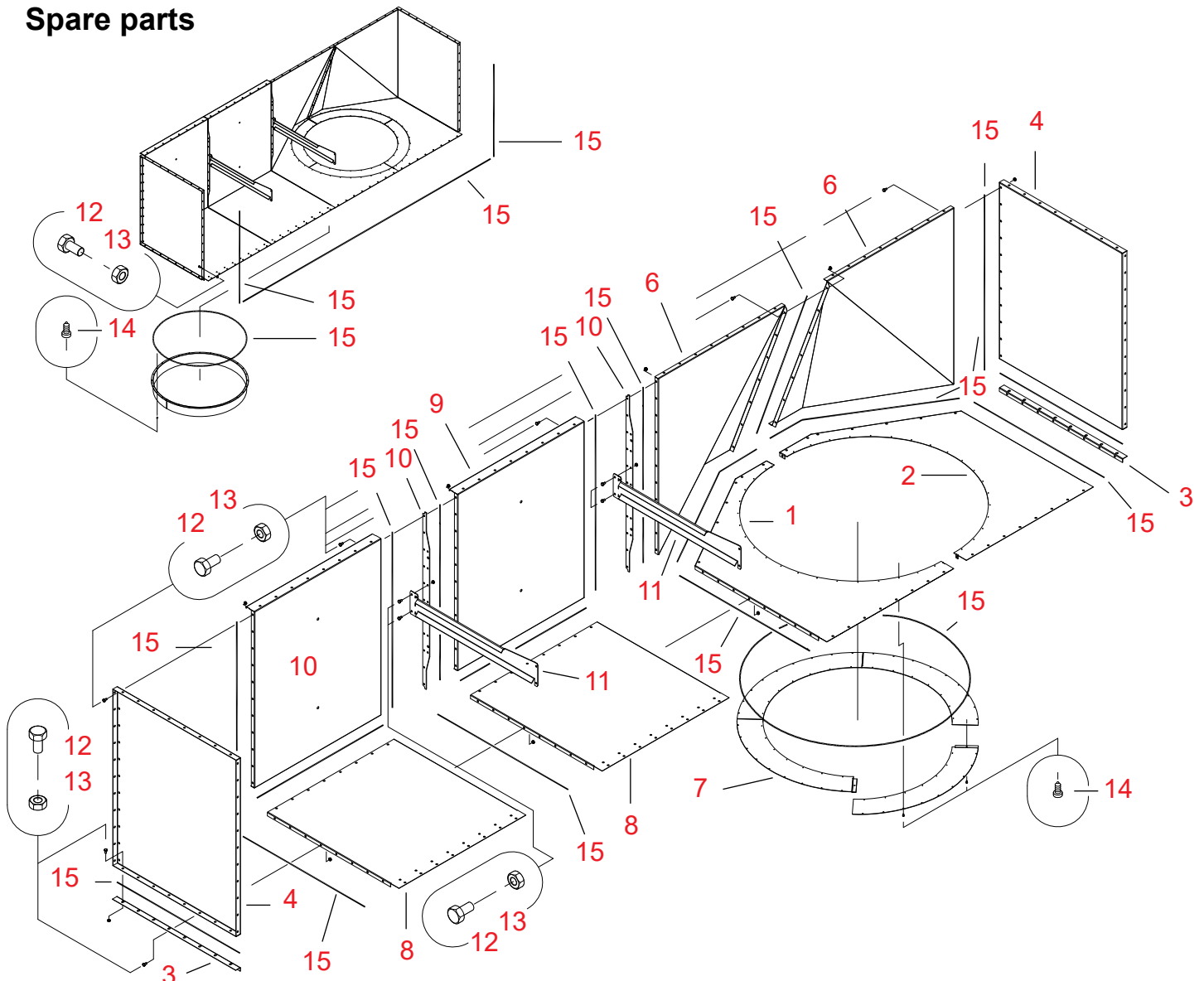
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- \* See point "Installing the air pipe connector in the air channel end".
- 8 Fix the connector to the air channel end using self-tapping screws (4,8 x 13, 28 pcs.).
- 5, 6 Fix the straight support for the air channel end to the section using bolts and nuts (M 8 x 16, 2 pcs.).  
See detail drawing 2. Tighten the bolts only lightly so that you can straighten the air channel end later.
- \* Check the joints and rectangular shape of the air channel end. Tighten all bolts.

## Air channel end 1.0 4W (A71222) - lower part / upper part DGL, Ø 1250 / 1000 mm

### Spare parts





Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	A72964	AIR CH END WM09 1.0 V SHUTTER-PL D1250 R	1	A72964	7,12	3000
2	A72963	AIR CH END WM09 1.0 V SHUTTER-PL D1250 L	1	A72963	7,12	3000
3	A70570	AIR CHANNEL END WM06 1.0 CORNER-S	2	A70570	0,94	3000
4	A70640	AIR CHANNEL END WM06 1.0 SIDE-PLATE	2	A70640	14,18	3000
5	A75079	AIR CH END WM06 1.0 V DIAGON D1250 R	1	A75079	15,49	3000
6	A75080	AIR CH END WM06 1.0 V DIAGON D1250 L	1	A75080	15,49	3000
7	A71254	AIR CH END WM06 1/4 CIRCLE D1250/D1000	4	A71254	2,00	3000
8	A70642	AIR CHANNEL END WM06 1.0 SHUTTER-PLATE	2	A70642	11,67	3000
9	A70563	TOP SECTION/AIR CH END END-PLATE	2	A70563	14,6	3050
10	A70810	TOP SECTION WM06 VERTICAL SUPPORT PL3	2	A70810	2,34	3000
11	A70678	AIR CHANNEL END WM06 1.0 SUPP STRAIGHT	2	A70678	1,79	3000
12	101810	BOLT 6K ZN 8.8 8x16 AM DIN933 CE	198			2010
13	110540	NUT M8 ZN 8 DIN934 CE	198			2010
14	107720	SCREW SELF-TAP HEX 4.8X13 ZN	64			2010
15	115570	SEALING STRIP 4X8 EKO-40	45			2600

## Assembling air channel end A71222

*We recommend carrying out assembly of the air channel end on an even plane. This ensures the ready-assembled air channel end is straight.*

### 1. Assembling the end-plate set-up for the air channel end

Parts The numbering of work stages refers to reference numbers in the spare parts drawing A71222 for the air channel end.

See illustration of this stage on next page.

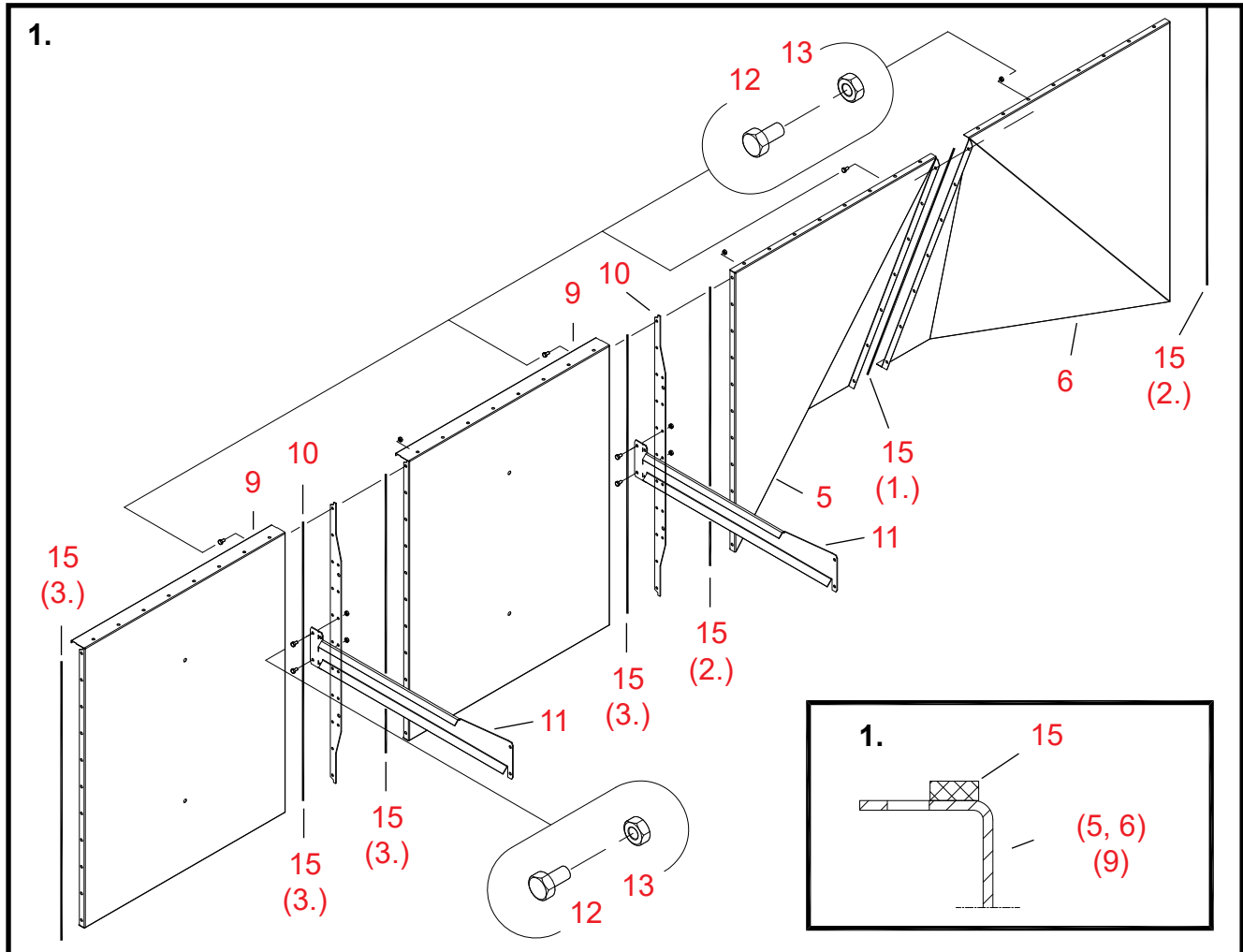
**15 (1.)** Fix a sealing strip on both end-flanges of the right diagonal end (part 5).  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).

**5, 6** Join together the left and right diagonal ends.  
**Be careful not to damage the sealing strips while joining the parts.**

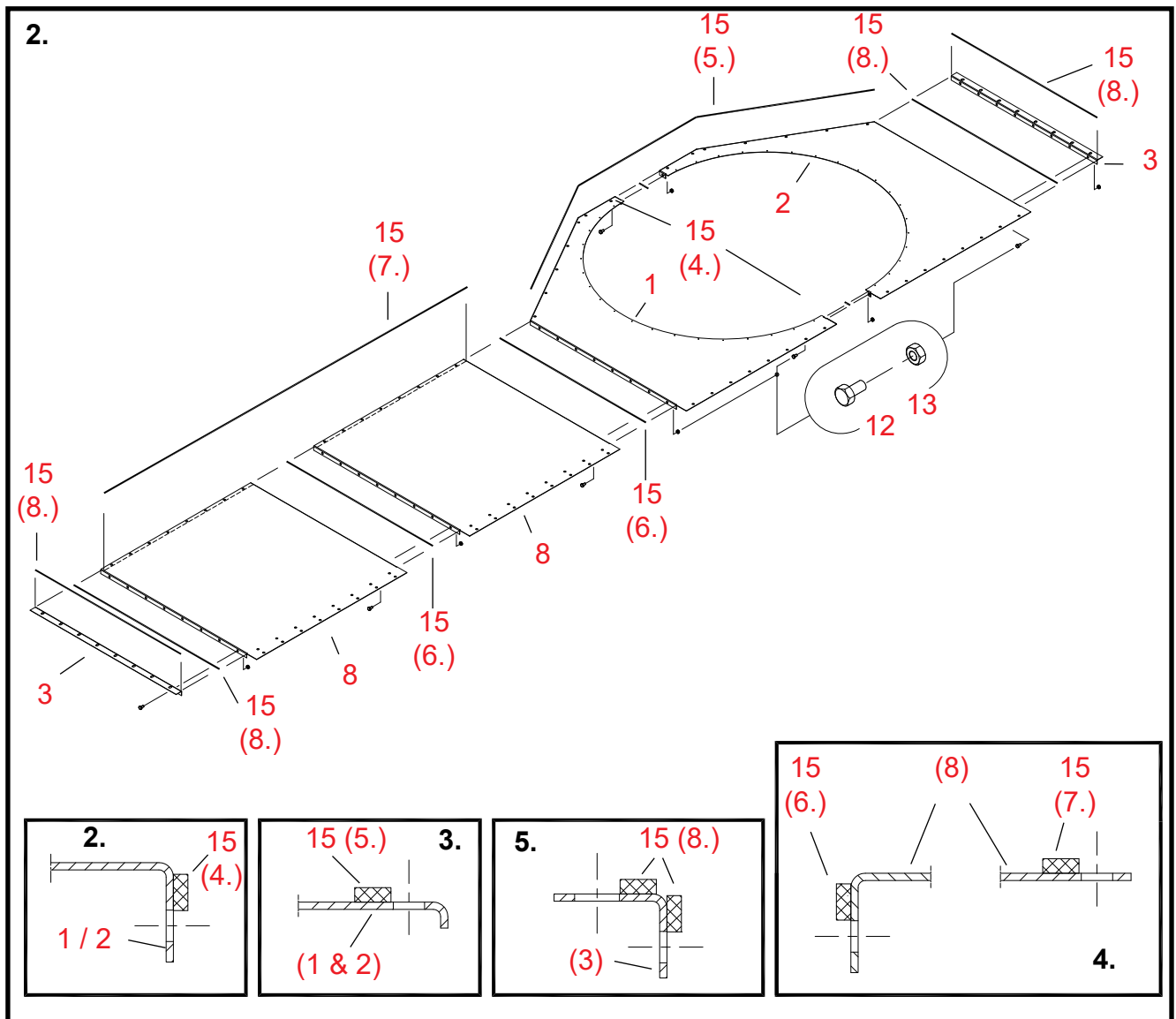
**12, 13** Fix the diagonal end joints (2 pcs.) using bolts and nuts (M8 x 16, 7pcs).  
Tighten the bolts only lightly so that you can straighten the air channel end later.

**15 (2.)** Fix sealing strips to the end-flanges of the end-plate set-up, joined at stage 1.  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).

>>>



- 15 (3.)**     **Fix sealing strips to the end-flanges of the end-plate (parts 9).**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).
- 10**            **Place vertical supports between the diagonal end and the end-plates.**  
*Be careful not to damage the sealing strips while installing the vertical support.*
- 12, 13**        **Fix the diagonal end, the end-plates and the vertical supports using bolts and nuts (M8 x 16, 11 + 11pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 11**            **Install the straight supports for the air channel end in the vertical supports (parts 11).**
- 12, 13**        **Fix the supports using bolts and nuts (M8 x 16, 2 pcs./support).**



## 2. Assembling the shutter-plate set-up for the air channel end

- 15 (4.)     **Fix sealing strips to the centre-plate flanges of one of the shutter-plate-halves with opening (part 1 or 2).**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 2).
- 1, 2         **Join together the shutter-plate halves.**
- 12, 13      **Fix the joints (2 pcs.) of the shutter-plates using bolt and nut (M 8 x 16, 1 + 1 pcs.).**

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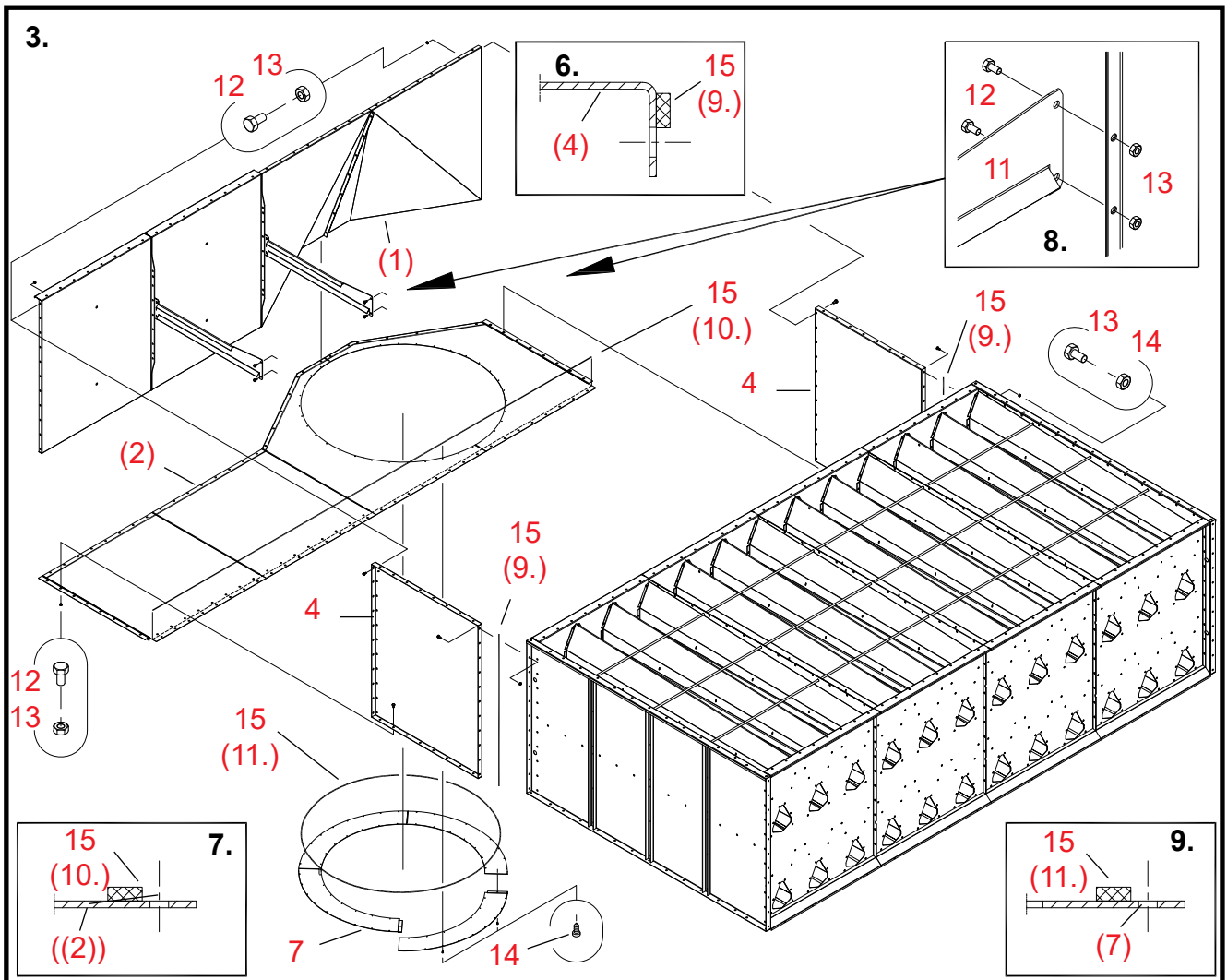
- 15 (5.) **Fix sealing strips on the upper surface of the shutter-plate at the side-parts of the diagonal end.**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 3).
- 15 (6.) **Fix a sealing strip to the other end-flange of both shutter-plates (part 8).**  
Fix the sealing strips inside the bolthole rows. (see detail drawing 4).
- 8 + 8 **Install the shutter-plates (parts 8) with their centre-flanges face to face.**
- 12, 13 **Fix the plates using bolts and nuts (M8 x 16, 8 pcs).**
- 15 (7.) **Fix a sealing strip to the upper surface of the shutter-plates (part 8).**  
Fix the sealing strips inside the bolthole rows. (see detail drawing 4).
- 8 + 8 **Place the shutter-plate pair (2 pcs. of part 8) against the end-flange of the large shutter-plate (parts 1 and 2).**
- 12, 13 **Fix the plate using bolts and nuts (M8 x 16, 8 pcs.).**
- 15 (8.) **Fix sealing strips to the flanges of the corner-strips (parts 3).**  
Fix the sealing strips inside the bolthole rows (see detail drawing 5).
- 3 **Attach corner-strips to the end-flanges of the shutter-plate.**
- 12, 13 **Fix the corner-strips (2 pcs.) using bolts and nuts (M8 x 16, 8 + 8 pcs.).**

### 3. Assembling the air channel end

- 15 (9.) **Fix sealing strips to the attachment flanges of the side-plates (parts 4) to be attached to the drying section.**  
Fix the sealing strips inside the bolthole rows (see detail drawing 6).
- 4 **Move the side-plates tight against the end of the section.**  
*Be careful not to damage the sealing strips while installing the side-plates.*
- 12, 13 **Fix the side-plates to the section using bolts and nuts (M8 x 16, 11 pcs. /side-plate).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 15 (10.) **Fix a sealing strip to the long edge of the set-up, assembled at stage 2.**  
Fix the sealing strips inside the screw hole row (see detail drawing 7).
- (2) **Move the set-up, assembled at stage 2, under the edge of the section.**  
**Align the holes in the screw hole row with the holes in the section.**  
*Be careful not to damage the sealing strips while moving the set-ups.*
- 12, 13 **Fix the part to the section and to the side-plates using bolts and nuts (M8 x 16, 32 + 8 + 8 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- (1) **Move the set-up, assembled at stage 1 on top of the set-up assembled at stage 2, between the side-plates.**  
*Be careful not to damage the sealing strips while moving the set-ups.*
- 12, 13 **Fix the set-up, assembled at stage 1, using bolts and nuts (M8 x 16, 30 + 11 + 11 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 12, 13 **Fix the straight support for the air channel end (part 11) to the section using bolts and nuts (M 8 x 16, 2 pcs.).**  
See detail drawing 8. Tighten the bolts only lightly so that you can straighten the air channel end later.

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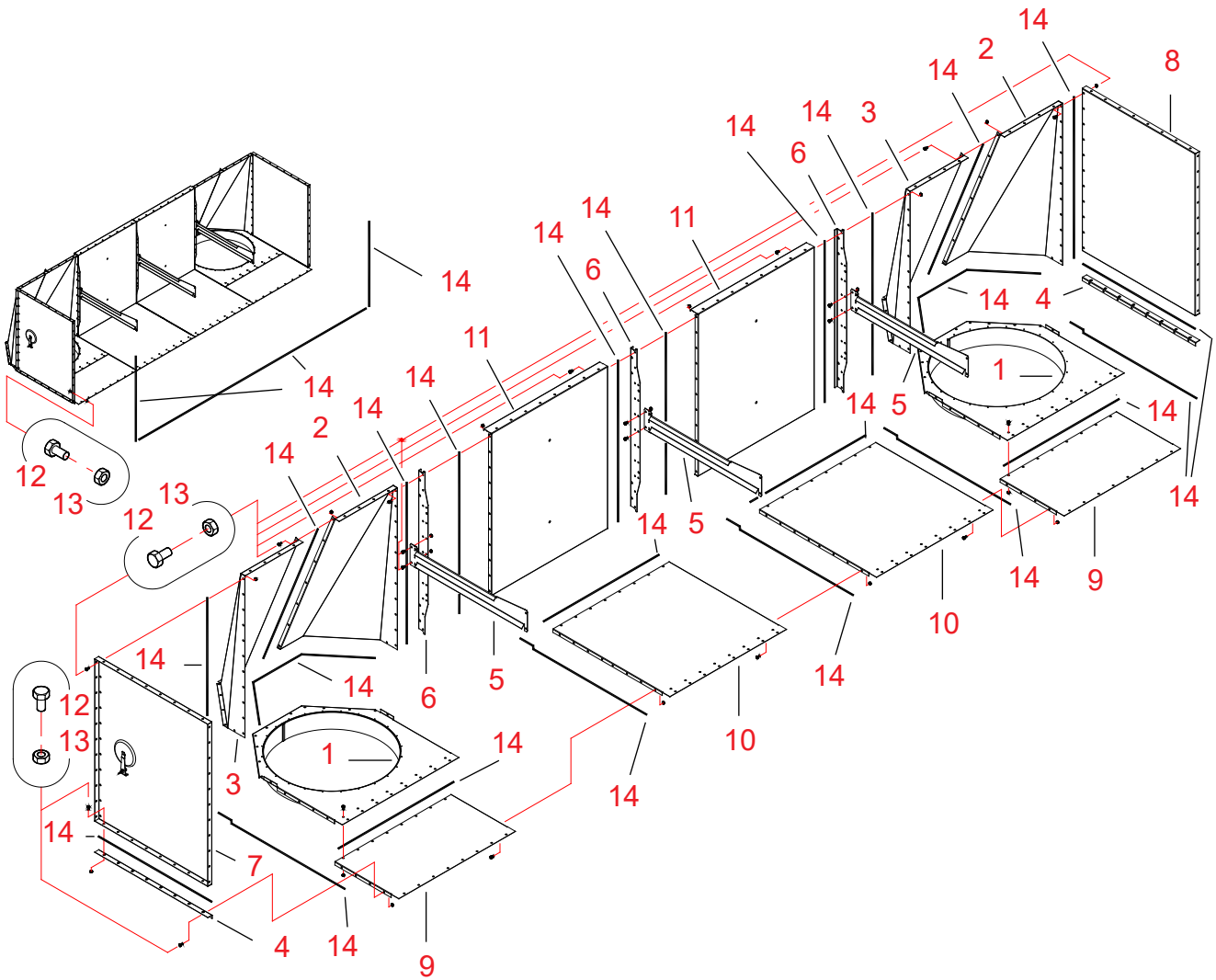
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- \* With pipes, which are 1000 mm or less in diameter, use in the shutter-plate a reducer assembled of four sectors (parts 7).
- 7 Join up the sectors in such a manner that they form a round reduction circle.
- 14 Fix the sectors using self-tapping screws (4,8 x 13, 4 pcs.).
- 15 (11.) Fix the sealing strip so that it forms a circle on the upper surface of the reduction circle. Fix the sealing strips inside the bolthole rows (see detail drawing 9).
- 14 Fix the reduction circle to the air channel end using self-tapping screws (4,8x13, 40 pcs.).
- \* See point "Installing the air pipe connector in the air channel end".  
Pipe sleeve Ø 1000 mm, conversion part 1000/800 mm or 1000/630 mm.
- 14 Fix the connector to the air channel end using self-tapping screws (4,8 x 13, 28 pcs.).
- \* Check the joints and rectangular shape of the air channel end. Tighten all bolts.



Air channel end 1.0 4W (A73409) - lower part / upper part DGL, 2 x Ø 800 mm

## Spare parts





20101101

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	A70630	AIR CH END DGL SINGLE 0.5 D 800 WM06	2	A70630	8.94	3000
2	A70609	AIR CH END SINGLE LEFT 0.5 V D 800 WM06	2	A70609	9.75	3000
3	A70610	AIR CH END SINGLE RIGHT 0.5 V D 800 WM06	2	A70610	9.75	3000
4	A70570	AIR CHANNEL END CORNER-S 1.0 WM06	2	A70570	0.61	3000
5	A70678	AIR CHANNEL END SUPP STRAIGHT 1.0 WM06	3	A70678	3.10	3000
6	A70810	TOP SECTION VERTICAL SUPPORT PL 3 WM06	3	A70810	2.34	3000
7	A71400	AIR CHANNEL END SIDE-PLATE CLEAN HTCH WM06 1.0	1	A71400	14.56	3000
8	A70640	AIR CHANNEL END SIDE-PLATE 1.0 WM06	1	A70640	14.18	3000
9	A70636	AIR CHANNEL END SHUTTER-PL 0.5 WM06	2	A70636	6.14	3000
10	A70642	AIR CHANNEL END SHUTTER-PL 1.0 WM06	2	A70642	11.46	3000
11	A70563	TOP SECTION/AIR CH END END-PLATE WM06	2	A70563	14.65	3000
12	101810	BOLT 6K ZN – 8x16 AM DIN933	300		0.00	2010
13	110540	NUT M8 ZN 8 DIN934	300		0.00	2010
14	115570	SEALING STRIP 4x8 EKO-40	48		0.00	2600

## Assembling air channel end A73409

*We recommend carrying out assembly of the air channel end on an even plane. This ensures the ready-assembled air channel end is straight.*

### 1. Assembling the end-plate set-up for the air channel end

Parts The numbering of work stages refers to reference numbers in the spare parts drawing A73409 for the air channel end.

**14 (1.)** Fix sealing strips to the centre-flange of the diagonal end's (part 3) left halves.  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).

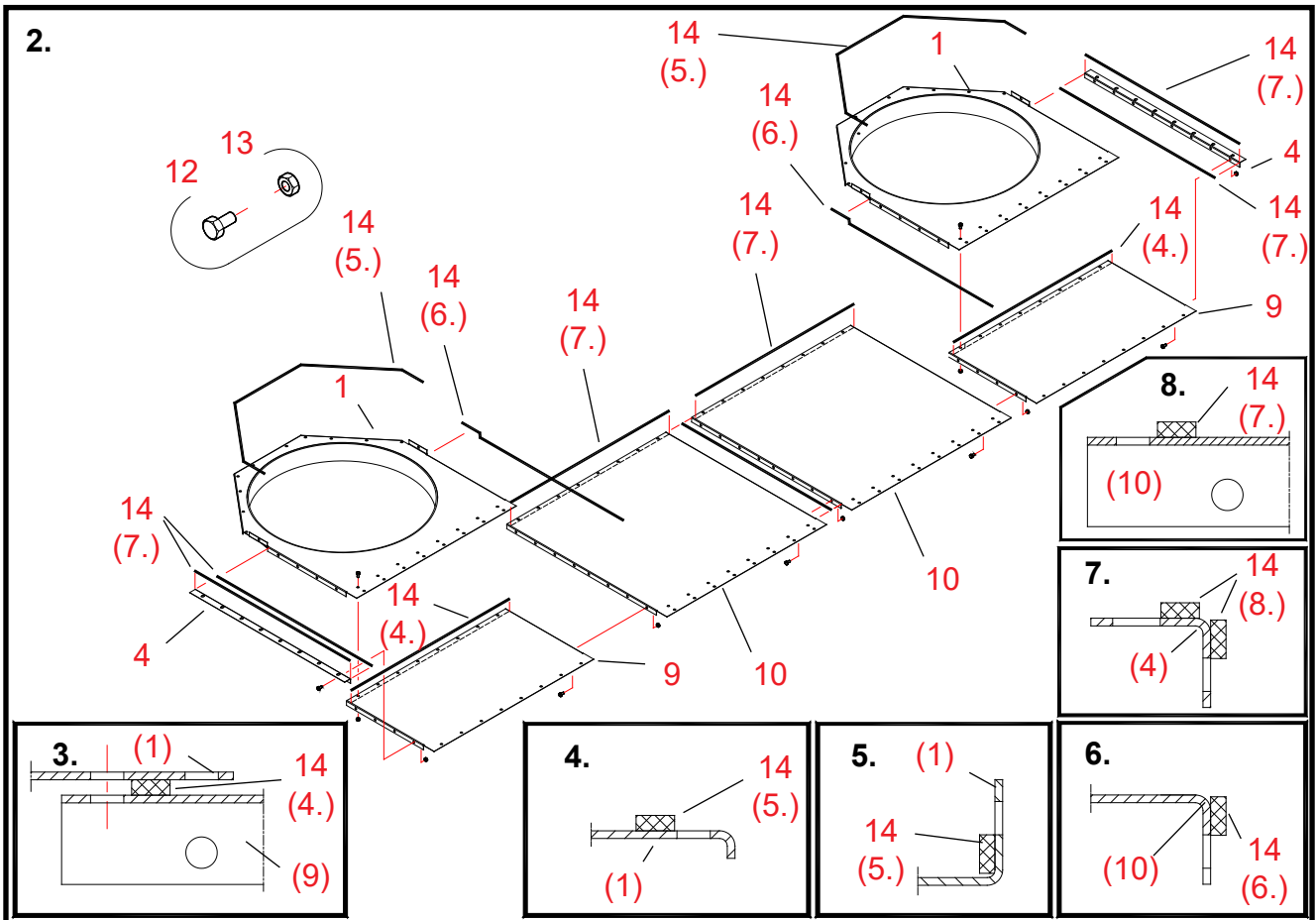
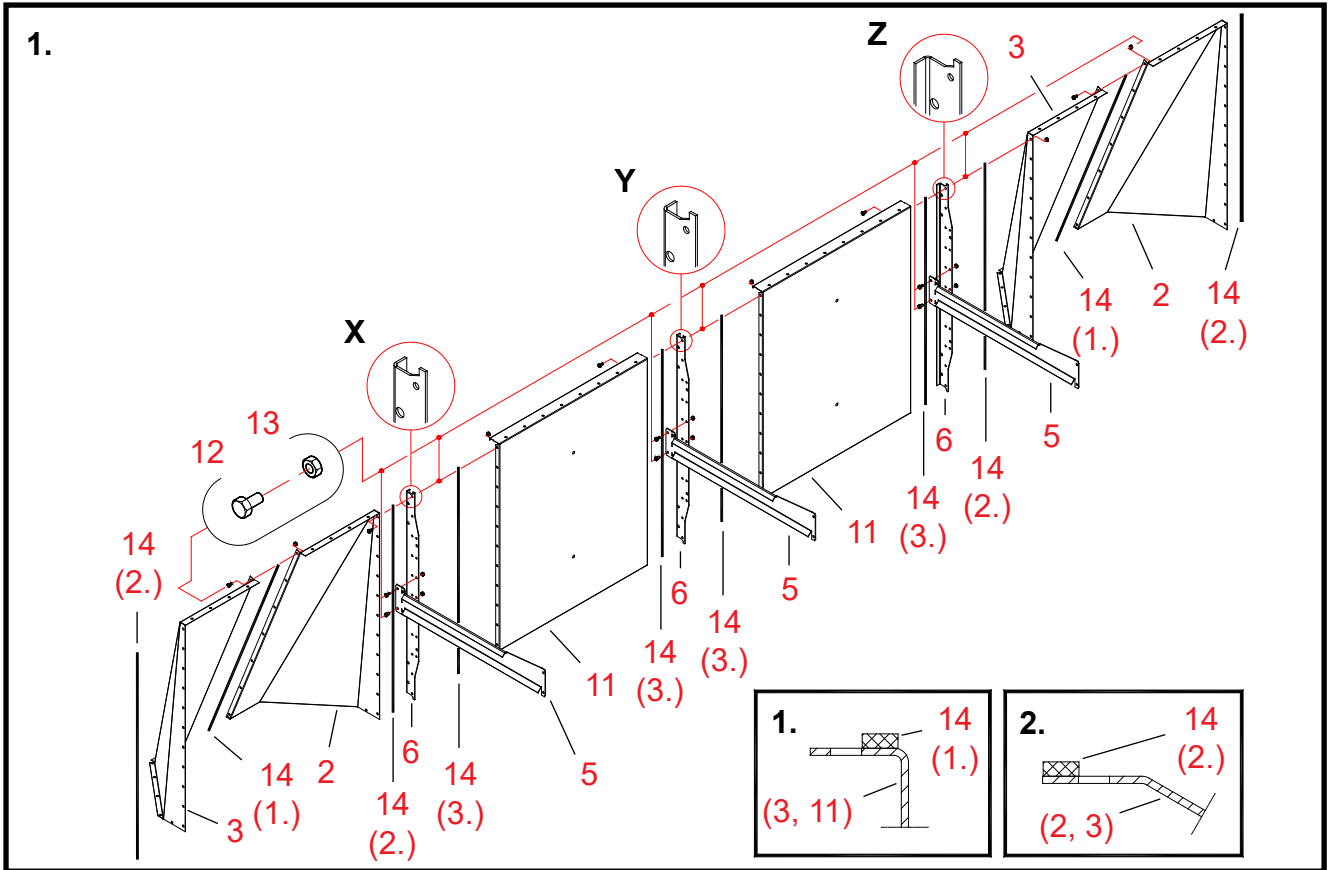
**2, 3** Assemble two similar diagonal end set-ups (of parts 2 and 3).  
*Be careful not to damage the sealing strips while joining the parts.*

**12, 13** Fix the centre-joints of the diagonal end set-ups using bolts and nuts (M8 x 16, 7 + 7 pcs.).  
Tighten the bolts only lightly so that you can straighten the air channel end later.

**14 (2.)** Fix sealing strips to both side-flanges of the diagonal end set-ups (parts 2 + 3).  
Fix the sealing strips outside the bolthole rows in the flanges (see detail drawing 2).

**14 (3.)** Fix sealing strips to the end-flanges of the end-plate (parts 11).  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).

See the next page for the illustration and continuation of the text for this stage >>>





Continued from previous page >>>

- 6**      **Place the vertical supports on both sides of the end-plate, against the diagonal end set-ups.**  
Check the installation direction of the supports in the close-ups X, Y and Z.  
***Be careful not to damage the sealing strips while installing the vertical support.***
- 11**      **Place the end-plates (parts 11) between the diagonal end set-ups (parts 2 + 3).**
- 12, 13**      **Fix the diagonal ends, end-plates and vertical supports using bolts and nuts (M8x16, 11+11+11 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 5**      **Install the straight supports for the air channel end in the vertical supports (parts 6).**  
Look up correct position for the supports in the drawing.
- 12, 13**      **Fix the supports using bolts and nuts (M8 x 16, 2 + 2 + 2 pcs.).**

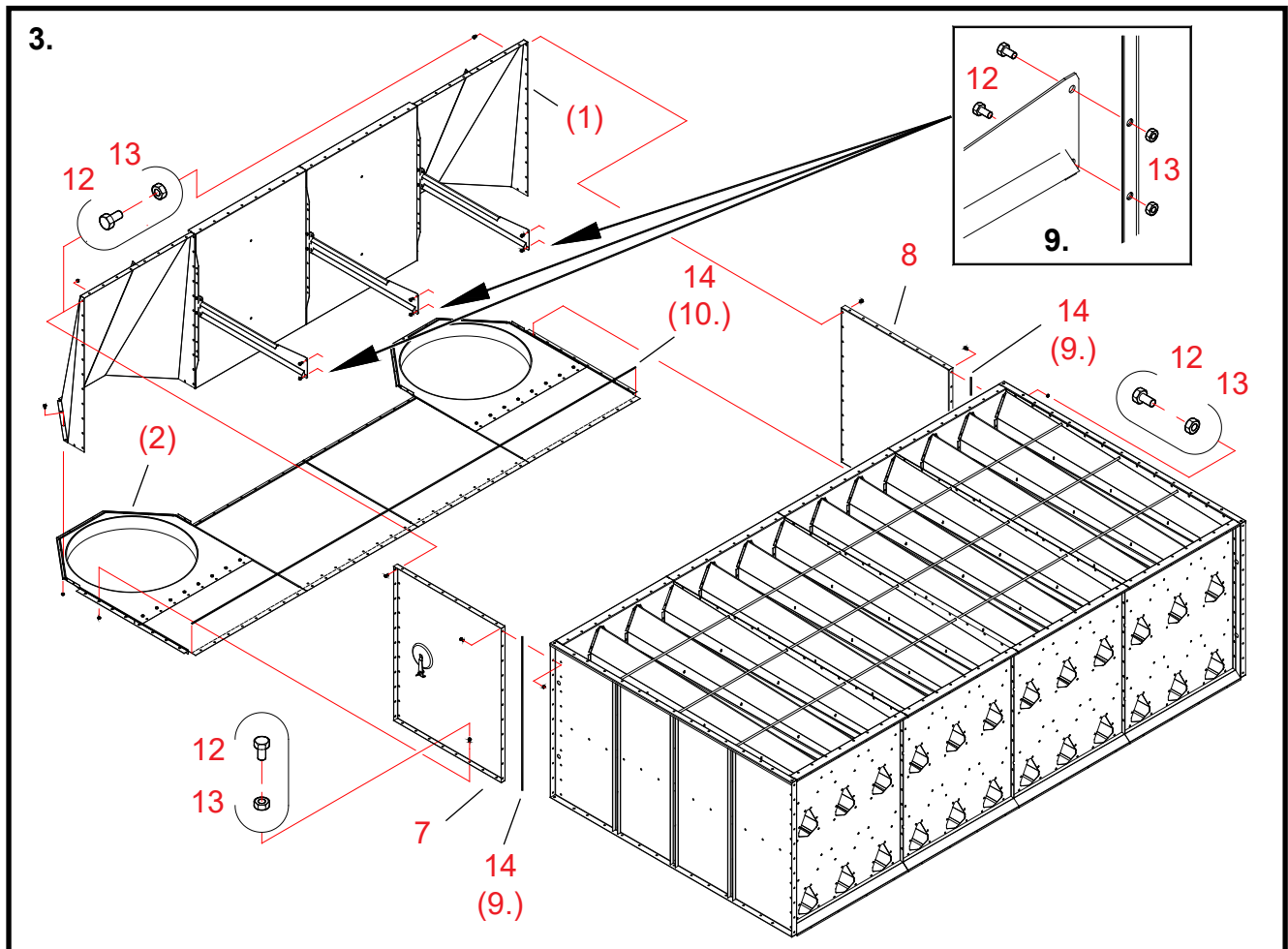
## 2. Assembling the shutter-plate set-up for the air channel end

- 14 (4.)**      **Fix sealing strips to the upper surface of the shutter-plates (part 9) inside the screw hole row.**  
Fix the sealing strips to those ends of the plates, where the flanges extend to the very end of the plate (see detail drawing 3).
- 1, 9**      **Assemble two similar set-ups by joining the shutter-plate 1 and shutter-plate 9 together.**  
Fix the plates 9 under the plates 1. Insert the bolts into the screw holes in the plates 1 that are closer to the centre (see detail drawing 3).
- 12, 13**      **Fix the plates together using bolts and nuts (M8x16, 8+8 pcs.).**
- 14 (5.)**      **Fix sealing strips to the upper surface of the shutter-plates (parts 1) at the diagonal end.**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 4).  
Extend the sealing strips to inside the vertical flanges of the shutter-plate (see detail drawing 5).
- 14 (6.)**      **On both of the shutter-plate set-ups (parts 1 + 9), fix the sealing strip only to one of the side-flanges.**  
Fix the sealing strips to those side-flanges, which come against the centremost plates (parts 10) of the shutter-plates.  
Fix the sealing strip inside the bolthole rows in the flange (see detail drawing 6).
- 14 (7.)**      **Fix a sealing strip to the upper surfaces of the shutter-plates (parts 10) inside the screw hole row.**  
Fix the sealing strips to those ends of the plates, where the flanges extend to the very end of the plate (see detail drawing 8).
- 1 + 9, 10**      **Place the end-flanges of the shutter-plate set-up (parts 1 + 9) and the shutter-plate (parts 10) face to face.**  
Place the shutter-plate (part 10) against the flange with sealing strip of the shutter-plate set-up (parts 1 + 9).
- 12, 13**      **Join the shutter-plates together using bolts and nuts (M8 x 16, 8 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 10**      **Install another shutter-plate (part 10) as an extension for the shutter-plate (part 10) of the previous set-up.**  
Join the shutter-plates together using bolts and nuts (M8 x 16, 8 pcs.).

The text for this stage is continued on next page >>>

Continued from previous page >>>

- 1 + 9     **Fix another shutter-plate set-up (parts 1 + 9) to the shutter-plate (part 10) of the previous set-up.**  
Join the shutter-plates together using bolts and nuts (M8 x 16, 8 pcs.).
- 14 (8.)     **Fix sealing strips to the flanges of the corner-strips (parts 4).**  
Fix the sealing strips inside the bolthole rows (see detail drawing 7).
- 4     **Aim the corner-strips at the end-flanges of the shutter-plate.**
- 12, 13     **Fix the corner-strips (2 pcs.) using bolts and nuts (M8 x 16, 8 + 8 pcs.).**





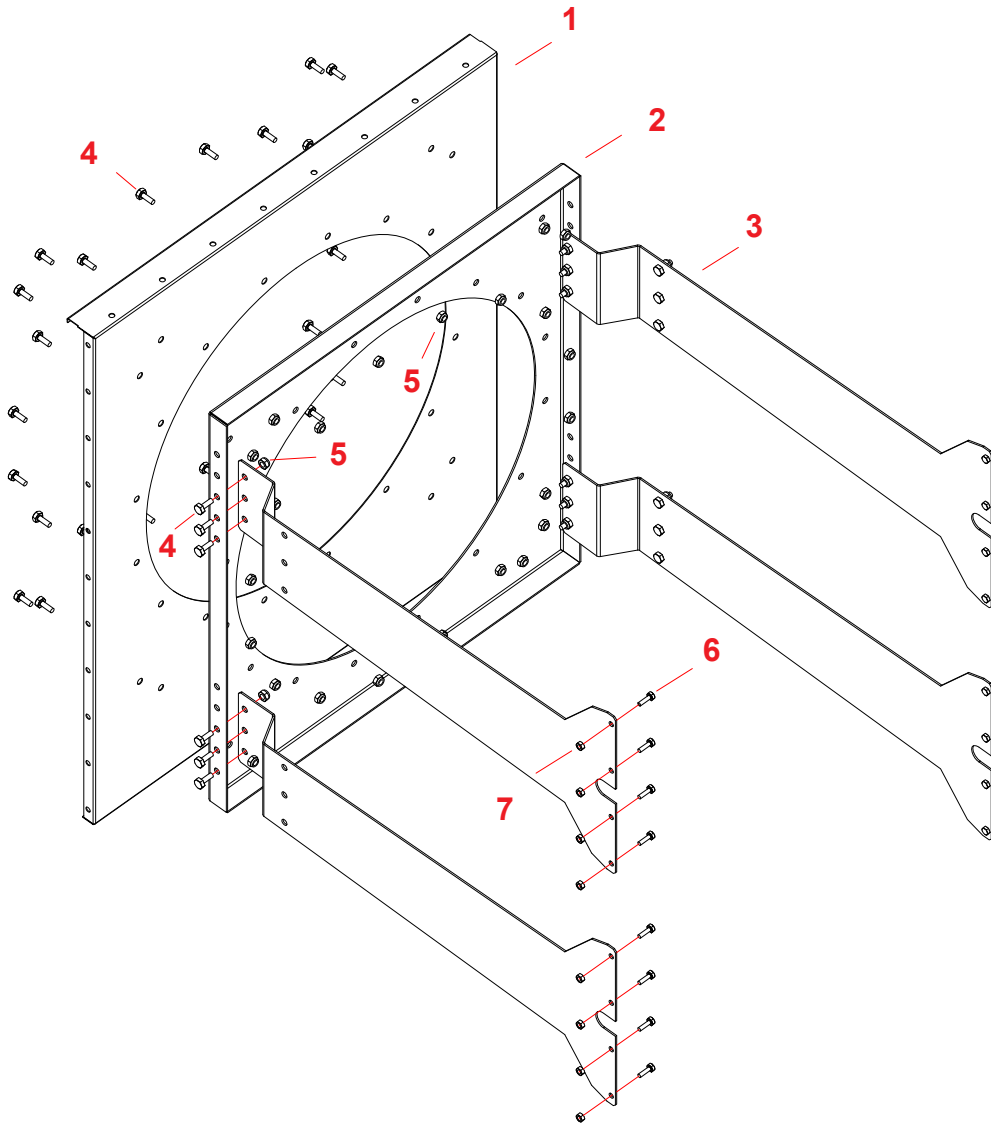
### 3. Assembling the air channel end

- 14 (9.) **Fix sealing strips to the flanges of the side-plates (parts 7 and 8).**  
Fix the sealing strips inside the bolthole rows.
- 7, 8 **Move the side-plates tight against the end of the section.**  
*Be careful not to damage the sealing strips while installing the side-plates.*
- 12, 13 **Fix the side-plates to the section using bolts and nuts (M8 x 16, 11 pcs. /side-plate).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 14 (10.) **Fix a sealing strip to the long edge of the set-up, assembled at stage 2.**  
Fix the sealing strips inside the screw hole row.
- (2) **Move the set-up, assembled at stage 2, under the edge of the section.**  
Align the holes in the screw hole row with the holes in the section.  
*Be careful not to damage the sealing strips while moving the set-ups.*
- 12, 13 **Fix the part to the section and to the side-plates using bolts and nuts (M8 x 16, 32 + 8 + 8 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- (1) **Move the set-up, assembled at stage 1, on top of the set-up, assembled at stage 2, and against the side-plates.**  
*Be careful not to damage the sealing strips while moving the set-ups.*
- 12, 13 **Fix the set-up, assembled at stage 1, by its lower edge using bolts and nuts (M8 x 16, 39 pcs.).**  
12, 13 **Fix the set-up, assembled at stage 1, by its ends using bolts and nuts (M8 x 16, 11 + 11 pcs.).**
- 12, 13 **Fix the straight supports for the air channel end using bolts and nuts (M8x16, 3x2 pcs.).**  
See detail drawing 9. Tighten the bolts only lightly so that you can straighten the air channel end later.
- \* **Check the joints and rectangular shape of the air channel end. Tighten all bolts.**



## Air channel end 1,0 3W (A76264) - fan mounting parts

### Spare parts

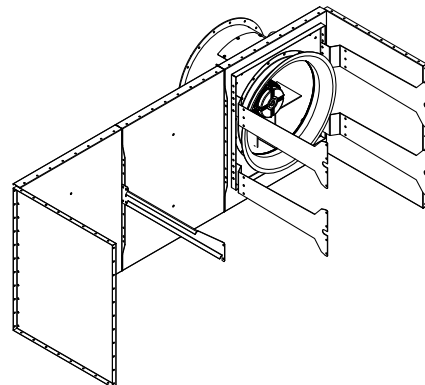
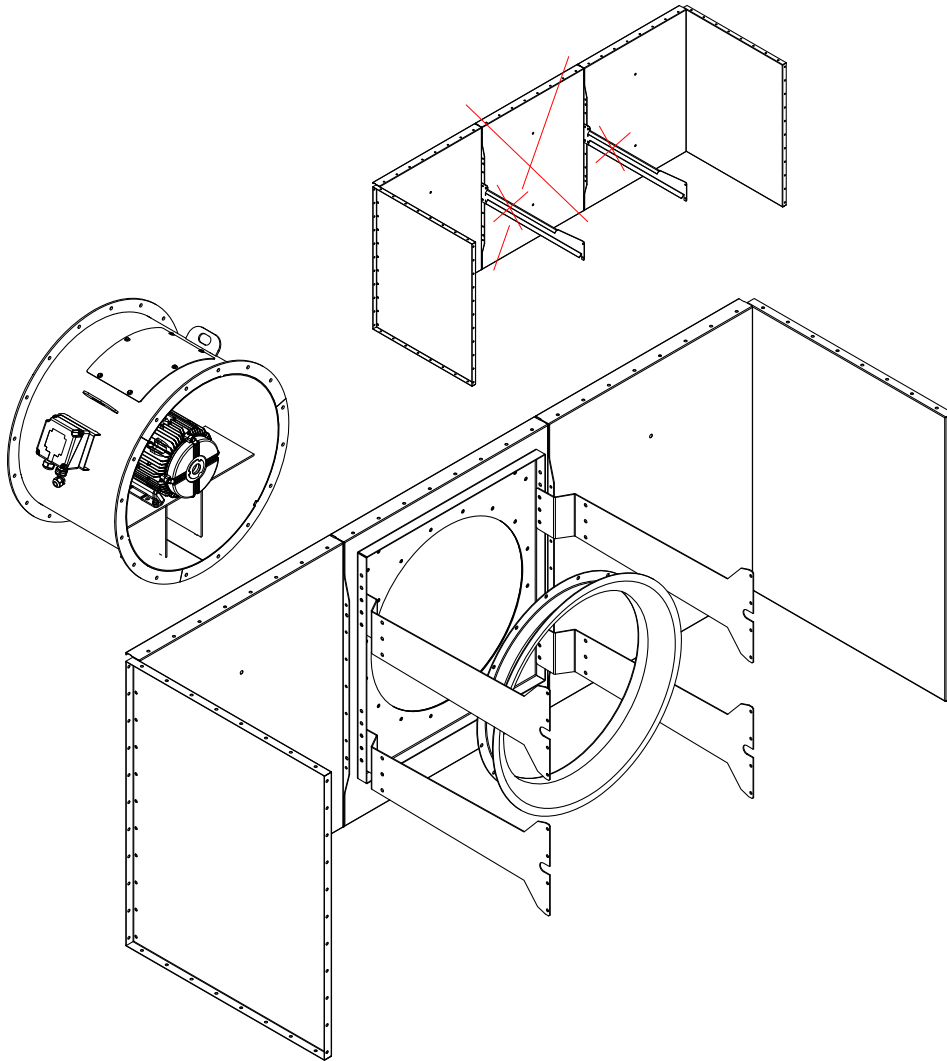


Ref.	Part no	Denomination	Pcs	Drawing No	Weight
1	A76255	AIR CHANN END AXIAL D710 FAN END WM06	1	A76255	9.97
2	A76256	AIR CHANN END AXIAL D710 RESPONSE PLATE WM06	1	A76256	12
3	A76259	AIR CHANN END AXIAL D710 RESPONSE PLATE WM06 1.0	4	A76259	4.51
4	102210	BOLT HEX ZN 8.8 10X25 AM DIN933	42		
5	110800	NUT NYLOC M10 ZN DIN985	42		
6	101830	BOLT HEX ZN 8.8 8X25 AM DIN933	16		
7	110540	NUT M8 ZN 8 DIN934	16		

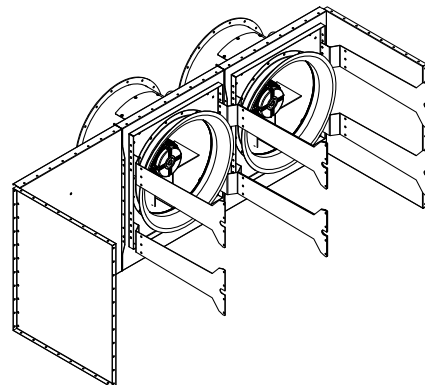




## Installing axial fan mounting parts (A76264)



Installing to the edge.

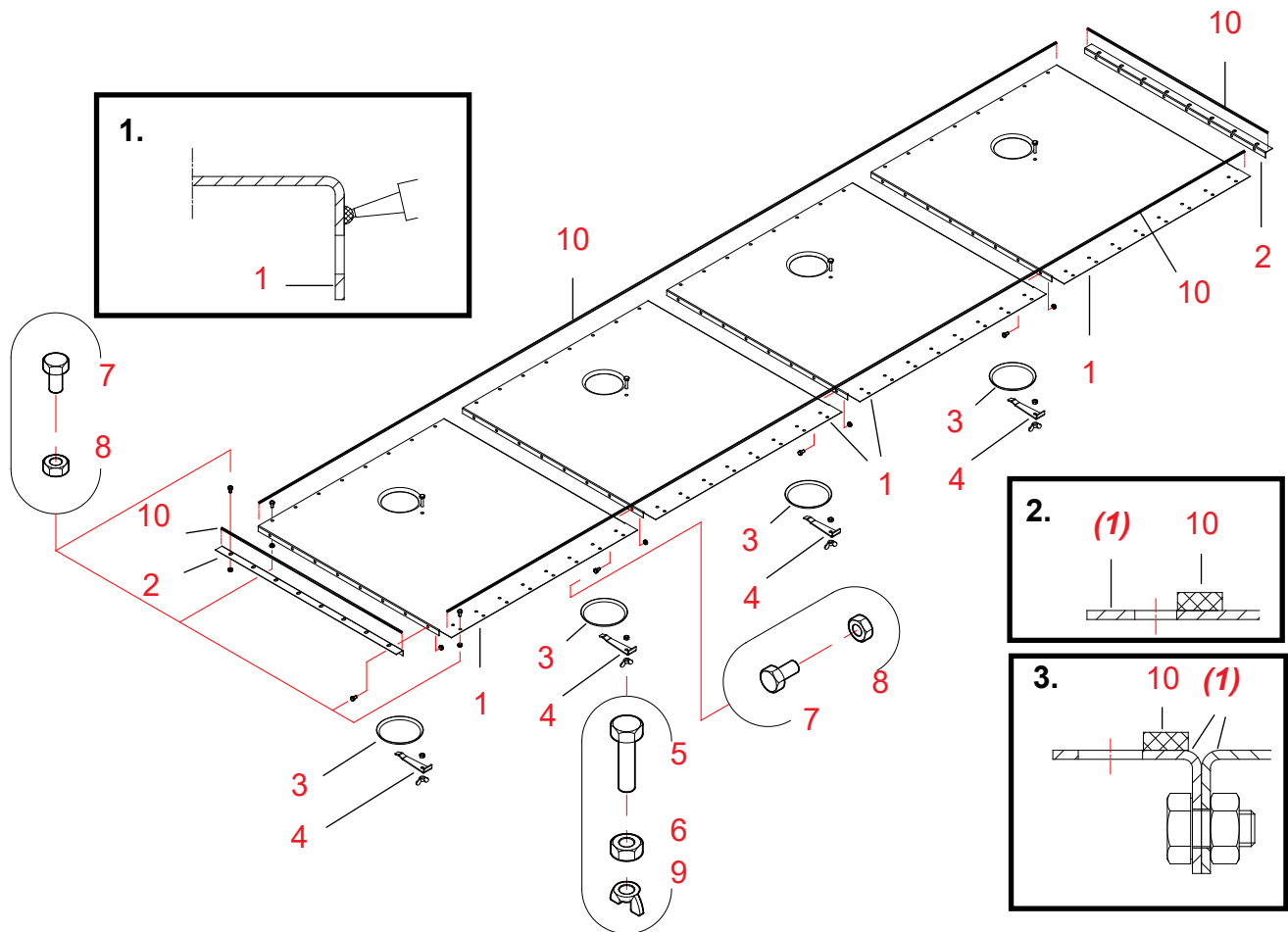


Installing side by side.



## Air channel end 1,0 4W (A70957) - lower shutter B

## Spare parts



20080715

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A70643	AIR CHANN END WM06 1.0	SHUTTER-PL CLEAN HATCH	4	A70643-A	11.53	3000
2	A70570	AIR CHANN END WM06 1.0	CORNER-STRIP	2	A70570-A	0.94	3000
3	400140	SHUTTER D173		4	S4293	0	3500
4	400150	HATCH HOLDER		4	4461-B	0	3500
5	102250	HEX BOLT ZN 8.8	10X40 AM DIN933	4		0	2010
6	110560	NUT ZN 8 M10	DIN934	4		0	2010
7	101810	HEX BOLT ZN 8.8	8X16 AM DIN933	88		0	2010
8	110540	NUT ZN 8 M 8	DIN934	88		0	2010
9	111030	NUT WING ZN M10	DIN315	4		0	2010
10	115570	SEALING STRIP	4X10 MAPA	6		0	2600
11	800271	MASTIC SEALING/GLUE	GREY 310 ML	1			2600

## Installing the lower shutter A70957 for the air channel end

### 1. Joining together the shutter-plates and the corner-strips

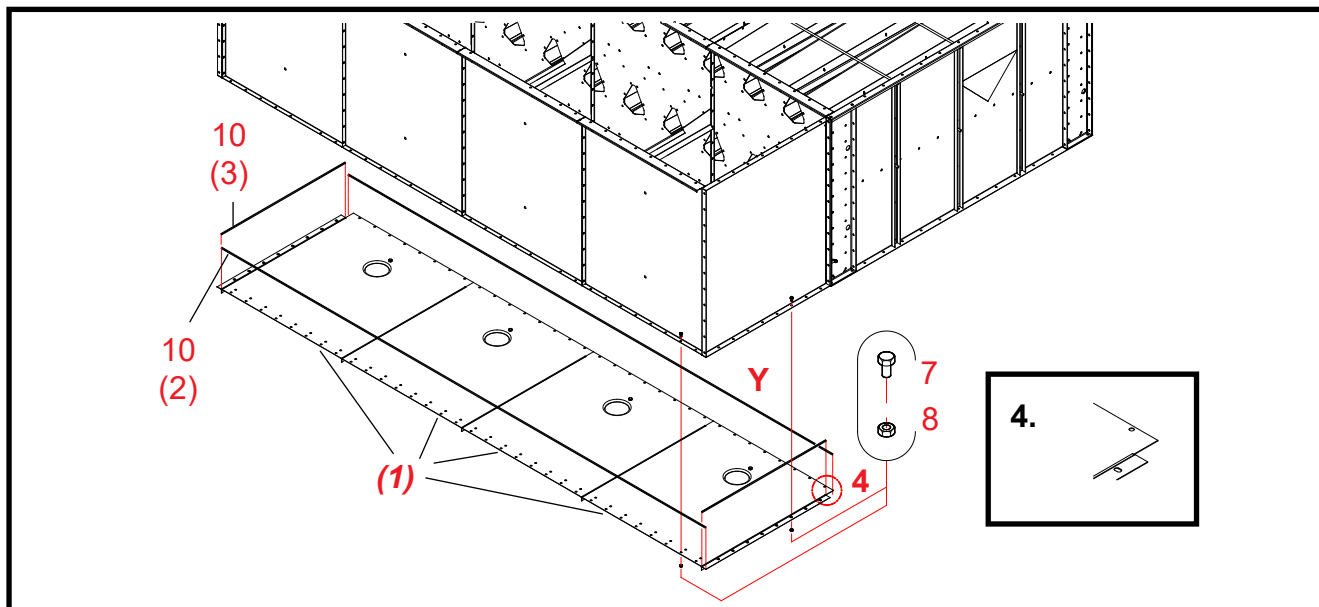
Parts The numbering of work stages refers to reference numbers in the spare parts drawing A70957 for the lower shutter.

- \* **Apply sealing mastic on the outside of both end flanges (parts 1).**  
Apply sealing mastic inside the bolthole rows in the plates (see detail drawing 1).  
Try to keep the mastic strip as even and continuous as possible.
- 7, 8 **Join the shutter-plates together using bolts and nuts (M8 x 16, 8 pcs./joint).**  
*Be careful not to damage the sealing mastic strip while joining the plates.*
- 2 **Fix the corner-strips against the flanges at the outer ends of the shutter-plate set-up.**  
*Be careful not to damage the sealing mastic strip while installing the corner-strips.*
- 7, 8 **Fix them in place using bolts and nuts (M 8 x 16, 8 pcs./corner-strip).**
- 10 **Fix sealing strips to the upper surfaces of the shutter-plate/corner-strip assembly.**  
Fix the sealing strips inside the bolthole rows in the shutter-plates (see detail drawing 2).  
Fix the sealing strips inside the bolthole rows in the corner-strips (see detail drawing 3).

### 2. Fixing the shutter-plate to the lower end of the air channel end

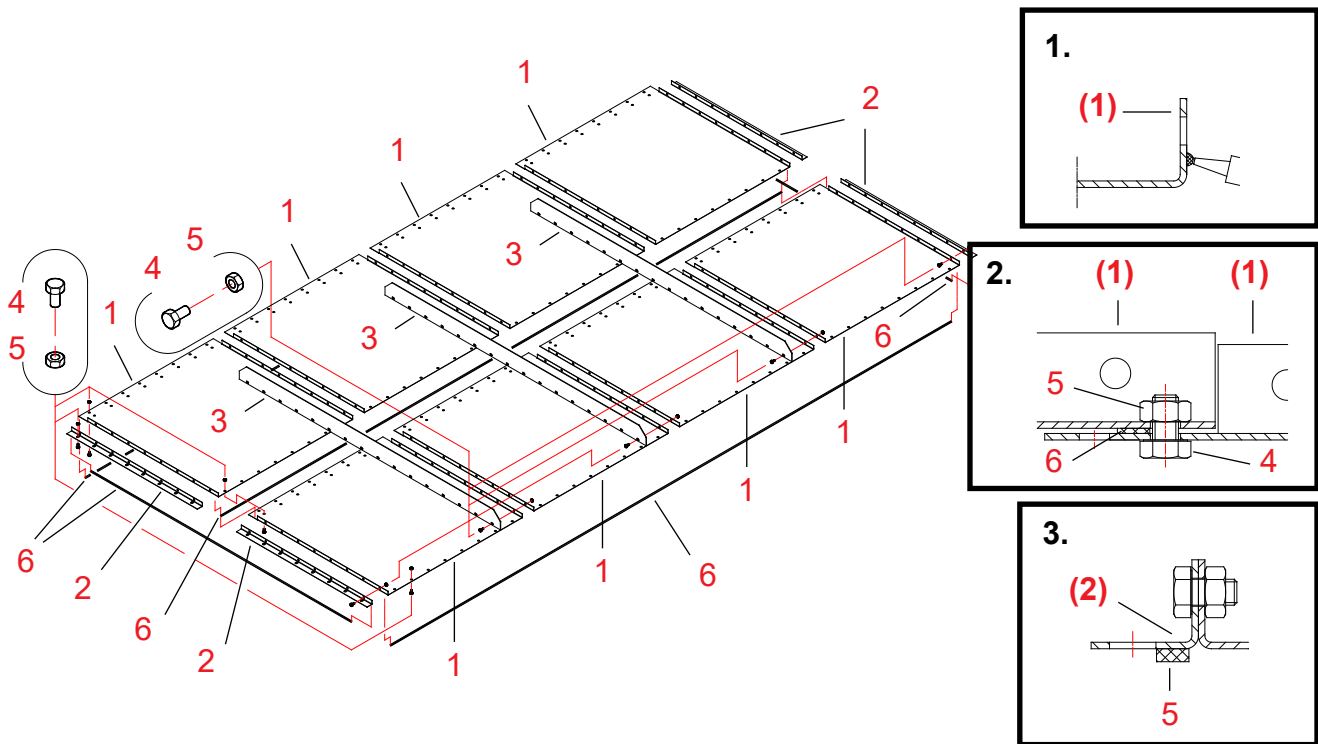
Parts Refer to installation drawing for the lower shutter A70957 of the air channel end.

- (1) **Move the assembly against the flanges at the lower end of the air channel end.**  
*Be careful not to damage the sealing strips while installing the plate.*  
Check correct position for the assembly in detail drawing 4.
- 7, 8 **Fix the shutter-plate using bolts and nuts (M 8 x 16, 80 pcs.).**  
*Note! Do not install the bolts on the other long side (Y) until the dryer is being assembled.*



## Air channel end 1,0 x 2 4W (A70974) - upper shutter B

### Spare parts



20080715

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A70642	AIR CHANN END WM06 1.0	SHUTTER-PLATE	8	A70642	11.67	3000
2	A70570	AIR CHANN END WM06 1.0	CORNER-STRIP	4	A70570-A	0.94	3000
3	A70975	AIR CH END WM06 1.0X2	LONG SUPPORT 1860	3	A70975	4.27	3000
4	101810	HEX BOLT ZN 8.8	8X16 AM DIN933	208		0	2010
5	110540	NUT ZN 8 M 8	DIN934	208		0	2010
6	115570	SEALING STRIP	4X10 MAPA	8		0	2600
7	800271	MASTIC SEALING/GLUE	GREY 310 ML	1			2600

## Installing upper shutter A70974 in the air channel end

### 1. Joining together the shutter-plates and the corner-strips

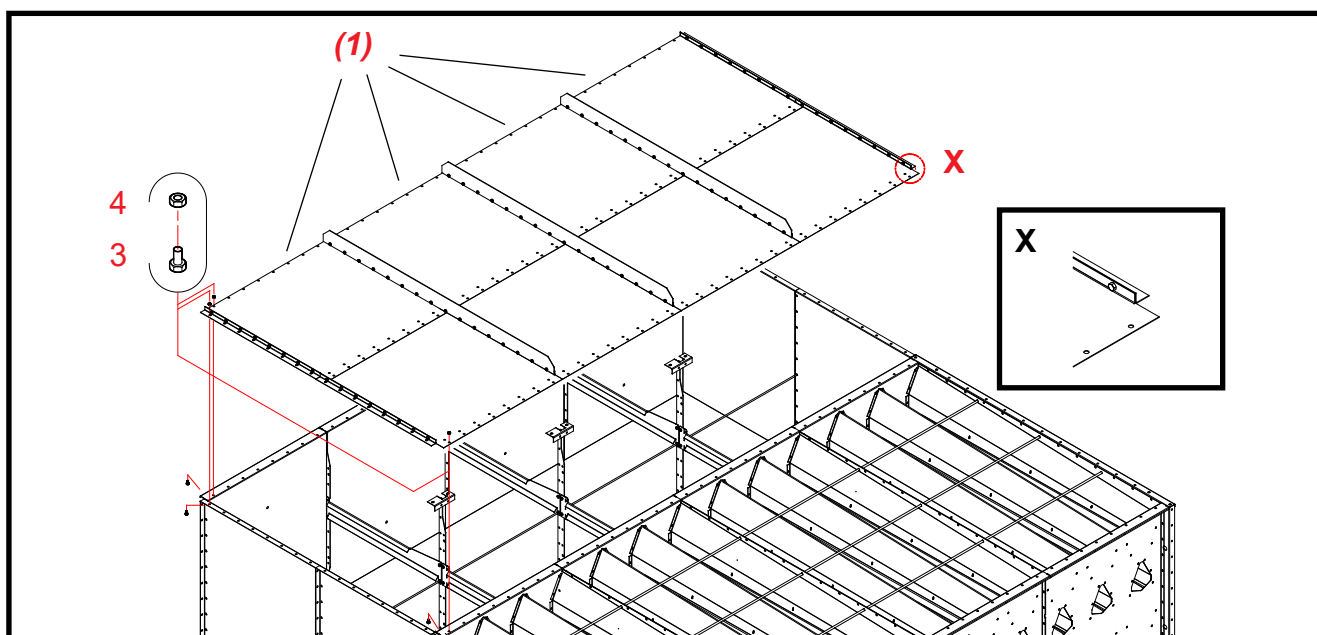
Parts The numbering of work stages refers to reference numbers in the spare parts drawing A70974 for the upper shutter.

- \* **Apply sealing mastic on the outside of both end flanges (parts 1).**  
Apply sealing mastic inside the bolthole rows in the supports (see detail drawing 1).  
Try to keep the mastic strip as even and continuous as possible.

- 4 x 1     **Place four shutter-plates side by side, with their end-flanges face to face.**  
*Be careful not to damage the sealing mastic strip while joining the plates.*
- 4, 5     **Join the plates together using bolts and nuts (M 8 x 16, 8 + 8 + 8 pcs.).**
- 4 x 1, 6     **Assemble one more similar shutter-plate group. Fix a sealing strip to its lower surface.**  
Fix a sealing strip to the straight edge of the plate group with single screw hole row.  
Fix the sealing strip inside the screw hole row (see detail drawing 2).
- \*     **Place the shutter-plate group with sealing on top of the other plate group.**  
*Be careful not to damage the sealing strip while joining the plates.*  
Align the hole row in the upper plate group with the inner hole row in the lower plate group (see detail drawing 2).
- 4, 5     **Fix the plate groups by their straight edges using bolts and nuts (M 8 x 16, 8 + 8 + 8 pcs.).**
- 3, 4, 5     **Fix the long supports and the centre seams of the plate groups using bolts and nuts (M 8 x 16, 3 x 16 pcs.).**
- 2     **Fix the corner-strips against the flanges at the outer ends of the shutter-plate set-up.**  
*Be careful not to damage the sealing mastic strip while installing the corner-strips.*
- 3, 4     **Fix them in place using bolts and nuts (M 8 x 16, 8 pcs./corner-strip).**
- 5     **Fix sealing strips to the lower surfaces of the shutter-plate/corner-strip assembly.**  
Fix the sealing strips inside the bolthole rows in the shutter-plates (see detail drawing 2).  
Fix the sealing strips inside the bolthole rows in the corner-strips (see detail drawing 3).

## 2. Fixing the shutter-plate to the upper end of the air channel end

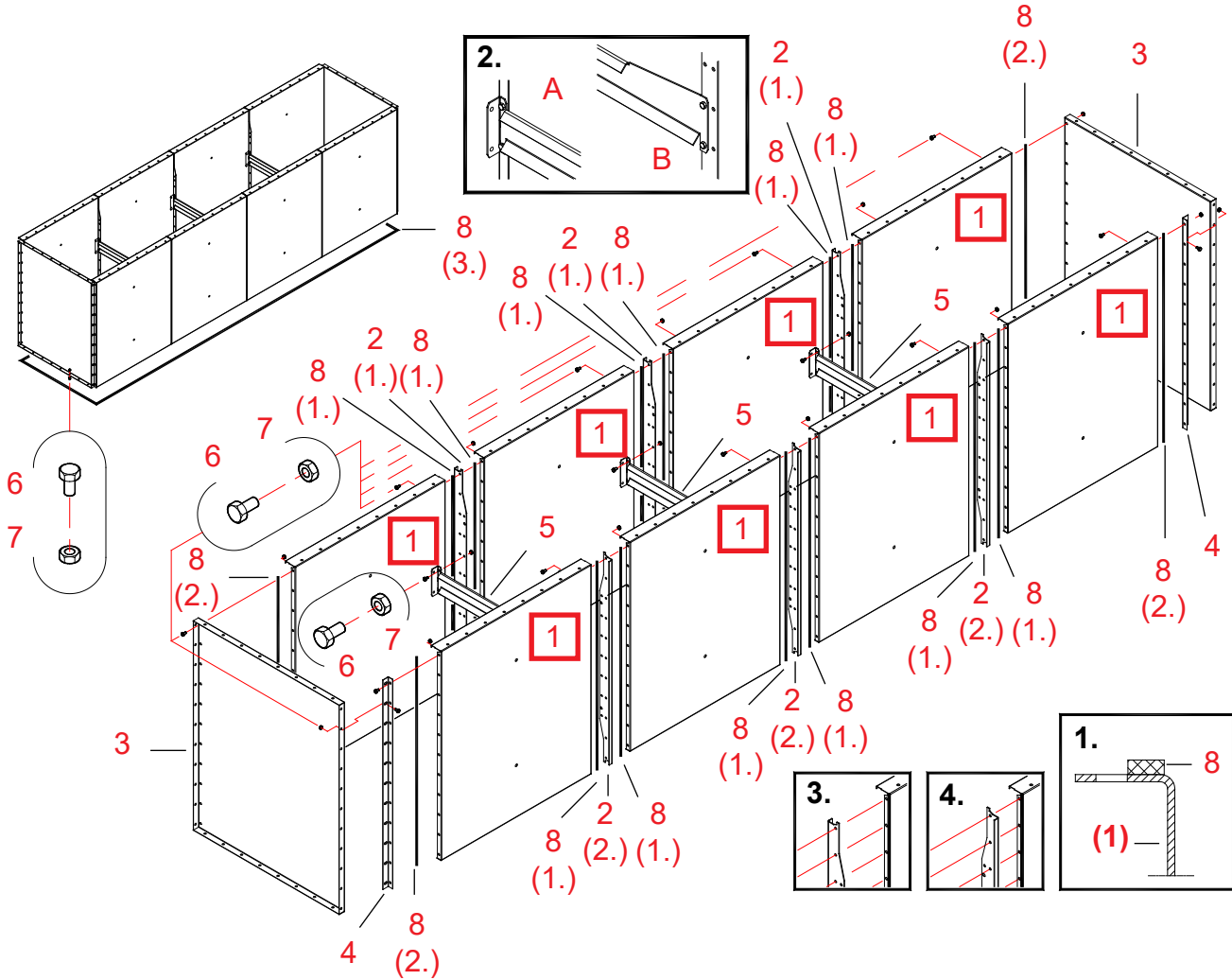
- (1)     **Move the assembly against the flanges at the upper end of the air channel end.**  
*Be careful not to damage the sealing strips while installing the plate.*  
Check correct position for the assembly in detail drawing X.
- 3, 4     **Fix the shutter-plate using bolts and nuts (M 8 x 16, 96 pcs.).**





## Air channel end 1,0 4W (A71334) - air channel extension

### Spare parts



20080901

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A70563	TOP SECTION/AIR CH END	END-PLATE	8	A70563-B	14.65	3000
2	A70810	TOP SECTION WM06	VERTICAL SUPPORT PL3	6	A70810-C	2.34	3000
3	A70640	AIR CHANN END WM06 1.0	SIDE-PLATE	2	A70640	14.18	3000
4	A70739	AIR CHANN END WM06	CORNER-S 1154 VERT	2	A70739-A	0.74	3000
5	A70678	AIR CHANN END WM06 1.0	STRAIGHT SUPPORT	3	A70678-B	1.79	3000
6	101810	HEX BOLT ZN 8.8	8X16 AM DIN933	218		0	2010
7	110540	NUT ZN 8 M 8	DIN934	218		0	2010
8	115570	SEALING STRIP	4X10 MAPA	32		0	2600



## Assembling air channel end A71334

### 1. Assembling the end-plate set-up for the air channel end

Parts            The numbering of work stages refers to reference numbers in the spare parts drawing A71334 for the air channel end.

*We recommend carrying out assembly of the air channel end on an even plane.  
This ensures the ready-assembled air channel end is straight.*

- 8 (1.)            **Fix sealing strips to the flanges of the eight end-plates (parts 1) to be joined together.**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).
- 2 (1. and 2.)    **Assemble two groups of end-plates with vertical supports. Place the vertical supports between the end-plates.**  
*Note, that the position of the vertical supports in the end-plate pairs varies.*  
See detail drawing 3: part 2 (1.) and 4: part 2 (2.).  
*The installation practice of the vertical supports is different if radiation shields are used; see instructions A71378.*  
*Be careful not to damage the sealing strips while installing the vertical support.*
- 6, 7             **Fix the end-plates and the vertical supports using bolts and nuts (M8 x 16, 11 + 11 + 11 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 5                **Bend the straight supports for the air channel end along the bending line and install them in the vertical supports (parts 2).**  
Look up, in the detail drawing 2A, how to bend the support and, in the main drawing, its correct position.  
Place the other ends of the supports in the vertical supports of the other end-plate group as shown in the detail drawing 2B.
- 6, 7             **Fix both ends of the supports using bolts and nuts (M8 x 16, 2 + 2 pcs.).**

### 2. Attaching the side-plates of the air channel end to the end-plates

- 8 (2.)            **Fix sealing strips to the end-flanges of the end-plate set-up, joined at stage 1.**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).
- 3                **Move the side-plates tight against the ends of the end-plate set-up.**  
*Be careful not to damage the sealing strips while installing the side-plates.*
- 6, 7             **Fix the side-plates using bolts and nuts (M8 x 16, 11 pcs. /side-plate).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- \*                **Check the joints of the air channel end, its rectangular shape and alignment of the side-plates.**  
**Tighten all bolts.**

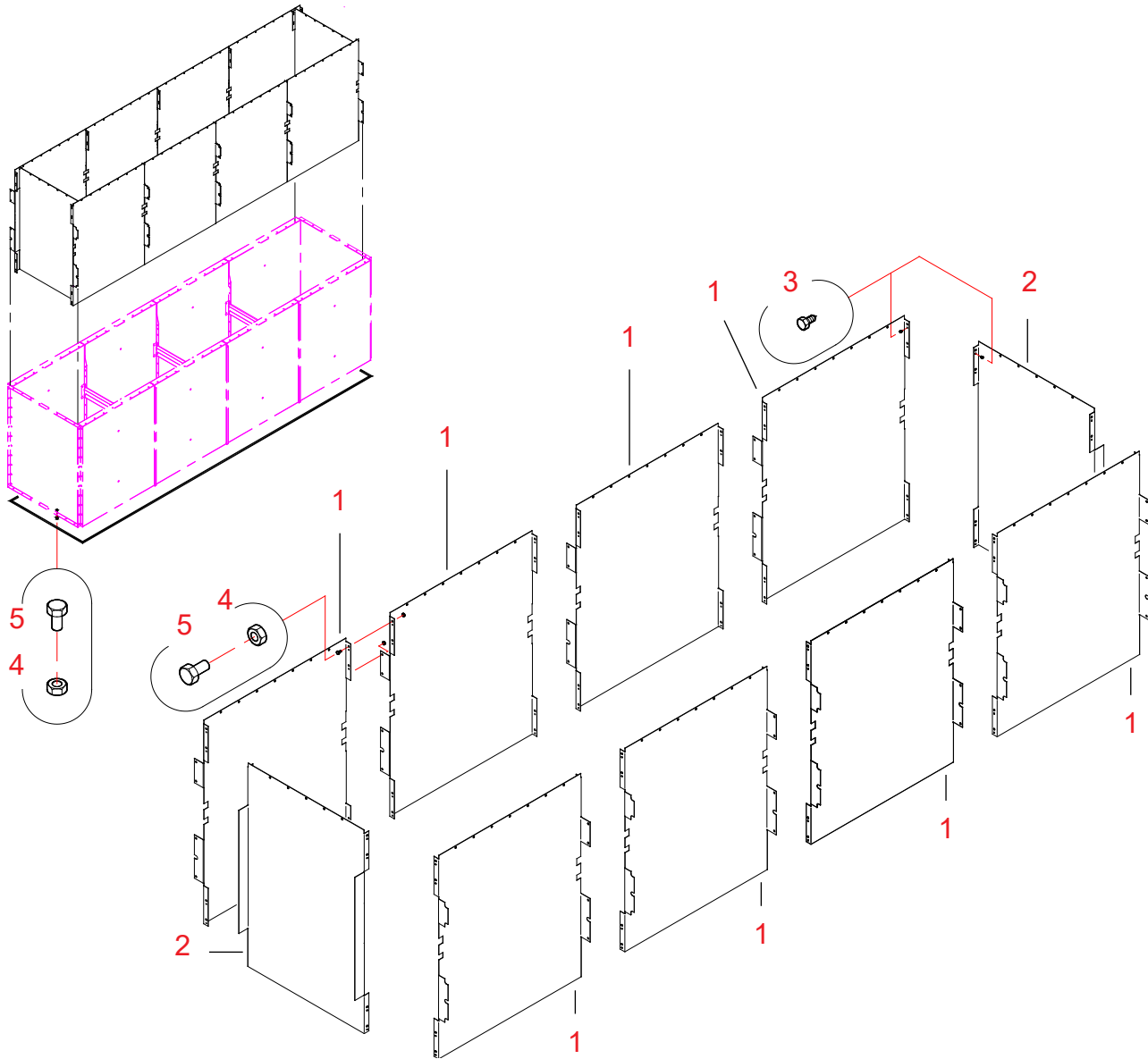
### 3. Installing the air channel end

- 8 (3.)            **Fix a sealing strip to the lower flange of the set-up, assembled at stage 2.**  
Fix the sealing strips inside the screw hole row.
- (2)              **Move the set-up, assembled at stage 2, on top of the ready-assembled air channel end.**  
*Be careful not to damage the sealing strips while moving the set-ups.*
- 6, 7             **Fix the part to the air channel end using bolts and nuts (M8 x 16, 32 + 32 + 8 + 8 pcs.).**
- \*                **Check the joints and rectangular shape of the set-up. Tighten all bolts.**



## Air channel end 1,0 4W (A71378) - radiation shields Spare parts

An accessory to be installed inside the air channel ends



20080716

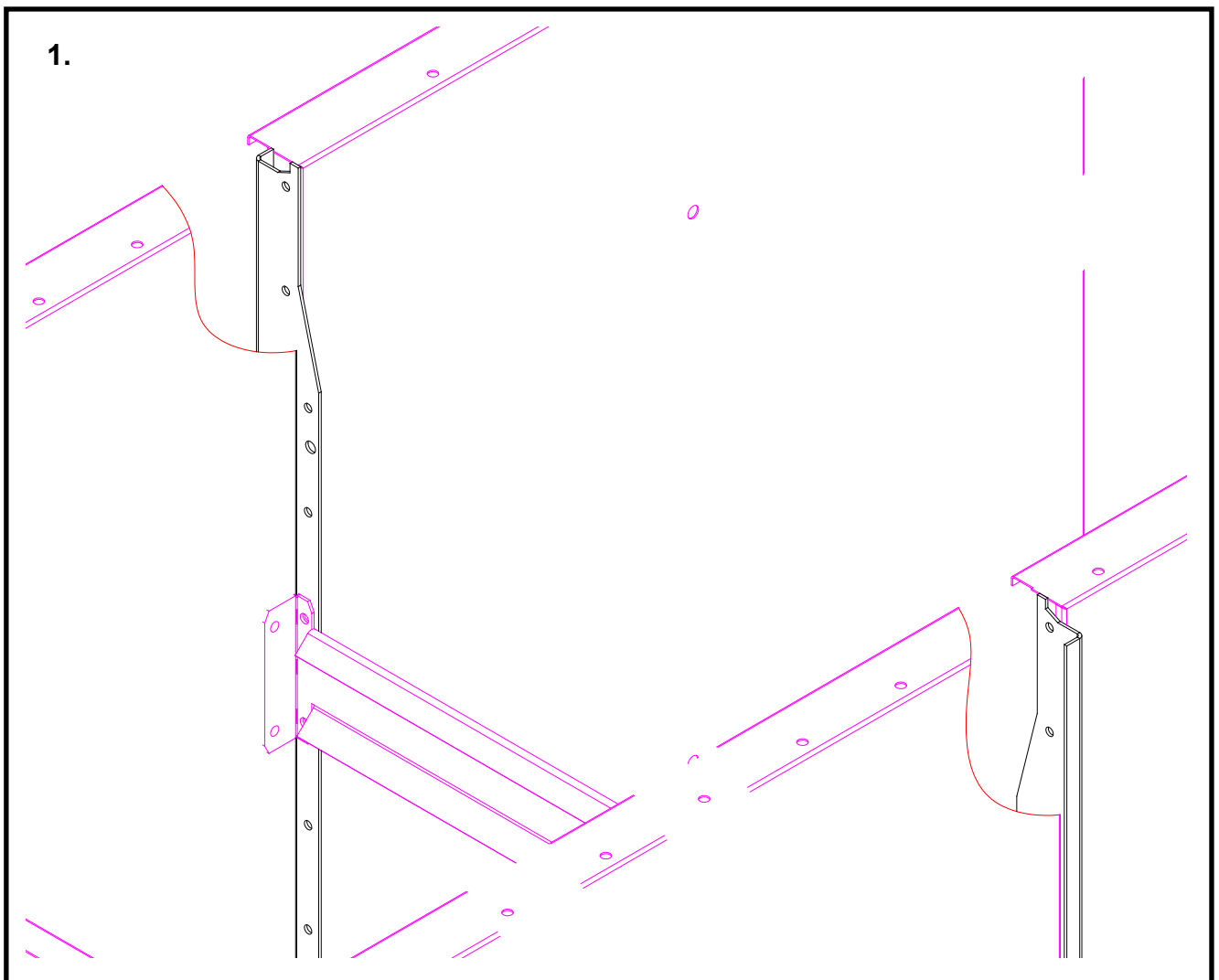
Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A71375	AIR CHANN END WM06 1,0	RAD SHIELD END	8		14.07	3000
2	A71374	AIR CHANN END WM06 1,0	RAD SHIELD SIDE	2		11.98	3000
3	107720	SELF-TAP HEX SCREW	4,8X13 ZN	102		0	2010
4	110540	NUT ZN 8 M 8	DIN934	48		0	2010
5	101820	HEX BOLT ZN 8.8	8X20 AM DIN933	48		0	2010

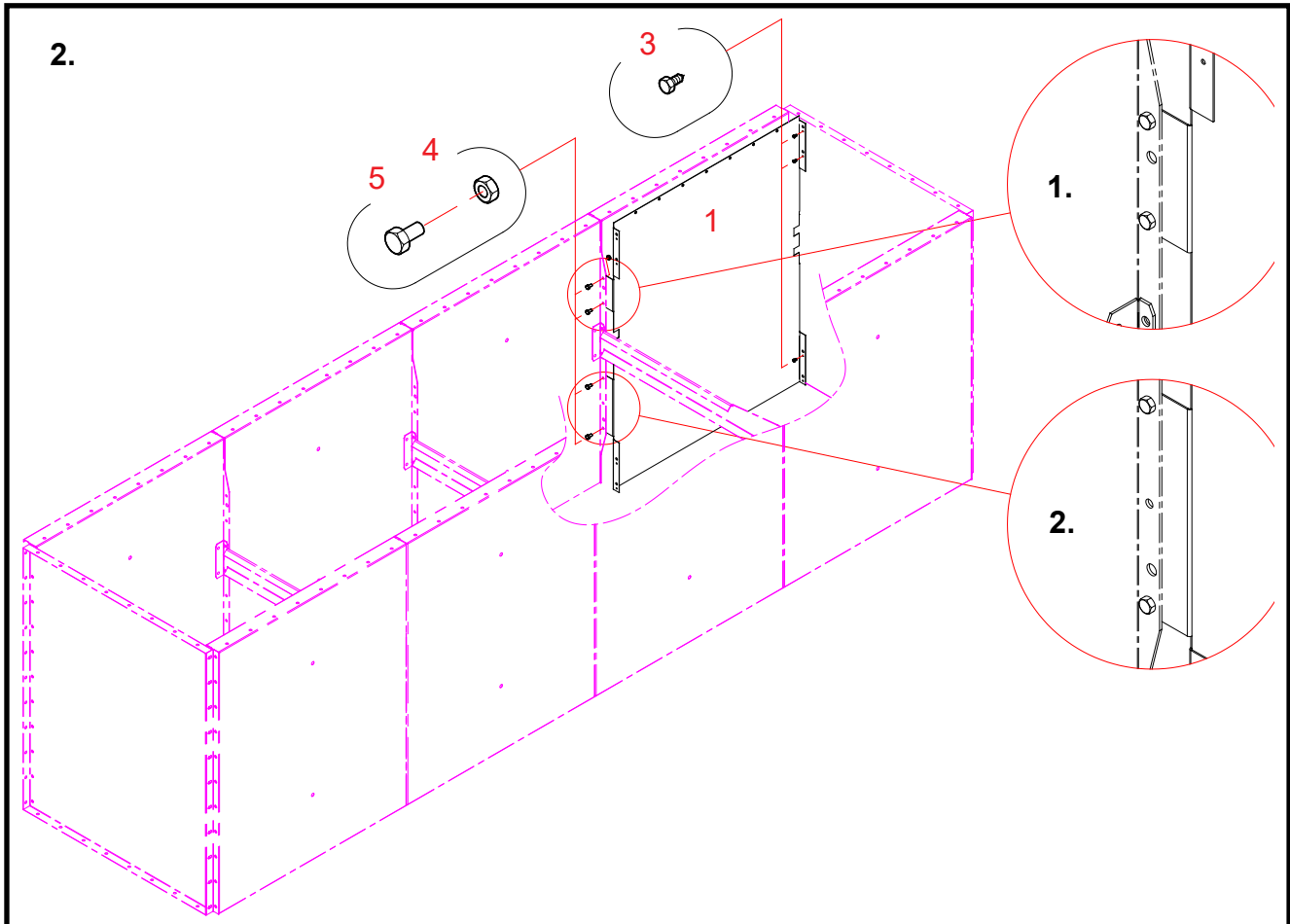


## Assembling air channel end A71378

Stages 1 - 5: Standard installation (1 x 1,0 m air channel end).

1. Check, that the vertical supports in the ready-assembled air channel end are installed as illustrated in the drawing 1!





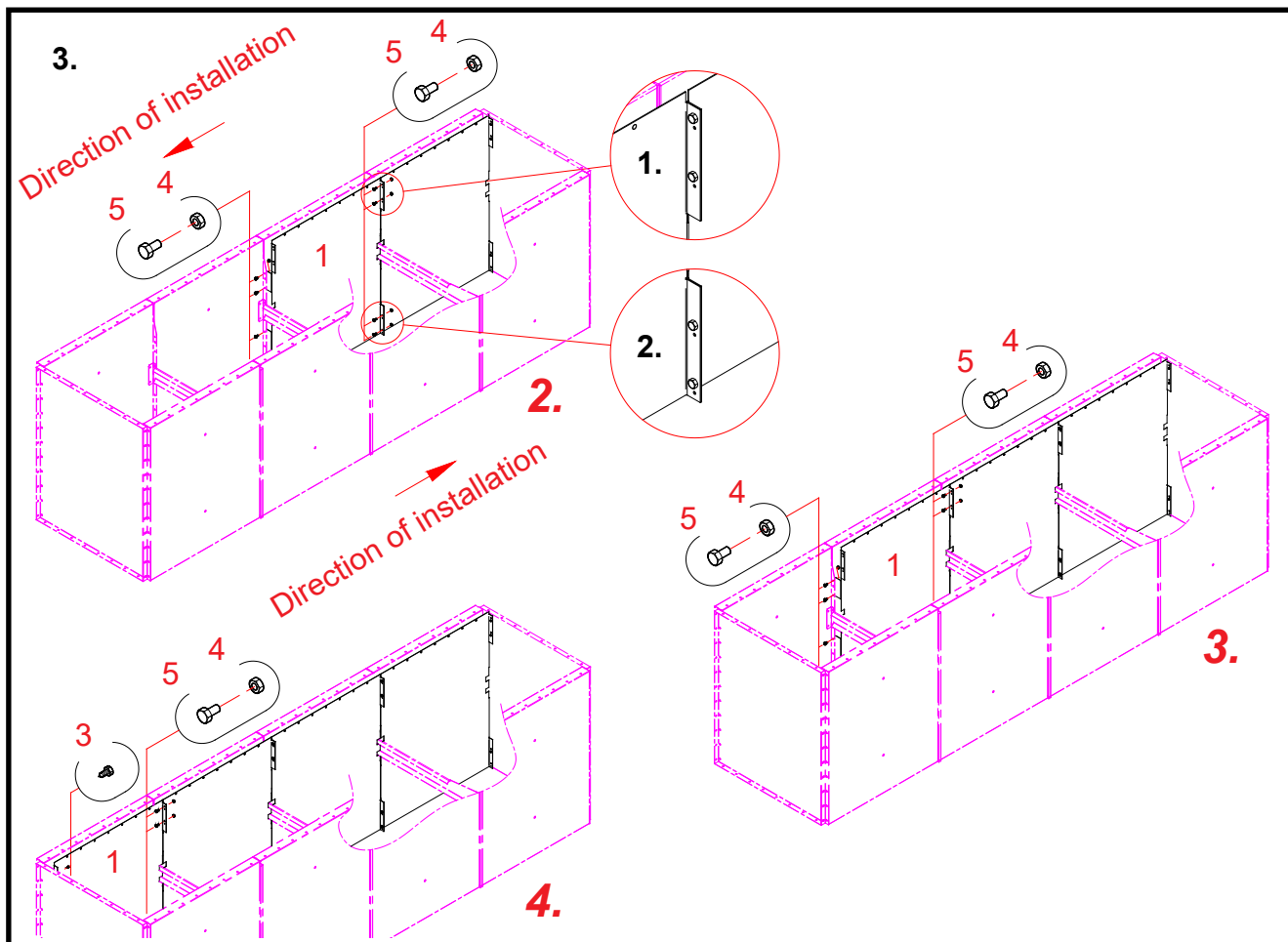
## 2. Installing the first radiation shield in the end-plate of the air channel end.

Parts The numbering of work stages refers to reference numbers in the spare parts drawing A71378 for the air channel end.

1 Place the first radiation shield for the end inside the air channel end.

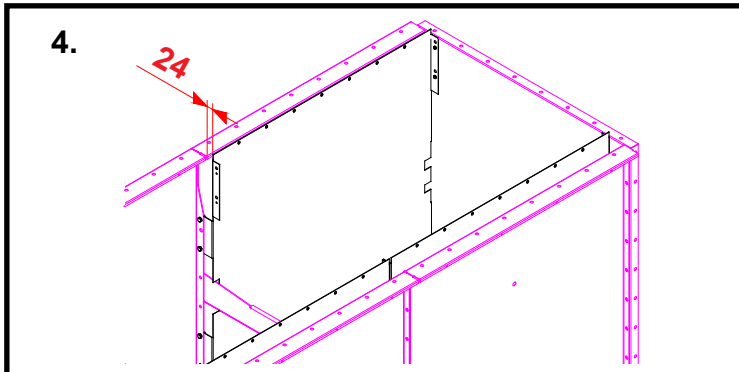
4, 5 Fix the radiation shield to the vertical support for the air channel end using bolts and nuts (M 8 x 20, 4 pcs.).  
See detail drawings 1 and 2.

3 Fix the radiation shield to the side-plate of the air channel end using self-tapping screws (4,8 x 13, 3 pcs.).  
Fix the radiation shield so that its upper edge is exactly parallel to the upper edge of the air channel end.

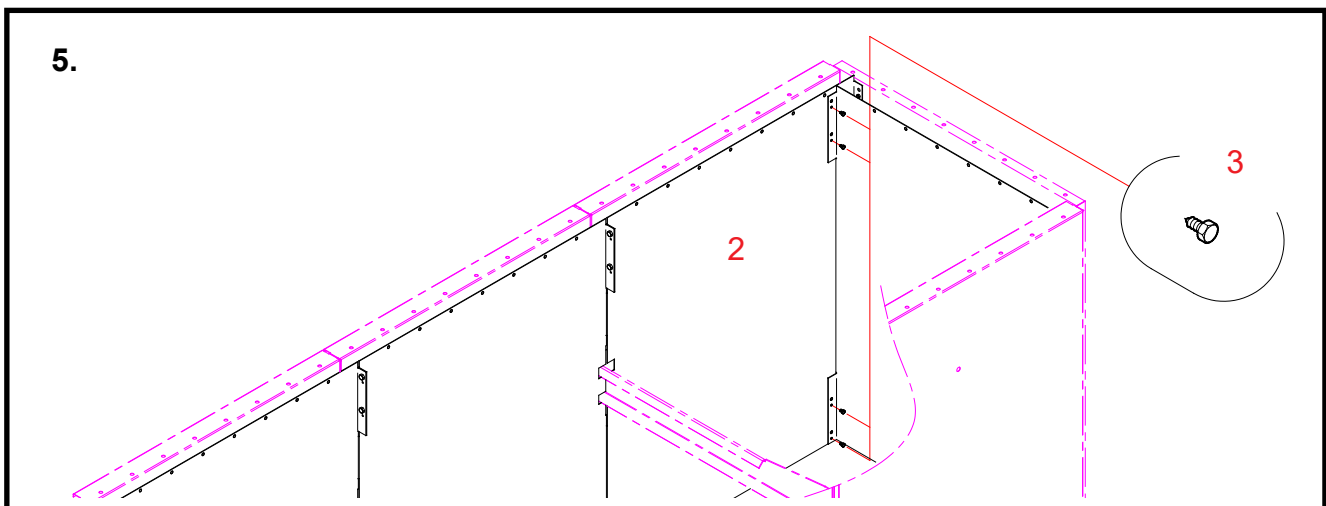


### 3. Installing the second, the third and the fourth radiation shield in the end-plate of the air channel end

- Drawing presenting stage 2: second radiation shield.
- 1 **Place the second radiation shield for the end next to the first one inside the air channel end.**
  - 4, 5 **Fix the plate to the radiation shield, installed earlier, using bolts and nuts (M8 x 20, 4 pcs.).**  
See detail drawings 1 and 2.
  - 4, 5 **Fix the radiation shield to the vertical support for the air channel end using bolts and nuts (M 8 x 20, 4 pcs.).**
- Drawing presenting stage 3: second radiation shield.
- 1 **Place the third radiation shield for the end next to the previous one inside the air channel end.**
  - 4, 5 **Attach in the same way as at stage 2.**
- Drawing presenting stage 4: third radiation shield.
- 1 **Place the third radiation shield for the end next to the previous one inside the air channel end.**
  - 4, 5 **Fix the plate to the radiation shield, installed earlier, using bolts and nuts (M8 x 20, 4 pcs.).**
  - 3 **Fix the radiation shield to the side-plate of the air channel end using self-tapping screws (4,8 x 13, 3 pcs.).**

**4. Note!**

A space of about 24 mm will be left between the radiation shield installed in the correct position and the upper flange of the air channel end that is bent inward.

**5. Installing the radiation shields on the side-plates of the air channel end**

- 2** Place the first radiation shield for the side inside the air channel end.  
Place the upper edge of the plate level with the upper edges of the radiation shields for the end.  
Press the tongues of the radiation shield for the side against the side-plate of the air channel end.
- 3** Fix the plate to the radiation shield for the air channel end using self-tapping screws (4,8 x 13, 4+4 pcs.).
- \*** Fix the radiation shield to the other side-plate of the air channel end in the same way.

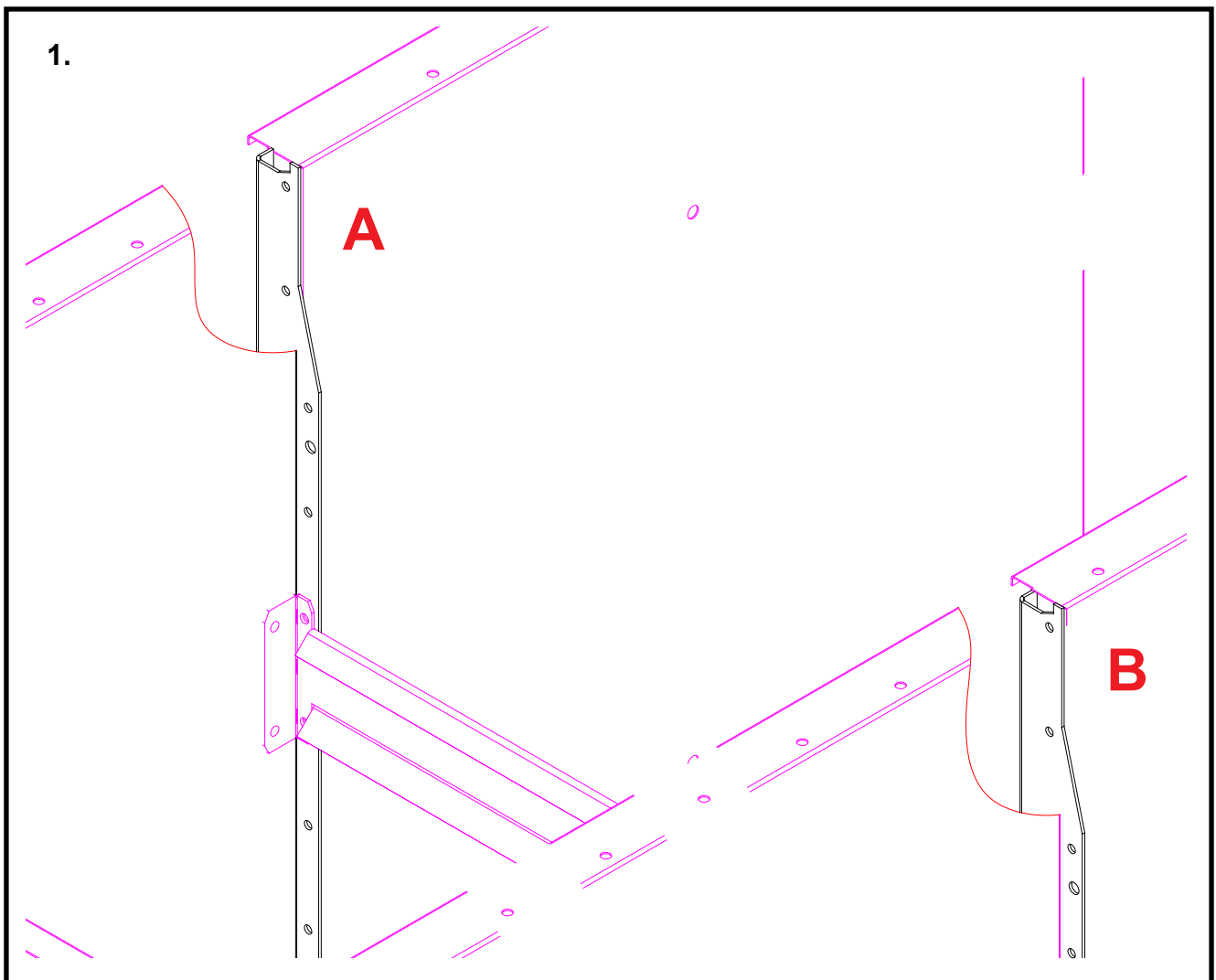
## Assembling air channel end A71378

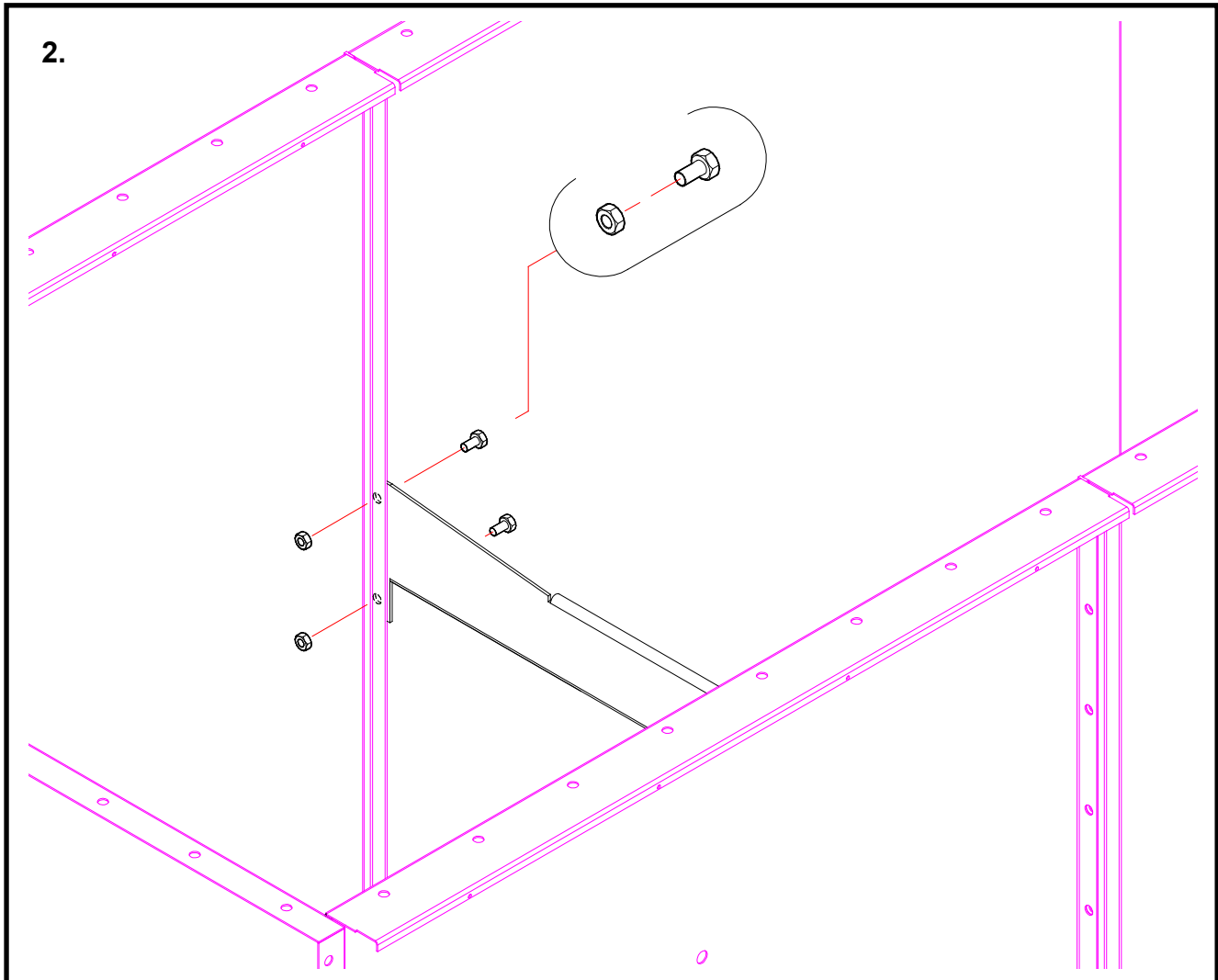
Stages 1 - 5: Special installation - of the two parallel air channel ends (2 x 1,0 m) the one installed on the same side as the drying section.

1. Check, that the vertical supports A in the ready-assembled air channel end are installed as illustrated in the drawing 1.  
This is the standard direction of the installation.

The direction of installation of the vertical supports B (on the drying section side) differs from standard.

Check the direction of installation of the vertical supports and turn them, as necessary.

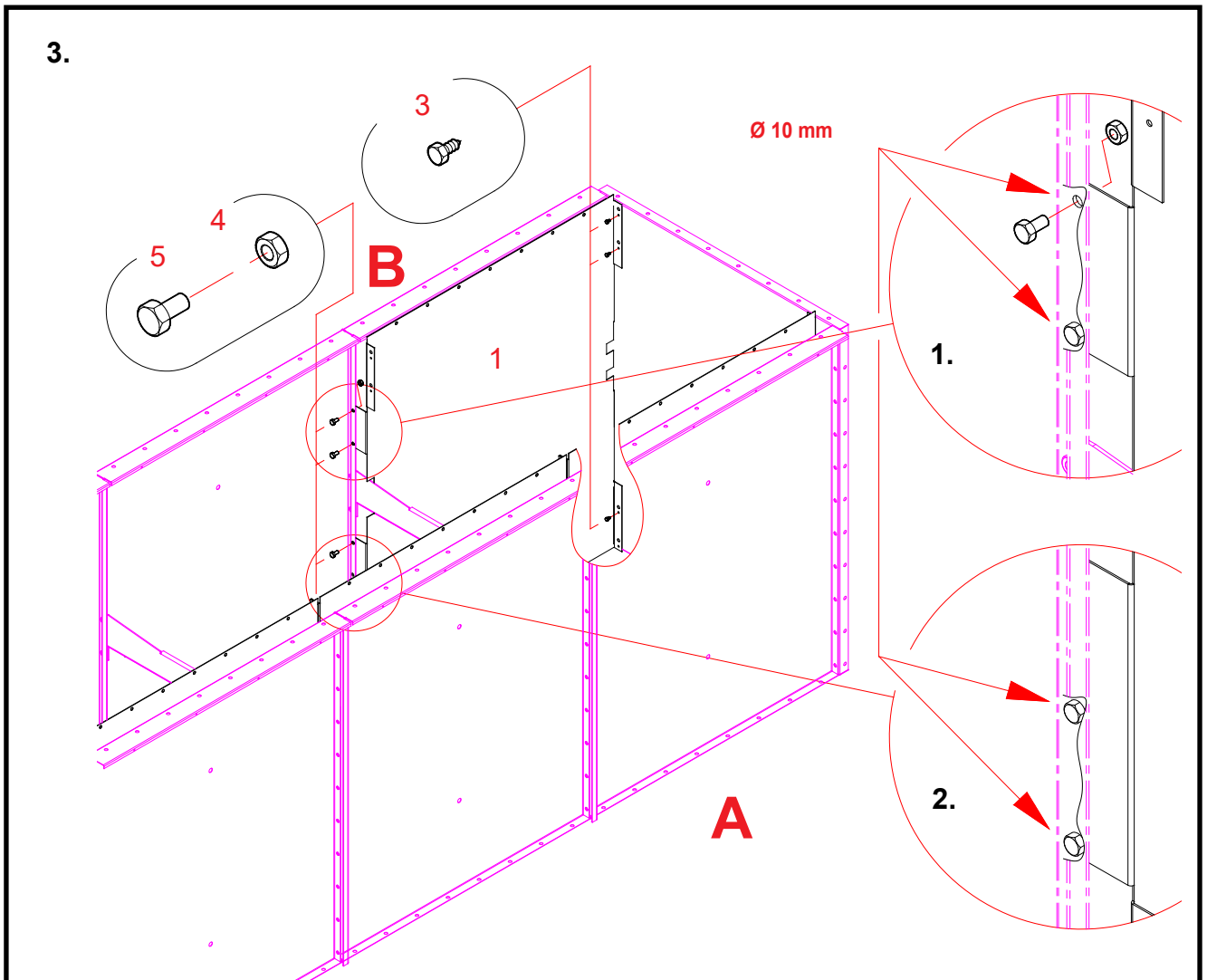




## 2. Reattachment of the straight supports for the air channel end, if you have had to turn the vertical supports

### Parts

- \* Drill two  $\text{Ø } 10$  mm holes in the vertical supports for the air channel end for attachment of the straight supports. Use the straight support as a jig.
- \* Fix the straight supports to the vertical supports for the air channel end using nuts and bolts. Use the same nuts and bolts that were used for attachment of the supports (M8 x 16, 2 pcs./support).



### 3. Installing the first radiation shield in the end-plate of the air channel end (side B in the drawing)

Parts The numbering of work stages refers to reference numbers in the spare parts drawing A71378 for the air channel end.

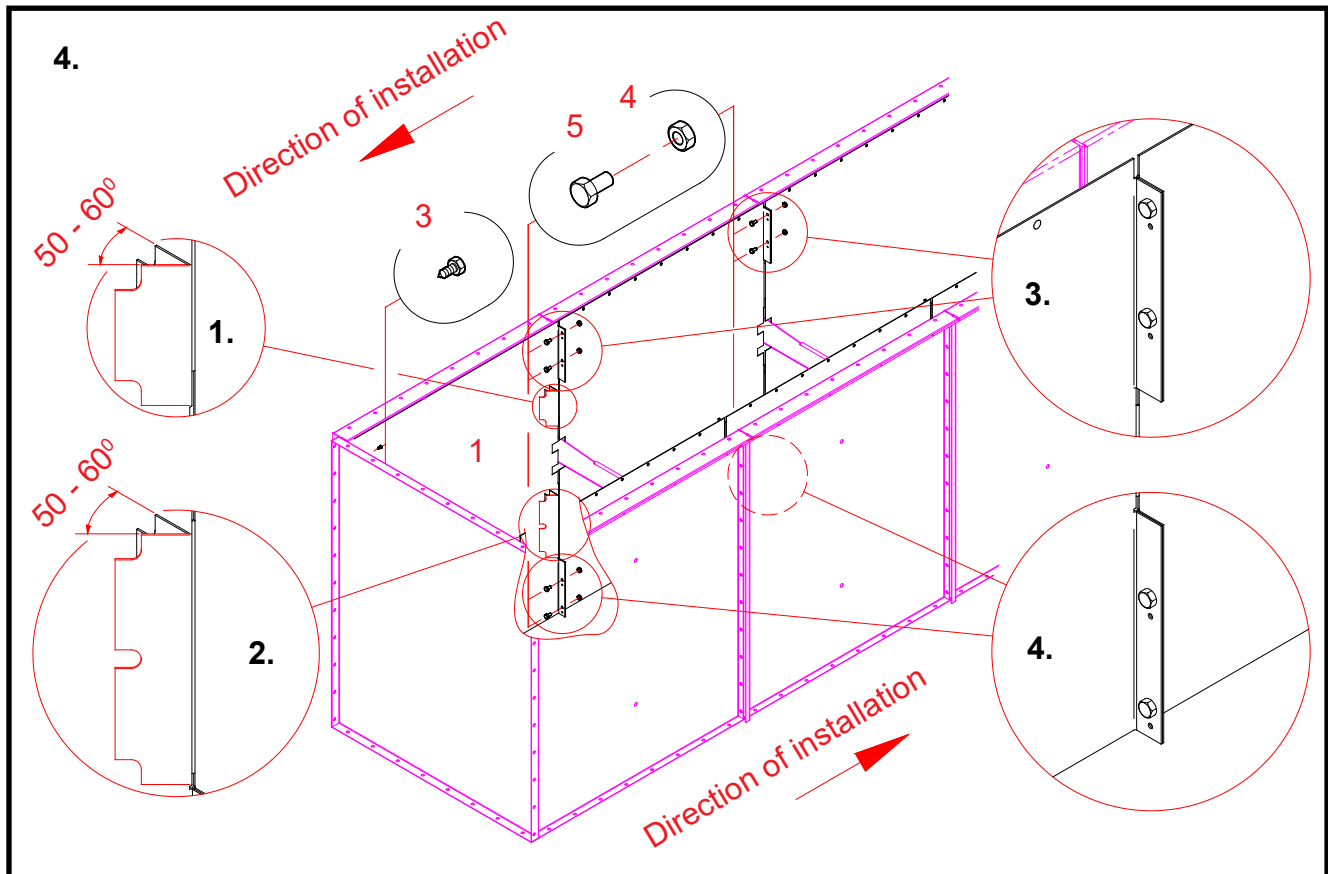
\* Install the radiation shields on the side A in accordance with the points 2-3 for the standard installation.

1 Place the first radiation shield for the end on the side B inside the air channel end.

\* Drill four Ø 10 mm holes in the vertical support for attachment of the radiation shield.  
Use the radiation shield as a jig.

4, 5 Fix the radiation shield to the vertical support for the air channel end using bolts and nuts (M 8 x 20, 4 pcs.).  
See detail drawings 1 and 2.

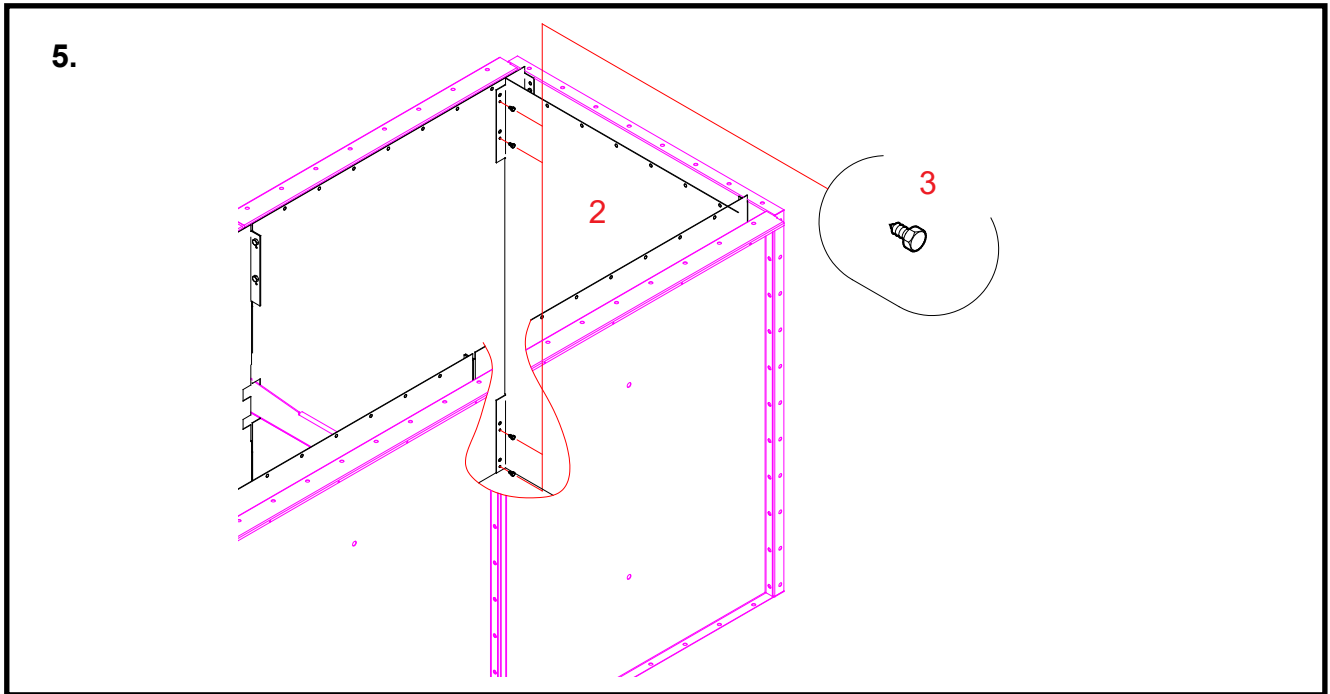
3 Fix the radiation shield to the side-plate of the air channel end using self-tapping screws (4,8 x 13, 3 pcs.).  
Fix the radiation shield so that its upper edge is exactly parallel to the upper edge of the air channel end.



#### 4. Installing the second, the third and the fourth radiation shield in the end-plate of the air channel end

- \* **Bend more the two tongues in the three radiation shields to be installed.**  
Bend the tongues about 60 degrees more so that they do not come in contact with the vertical support.  
See detail drawings 1 and 2.
- 1 **Place the second radiation shield for the end next to the first one inside the air channel end.**
- 4, 5 **Fix the plate to the radiation shield, installed earlier, using bolts and nuts (M8 x 20, 4 pcs.).**  
See detail drawings 3 and 4.
- \* **Drill four Ø 10 mm holes in the vertical support for attachment of the radiation shield.**  
Use the radiation shield as a jig.
- 4, 5 **Fix the radiation shield to the vertical support for the air channel end using bolts and nuts (M 8 x 20, 4 pcs.).**
- 1 **Place the third radiation shield for the end next to the previous one and attach it in the same way.**
- 1 **Place the fourth radiation shield for the end next to the previous one inside the air channel end.**
- 4, 5 **Fix the plate to the radiation shield, installed earlier, using bolts and nuts (M8 x 20, 4 pcs.).**  
See detail drawings 3 and 4.
- 3 **Fix the radiation shield to the side-plate of the air channel end using self-tapping screws (4,8 x 13, 3 pcs.).**





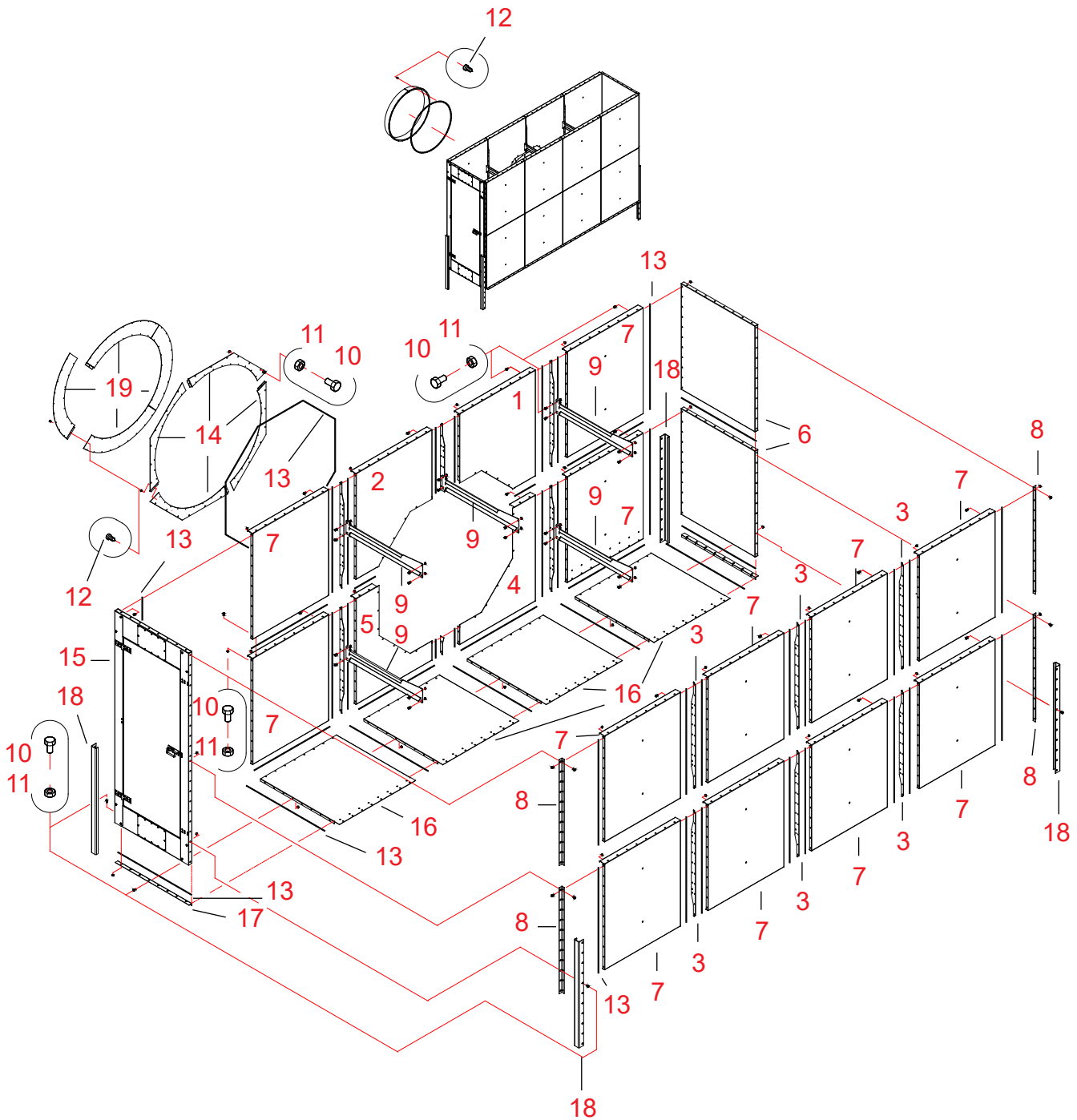
### 5. Installing the radiation shields on the side-plates of the air channel end

- 2 **Place the first radiation shield for the side inside the air channel end.**  
Place the upper edge of the plate level with the upper edges of the radiation shields for the end.  
Press the tongues of the radiation shield for the side against the side-plate of the air channel end.
- 3 **Fix the plate to the radiation shield for the air channel end using self-tapping screws (4,8 x 13, 4+4 pcs.).**
- \* **Fix the radiation shield to the other side-plate of the air channel end in the same way.**



## Air channel end 1,0 4W (A71395) - channel S, octagonal / Ø 1250 mm

### Spare parts





20061106

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A71388	AIR CHANN END WM06	OCTAGON TOP/L	1		12.1	3000
2	A71389	AIR CHANN END WM06	OCTAGON TOP/R	1		12.1	3000
3	A70810	TOP SECTION WM06	VERTICAL SUPPORT PL3	11	A70810-B	1.12	3000
4	A71390	AIR CHANN END WM06	OCTAGON BOTTOM/L	1		7.36	3000
5	A71391	AIR CHANN END WM06	OCTAGON BOTTOM/R	1		7.36	3000
6	A70640	AIR CHANN END WM06 1.0	SIDE-PLATE	2	A70640	14.18	3000
7	A70563	TOP SECTION/AIR CH END	END-PLATE	12	A70563-B	14.65	3000
8	A70739	AIR CHANN END WM06	CORNER-S 1154 VERT	4	A70739-A	0.74	3000
9	A70678	AIR CHANN END WM06 1.0	STRAIGHT SUPPORT	5	A70678-B	1.79	3000
10	101810	HEX BOLT ZN 8.8	8X16 AM DIN933	587		0	2010
11	110540	NUT ZN 8 M 8	DIN934	587		0	2010
12	107720	SELF-TAP HEX SCREW	4,8X13 ZN	72		0	2010
13	115570	SEALING STRIP	4X10 MAPA	76		0	2600
14	A71392	AIR CHANN END WM06	ADAPT OCTAG D1250	4		1.33	3000
15	A71301	DOOR ELEMENT		1	A71301	35.23	3000
16	A70642	AIR CHANN END WM06 1.0	SHUTTER-PLATE	4	A70642	11.67	3000
17	A70570	AIR CHANN END WM06 1.0	CORNER-STRIP	2	A70570-A	0.94	3000
18	A71396	AIR CHANN END WM06	GROUND SUPP LEG	4		4.84	3000
19	A71254	AIR CHANN END WM06	1/4 CIRCLE D1250/1000	4	A71254-A	2	3000

## Assembling air channel end A71395

### 1. Joining together the lower end-plate and the side-plates

Parts The numbering of work stages refers to reference numbers in the spare parts drawing A71395 for the air channel end.

See illustration of these stages on next page.

***We recommend carrying out assembly of the air channel end on an even plane.***

***This ensures the ready-assembled air channel end is straight.***

**13 (1.)** Fix sealing strips to the long and short end-flanges of the end-plates (parts 4 and 5).

**13 (2.)** Fix sealing strips to the end-flanges of one of the end-plates 7.

Fix the sealings to both end-flanges of the first part 7, and to only one end-flange of the second part 7.

Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).

**4 + 5** Move the short flanges of the end-plates close to each other.

**3.1** Trim the vertical support to a length of 192 mm.

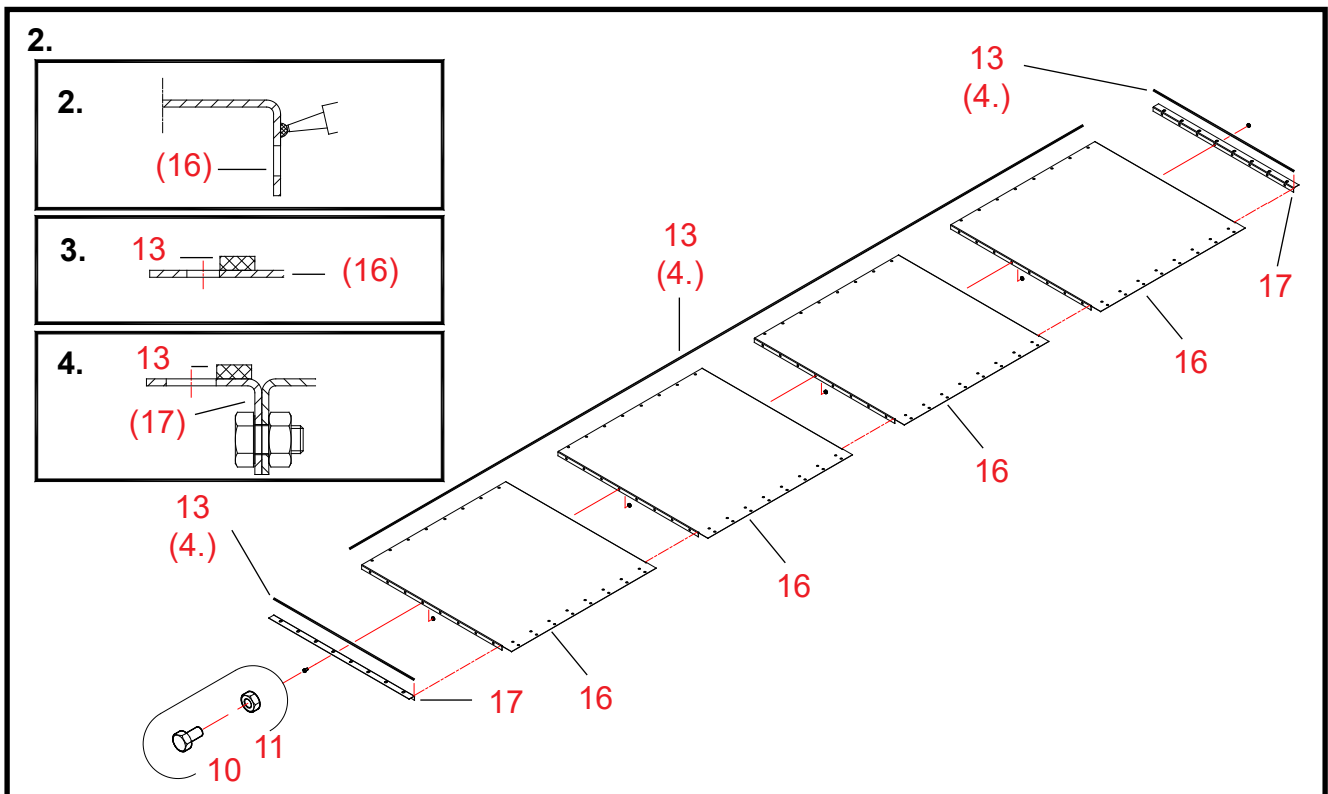
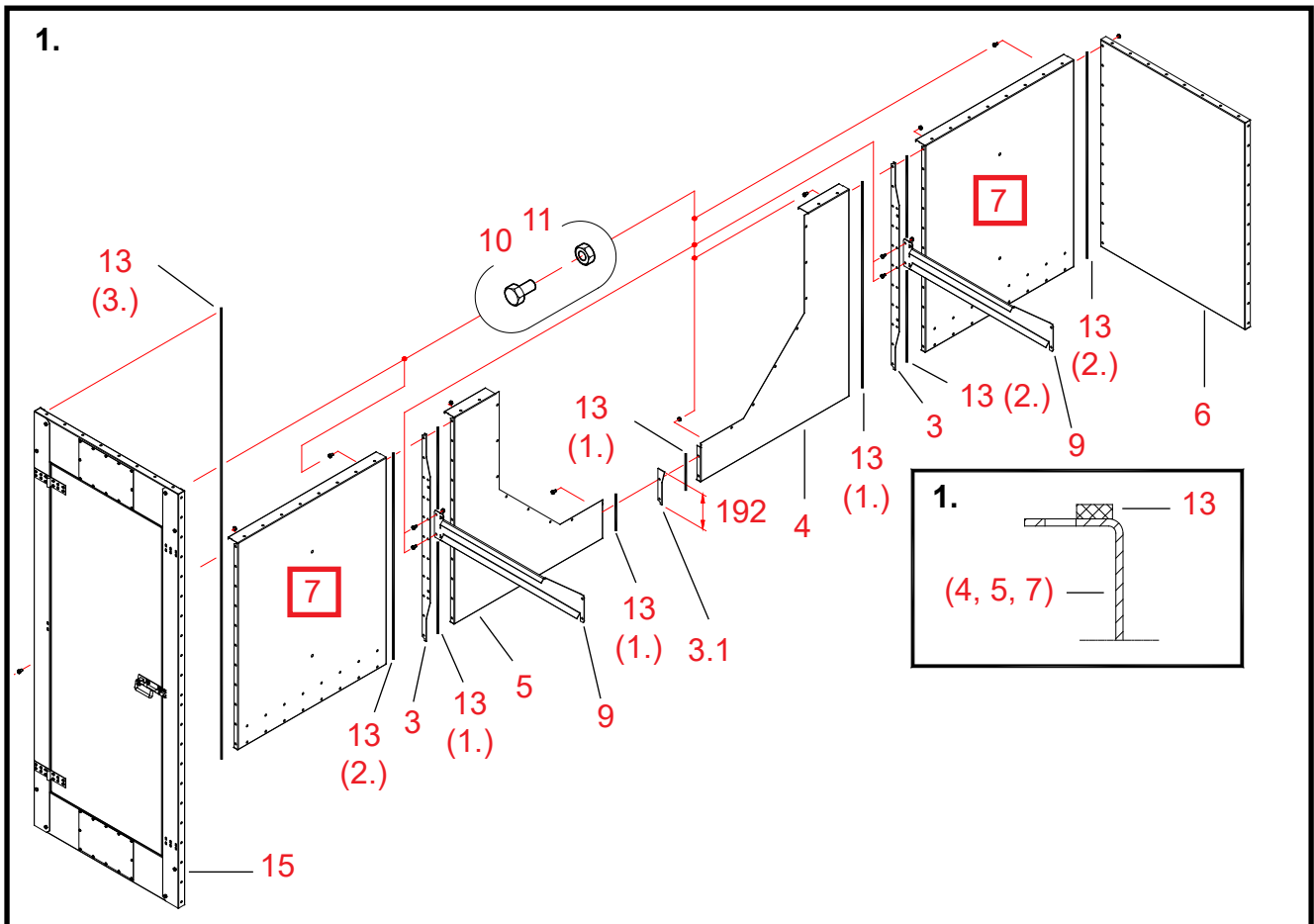
**\*** Place the shortened vertical support between the end-plates.

***Be careful not to damage the sealing strips while installing the end-plates.***

**10, 11** Fix the end-plates and the vertical support using bolts and nuts (M8 x 16, 2 pcs.).

Tighten the bolts only lightly so that you can straighten the air channel end later.

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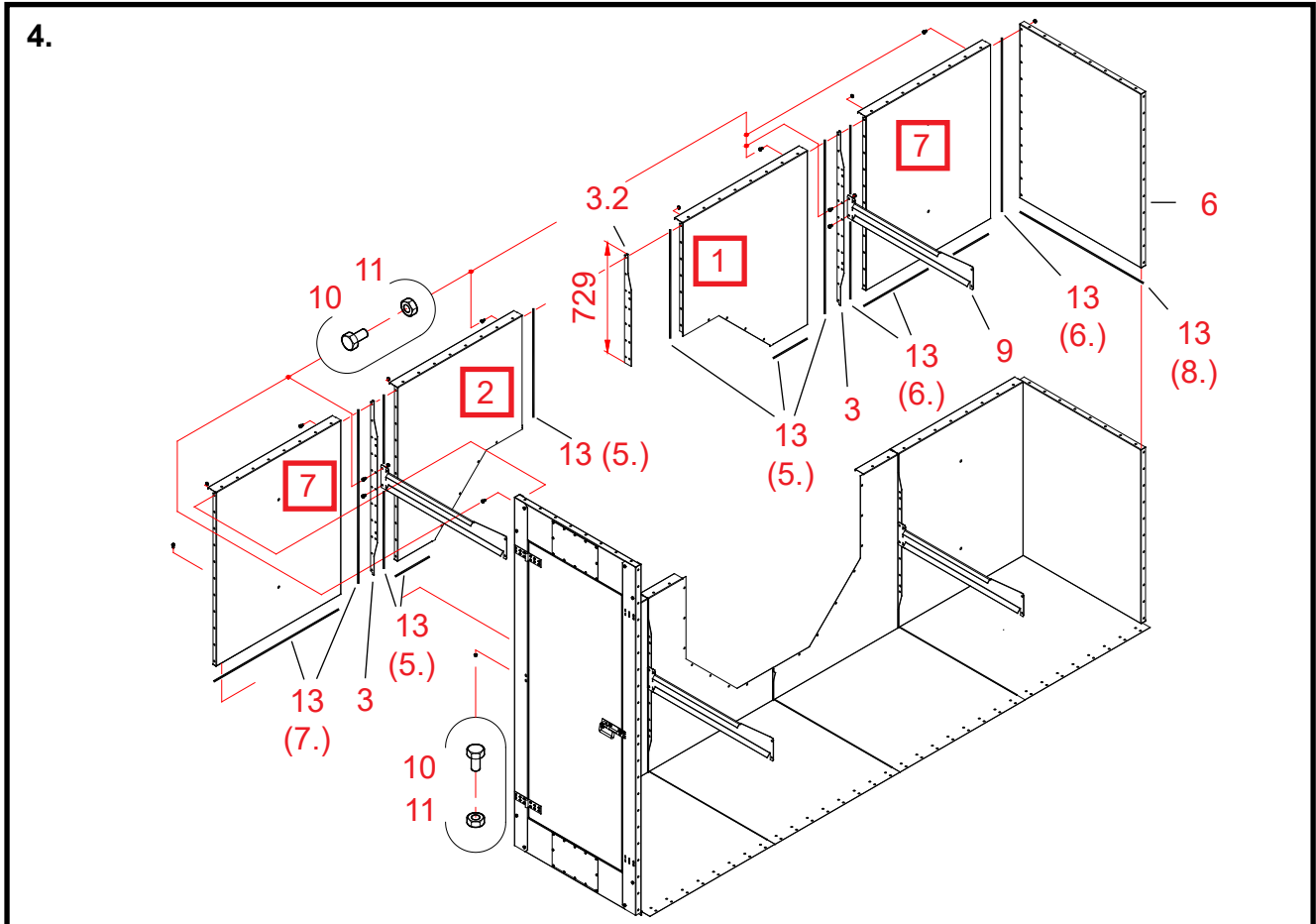
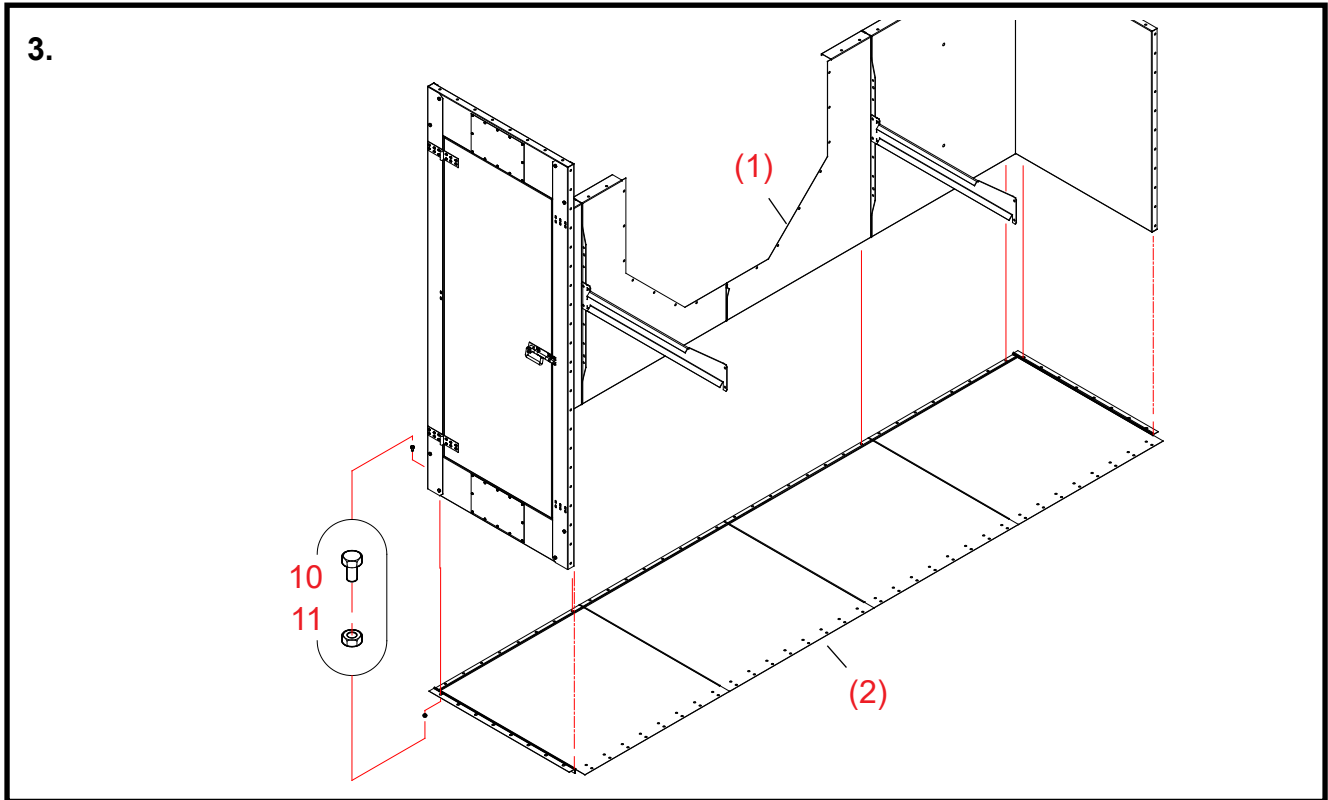


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- 3**            **Place vertical supports between end-plates 4 and 7 as well as between plates 5 and 7.**  
*Be careful not to damage the sealing strips while installing the vertical support.*
  
- 10, 11**       **Fix the end-plates and the vertical supports using bolts and nuts (M8 x 16, 11 + 11 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
  
- 9**            **Install the straight supports for the air channel end in the vertical supports (parts 3).**  
Look up correct position for the supports in the drawing.
  
- 10, 11**       **Fix the supports using bolts and nuts (M8 x 16, 2 pcs./support).**
  
- 13 (3.)**      **Fix a sealing strip to the door element (part 15), onto the surface to be attached to the end-plate.**
  
- 6, 15**       **Move the side-plate and the door element tight against the ends of the end-plate set-up.**  
*Be careful not to damage the sealing strips while installing the side-plates.*
  
- 10, 11**       **Fix the side-plate and the door element using bolts and nuts (M8 x 16, 11 pcs./ part).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.

## 2. Joining together the shutter-plates of the air channel end

- \***            **Apply sealing mastic on the outer faces of the shutter-plates' (parts 16) end-plates.**  
Apply sealing mastic inside the bolthole rows in the plates (see detail drawing 2).  
Try to keep the mastic strip as even and continuous as possible.
  
- 10, 11**       **Join the shutter-plates together using bolts and nuts (M8 x 16, 8 + 8 + 8 pcs.).**  
*Be careful not to damage the sealing mastic strip while joining the plates.*
  
- 17**           **Fix the corner-strips against the flanges at the outer ends of the shutter-plate set-up.**  
*Be careful not to damage the sealing mastic strip while installing the corner-strips.*
  
- 10, 11**       **Fix them in place using bolts and nuts (M 8 x 16, 8 pcs./corner-strip).**
  
- 13 (4.)**      **Fix sealing strips to three sides of the shutter-plate/corner-strip assembly.**  
Fix the sealing strips inside the screw hole rows onto the upper surfaces of the shutter-plates (see detail drawing 3).  
Fix the sealing strips inside the screw hole rows onto the upper surfaces of the corner-strips (see detail drawing 4).



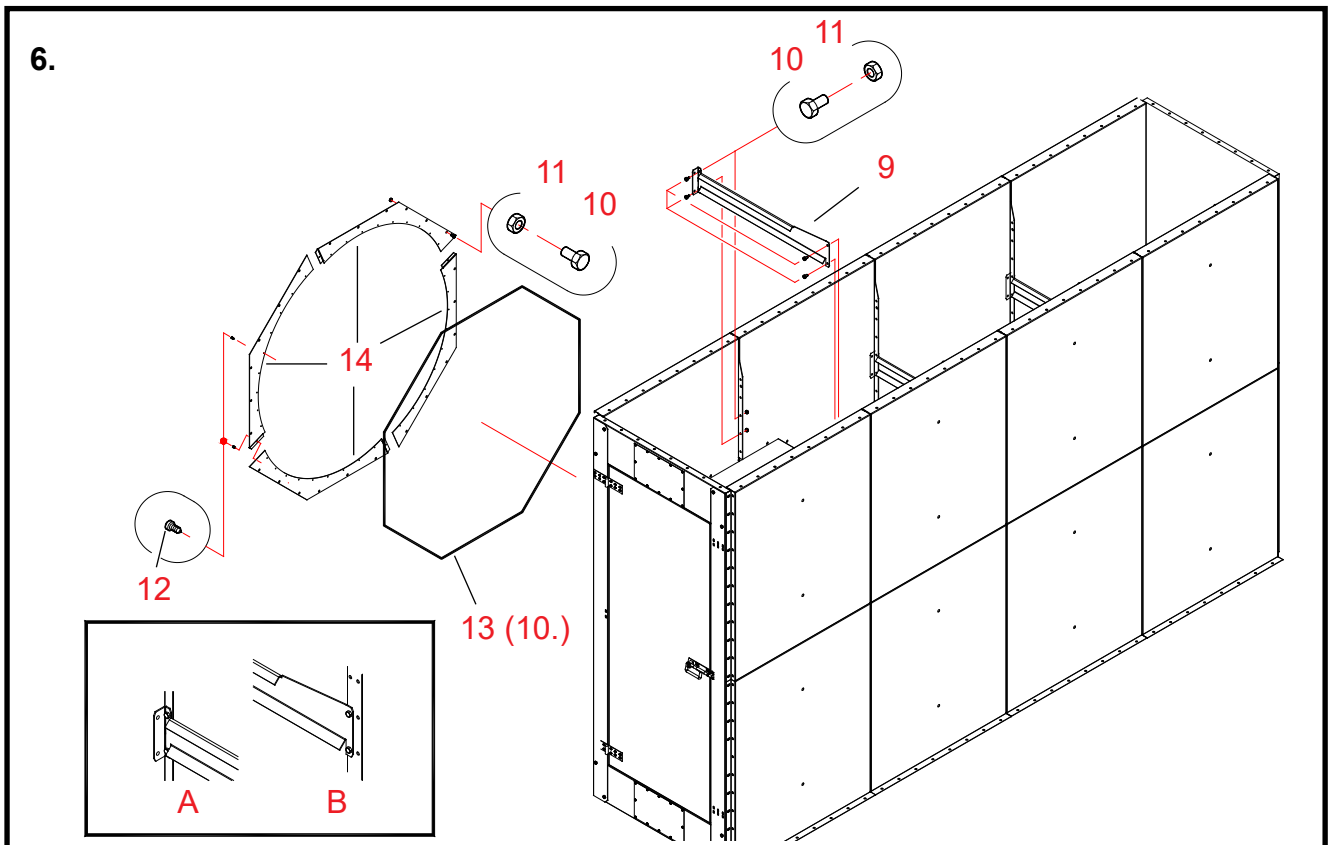
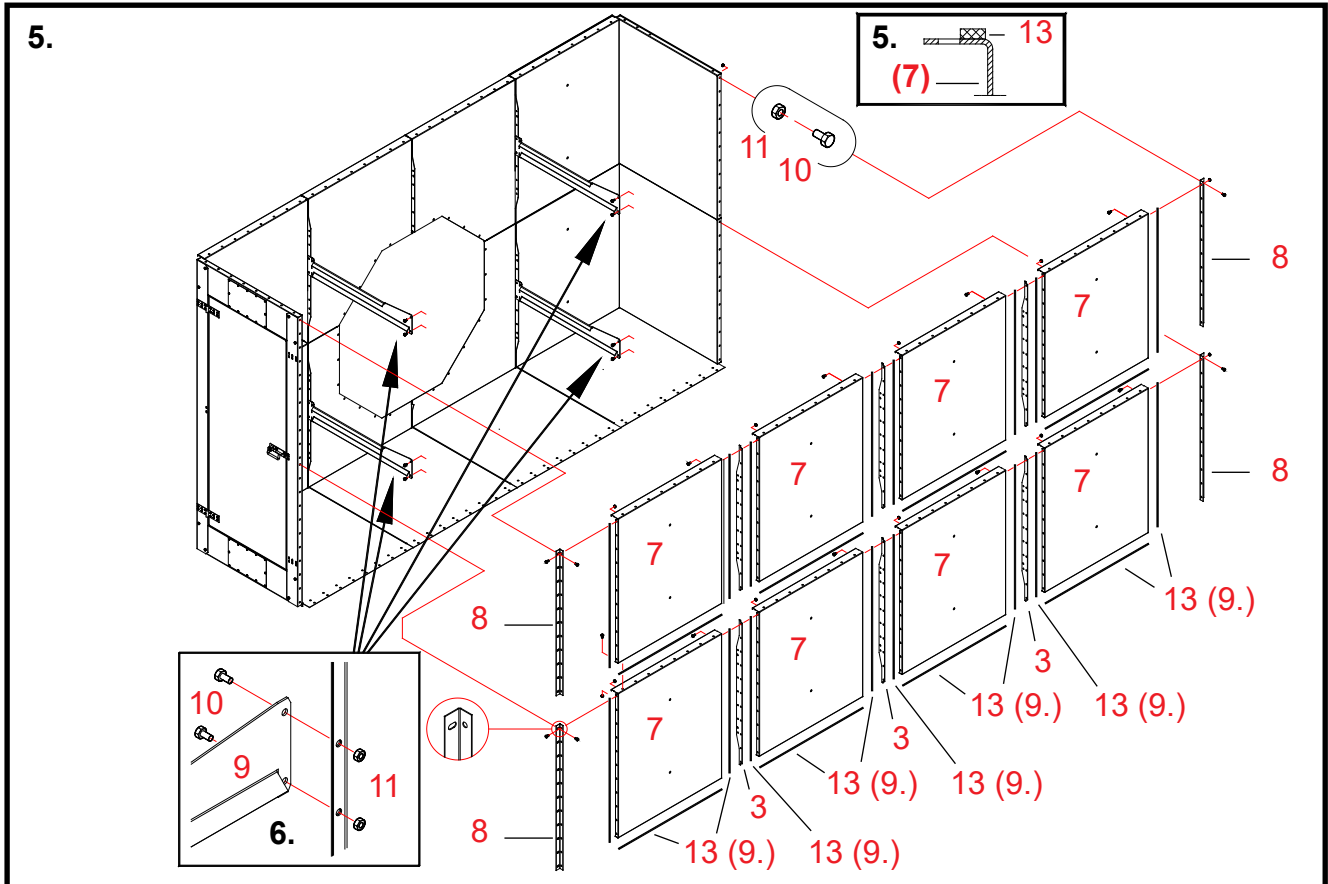


### 3. Fixing the shutter-plate to the lower end of the air channel end

- (2) **Move the set-up, assembled at stage 2, against the lower flanges of the set-up, assembled at stage 1.**  
*Be careful not to damage the sealing strips while installing the plate.*
- 10, 11 **Fix the shutter-plate using bolts and nuts (M 8 x 16, 8 + 32 + 8 pcs.).**

### 4. Joining together the upper end-plate and the side-plate of the air channel end

- 13 (5.) **Fix sealing strips to both end-flanges and lower flanges of the end-plates (parts 1 and 2).**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing in drawing 1).
- 1 + 2 **Move the short vertical flanges of the end-plates close to each other.**
- 3.2 **Trim the vertical support to a length of 729 mm.**  
\* **Place the shortened vertical support between the end-plates.**  
*Be careful not to damage the sealing strip while installing the end-plates.*
- 10, 11 **Fix the parts using bolts and nuts (M8 x 16, 7 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 13 (6.) **Fix sealing strips to both end-flanges and lower flanges of the end-plate (part 7, to the right in the drawing).**  
13 (7.) **Fix sealing strips to both end-flanges and lower flanges of the end-plate (part 7, to the left in the drawing).**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing in drawing 1).
- 3 **Place vertical supports between end-plates 1 and 7 as well as between plates 2 and 7.**  
*Be careful not to damage the sealing strips while installing the vertical support.*
- 10, 11 **Fix the end-plates and the vertical supports using bolts and nuts (M8 x 16, 11 + 11 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 9 **Install the straight supports for the air channel end in the vertical supports (parts 3).**  
Look up correct position for the supports in the drawing.
- 10, 11 **Fix the supports using bolts and nuts (M8 x 16, 2 pcs./support).**
- 13 (8.) **Fix a sealing strip onto the lower surface of the side-plate (part 6).**  
Fix the sealing strip inside the screw hole row in the flange (see detail drawing 1).
- 6 **Move the side-plate tight against the end of the end-plate set-up.**  
*Be careful not to damage the sealing strips while installing the side-plates.*
- 10, 11 **Fix the side-plate using bolts and nuts (M8 x 16, 11 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- (4) **Move the set-up, assembled at stage 4, on top of the set-up, assembled at stage 1.**
- 10, 11 **Join the set-ups together using bolts and nuts (M8 x 16, 39 pcs.).**





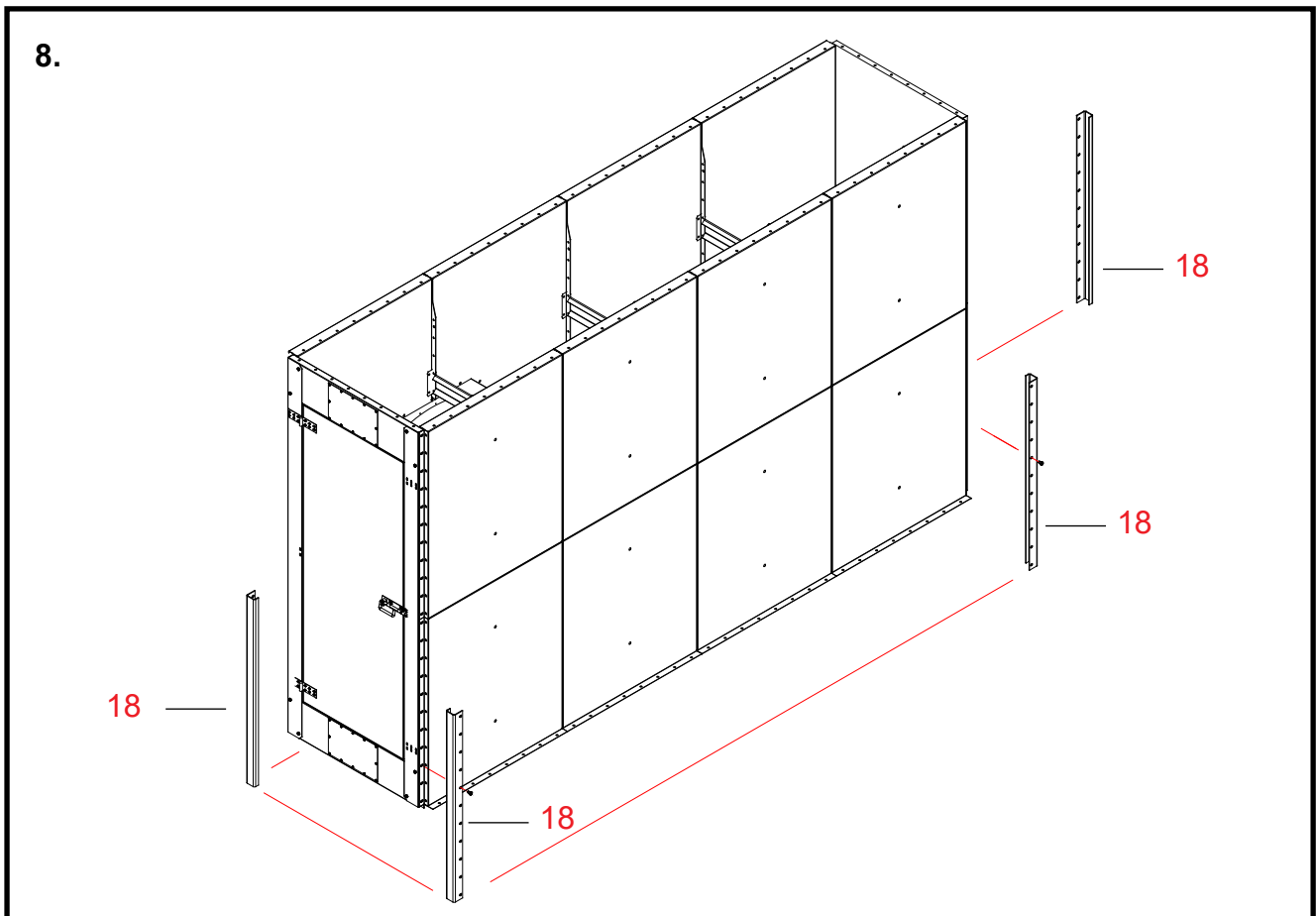
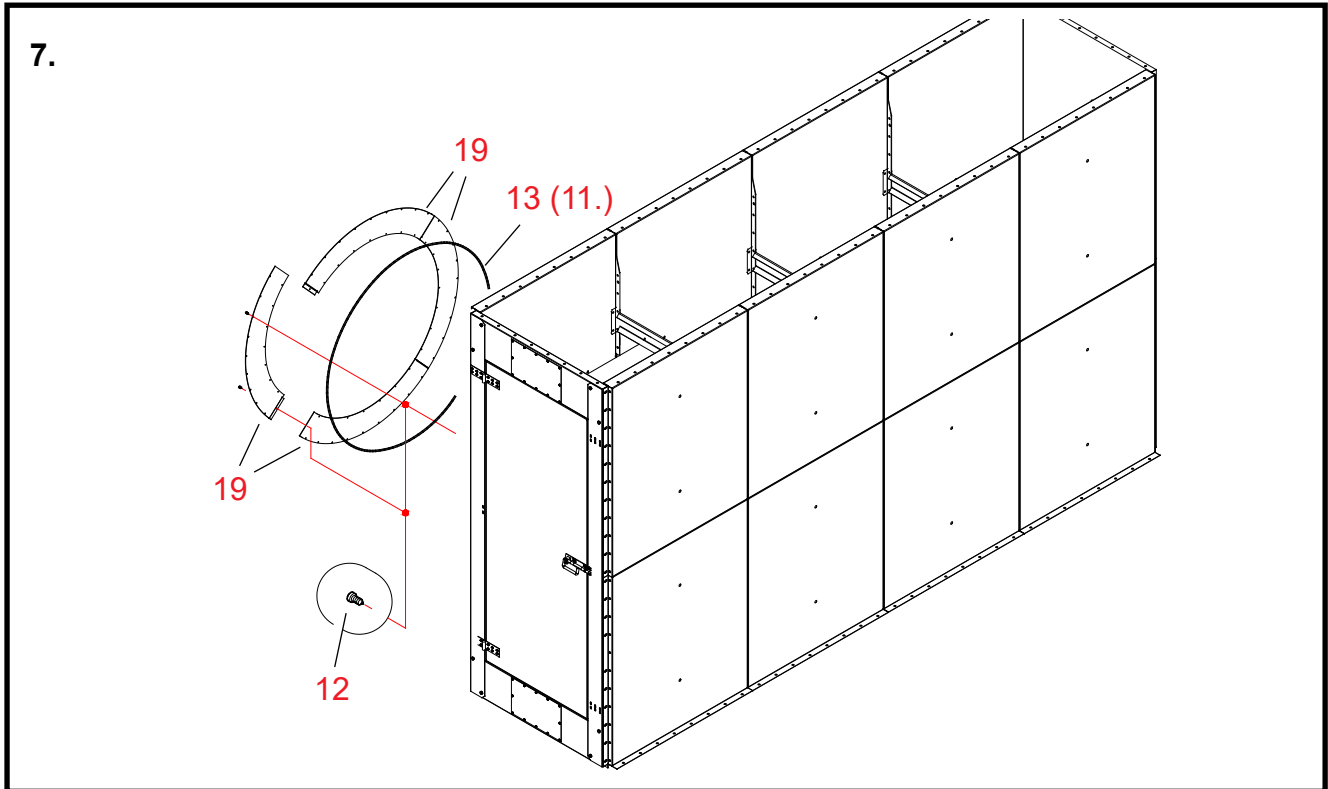


### 5. Installing the rear-plate and the straight support for the air channel end

- 13 (9.) **Fix sealing strips to both end-flanges and lower flanges of the end-plates ( 8 pcs. of parts 7).**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 5).
- 3 **Place the vertical supports (6 pcs.) between the end-plates.**  
*Be careful not to damage the sealing strip while installing the end-plates.*
- 10, 11 **Fix the parts using bolts and nuts (M8 x 16, 11 pcs./plate pair).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 10, 11 **Fix the horizontal seam of the assembled plate pairs using bolts and nuts (M 8 x 16, 8 + 8 + 8 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 8 **Fix the vertical corner-strips (4 pcs) against the flanges at the outer ends of the end-plate set-up.**
- 10, 11 **Fix them in place using bolts and nuts (M 8 x 16, 8 pcs./corner-strip).**
- (7) **Place the rear-plate against the set-up, assembled at stage 4.**
- 10, 11 **Fix the plate by the corner-strip and the lower edge using bolts and nuts (M8 x 16).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 11, 12 **Fix the straight supports for the air channel end to the section using bolts and nuts (M 8 x 16, 2 pcs./support).**  
See detail drawing 6. Tighten the bolts only lightly so that you can straighten the air channel end later.

### 6. Installing the straight support and the octagonal adapter for the air channel end

- 9 **Bend the straight support for the air channel end along the bending line and install it in the vertical support (part 3).**  
Check in the detail drawing A, how to bend the support and, in the main drawing, its correct position.  
Place one end of the support in the vertical support for the other end-plate as shown in the detail drawing B.
- 10, 11 **Fix both ends of the support using bolts and nuts (M8 x 16, 2 + 2 pcs.).**
- 14 **Assemble the octagonal adapter of the four parts.**
- 12 **Fix the parts using self-tapping screws (4,8 x 13, 4 pcs.).**
- 13 (10.) **Fix a sealing strip to the surface of the octagonal adapter (4 x part 14).**  
Fix the sealing strip inside the screw hole circle in the ring.
- 4 x 14 **Place the octagonal adapter outside the air channel end.**  
Align the attachment holes.  
*Be careful not to damage the sealing strip while installing the end-plates.*
- 10, 11 **Fix the adapter using bolts and nuts (M 8 x 16, 24 pcs.).**





## 7. Installing the adapter D1250/1000 for the 1000 mm pipe system

- 19            **As required, assemble the round adapter D1250/1000 of four parts.**
- 12            **Fix the parts using self-tapping screws (4,8 x 13, 4 pcs.).**
- 13 (11.)      **Fix a sealing strip to the surface of the round adapter (4 x part 19).**  
Fix the sealing strip inside the screw hole circle in the ring.
- 4 x 19        **Place the adapter D1250/1000 outside the octagonal adapter.**  
**Align the attachment holes.**
- 8, 9          **Fix the adapter using self-tapping screws (4,8 x 13, 36 pcs.).**
- \*             **See point "Installing the air pipe connector in the air channel end".**  
**If the octagonal adapter / 1250 (part 14) is used: pipe sleeve Ø 1250 mm.**  
**In addition, if adapter D 1250 / 1000 (part 19) is used: pipe sleeve Ø 1000 mm, conversion part 1000/800 mm or 1000/630 mm.**
- 11            **Fix the connector to the air channel end using self-tapping screws (4,8 x 13, 28 pcs.).**
- \*             **Check the joints of the air channel end, its rectangular shape and alignment of the side-plates.**  
**Tighten all bolts.**

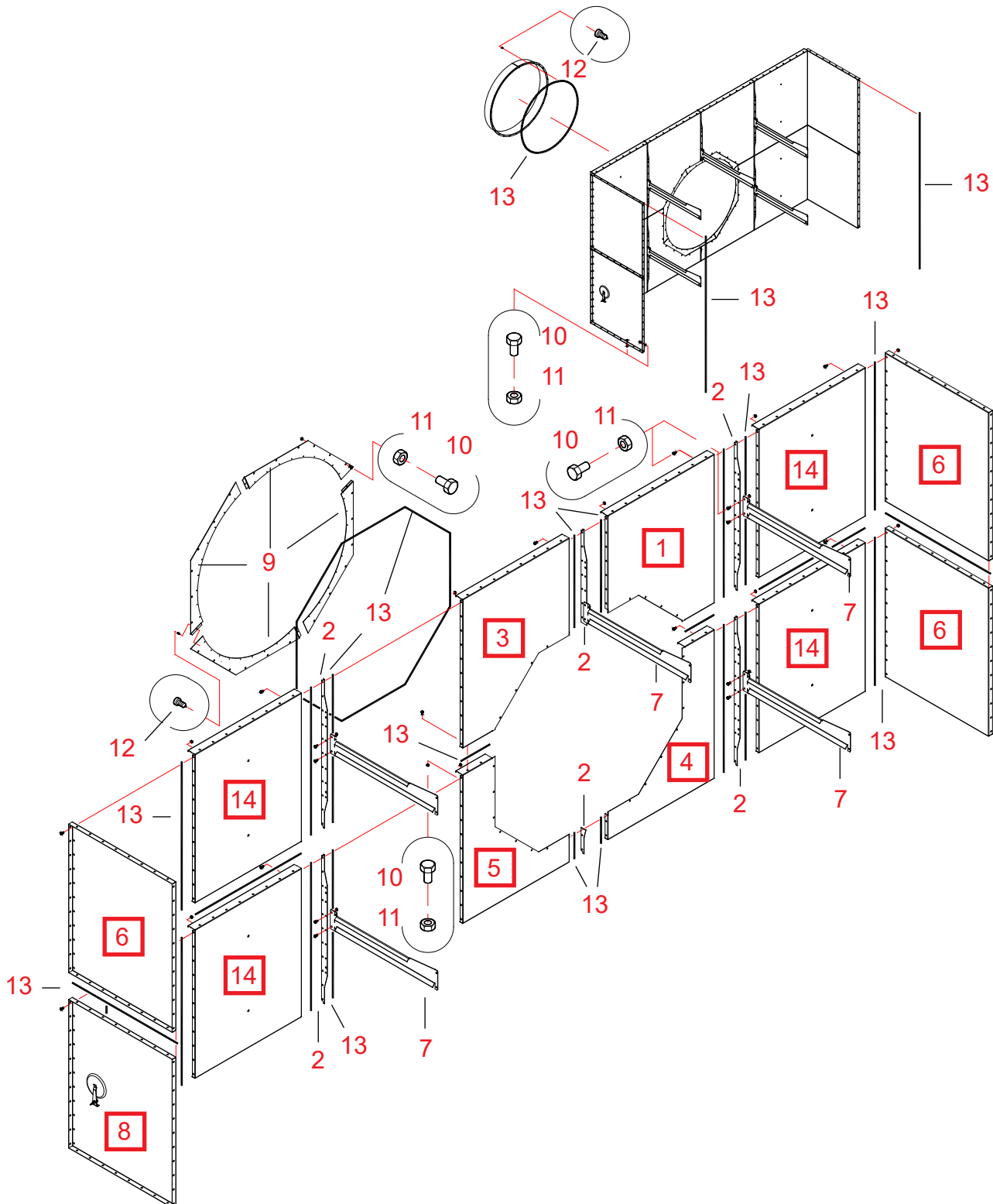
## 8. Installing the ground support legs for the air channel end

- 18            ***Attach the ground support legs for the air channel end only in connection with final assembly of the dryer.***



Air channel end 1,0 4W (A71404) - centre-part S, octagonal / Ø 1250 mm

## Spare parts





20061106

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A71388	AIR CHANN END WM06	OCTAGON TOP/L	1		12.1	3000
2	A70810	TOP SECTION WM06	VERTICAL SUPPORT PL3	6	A70810-B	1.12	3000
3	A71389	AIR CHANN END WM06	OCTAGON TOP/R	1		12.1	3000
4	A71390	AIR CHANN END WM06	OCTAGON BOTTOM/L	1		7.36	3000
5	A71391	AIR CHANN END WM06	OCTAGON BOTTOM/R	1		7.36	3000
6	A70640	AIR CHANN END WM06 1.0	SIDE-PLATE	3	A70640	14.18	3000
7	A70678	AIR CHANN END WM06 1.0	STRAIGHT SUPPORT	5	A70678-B	1.79	3000
8	A71400	AIR CHANN END WM06 1.0	SIDE-PL CLEAN HATCH	1	A71400	14.56	3000
9	A71392	AIR CHANN END WM06	ADAPT OCTAG D1250	4		1.33	3000
10	101810	HEX BOLT ZN 8.8	8X16 AM DIN933	267		0	2010
11	110540	NUT ZN 8 M 8	DIN934	267		0	2010
12	107720	SELF-TAP HEX SCREW	4,8X13 ZN	40		0	2010
13	115570	SEALING STRIP	4X10 MAPA	35		0	260
14	A70563	TOP SECTION/AIR CH END	END-PLATE	4	A70563-B	14.65	3000

## Assembling air channel end A71404

### 1. Assembling the end-plate of the air channel end

Parts The numbering of work stages refers to reference numbers in the spare parts drawing A71404 for the air channel end.

***We recommend carrying out assembly of the air channel end on an even plane.  
This ensures the ready-assembled air channel end is straight.***

**13 (1.)** Fix sealing strips to the long and short end-flanges of the end-plates (parts 4 and 5).

**13 (2.)** Fix sealing strips to the end-flanges of the end-plates (4 pcs. of parts 14).

Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).

**4 + 5** Move the short flanges of the end-plates close to each other.

**2.1** Trim the vertical support to a length of 191.5 mm.

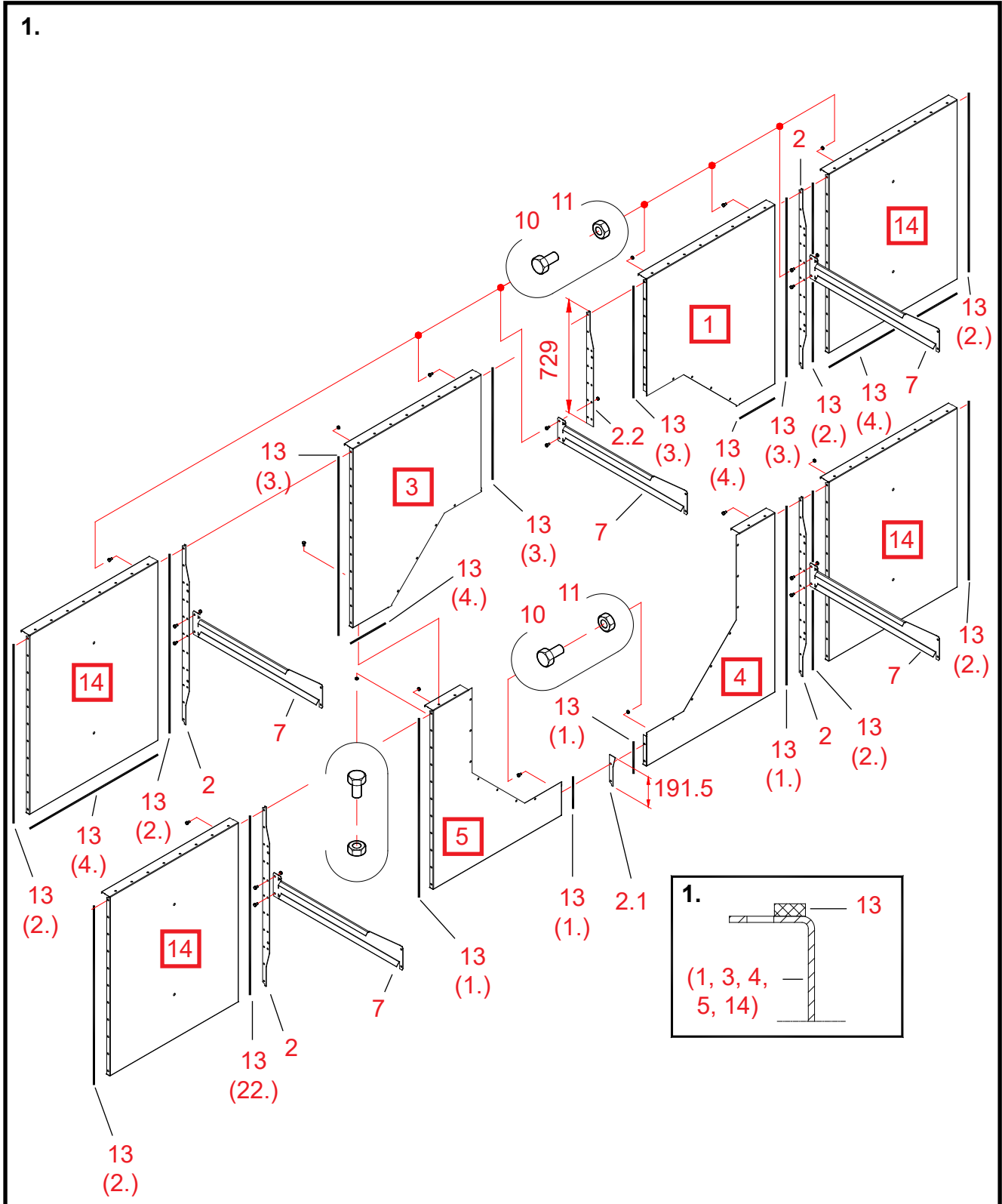
**\*** Place the shortened vertical support between the end-plates.

***Be careful not to damage the sealing strips while installing the end-plates.***

**10, 11** Fix the end-plates and the vertical support using bolts and nuts (M8 x 16, 2 pcs.).

Tighten the bolts only lightly so that you can straighten the air channel end later.

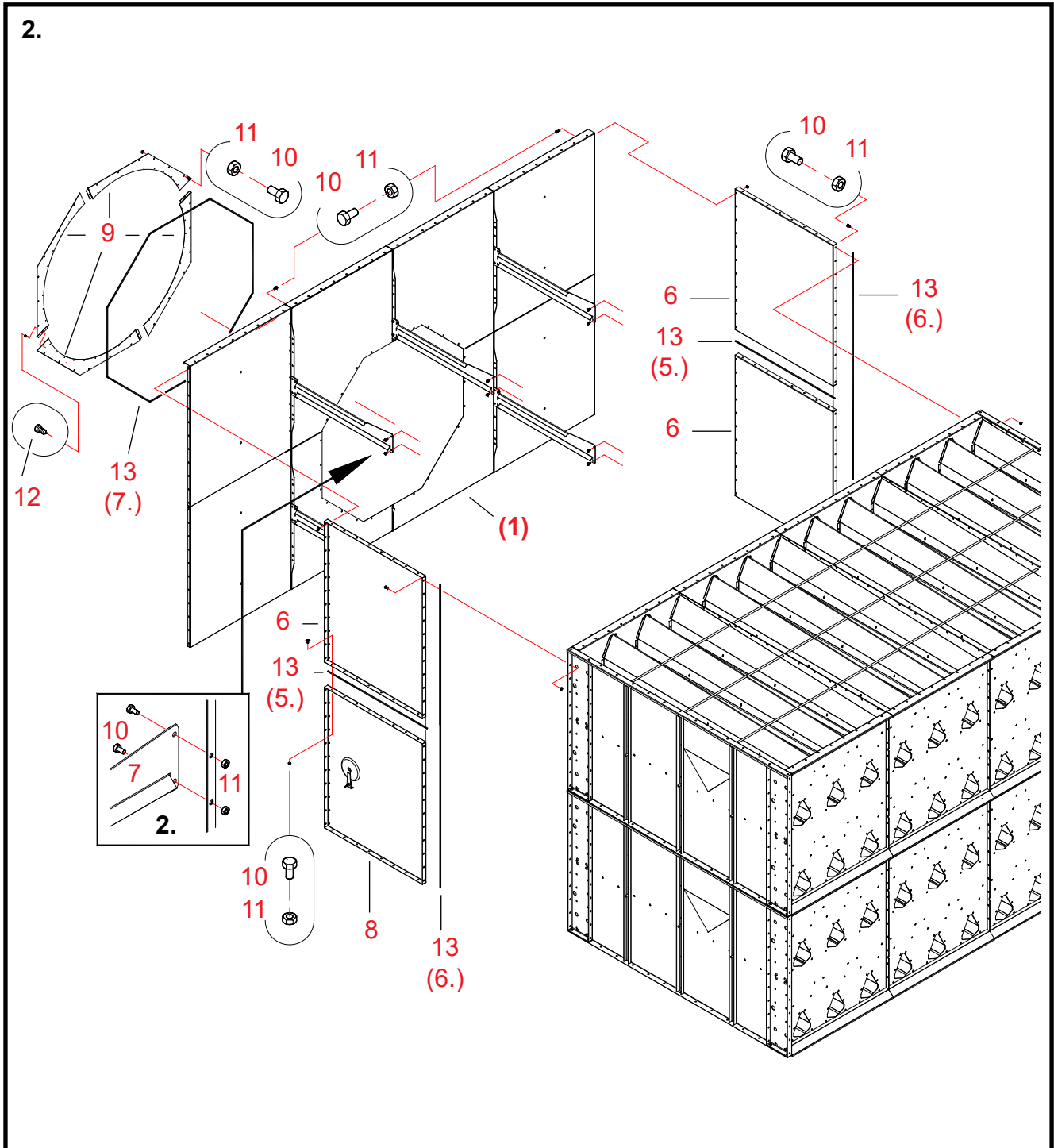
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- 2** Place vertical supports between the end-plates (parts 4 + 5 and 2 pcs. of part 14).  
*Be careful not to damage the sealing strips while installing the end-plates.*
- 10, 11** Fix the end-plates and the vertical supports using bolts and nuts (M8 x 16, 11 + 11 pcs.).  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 13 (3.)** Fix sealing strips to the long and short end-flanges of the end-plates (parts 1 and 3).  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing in drawing 1).
- 1 + 3** Move the short vertical flanges of the end-plates close to each other.
- 2.2** Trim the vertical support to a length of 729 mm.  
**\*** Place the shortened vertical support between the end-plates.  
*Be careful not to damage the sealing strip while installing the end-plates.*
- 10, 11** Fix the parts using bolts and nuts (M8 x 16, 7 pcs.).  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 2** Place vertical supports between the end-plates (parts 1 + 3 and 2 pcs. of part 14).  
*Be careful not to damage the sealing strips while installing the end-plates.*
- 10, 11** Fix the end-plates and the vertical support using bolts and nuts (M8 x 16, 11 + 11 pcs.).  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 13 (4.)** Fix sealing strips to the lower flanges of the end-plates 1 and 3 as well as to two of the parts 14.  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing in drawing 1).
- 1 + 3 + 14**  
**4 + 5 + 14** Move the end-plate set-ups tight against one another.  
*Be careful not to damage the sealing strips while installing the side-plates.*
- 10, 11** Fix the end-plate set-ups using bolts and nuts (M8 x 16, 8 + 2 + 2 + 8 pcs.).  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 7** Install the straight supports (5 pcs.) for the air channel end in the vertical supports for the end-plates.  
Look up correct position for the supports in the drawing.
- 10, 11** Fix the supports using bolts and nuts (M8 x 16, 2 pcs./support).  
Tighten the bolts only lightly so that you can straighten the air channel end later.







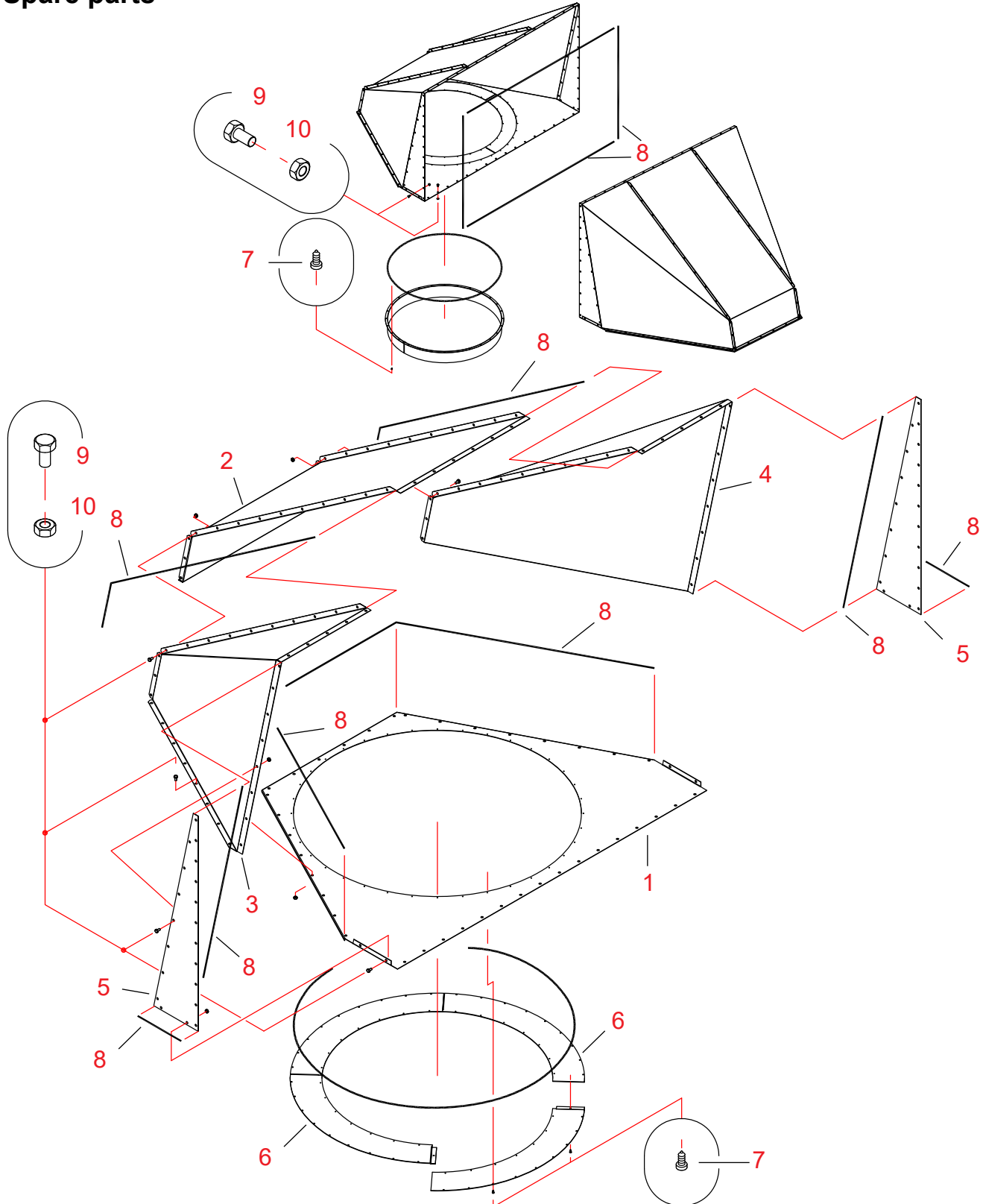
### 2. Installing the side-plates of the air channel end

- 13 (5.) **Fix sealing strips to lower flanges of the two side-plates (parts 6).**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing in drawing 1).
- 6 + 6 **Join together two identical side-plates (parts 6).**  
*Be careful not to damage the sealing strips while installing the side-plates.*
- 10, 11 **Fix the side-plates using bolts and nuts (M8 x 16, 8 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- \* **Join together another pair of side-plates so, that the lower part comes with a control opening (part 8).**
- 13 (6.) **Fix sealing strips to the flanges of the side-plate pairs to be attached to the drying sections.**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing in drawing 1).
- 6 + 8 **Move the side-plate pair (the one closer in the picture) against the sections.**  
*Be careful not to damage the sealing strips while installing the side-plates.*
- 10, 11 **Fix the side-plate pair using bolts and nuts (M8 x 16, 11 + 11 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 6 + 6 **Attach the other side-plate pair (the one farther away in the picture) to the sections in the same way.**
- (1) **Move the end-plate set-up, assembled at stage 1, between the side-plates.**  
*Be careful not to damage the sealing strips while installing the side-plates.*
- 10, 11 **Fix the end-plate set-up using bolts and nuts (M8 x 16, 4 + 11 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 10, 11 **Fix the straight supports for the air channel end to the section using bolts and nuts (M 8 x 16, 5 x 2 pcs.).**  
See detail drawing 2. Tighten the bolts only lightly so that you can straighten the air channel end later.
- 9, 12 **Assemble the octagonal adapter of the four parts.**  
**Fix the parts using self-tapping screws (4,8 x 13, 4 pcs.).**
- 13 (7.) **Fix a sealing strip to the surface of the octagonal adapter (4 x part 9).**  
Fix a sealing strip inside the outer screw hole circle in the ring.
- 4 x 9 **Place the octagonal adapter outside the air channel end.**  
*Be careful not to damage the sealing strip while installing the end-plates.*
- 10, 11 **Fix the parts using bolts and nuts (M8 x 16, 24 pcs.).**
- \* **See point "Installing the air pipe connector in the air channel end". Pipe sleeve Ø 1250 mm.**
- 11 **Fix the connector to the air channel end using self-tapping screws (4,8 x 13, 28 pcs.).**
- \* **Check the joints and rectangular shape of the air channel end. Tighten all bolts.**



Air channel end 2W / 3W / 4W (A71090) - centre-part L,  $\varnothing$  1250 / 1000 mm

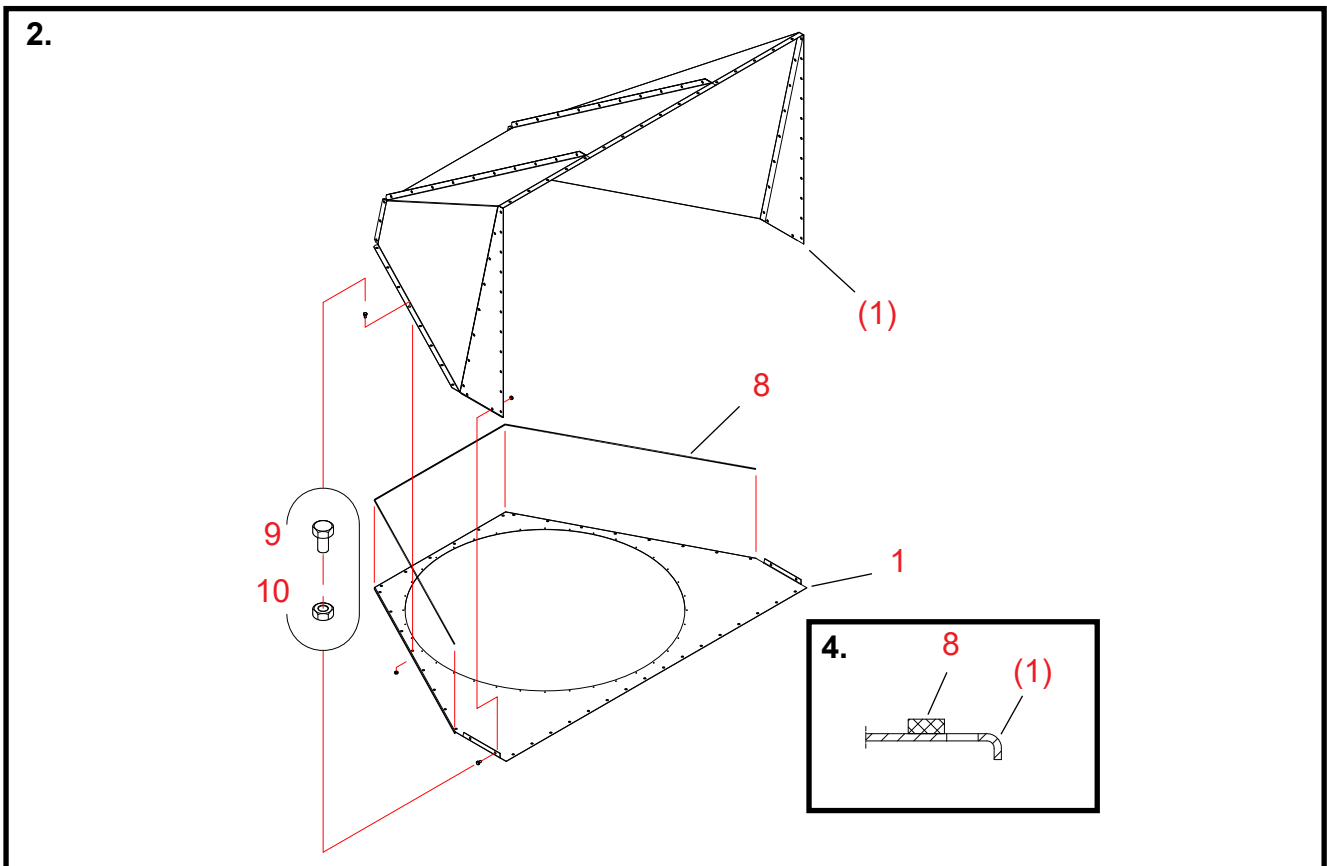
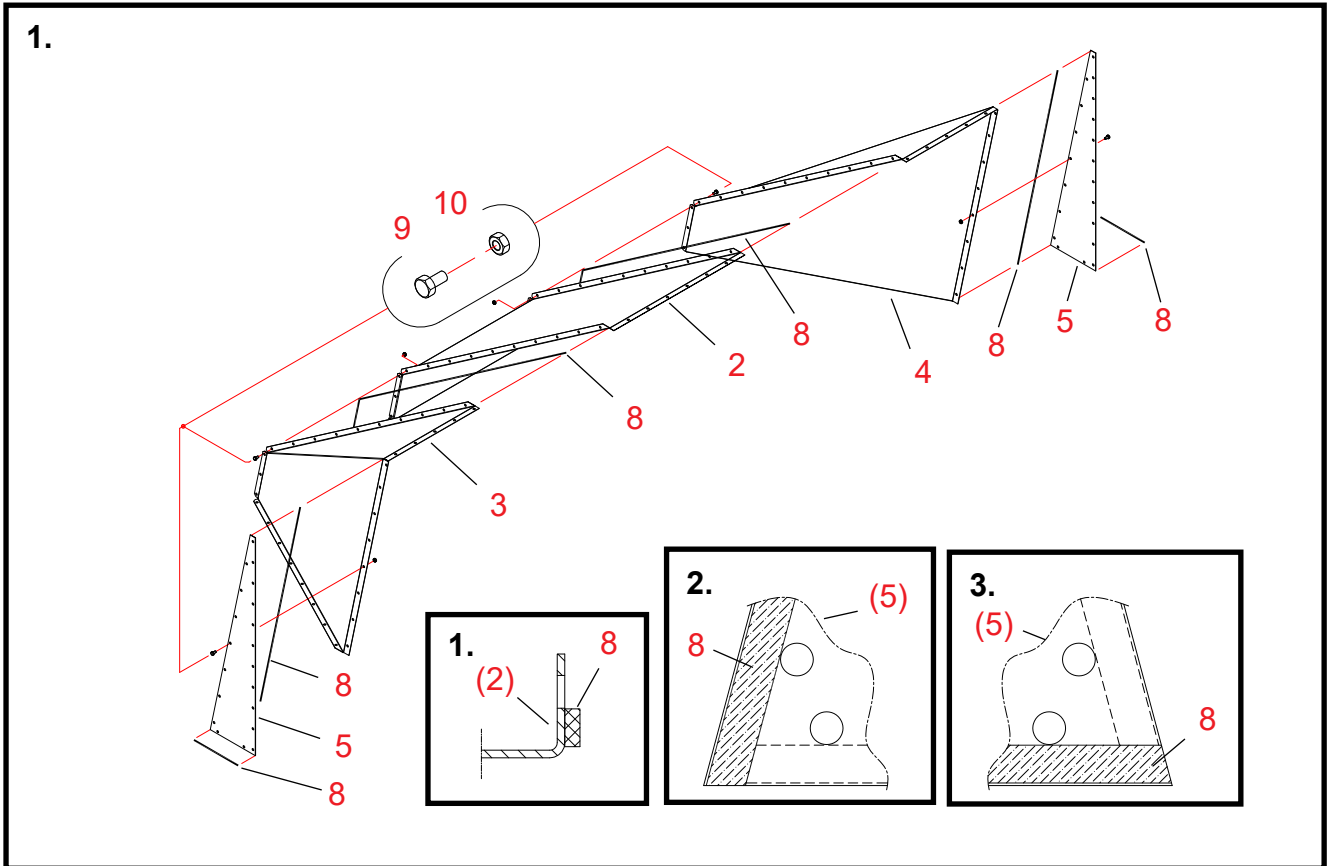
## Spare parts





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Ref.	Part no.	Denomination 1	Pcs.	Drawing No.	Weight	Group
1	A71084	AIR CHANN END SHUTTER-PL SINGLE D1250 WM06 L	1	A71084	10,1	3000
2	A71086	AIR CHANN END SINGLE D1250 WM06 L CENTRE	1	A71086	18,6	3000
3	A71087	AIR CHANN END SINGLE RIGHT D1250 WM06 L	1	A71087	16,6	3000
4	A71088	AIR CHANN END SINGLE LEFT D1250 WM06 L	1	A71088	16,6	3000
5	A71089	AIR CHANN END TRIANGLE D1250 WM06 L	2	A71089	2,1	3000
6	A71254	AIR CHANN END 1/4 CIRCLE D1250/1000 WM06	4	A71254	2,0	3000
7	107720	SELF-TAP HEX SCREW 4,8X13 ZN	72			2010
8	115570	SEALING STRIP 4X8 EKO-40	24			2600
9	101810	BOLT HEX ZN 8.8 8X16 AM DIN933	126			2010
10	110540	NUT M8 ZN 8 DIN934	126			2010





## Assembling air channel end A71090

*We recommend carrying out assembly of the air channel end on an even plane.  
This ensures the ready-assembled air channel end is straight.*

### 1. Assembling the end-plate set-up for the air channel end

(See drawing on the previous page)

- Parts            The numbering of work stages refers to reference numbers in the spare parts drawing A71090 for the air channel end.
- 8**                **Fix sealing strips to both end-flanges of the diagonal end's centre-part (part 2).**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1 on the previous page).
- 2, 3, 4**         **Join together the centre-part and the left and right side-parts of the diagonal end.**  
*Be careful not to damage the sealing strips while joining the parts.*
- 9, 10**         **Fix the joints of the diagonal end (2, 3 and 4) using bolts and nuts (M8 x 16, 11 + 11 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 8**                **Fix the long sealing strips to the sides with 7 holes of the triangular plates (parts 5).**  
Fix the sealing strips to the edge of the plate, outside the screw hole rows (see detail drawing 2 on the previous page).  
Observe, that you should make one right-handed and one left-handed plate, i.e place the sealings on opposite sides of the plate.  
The triangular plate to be attached to the left side of the diagonal end is shown in the detail drawing 2.
- 8**                **Fix the short sealing strips to the sides with 2 holes of the triangular plates (parts 5).**  
Fix the sealing strips to the edge of the plate, outside the screw hole rows (see detail drawing 3 on the previous page).  
Observe, that the short sealings are fixed on different side of the plate than the long ones.  
The triangular plate to be attached to the left side of the diagonal end is shown in the detail drawing 3.
- 4**                **Move the triangular plates tight against the ends of the diagonal end set-up.**  
*Be careful not to damage the sealing strips while installing the side-plates.*
- 9, 10**         **Fix the triangular plates using bolts and nuts (M 8 x 16, 7 pcs./triangular plate).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.

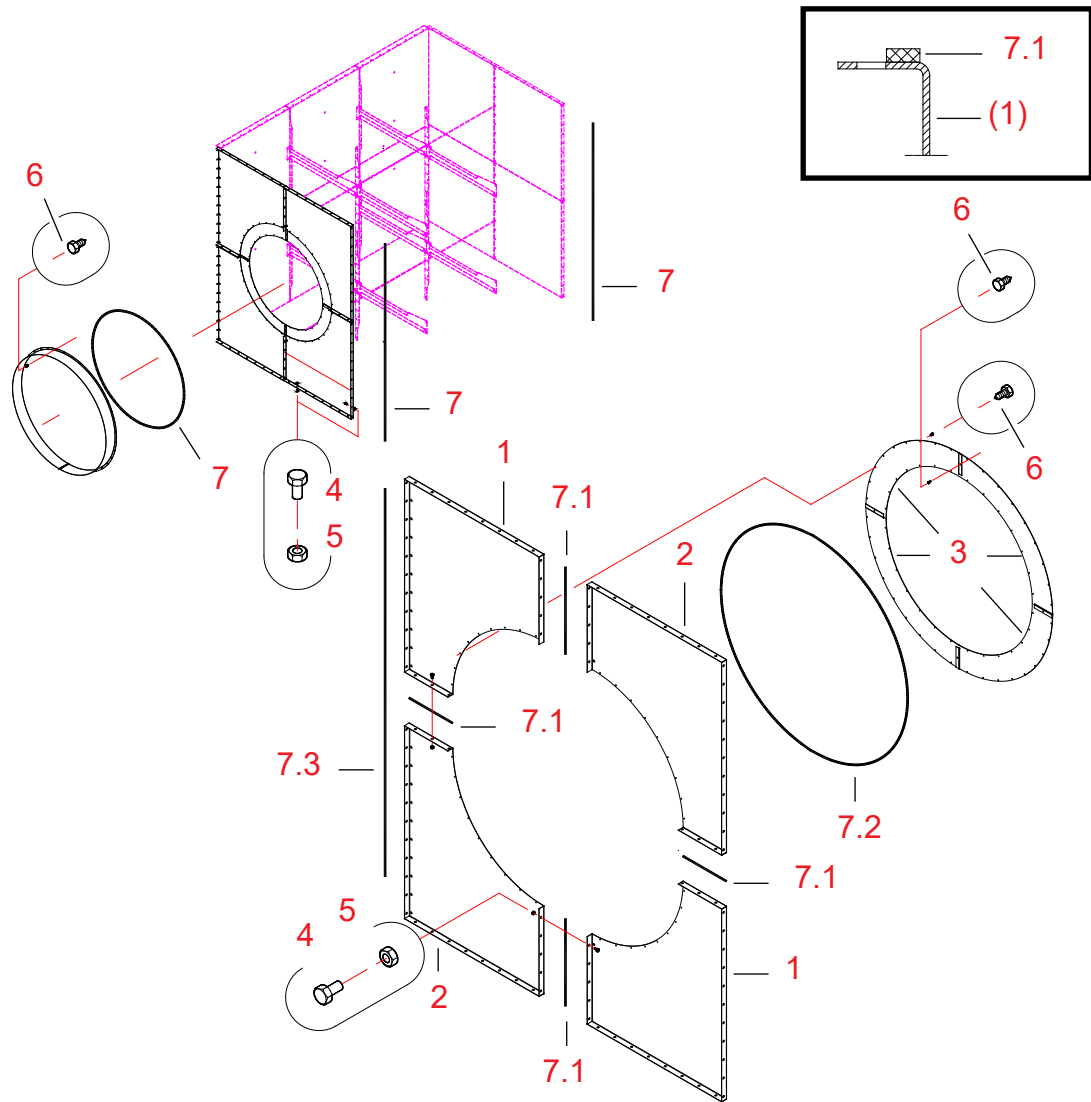
### 2. Assembling the air channel end

- 8**                **Fix sealing strips to the upper surface of the shutter-plate at the centre-part and the side-parts of the diagonal end.**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 4).
- 1**                **Attach the shutter-plate to the lower surface of the diagonal end, assembled at stage 1.**  
Place the lower ends of the triangular plates inside the vertical flanges.  
*Be careful not to damage the sealing strips while joining the parts.*
- 9, 10**         **Fix the shutter-plate to the diagonal end and the triangular plates using bolts and nuts (M 8 x 16, 22 pcs.).**
- \***                **See point "Installing the air pipe connector in the air channel end".**  
Pipe sleeve Ø 1250 mm, pipe sleeve Ø 1000 mm, conversion part 1000/800 mm or 1000/630 mm.
- 7**                **Fix the adapter (parts 6) to the air channel end using self-tapping screws (4,8 x 13, 28 pcs.).**
- \***                **Check the joints and rectangular shape of the air channel end. Tighten all bolts.**



Air channel end 1,0 x 2 x 2 (A71245) - side opening, Ø 1250 mm / Ø 1000 mm

## Spare parts



20061106

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A71246	AIR CH END WM06 1.0X2X2	SIDE D1250 1PL	2	A71246	10.04	3000
2	A71247	AIR CH END WM06 1.0X2X2	SIDE D1250 2PL	2	A71247	10.04	3000
3	A71254	AIR CHANN END WM06	1/4 CIRCLE D1250/1000	4	A71254-A	2	3000
4	101810	HEX BOLT ZN 8.8	8X16 AM DIN933	76		0	2010
5	110540	NUT ZN 8 M 8	DIN934	76		0	2010
6	107720	SELF-TAP HEX SCREW	4,8X13 ZN	68		0	2010
7	115570	SEALING STRIP	4X10 MAPA	16		0	2600



## Assembling the side opening for the air channel end A71245

The side opening for the air channel end can be installed in place of side-plates of the 1,0 x 2 x 2 air channel end  
(e.g. 2 pcs. A70976 + A70980)

### 1. Assembling the side-plates of the air channel end

Parts The numbering of work stages refers to reference numbers in the spare parts drawing A71245 for the air channel end.

*We recommend carrying out assembly of the air channel end on an even plane.  
This ensures the ready-assembled air channel end is straight.*

7.1 **Fix sealing strips to the short flanges of the side-plates 1.**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing).

1 + 2 **Place the short flanges of the side-plates face to face.**  
*Be careful not to damage the sealing strips while installing the end-plates.*

4, 5 **Fix the side-plates using bolts and nuts (M8 x 16, 2 x 5 pcs + 2 x 3 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.

3 **Assemble the octagonal adapter of the four parts.**

6 **Fix the parts using self-tapping screws (4,8 x 13, 4 pcs.).**

7.2 **Fix a sealing strip to the surface of the octagonal adapter (4 x part 6).**  
Fix a sealing strip inside the outer screw hole circle in the ring.

4 x 6 **Place the adapter inside the air channel end.**  
Align the attachment holes.  
*Be careful not to damage the sealing strip while installing the adapter ring.*

6 **Fix the adapter using self-tapping screws (4.8 x 13, 36 pcs.).**

### 2. Assembling side-plate set-up for the air channel end

7.3 **Fix a sealing strip to the vertical flange of the side-plate set-up.**  
Fix the sealing strip inside the screw hole row in the flange (see detail drawing).

(1) **Install the side-plate set-up as side-plate for the assembled air channel end.**  
*Be careful not to damage the sealing strip while installing the end-plate.*

4, 5 **Fix the side-plate set-up using bolts and nuts (M8 x 16, 22 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.

\* **See point "Installing the air pipe connector in the air channel end".**  
Without adapter: pipe sleeve Ø 1250 mm.  
If adapter D 1250 / 1000 (part 3) is used:  
pipe sleeve Ø 1000 mm, conversion part 1000/800 mm or 1000/630 mm.

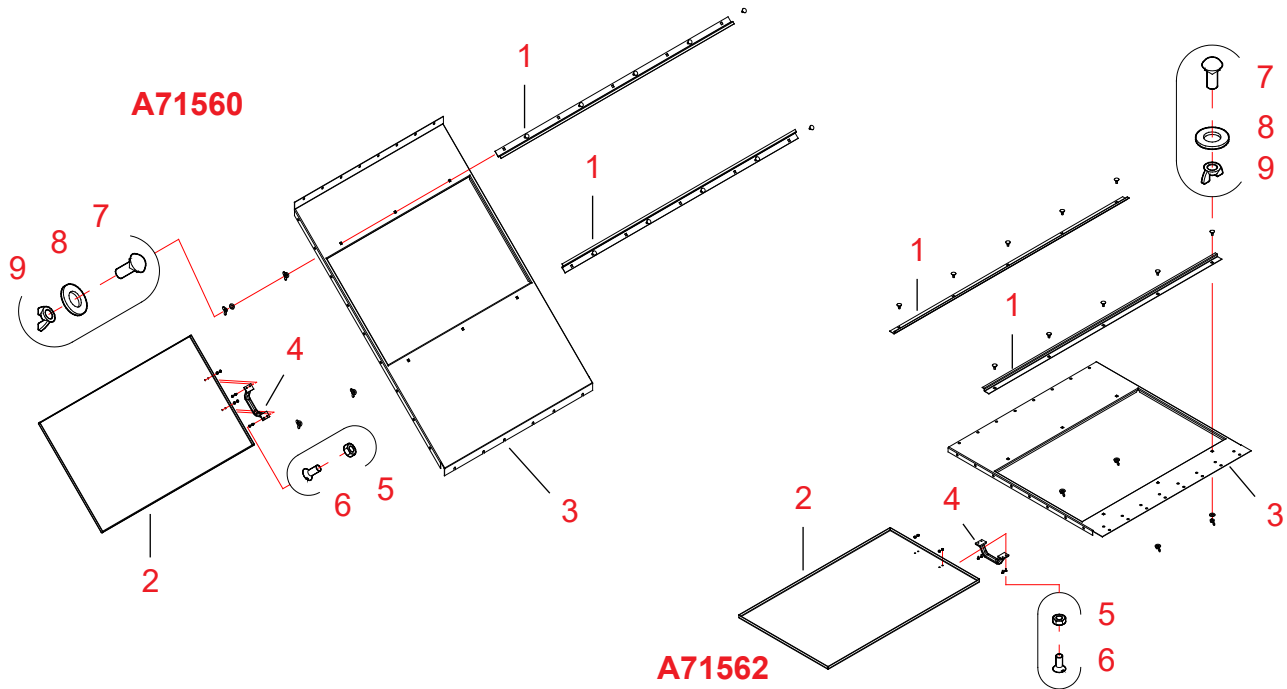
11 **Fix the connector to the air channel end using self-tapping screws (4,8 x 13, 28 pcs.).**

\* **Check the joints of the air channel end, its rectangular shape and alignment of the side-plates.**  
Tighten all bolts



**Air channel end 1,0 (A71560) - replacement air opening in the return bottom**  
**Air channel end 1,0 (A71562) - replacement air opening in the shutter-plate**

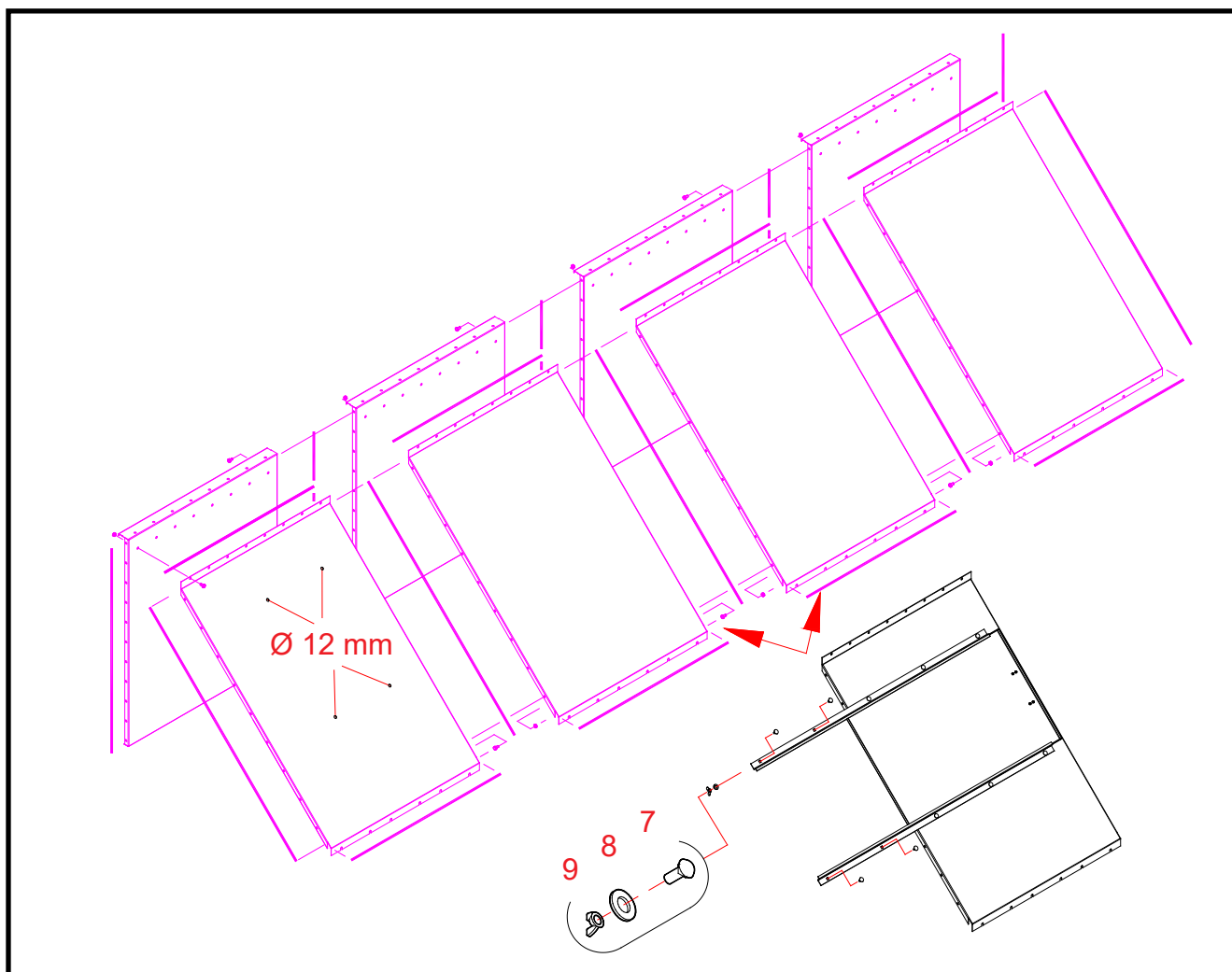
## Spare parts



20070322

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
A71560							
1	A71555	AIR CHANN END WM06	REPLAC AIR GUIDE	2	A71555-0	0.95	
2	A71556	AIR CHANN END WM06	REPLAC AIR PLATE	1	A71556-0	9.44	
3	A71557	AIR CHANN END WM06	1.0 RET BOTT WITH OPEN	1	A71557-0	14.99	
4	119034	PLAST HANDLE	LGT GREY PISLA 805	1	119034-	0.59	
5	110520	NUT ZN 8 M 5	DIN934	4		0	
6	103691	BOLT CTRSUNK SLOT	5X12XAM	4		0	
7	107913	LOCK SCREW ZN	M8X20 DIN603 8.8	10		0.02	
8	111560	WASHER ZN	M12 ZN DIN 125	10		0	
9	111020	NUT WING ZN	M 8 DIN315	10		0.01	
A71562							
1	A71555	AIR CHANN END WM06	REPLAC AIR GUIDE	2	A71555-0	0.95	
2	A71556	AIR CHANN END WM06	REPLAC AIR PLATE	1	A71556-0	9.44	
3	A71559	AIR CHANN END WM06	1.0 SHUTT-PL WITH OPEN	1	A71559-0	7.97	
4	119034	PLAST HANDLE	LGT GREY PISLA 805	1	119034-	0.59	
5	110520	NUT ZN 8 M 5	DIN934	4		0	
6	103691	BOLT CTRSUNK SLOT	5X12XAM	4		0	
7	107913	LOCK SCREW ZN	M8X20 DIN603 8.8	10		0.02	
8	111560	WASHER ZN	M12 ZN DIN 125	10		0	
9	111020	NUT WING ZN	M 8 DIN315	10		0.01	





## Installing the replacement air opening A71560

The replacement air opening can be installed in place of one of the return bottom plates in the return bottom (A70748).

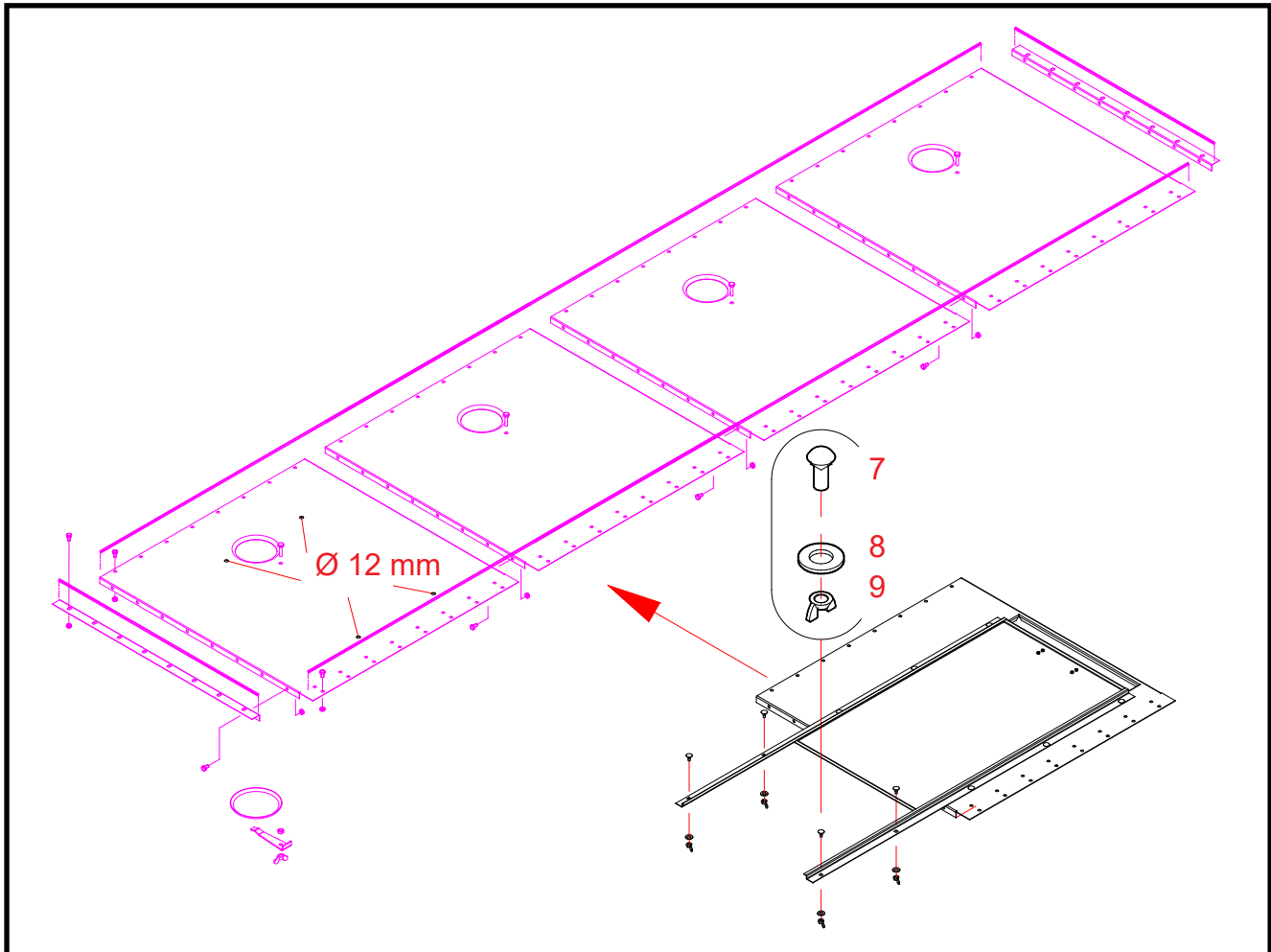
If possible, install the replacement air opening in one of the midmost modules of the air channel end.

### Installing the replacement air plate

Parts The numbering of parts refers to reference numbers in the spare parts drawing A71560 for the air channel end.

*Please refer to the assembly instructions for the return end A70748.*

1. The replacement air plate shall be installed in the same way as the return bottom, indicated by the arrow.
2. Drill four Ø 12 mm holes in the return bottom on the left-hand side in the drawing. Mark the places for the holes in accordance with the square holes in the guide strips.
3. Attach the guide strips to the left return bottom. Lock screws (parts 7), washers (parts 8) and wing nuts (parts 9) (M 8 x 20, 4 pcs.).



## Installing the replacement air opening A71562

The replacement air opening can be installed in place of one of the shutter-plates of the shutter-plate (A70956)

If possible, install the replacement air opening in one of the midmost modules of the air channel end.

### Installing the replacement air plate

Parts The numbering of parts refers to reference numbers in the spare parts drawing A71562 for the air channel end.

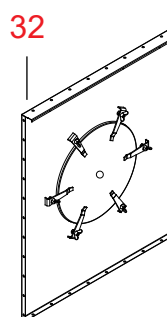
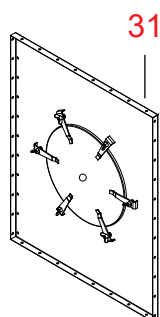
*Please refer to the assembly instructions for the lower shutter-plate A70956.*

1. The replacement air plate shall be installed in the same way as the return bottom, indicated by the arrow.
2. Drill four Ø 12 mm holes in the shutter-plate on the left-hand side in the drawing. Mark the places for the holes in accordance with the square holes in the guide strips.
3. Attach the guide strips to the left shutter-plate.  
Lock screws (parts 7), washers (parts 8) and wing nuts (parts 9) (M 8 x 20, 4 pcs.).



## Air channel end 1,0 (A71386), manhole hatch - sideplate

## Air channel end (A71406), manhole hatch - end-plate

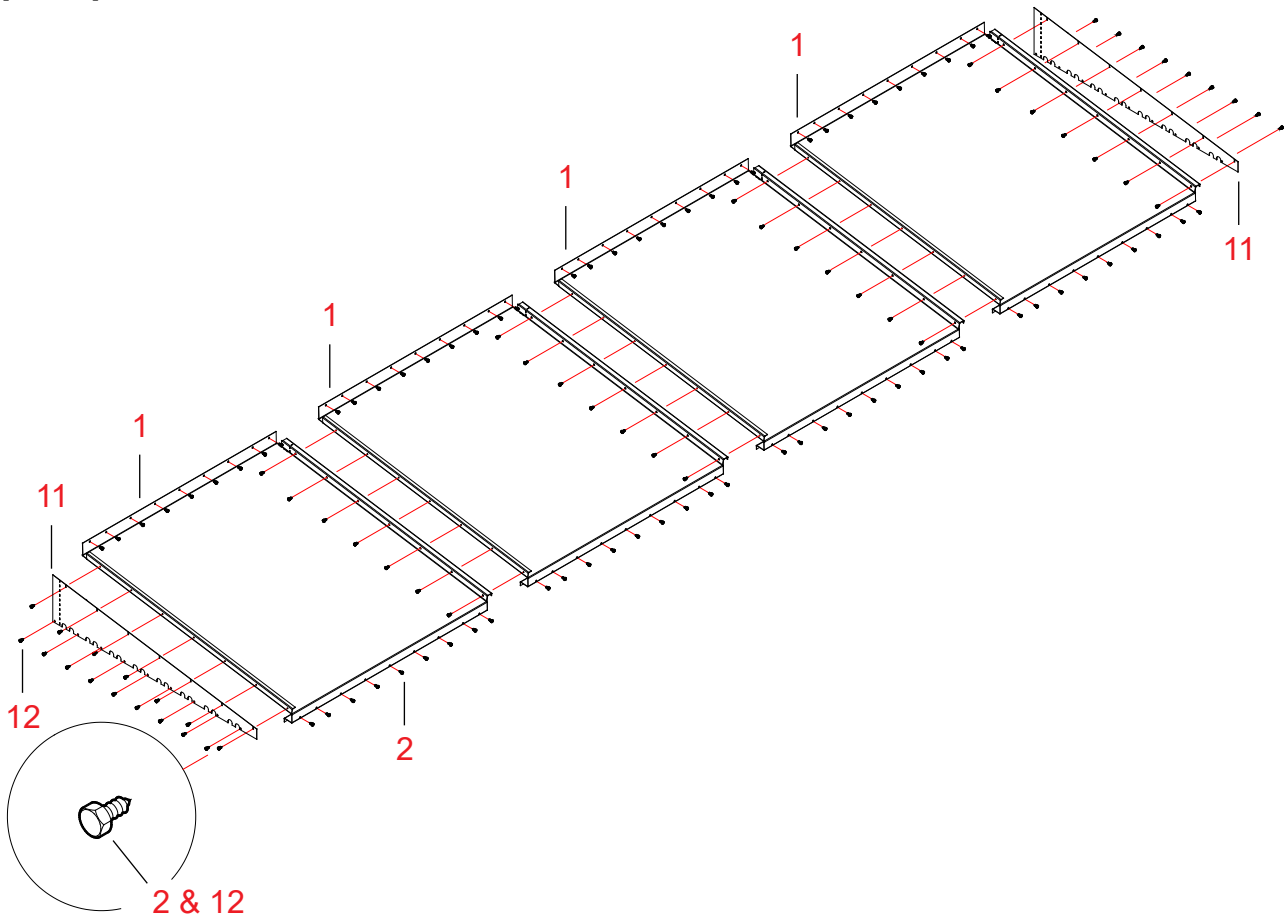


20080715

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
31	A71386	AIR CHANN END WM06 1.0	SIDE-PLATE MANHOLE	1	A71386-A	16.19	3000
32	A71406	AIR CHANN END WM06	END-PLATE MANHOLE HATCH	1	A71406-A	16.65	3000

## Rain roof (A72231, A72232) for the 1,0 m air channel end of 4W

### Spare parts



20080822

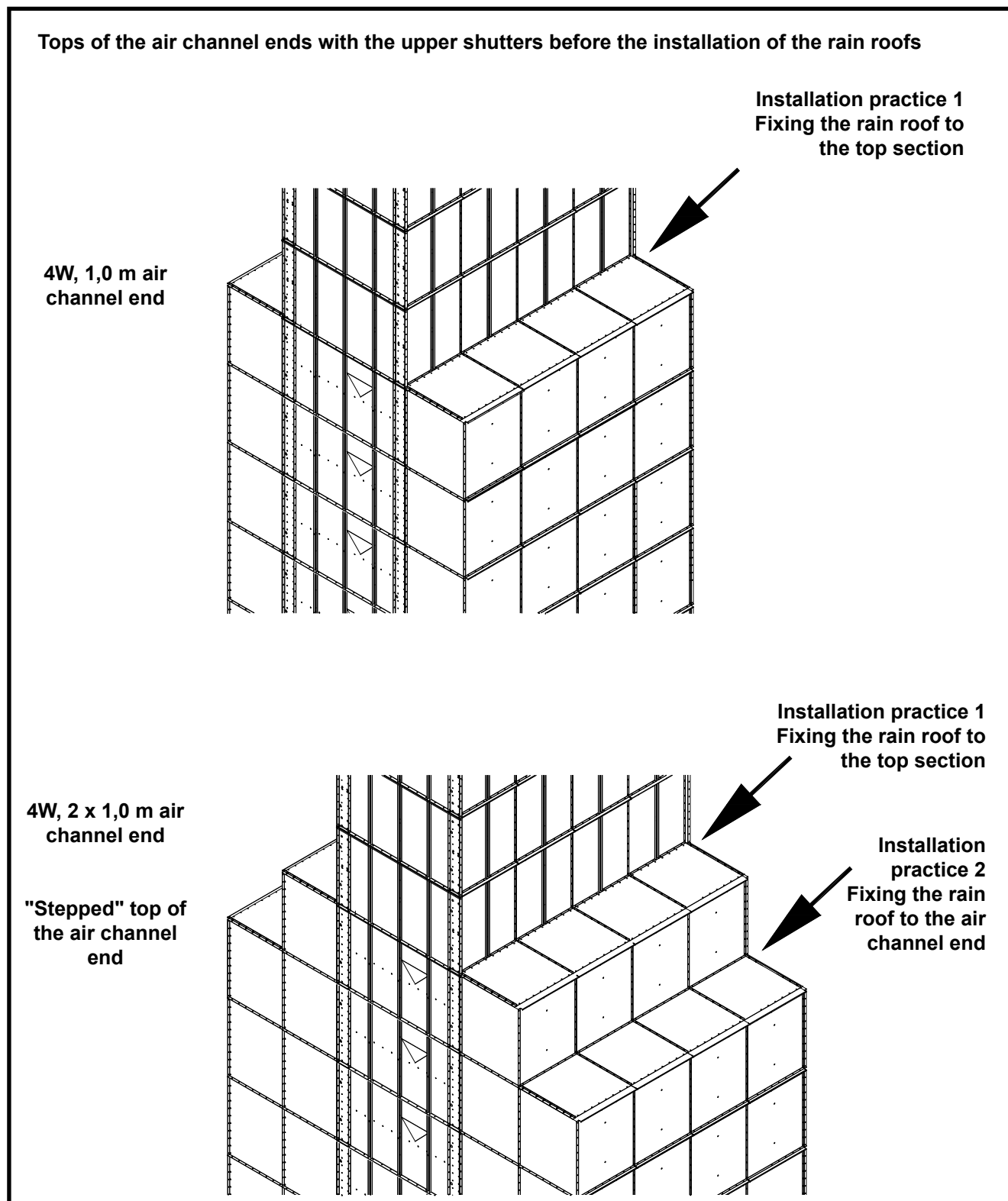
Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
4 pcs. of roof plates A72231 with their screws are required for one 1,0 m air channel end on 4W dryer.							
-	A72231	AIR CH END WM06 1.0 Includes parts 1 (1 pc.) and 2 (27 pcs.)	SLANTING ROOF	1	A72231-0		
1	A72223	AIR CH END WM06 1.0	ROOF PLATE	1			
2	107720	SELF-TAP HEX SCREW	4,8X13 ZN	27		0	2010

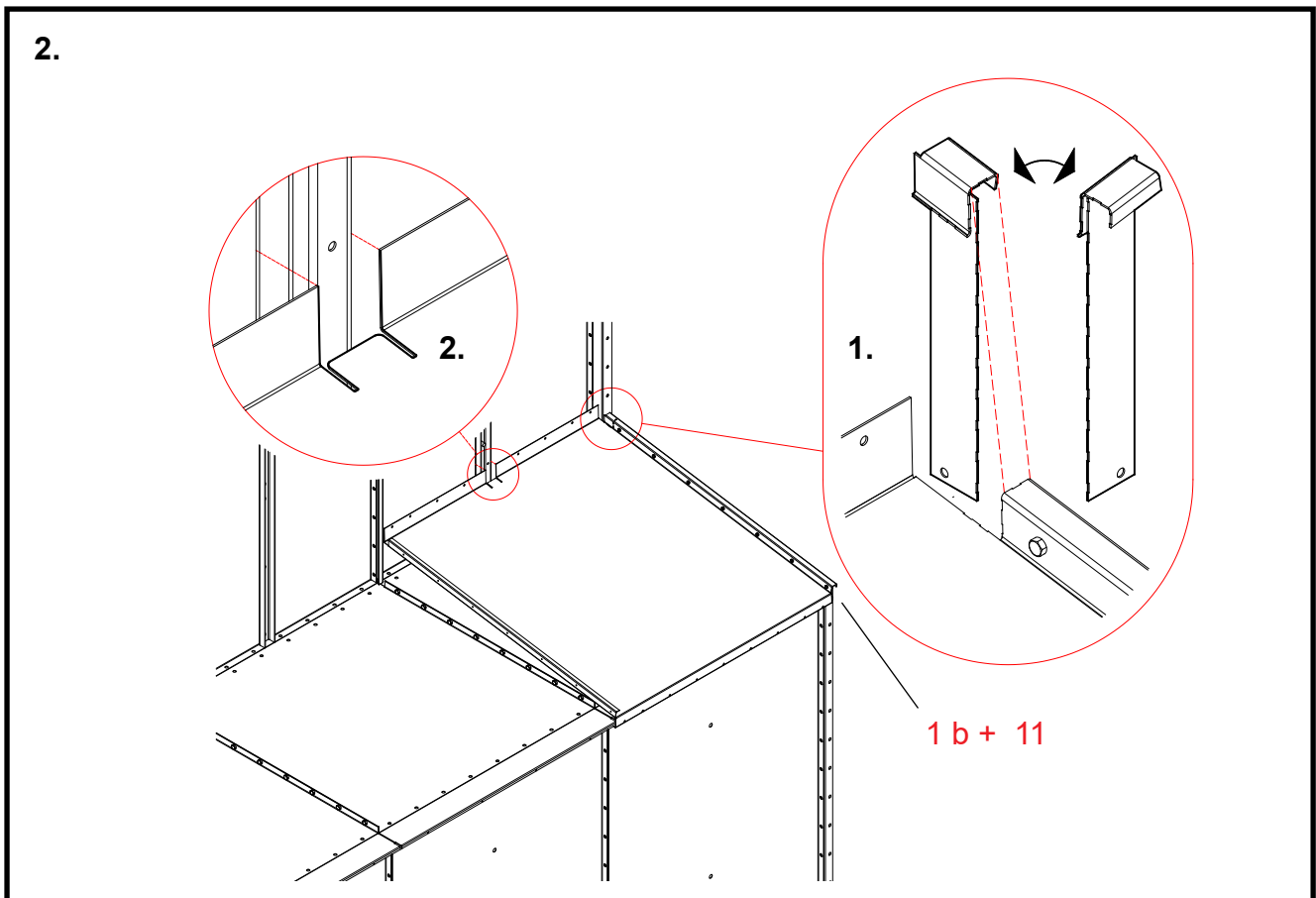
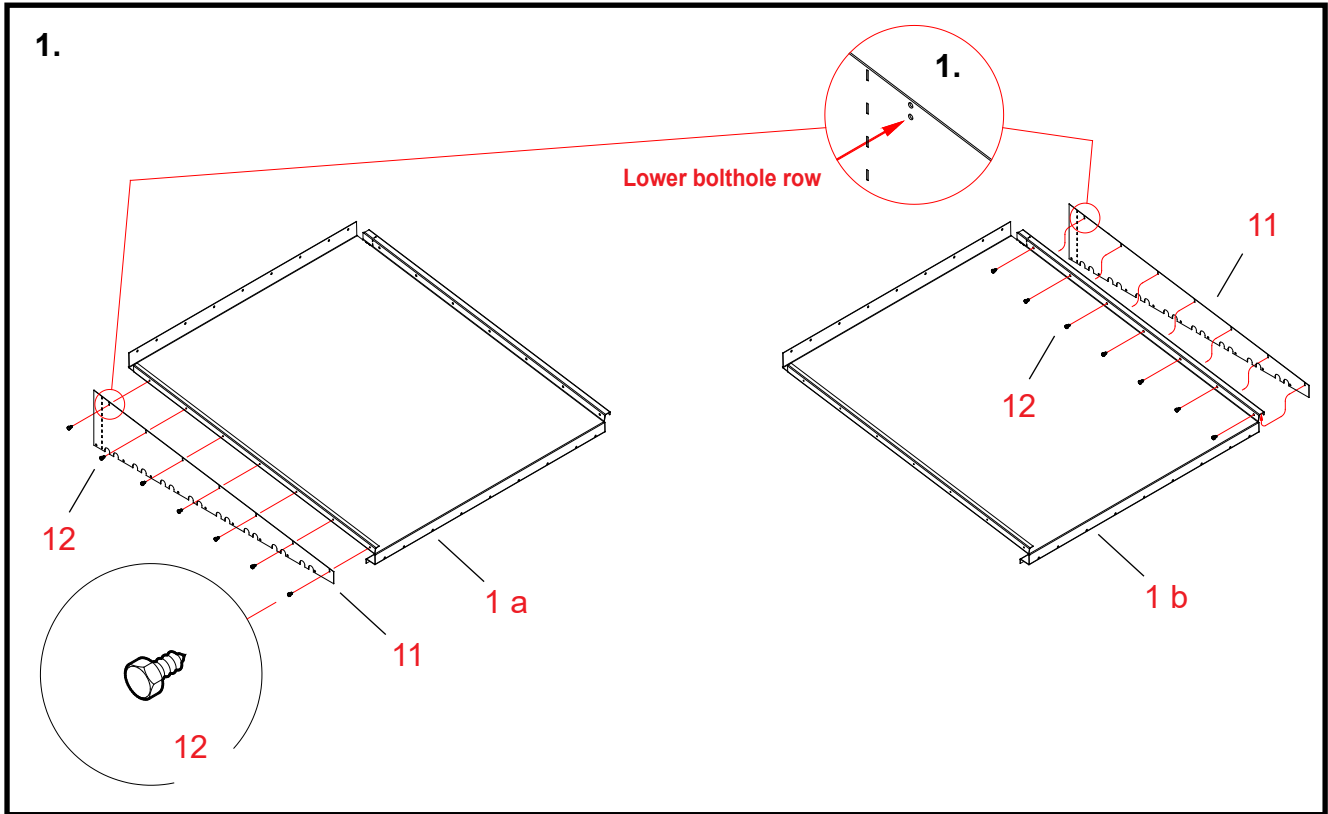
One pair of end cover plates A72232 with screws are required for one 1,0 m air channel end on 4W dryer.

-	A72232	AIR CH END WM06 1.0 Includes parts 11 (2 pc.) and 12 (27 pcs.)	SLANTING ROOF END COVER	1	A72232-0		
11	A72226	AIR CH END WM06 1.0	SLANTING ROOF END COVER	2	A72232-0		
12	107720	SELF-TAP HEX SCREW	4,8X13 ZN	27		0	2010

## Installing the rain roof (A72231, A72232) for the 1,0 m air channel end

The rain roof can be installed either on 1,0 m or 2 x 1,0 m air channel end







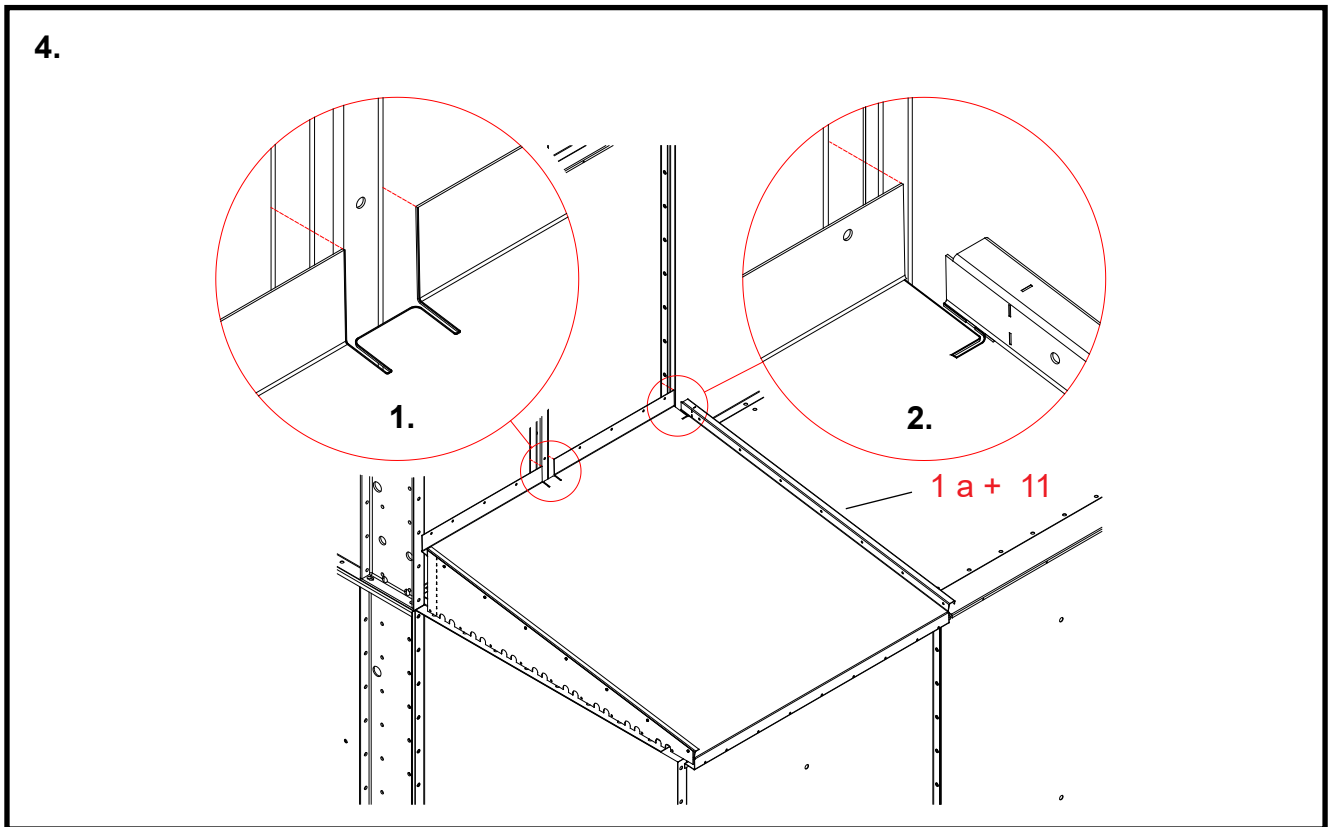
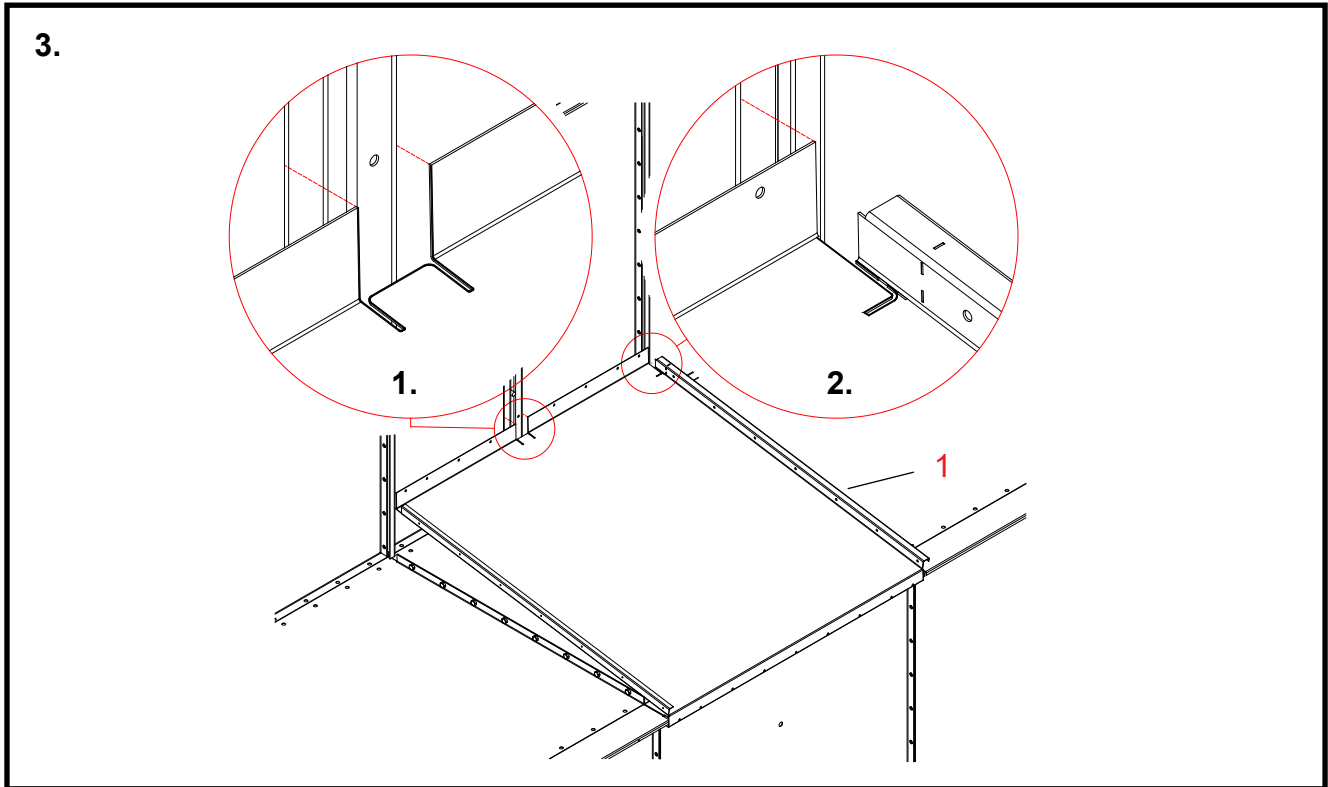
**Stages 1 - 8: Installation practice 1: Fixing the rain roof to the wall of the top section (air channel ends 1 x 1,0 m and 2 x 1,0 m).**

### 1. Joining together the slanting roof plates of the rain roof and the end covers

- Parts            The numbering of work stages refers to reference numbers in the spare parts drawing (A72231. A72232) for the rain roof.
- 1 a + 11        Place the end cover against the outer face of the slanting roof plate's end fold (the foremost in the drawing).  
Align the bolthole row of the end cover, the lower in the drawing, with the bolthole row in the slanting roof plate.  
See detail drawing 1.**
- 12                Fix the parts (1 a +11) using self-tapping screws (4,8 x 13, 7 pcs.).  
Place the screw caps against the end cover.**
- 1 b + 11        Place the end cover inside the slanting roof plate's end fold (the rearmost in the drawing).  
Align the bolthole row of the end cover, the lower in the drawing, with the bolthole row in the slanting roof plate.  
See detail drawing 2.**
- 12                Fix the parts (1 b + 11) using self-tapping screws (4,8 x 13, 7 pcs.).  
Place the screw caps against the slanting roof plate.**

### 2. Fitting the right-hand (1 b at stage 1) slanting roof plate of the rain roof

- Parts            The numbering of work stages refers to reference numbers in the spare parts drawing (A72231. A72232) for the rain roof.
- \*                Cut off a piece from the slanting roof plate's (rearmost in the drawing) end fold and the end cover.  
Carry out the cutting along the markings in the plate.  
See detail drawing 1. The piece to be removed viewed from two different directions.**
- \*                Push the vertical flange of the slanting roof plate against the vertical support of the top section.  
Press the end cover of the roof plate against the vertical flange of the upper shutter-plate during marking.**
- \*                Mark the position for the U-shaped vertical support in the plate.  
See detail drawing 2.**
- \*                Cut a notch in the slanting roof plate matching the marking as well as possible.**







### 3. Fitting the midmost slanting roof plates of the rain roof

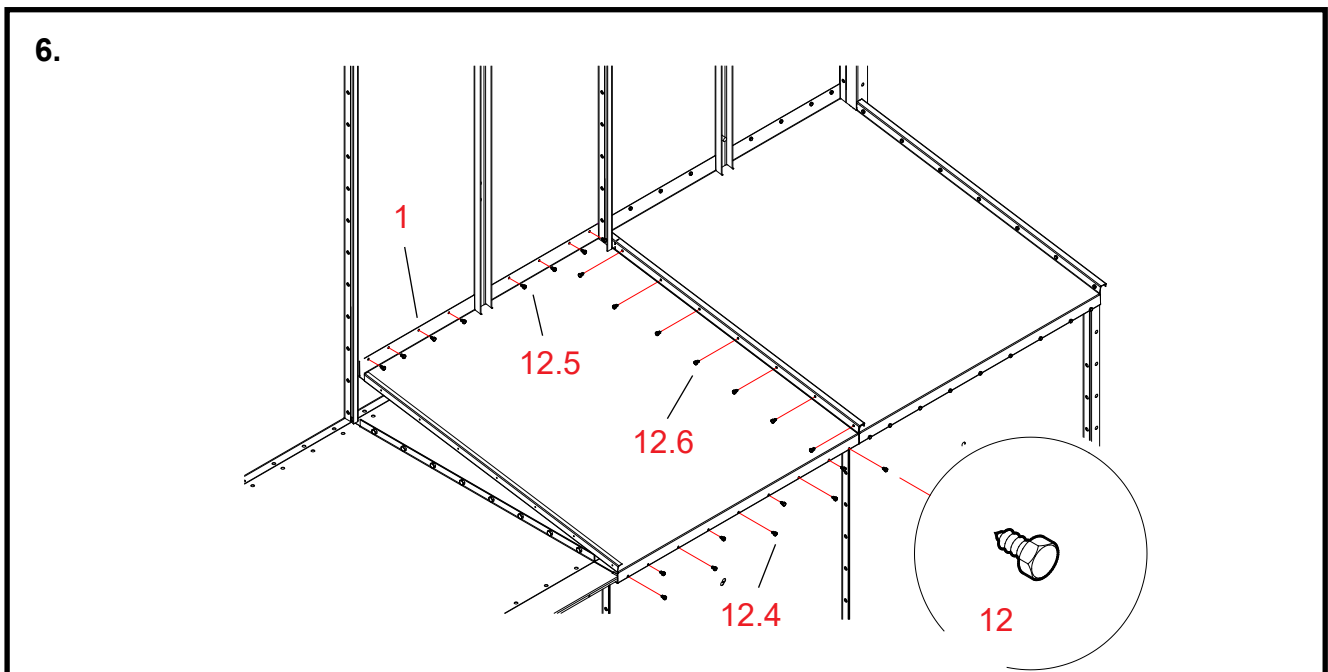
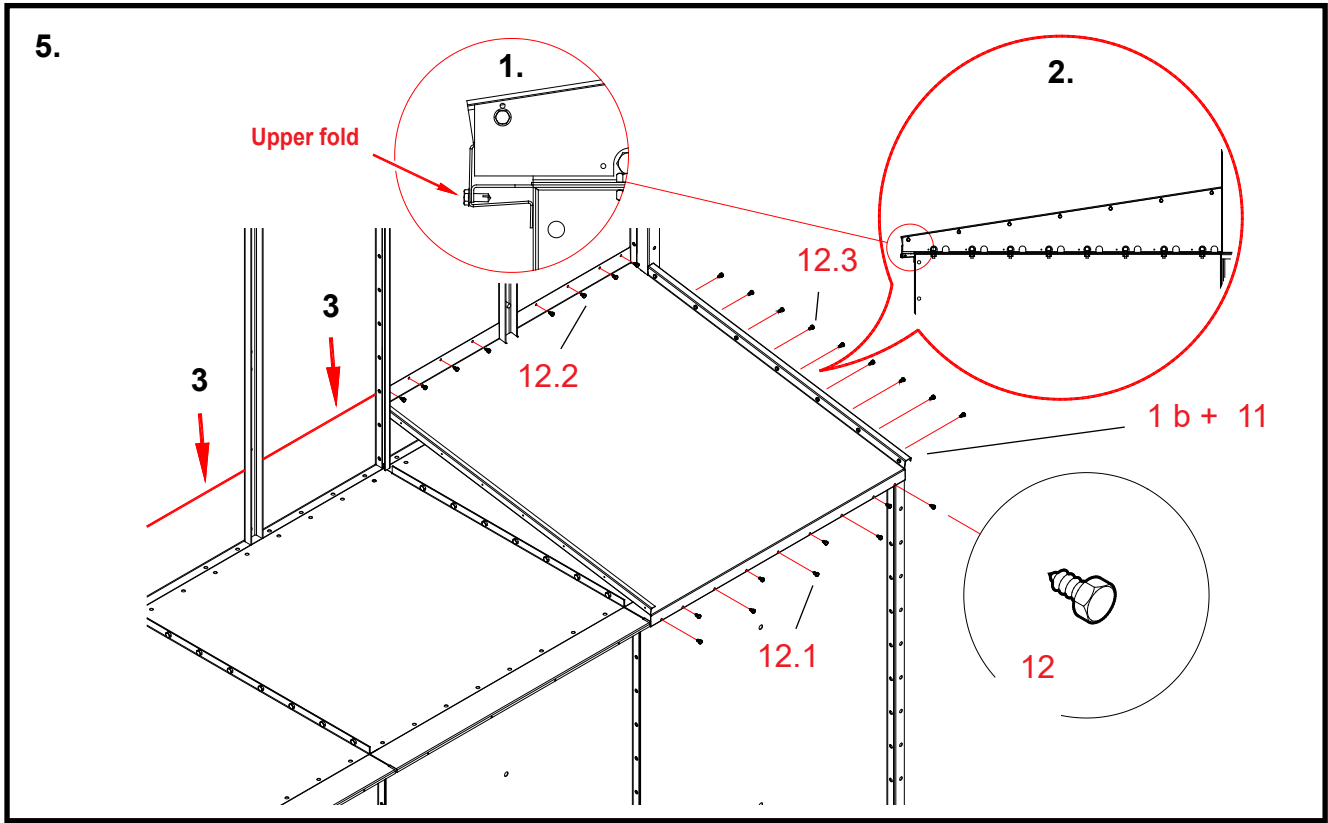
Parts            The numbering of work stages refers to reference numbers in the spare parts drawing (A72231. A72232) for the rain roof.

- \*            **Push the vertical flange of the slanting roof plate (part 1) against the vertical support of the top section.**  
Make sure, that the roof plate stays laterally in the correct position during marking.  
The plate must be located so that its right-hand edge fold comes against the left-hand fold of the plate that was just marked.
- \*            **Mark the position for the U-shaped vertical support in the plate.**  
See detail drawing 1.
- \*            **Mark in the plate the position for the vertical support between the end-plates of the top section.**  
See detail drawing 2.
- \*            **Cut a notch in the slanting roof plate matching the markings as well as possible.**
- \*            **Mark and cut the next slanting roof plate (part 1) to the left from the previous one.**

### 4. Fitting the left-hand (1 a at stage 1) slanting roof plate of the rain roof

Parts            The numbering of work stages refers to reference numbers in the spare parts drawing (A72231. A72232) for the rain roof.

- \*            **Push the vertical flange of the slanting roof plate against the vertical support of the top section.**  
Press the end cover of the roof plate against the vertical flange of the upper shutter-plate during marking.
- \*            **Mark the position for the U-shaped vertical support in the plate.**  
See detail drawing 1.
- \*            **Mark in the plate the position for the vertical support between the end-plates of the top section.**  
See detail drawing 2.
- \*            **Cut a notch in the slanting roof plate matching the markings as well as possible.**



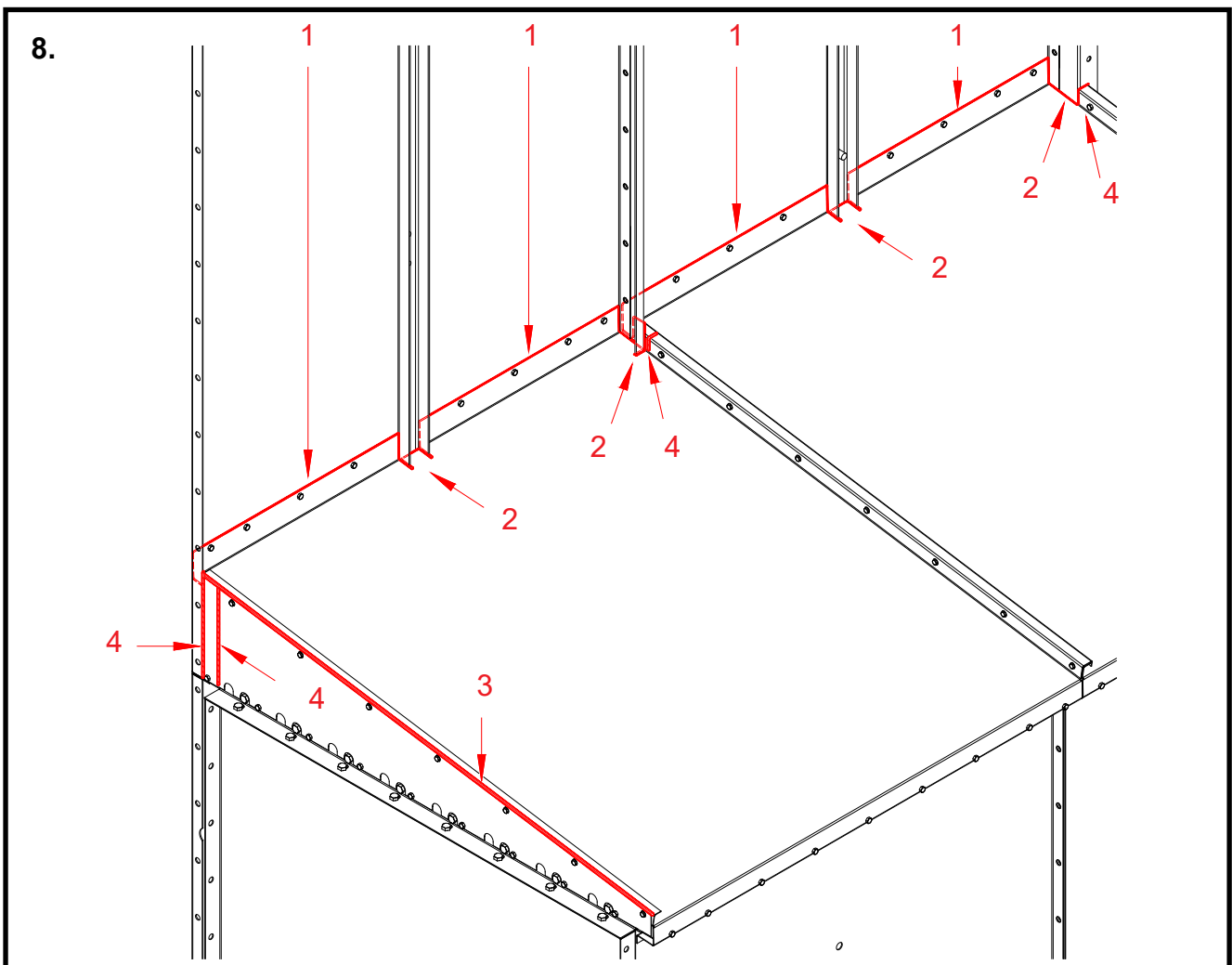
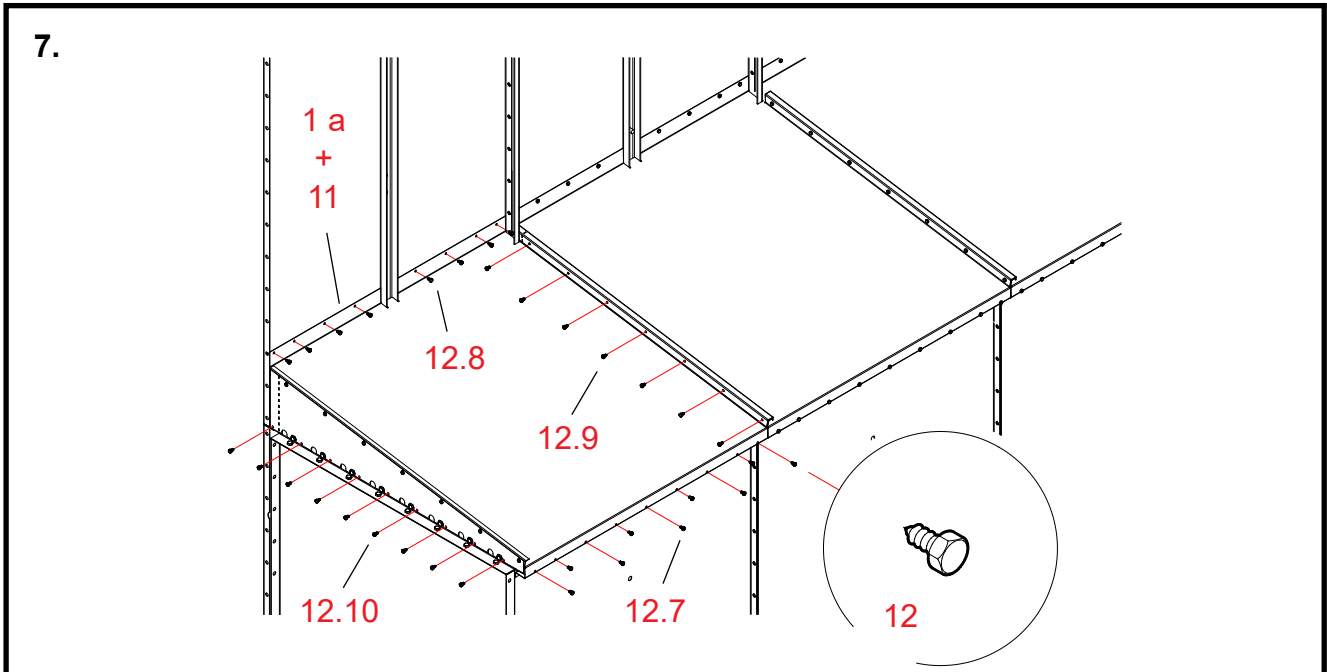


### 5. Installing the right-hand (1 b at stage 1) slanting roof plate of the rain roof

- Parts            The numbering of work stages refers to reference numbers in the spare parts drawing (A72231. A72232) for the rain roof.
- 1 b + 11        Position the slanting roof plate against the front edge of the air channel end's (rearmost in the drawing) upper shutter-plate.**  
Align the boltholes in the upper fold of the plate with the four holes at the edge of the upper shutter-plate.  
See detail drawing 1.
- 12. 1            Fix the plate to the front edge of the air channel end using self-tapping screws (4,8 x 13, 4 + 5 pcs.).**
- 1 b + 11        Position the vertical flange of the slanting roof plate against the wall of the top section.**  
Fit the notch that you made in the slanting roof plate in the vertical support of the top section.  
Check the alignment of the lower edge of the end cover with the bolt caps in the air channel end.  
See detail drawing 2.
- \***                **Mark the vertical line in the wall of the top section at the upper edge of the slanting roof plate.**  
The arrows in the drawing 3. The line is useful while straightening the upper edge of the roof.
- 12. 2            Fix the slanting roof plate to the top section using self-tapping screws (4,8 x 13, 8 pcs.).**
- 12. 3            Fix the end cover to the air channel end using self-tapping screws (4,8 x 13, 9 pcs.).**

### 6. Installing the midmost slanting roof plates of the rain roof

- Parts            The numbering of work stages refers to reference numbers in the spare parts drawing (A72231. A72232) for the rain roof.
- 1                Position the slanting roof plate against the front edge of the air channel end's (midmost in the drawing) upper shutter-plate.**  
Install the end fold of the plate on top of the fold in the plate installed at the previous stage.  
Align the boltholes in the lower fold of the plate with the four holes at the edge of the upper shutter-plate.  
Also align the holes in the plate with the holes in the slanting roof plate installed at the previous stage.
- 12. 4            Fix the plate to the front edge of the air channel end using self-tapping screws (4,8 x 13, 4 + 5 pcs.).**
- 1                Position the vertical flange of the slanting roof plate against the wall of the top section.**  
Fit the notches that you made in the slanting roof plate in the vertical supports of the top section.  
Position the upper edge of the slanting roof plate along the line marked at the previous stage.
- 12. 5            Fix the slanting roof plate to the top section using self-tapping screws (4,8 x 13, 8 pcs.).**
- 12. 6            Fix the slanting roof plate to the other slanting roof plate using self-tapping screws (4,8 x 13, 7 pcs.).**
- 1                Install the next slanting roof plate on top of the air channel end's (foremost in the drawing) upper shutter-plate.**  
Carry out the installation in the same way as you installed the previous slanting roof plate.





### 7. Installing the left-hand (1 a at stage 1) slanting roof plate of the rain roof

Parts            The numbering of work stages refers to reference numbers in the spare parts drawing (A72231. A72232) for the rain roof.

**1 a + 11        Position the slanting roof plate against the front edge of the air channel end's (foremost in the drawing) upper shutter-plate.**

Install the end fold of the plate on top of the fold in the plate installed at the previous stage.  
Align the boltholes in the lower fold of the plate with the four holes at the edge of the upper shutter-plate.  
Also align the holes in the plate with the holes in the slanting roof plate installed at the previous stage.

**12. 7            Fix the plate to the front edge of the air channel end using self-tapping screws (4,8 x 13, 4 + 5 pcs.).**

**1 a + 11        Position the vertical flange of the slanting roof plate against the wall of the top section.**  
Fit the notches that you made in the slanting roof plate in the vertical supports of the top section.  
Position the upper edge of the slanting roof plate along the line marked at stage 5.

**12. 8            Fix the slanting roof plate to the top section using self-tapping screws (4,8 x 13, 8 pcs.).**

**12. 9            Fix the slanting roof plate to the other slanting roof plate using self-tapping screws (4,8 x 13, 7 pcs.).**

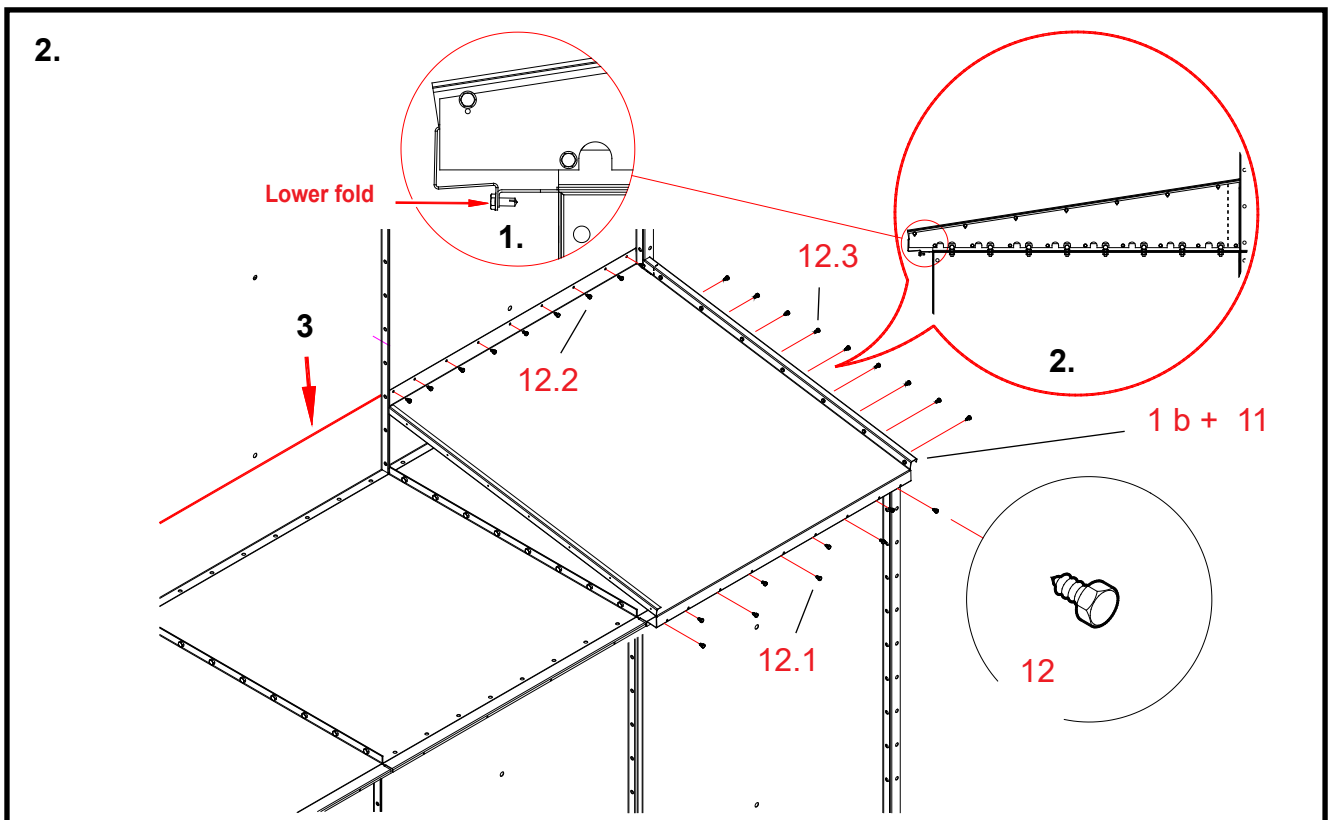
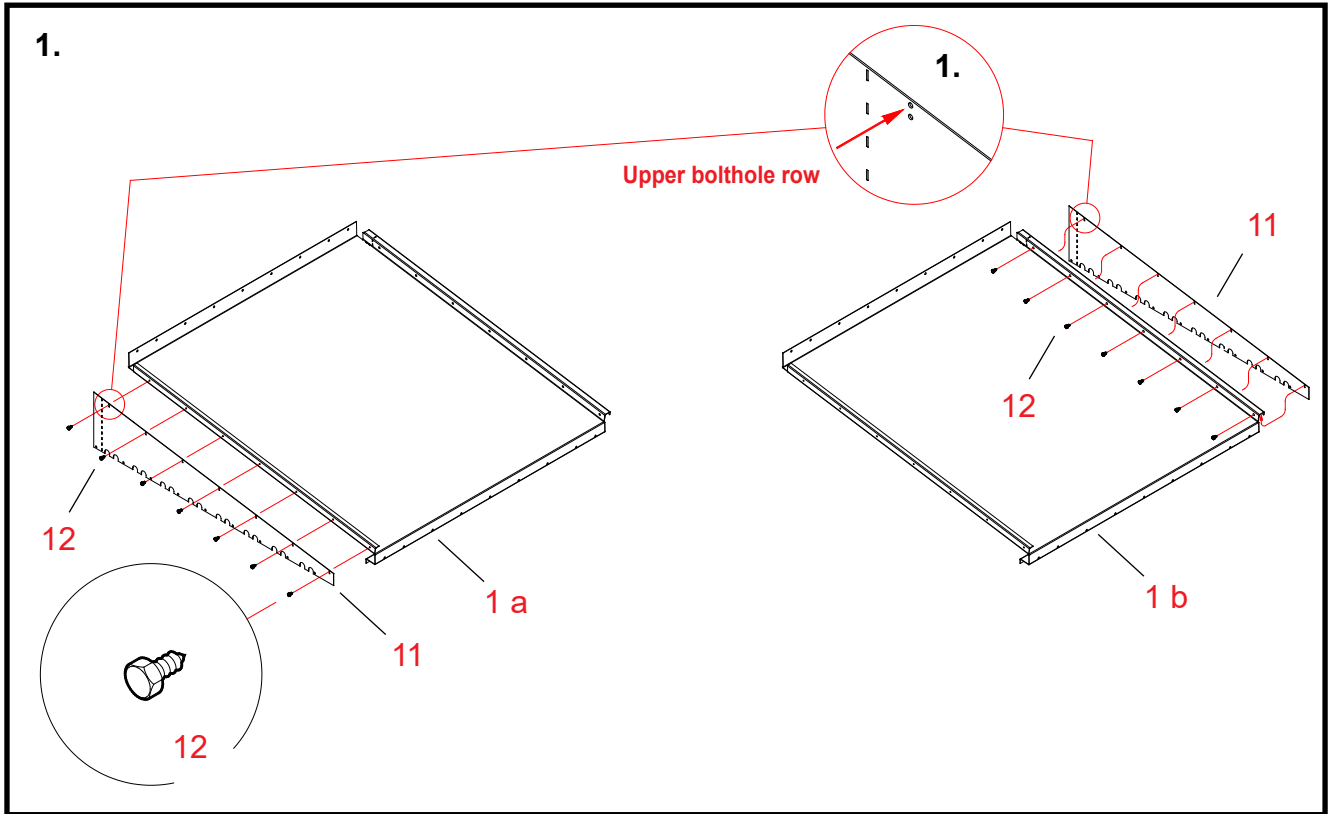
**12. 10          Fix the end cover to the top section using self-tapping screws (4,8 x 13, 9 pcs.).**

### 8. Sealing the rain roof seams

*In the drawing 2W dryer. In the 4W dryer the sealing is carried out following the same principle.*

- \*                Clean the areas to be sealed using grease removal agent before applying the mastic.
- 1                Squeeze a smooth layer of sealing mastic in the seams between the slanting roof plates and the top section.
- 2                Spread sealing mastic round the notches for the top section vertical supports in the slanting roof plates.
- 3                Squeeze sealing mastic into the upper seam between the slanting roof plate (closer in the drawing) and the end cover.
- 4                Also apply sealing mastic to the cutting mark notches in the slanting roof plates.

Try to fill with mastic all grooves and notches through which the rain water could enter the dryer.





**Stages 1 - 4: Installation practice 2: Fixing the rain roof to the wall of the air channel end (2 x 1,0 m air channel end).**

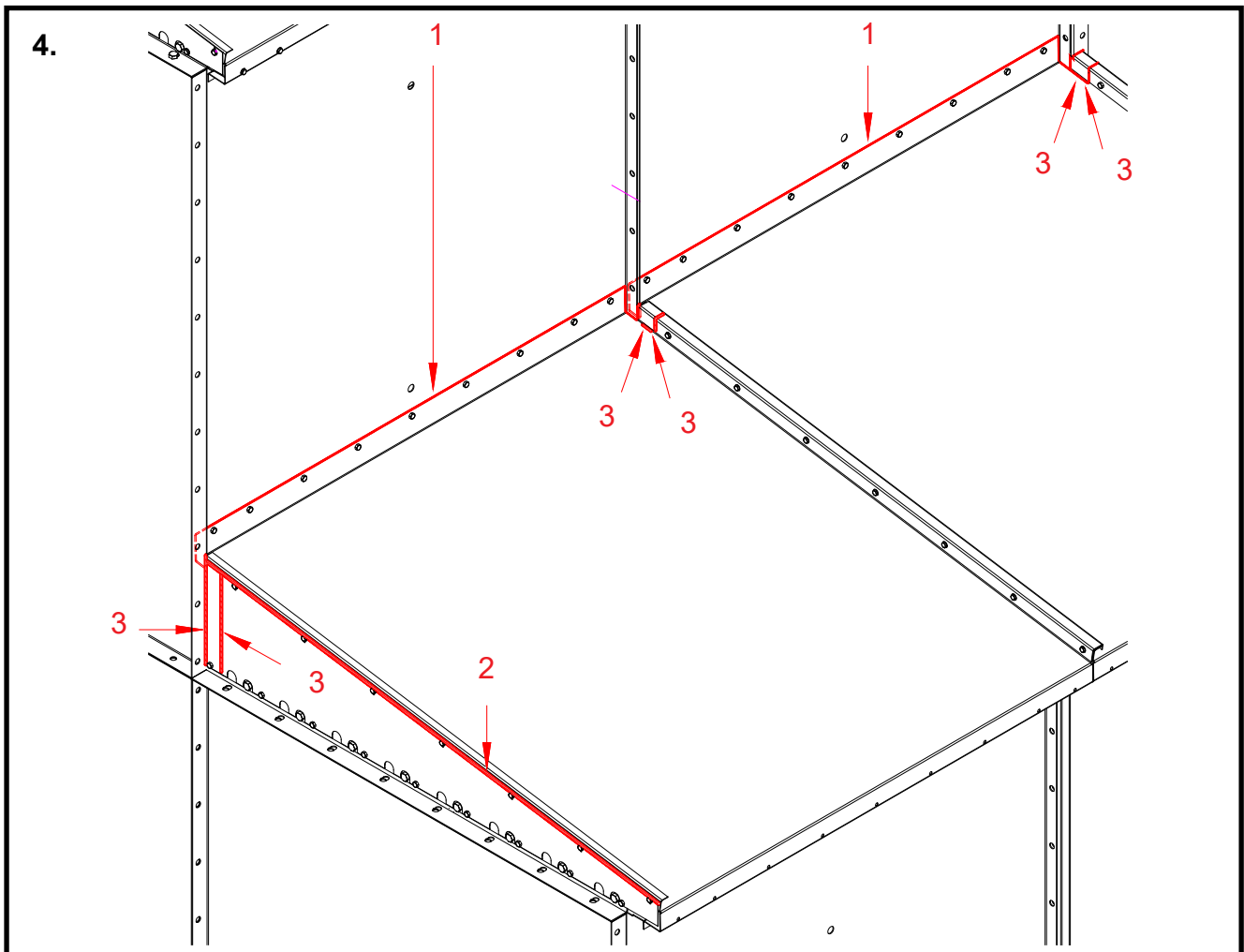
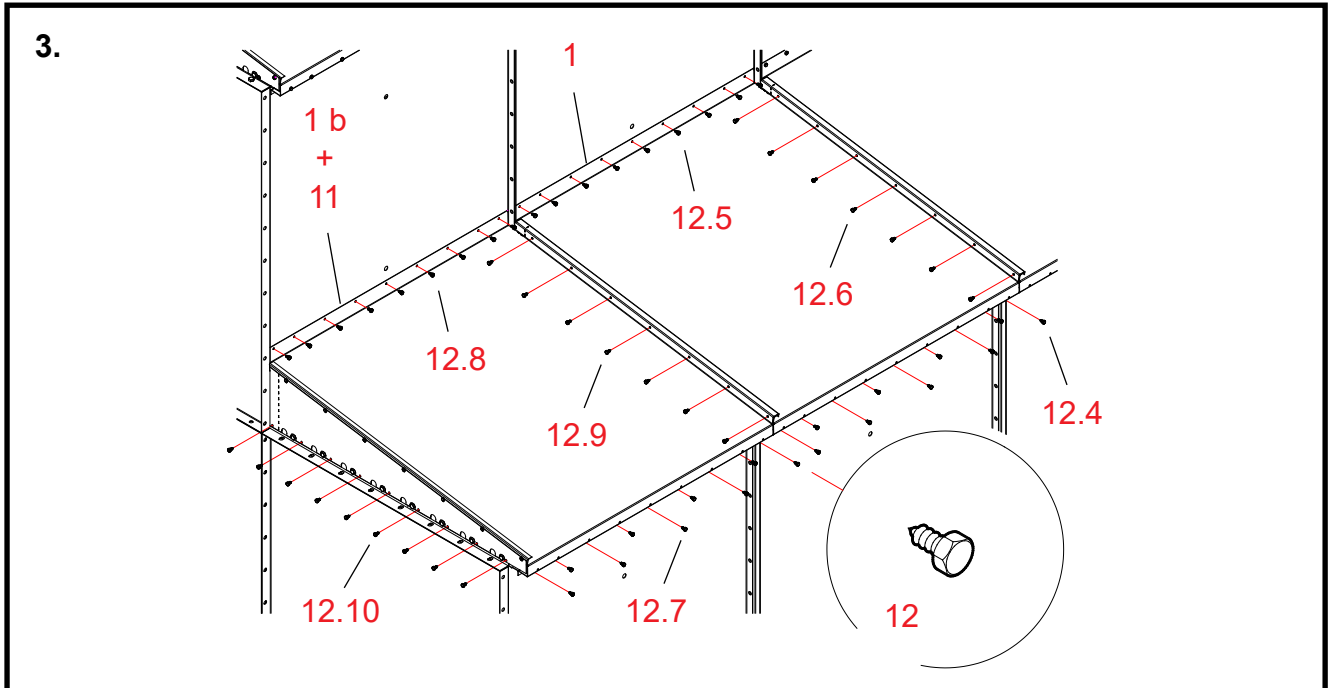
### 1. Joining together the slanting roof plates of the rain roof and the end covers

- Parts            The numbering of work stages refers to reference numbers in the spare parts drawing (A72231. A72232) for the rain roof.
- 1 a + 11        Place the end cover against the outer face of the slanting roof plate's end fold (the foremost in the drawing).  
Align the bolthole row of the end cover, the upper in the drawing, with the bolthole row in the slanting roof plate.  
See detail drawing 1.**
- 12                Fix the parts using self-tapping screws (4,8 x 13, 7 pcs.).  
Place the screw caps against the end cover.**
- 1 b + 11        Place the end cover inside the slanting roof plate's end fold (the rearmost in the drawing).  
Align the bolthole row of the end cover, the upper in the drawing, with the bolthole row in the slanting roof plate.  
See detail drawing 1.**
- 12                Fix the parts (1 b + 11) using self-tapping screws (4,8 x 13, 7 pcs.).  
Place the screw caps against the slanting roof plate.**

**No need to make any cuts in the slanting roof plates of the rain roof.**  
Go directly to the installation stage.

### 2. Installing the right-hand (1 b at stage 1) slanting roof plate of the rain roof

- Parts            The numbering of work stages refers to reference numbers in the spare parts drawing (A72231. A72232) for the rain roof.
- 1 b + 11        Position the slanting roof plate against the front edge of the air channel end's (rearmost in the drawing) upper shutter-plate.  
Align the boltholes in the lower fold of the plate with the four holes at the edge of the upper shutter-plate.  
See detail drawing 1.**
- 12. 1            Fix the plate to the front edge of the air channel end using self-tapping screws (4,8 x 13, 4 + 5 pcs.).**
- 1 b + 11        Position the vertical flange of the slanting roof plate against the wall of the upper air channel end.  
Check the alignment of the lower edge of the end cover with the bolt caps in the air channel end.  
See detail drawing 2.**
- \*                Mark the vertical line in the wall of the air channel end at the upper edge of the slanting roof plate.  
The arrow in the drawing 3. The line is useful while straightening the upper edge of the roof.**
- 12. 2            Fix the slanting roof plate to the air channel end using self-tapping screws (4,8 x 13, 9 pcs.).**
- 12. 3            Fix the end cover to the air channel end using self-tapping screws (4,8 x 13, 9 pcs.).**







### 3. Installing the midmost (parts 1) and the left-hand (1 a at stage 1) slanting roof plate of the rain roof

- Parts            The numbering of work stages refers to reference numbers in the spare parts drawing (A72231. A72232) for the rain roof.
- 1 (2 pcs.)      Place the slanting roof plates against the front edge of the air channel end's upper shutter-plate.**  
Install the end fold of first the plate on top of the fold in the plate installed at the previous stage.  
Install the end fold of the second plate on top of the fold in the previous plate.  
Align the boltholes in the lower folds of the plates with the four holes at the edge of the upper shutter-plate.  
Align the holes in the plates also with the holes in the end folds of the slanting roof plates installed earlier.
- 12. 4            Fix the plates to the front edges of the air channel ends using self-tapping screws (4,8 x 13, 4 + 5 pcs.).**
- 1                Position the vertical flanges of the slanting roof plates against the wall of the top section.**  
Position the upper edge of the slanting roof plate along the line marked at the previous stage.
- 12. 5            Fix the slanting roof plates to the air channel end using self-tapping screws (4,8 x 13, 9 pcs.).**
- 12. 6            Fix the slanting roof plates to one another using self-tapping screws (4,8 x 13, 7 pcs.).**
- 1 a + 11        Position the slanting roof plate against the front edge of the air channel end's (foremost in the drawing) upper shutter-plate.**  
Install the end fold of the plate on top of the fold in the plate installed at the previous stage.  
Align the boltholes in the lower fold of the plate with the four holes at the edge of the upper shutter-plate.  
Also align the holes in the plate with the holes in the slanting roof plate installed at the previous stage.
- 12. 7            Fix the plate to the front edge of the air channel end using self-tapping screws (4,8 x 13, 4 + 5 pcs.).**
- 1 a + 11        Position the vertical flange of the slanting roof plate against the wall of the top section.**  
Position the upper edge of the slanting roof plate along the line marked at the previous stage.
- 12. 8            Fix the slanting roof plate to the air channel end using self-tapping screws (4,8 x 13, 9 pcs.).**
- 12. 9            Fix the slanting roof plate to the other slanting roof plate using self-tapping screws (4,8 x 13, 7 pcs.).**
- 12. 10          Fix the end cover to the air channel end using self-tapping screws (4,8 x 13, 9 pcs.).**

### 4. Sealing the rain roof seams

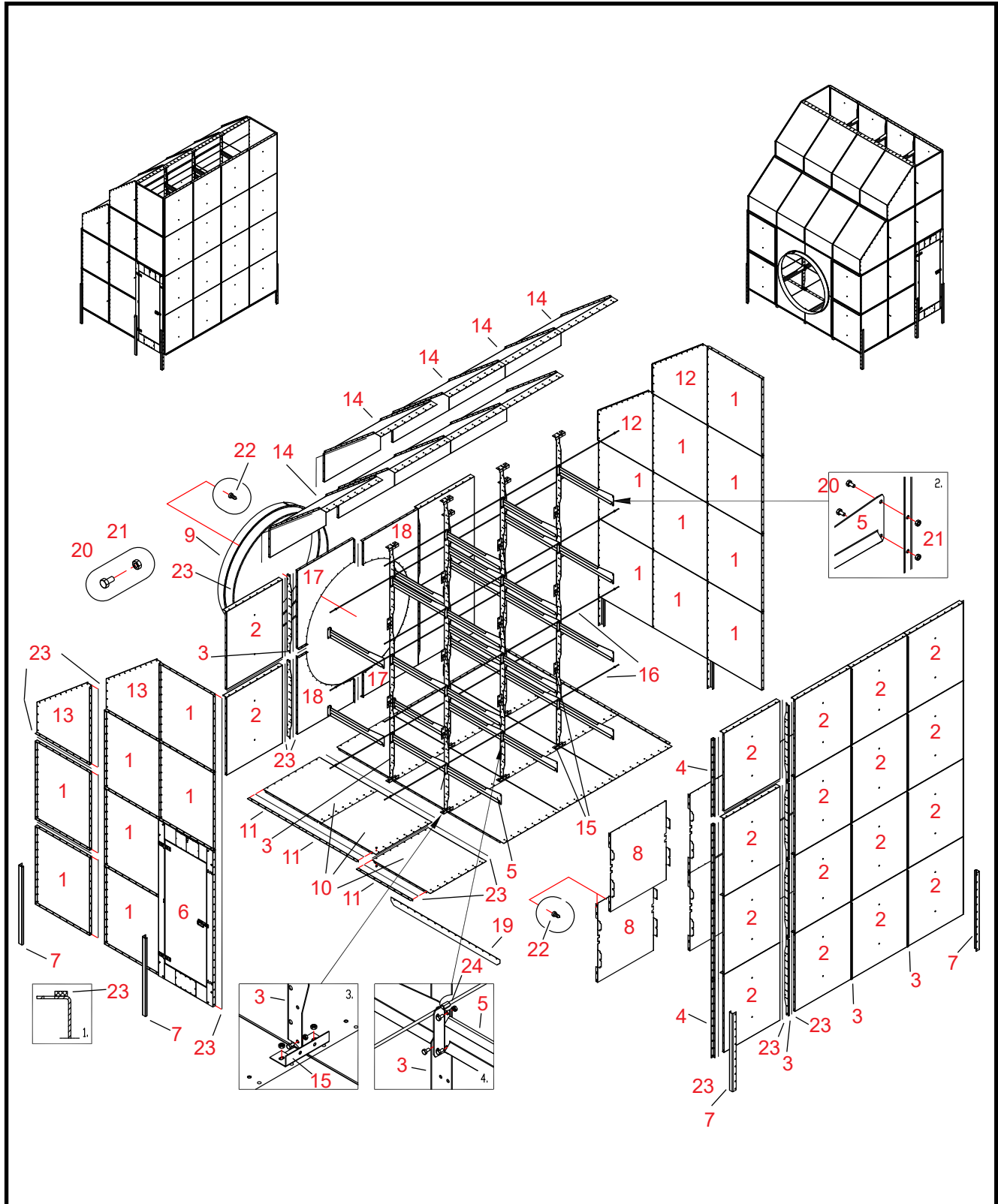
*In the drawing 2W dryer. In the 4W dryer the sealing is carried out following the same principle.*

- \***                Clean the areas to be sealed using grease removal agent before applying the mastic.
- 1                Squeeze a smooth layer of sealing mastic in the seams between the slanting roof plates and the air channel end.**
- 2                Squeeze sealing mastic into the upper seam between the slanting roof plate (closer in the drawing) and the end cover.**
- 3                Also apply sealing mastic to the cutting mark notches in the slanting roof plates.**
- Try to fill with mastic all grooves and notches through which the rain water could enter the dryer.



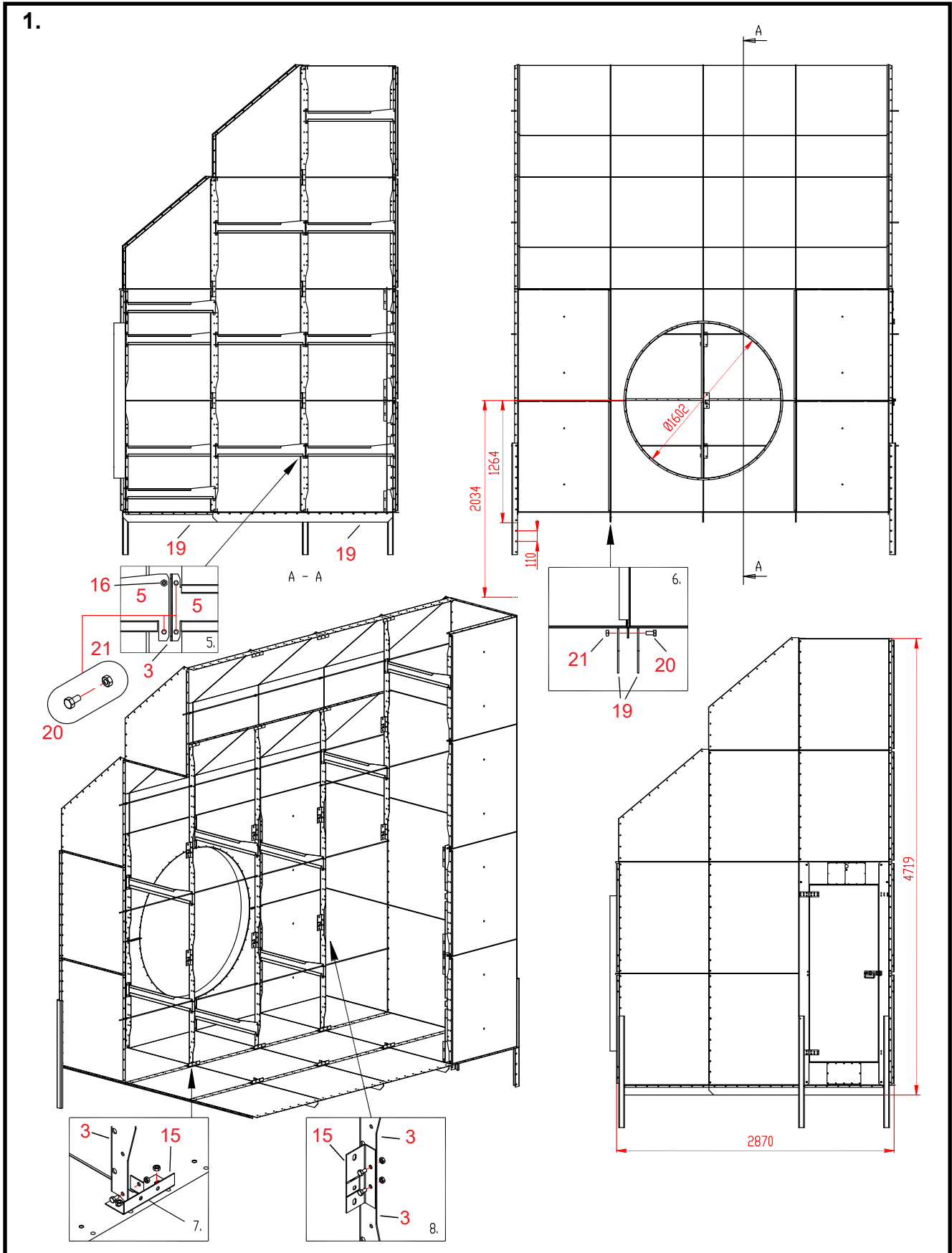
## Air channel end 1,0-3,0 4W (A75593) - channel S, $\varnothing 1602\text{mm}$

### Spare parts





Ref.	Part no.	Denomination	Pcs	Drawing no	Weight
1	A70640	AIR CHANN END WM06 1.0 SIDE-PLATE	16	A70640	14,2
2	A70563	TOP SECTION/AIR CH END WM06 END-PLATE	20	A70563	14,7
3	A70810	TOP SECTION WM06 VERTICAL SUPPORT PL3	37	A70810	2,3
4	A70739	AIR CHANNEL END CORNER-S 1154 VERT WM06	8	A70739	0,7
5	A70678	AIR CHANNEL END WM06 1.0 SUPP STRAIGHT	27	A70678	1,8
6	A71301	CHANNEL BURNER DOOR ELEMENT WM06	1	A71301	35,2
7	A71396	AIR CHANNEL END WM06 SUPP LEG FROM GROUND	6	A71396	4,8
8	A71375	AIR CHANNEL END RADIATION SHIELD END WM06 1.0	8	A71375	14,1
9	A75494	AIR PIPE INPUT STUB BOLT D1602X120	1	A75494	8,3
10	A70642	AIR CHANNEL END SHUTTER-PLATE 1.0 WM06	12	A70642	11,7
11	A70570	AIR CHANNEL END 1.0 WM06 CORNER-S	6	A70570	0,9
12	A75583	AIR CHANNEL END SIDE-PLATE DIAGONAL LEFT 1.0 M15	2	A75583	10,3
13	A75584	AIR CHANNEL END SIDE-PLATE DIAGONAL RIGHT 1.0 M15	2	A75584	10,3
14	A75585	AIR CHANNEL END SIDE-PLATE DIAGONAL END 1.0 M15	8	A75585	19,8
15	A70977	AIR CHANNEL END VERT SUPP ATTACHM WM06	27	A70977	0,2
16	119006	THREADED ROD ZN M 8X2000 MM 8.8 ZN	14		
17	A75594	AIR CHANNEL END END-PLATE 1 D1600 M16	2	A75594	7,7
18	A75595	AIR CHANNEL END END-PLATE 2 D1600 M16	2	A75595	7,7
19	A70975	AIR CHANNEL END LONG SUPPORT 1860 1.0X2 WM06	6	A70975	4,3
20	101810	BOLT 6K ZN 8.8 8X16 AM DIN933	1832		
21	110540	NUT M8 ZN 8 DIN934	1904		
22	107720	SCREW SELF-TAP HEX 4,8X13 ZN	95		
23	115570	SEALING STRIP 4X8 EKO-40	176		
24	110626	NUT EXTENSION M8X24 ZN DIN6334	8		





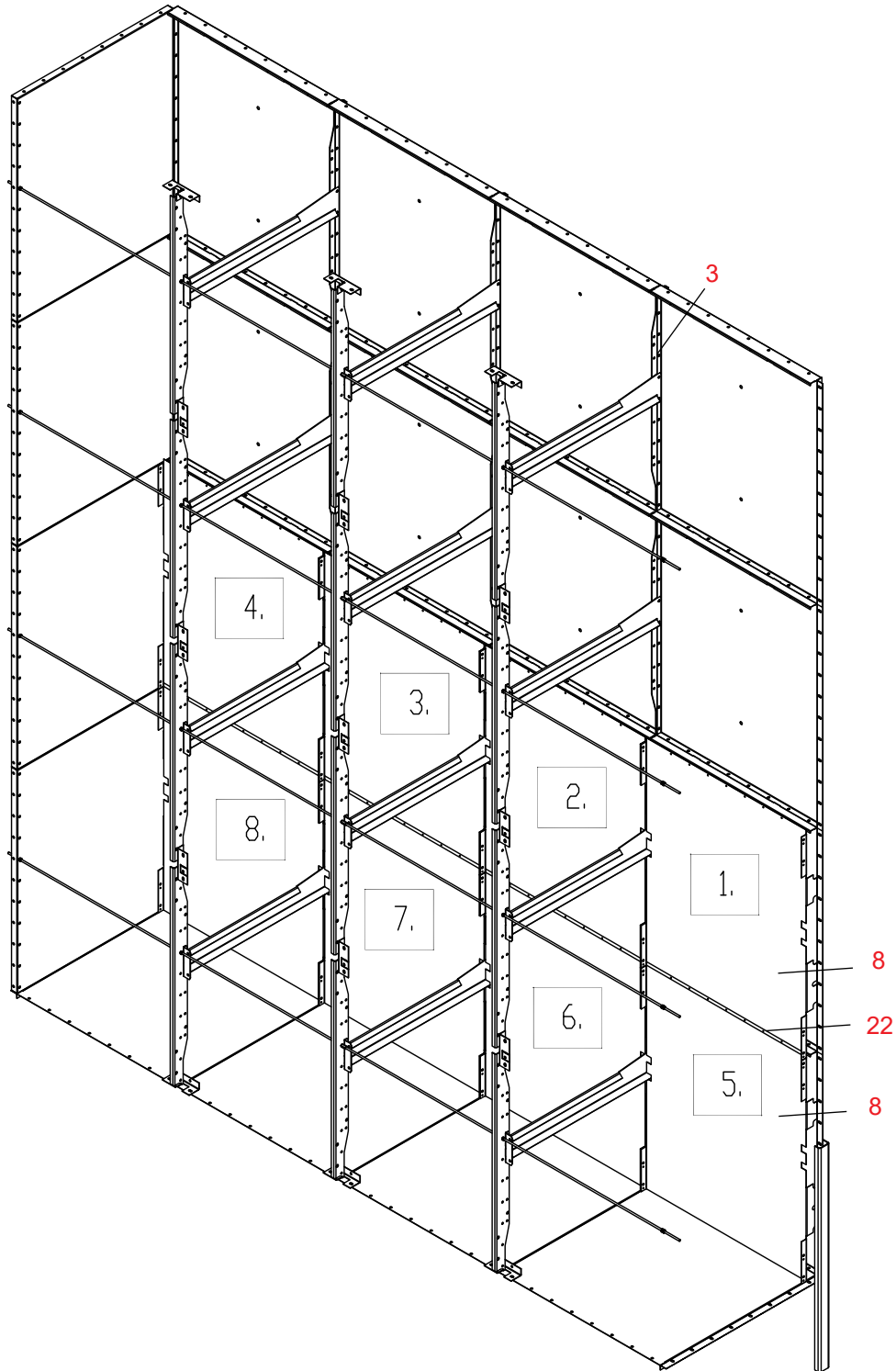
## Assembling air channel end A75593

*We recommend carrying out assembly of the air channel end on an even plane.  
This ensures the ready-assembled air channel end is straight.*

- Parts            The numbering of work stages refers to reference numbers in the spare parts drawing A75593 for the air channel end.
- 23**            **Fix a sealing strip between the plates at every joint of the outer jacket.**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).
- 10, 19, 15**    **Assemble the lower shutter plates ready in the form of a patchwork.**  
First join the shutter-plates (10) together, and provide the seams with the fastener (15)(see detail drawing 7). Bend the edge in the middle of the fastener upright.  
Use the inner holes of the double holes of the shutter-plates (the total length of the joined plates will be shorter).  
Remember to place the sealing strip in between.  
When joining the vertical seams of the plates, fix the supports (19) on both sides of the seams (see detail drawing 6).  
Overlap the supports lengthwise by a half, see cross section A-A.
- 11**            **Start the assembly of the side wall from the end with the air pipe.**  
Place a sealing strip on the edge of the end-plate (2). Join the side-plate (1) with the end-plate (2).  
Fix the sealing strips to the lower edges of the parts that you just assembled, inside the bolthole rows (see detail drawing 1).  
Lift the end-plate and the side-plate onto the lower shutter plate (10) and the corner strip (11).
- 2, 20, 21**      **Plug the holes in the middle of the end-plates, using nuts and bolts.**  
  
Assemble the side-plates for the first row in the same way.
- 2, 4**            **Use the vertical corner strip (4, L=1154) for joining the end-plate of the rear wall with the side wall.**  
The long upper edge of the end-plate (2) shall point inward into the channel (see spare part drawing).
- 2, 3**            **Install vertical supports (3) between the end-plates.**  
In the rear wall, install the vertical supports reversed (see drawing 2). Leave out the bolts in the middle, and later on, attach the supports (5) to them.
- 6**              **Fasten the door to the side-plate and the corner strip on the channel side, by the bends in the door element frame.**
- 7**              **As soon as the first row is complete, attach the support legs at a suitable height, as shown in the drawings.**  
Keep the bottom supported by the centre points of the ends until the support structures (3, 15, 16) inside the channel are completed.
- 5, 15, 16, 24** **Bend the ends of the supports at the notch (see detail drawing 4).**  
Attach the support to the vertical support (3) so that the lower hole in the support will align with the centre hole of the vertical support (see drawing 1, cross section A-A).  
Attach the separate vertical supports to the fasteners (15) that were attached to the shutter plates (see detail drawing 7).  
Fix the horizontal support (5) to the vertical support, and place the threaded rod (16) into the upper hole in the straight end of the horizontal support (see detail drawings 4 and 5)  
Fix the threaded rod, using nuts (21) on both sides.  
Use the extension nut (24) for extending the threaded rod in the middle (see detail drawing 4).  
Insert the threaded rod through the hole in the side-plate, and place nuts on both sides of the plate.
- 17, 18, 5**      **Place the horizontal supports (5) above and below the D1600 opening at the inlet of the air pipe (see drawing 1).**



2.



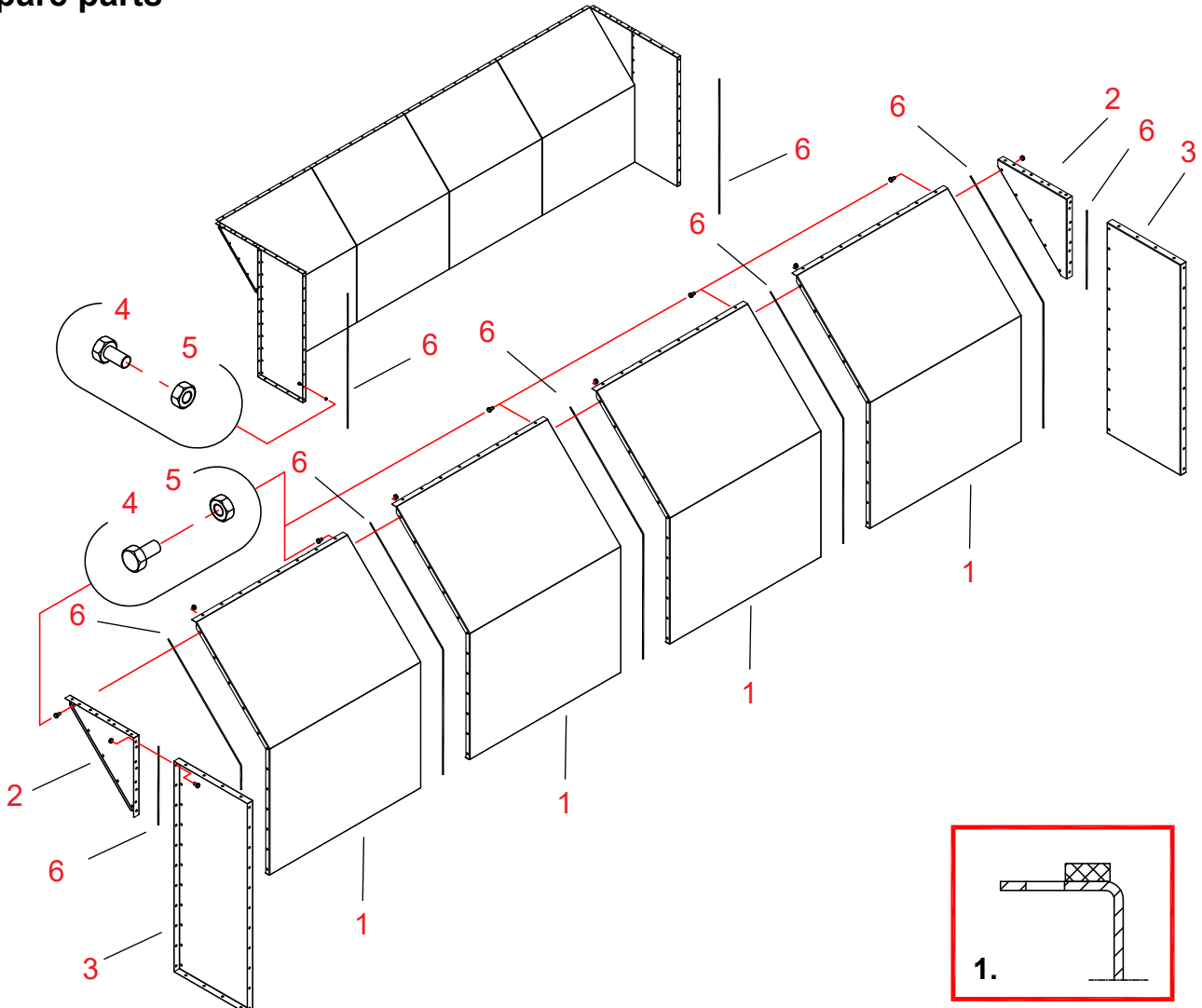


- 12, 13, 14**    **In the third row, fix the diagonal side-plates of the air channel ends (12 and 13) to the end on the air pipe side. Fix the end-plates (14) before installing the other side-plate.**
- 15, 3**        **Fix the fastener (15) for the vertical support to the end of the vertical support of the third row (3), which supports the diagonal end.**  
Install it in the same way as you installed it in the lower shutter (see detail drawing 7). Do not install the bolts of the horizontal flange until the uppermost plates of the diagonal end have been installed.
- 8**            **Finally, install the radiations shields.**  
Install the shields in the order presented in drawing 2. For more detailed assembly instructions for the radiation shield A71378, see the page 76.
- Plug the unused holes using nuts and bolts. Finally, tighten all the bolts.



## Air channel end 0,5-1,0 4W (A75961) - diagon

### Spare parts



Ref.	Part no	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	A75747	AIR CHANN END DIAGON END-PLATE 0,5-1,0 M16	4	A75747	16,43	3000
2	A75748	AIR CHANN END DIAGON COVER TRIANGLE 0,5-1,0 M16	2	A75748	1,69	3000
3	A70635	AIR CHANN END SIDE-PLATE 0.5 WM06	2	A70635	7,52	3000
4	101810	HEX BOLT ZN 8.8 8X16 AM DIN933 CE	145			2010
5	110540	NUT M8 ZN 8 DIN934 CE	145			2010
6	115570	SEALING STRIP 4X8 EKO-40	24			2600





## Assembling air channel end A75961

Parts            The numbering of work stages refers to reference numbers in the spare parts drawing A75961 for the air channel end.

*We recommend carrying out assembly of the air channel end on an even plane.  
This ensures the ready-assembled air channel end is straight.*

**6 (1,2,3)**        **Fix sealing strips to the flanges of the two end-plates (parts 1) to be joined together, as well as parts 2 and 3.**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing1).

**1,2,3**            **Join the end-plates together, and fix the side-plates and the cover triangle using bolts and nuts.**  
Tighten the bolts only lightly so that you can straighten the air channel end later.

**6 (3.)**            **Fix sealing strips to the flanges of the two side-plates (parts 3) to be attached to the drying section.**  
Fix the sealing strips inside the bolthole rows.

**4**                **Move the side-plates tight against the ends of the section.**  
Be careful not to damage the sealing strips while installing the side-plates.

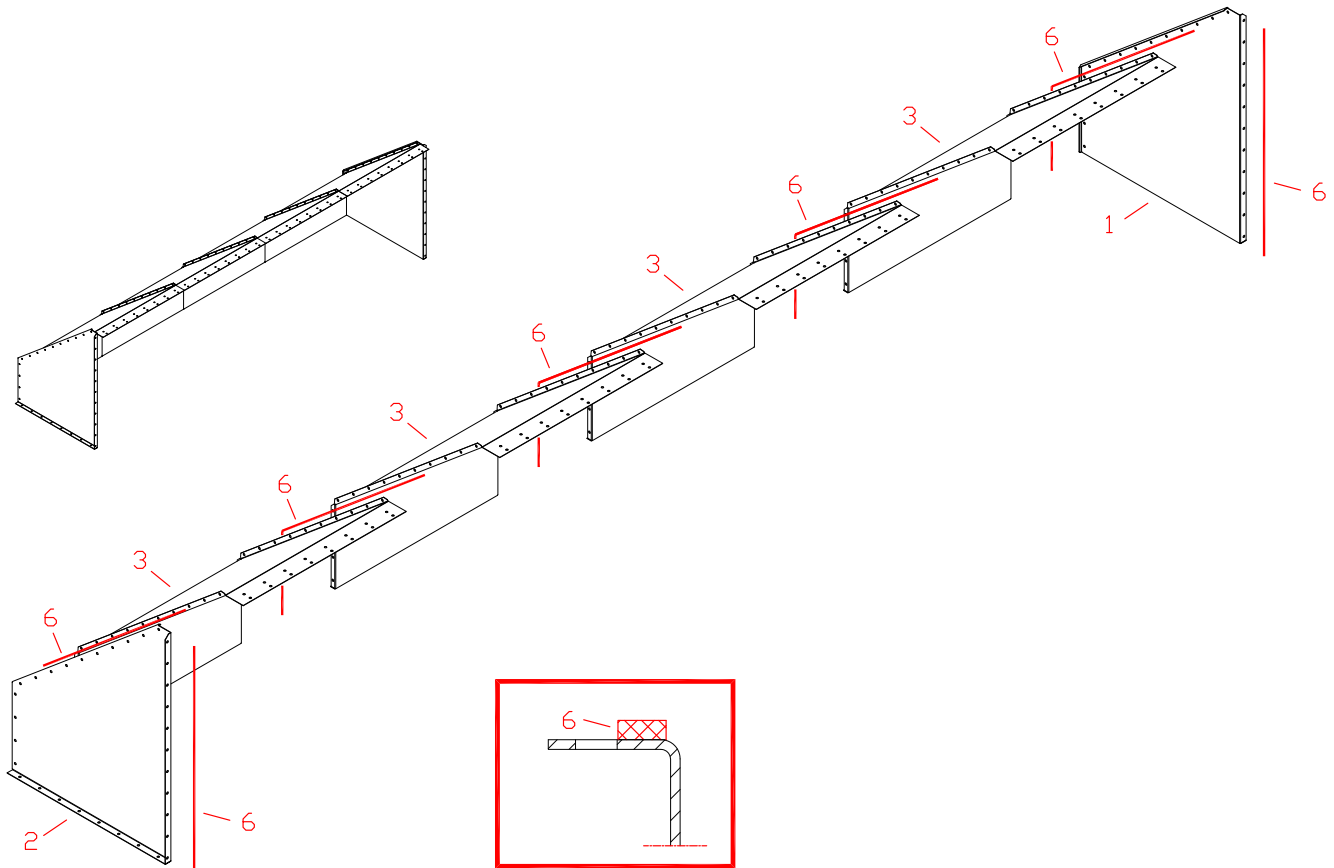
**4,5**            **Fix the side-plates using bolts and nuts (M 8 x 16, 11 pcs / side-plate).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.

**\***                **Check the joints and rectangular shape of the set-up. Tighten all bolts.**



## Air channel end diagonal roof 4W (A75591)

### Spare parts



Ref.	Part no	Denomination 1 and 2	Pcs.	Drawing No	Weight	Group
1	A75583	AIR CHANN SIDE PLATE DIAGON LEFT1.0 M15	1	A75583	10,3	3000
2	A75584	AIR CHANN SIDE PLATE DIAGON RIGHT 1.0 M15	1	A75584	10,3	3000
3	A75585	AIR CHANN SIDE PLATE DIAGON END 1.0 M15	4	A75585	19,8	3000
4	101810	HEX BOLT ZN 8.8 8X16 AM DIN933	147			2010
5	110540	NUT M8 ZN 8 DIN934	147			2010
6	115570	SEALING STRIP 4X8 EKO-40 100m rll	26			2600



## Assembling air channel end A75591

Parts            The numbering of work stages refers to reference numbers in the spare parts drawing A75591 for the air channel end.

***We recommend carrying out assembly of the air channel end on an even plane.  
This ensures the ready-assembled air channel end is straight.***

**6 (3)            Fix sealing strips to the flanges of the two end-plates (parts 3) parts.**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing).

**1,2,3            Join the end-plates together, and fix the side-plates using bolts and nuts. (M 8 x 16).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.

**6 (1,2)            Fix sealing strips to the flanges of the two side-plates (parts 1 and 2) to be attached to the drying section.**  
Fix the sealing strips inside the bolthole rows.

**4                Shift the side plates tight against the ends of the section and the end plate of the slanting roof on top of the edge of the section so that the edge comes between the edges of the section and the top tank.**  
Be careful not to damage the sealing strips while installing the side-plates.

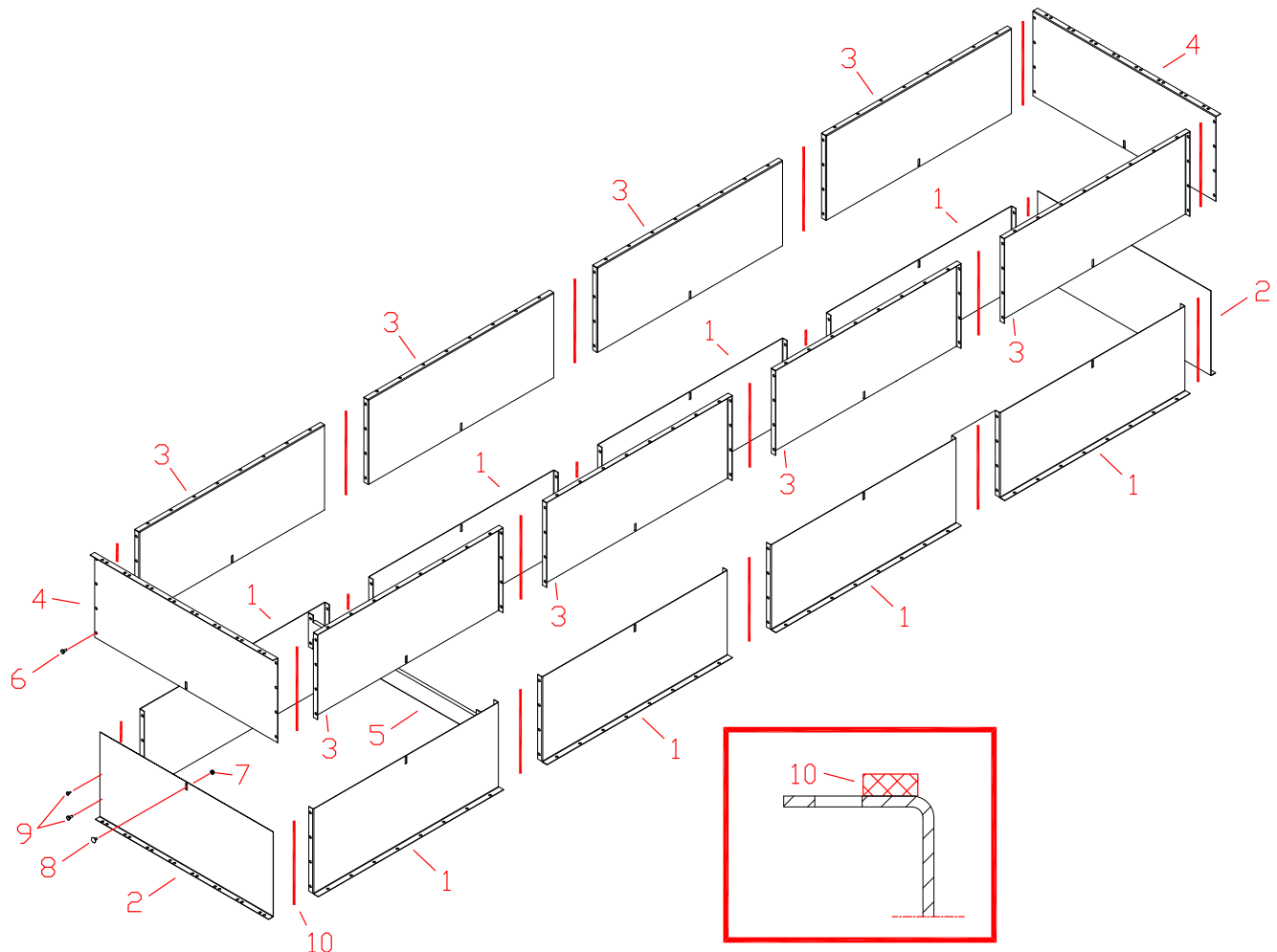
**4,5              Fix the side-plates using bolts and nuts (M 8 x 16, 11 pcs / side-plate).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.

**\*                Check the joints and rectangular shape of the set-up. Tighten all bolts.**



## Air channel end telescope 4W (A76736)

## Spare parts

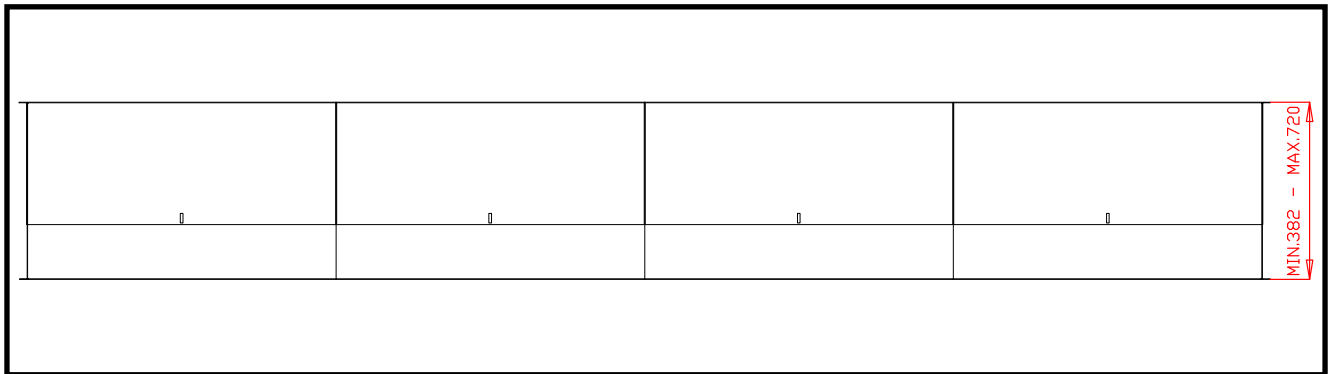


Ref.	Part no	Denomination 1 and 2	Pcs.	Drawing No	Weight	Group
1	A76729	AIR CHANNEL TELESCOPE LOWER PLATE M21	8	A76729	4,7	3000
2	A76730	AIR CHANNEL TELESCOPE SIDE LOWER PLATE 1.0 M21	2	A76730	4,2	3000
3	A76731	AIR CHANNEL TELESCOPE UPPER PLATE M21	8	A76731	4,7	3000
4	A76732	AIR CHANNEL TELESCOPE SIDE UPPER PLATE 1.0 M21	2	A76732	4,5	3000
5	A76733	AIR CHANNEL TELESCOPE SUPPORT 1.0 M21	3	A76733	2,9	3000
6	101810	HEX BOLT ZN 8.8 8X16 AM DIN933	319			2000
7	110540	NUTI M8 ZN 8 DIN934	340			2000
8	107910	SCREW LOCK ZN M 8X16 DIN603 8.8	21			2000
9	107720	SCREW SELF-DRILLED HEX DIN 7504K Zn 4,8x13	20			2000
10	115570	SEALING STRIP 4X8 EKO-40 100m rll	25			2600



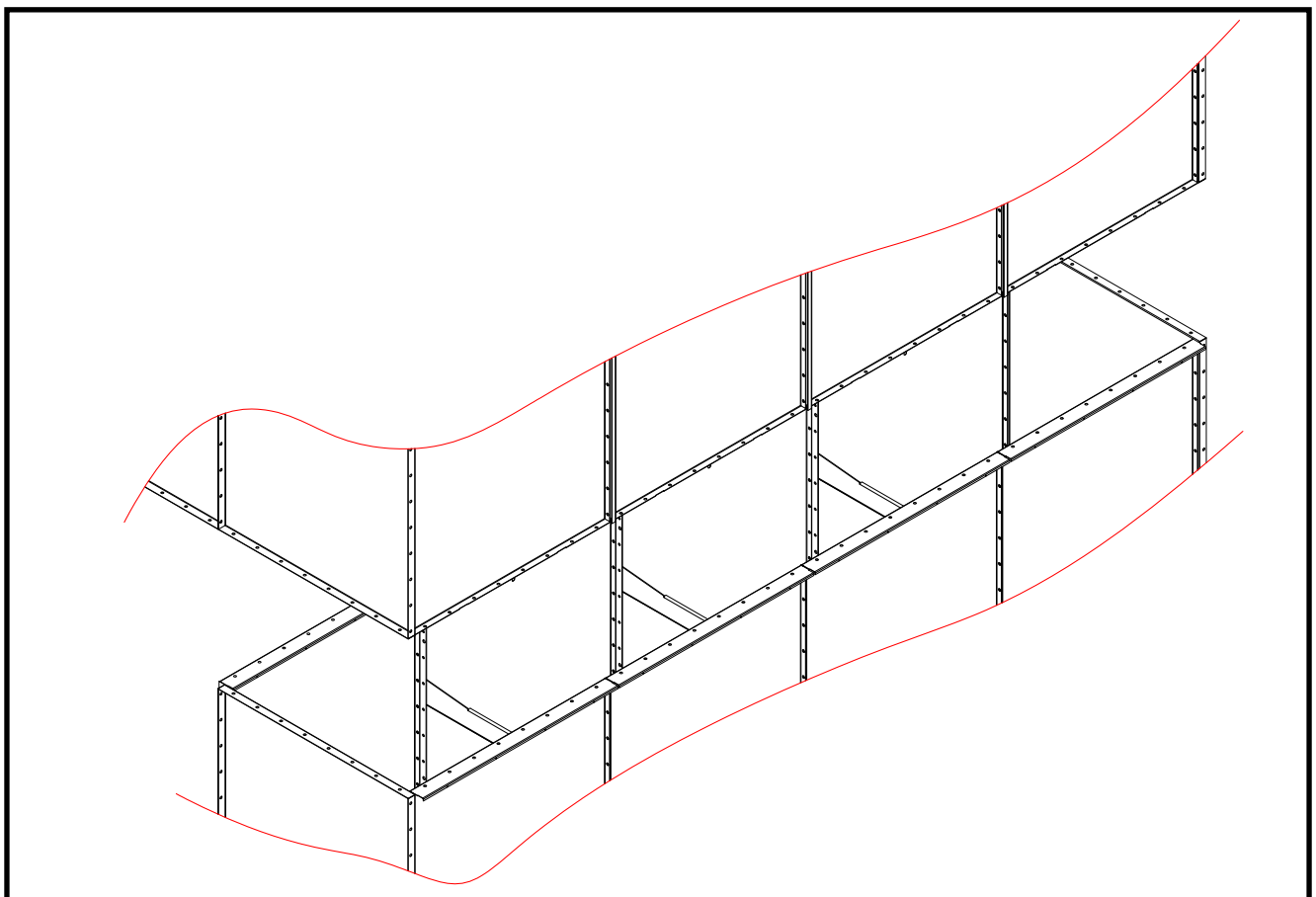
## Threshold values for the dimensions of the air channel end A76736

The maximum dimension of the telescope is 720 mm. The minimum is 382 mm when the original dimensions of the plates apply. It is possible to make it lower, but then also the plates must be cut lower. The support (part 5) is always required, even if the plate is lower.

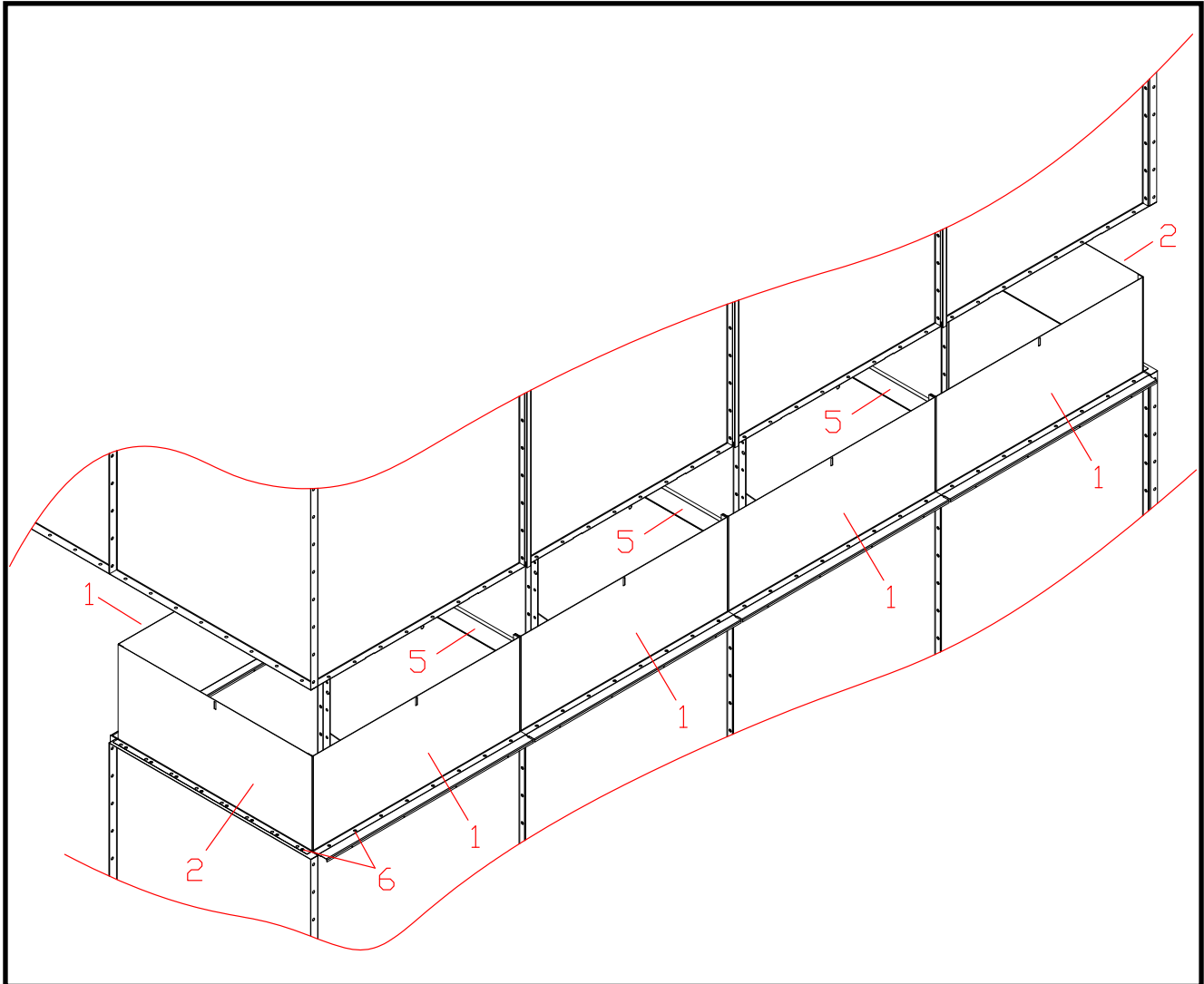


## Initial position before installation of the telescope

Assemble the air channel ends ready, and build in the telescope channel between them. The lower part must be in-line with the air channel end of the dryer machinery.



## 1. Installation of the lower part

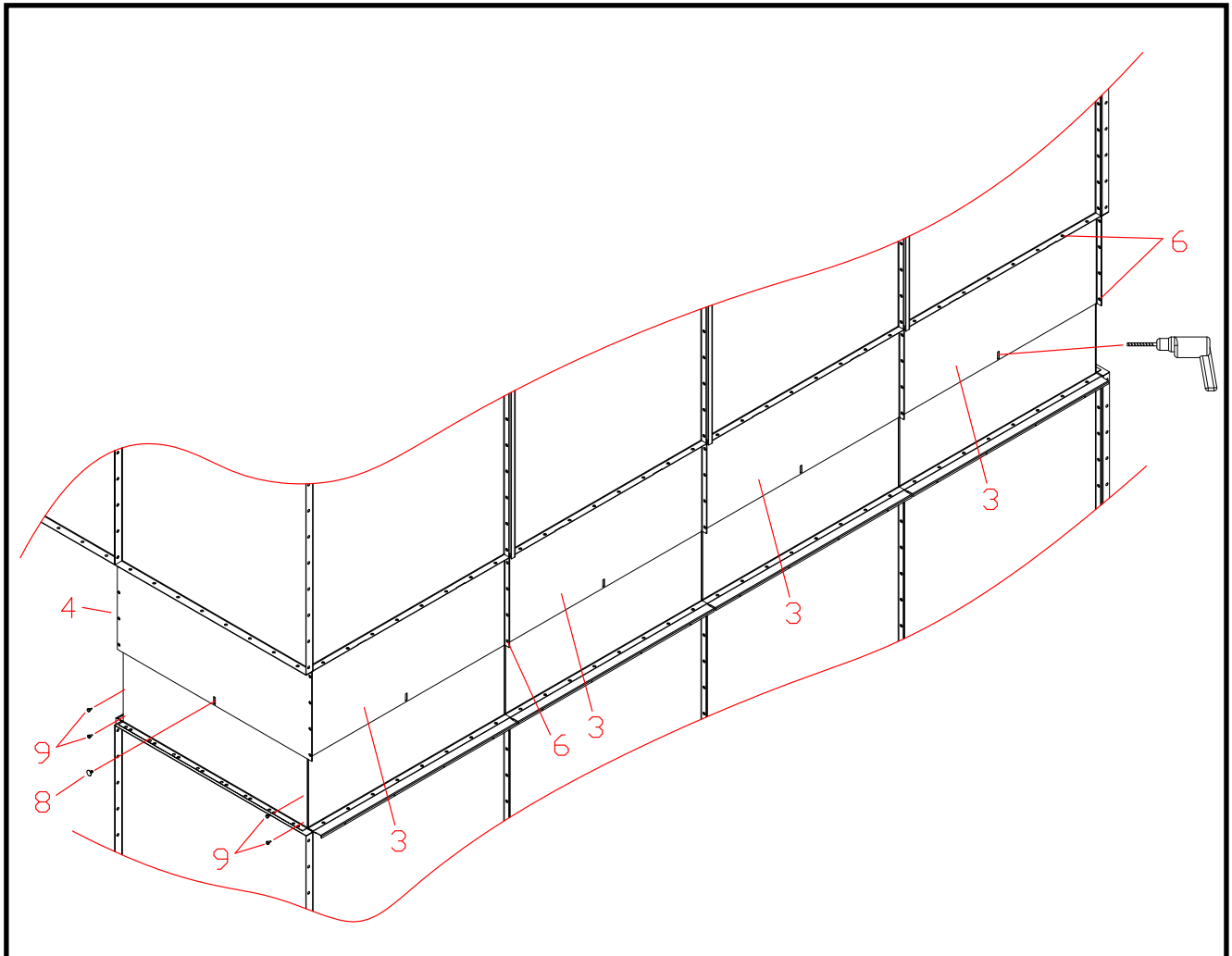


Parts The numbering of work stages refers to reference numbers in the spare parts drawing A76736 for the air channel end.

**10 (1,2)** Fix sealing strips to the flanges of the two end-plates (parts 1) parts and to the flanges of the lower surface. Fix the sealing strips inside the bolt hole rows in the flanges (see detail drawing).

**1,2,5** Join the end plates together, and side plates. Place the support (part 5) in the upper bolts. Fasten using nuts and bolts (M 8 x 16). Fasten only the lower flange of the part 2 at this stage.

## 2. Installation of the upper part



Parts The numbering of work stages refers to reference numbers in the spare parts drawing A76736 for the air channel end.

- 10 (3,4)** Fix sealing strips to the flanges of the two end-plates (parts 3) parts and yläpinnan laippoihin. Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing).
- 3,4** Join the end-plates together, and fix the side-plates using bolts and nuts. (M 8 x 16).
- 1,3** If the (the centres of the) long holes at the joint of the lower and the upper plate are not in-line, drill an 8mm hole through the hole into the lower plate. Attach using a square neck bolt (M 8 x 16). Tighten the nut against the thread of the square neck bolt so that the plates will remain slightly loose. This allows for a slight movement reserve in machineries equipped with a scale.
- 9** Fasten the corners of the lower part (1,2) using self-tapping screws Self-tapping screws, 5 pcs/corner.