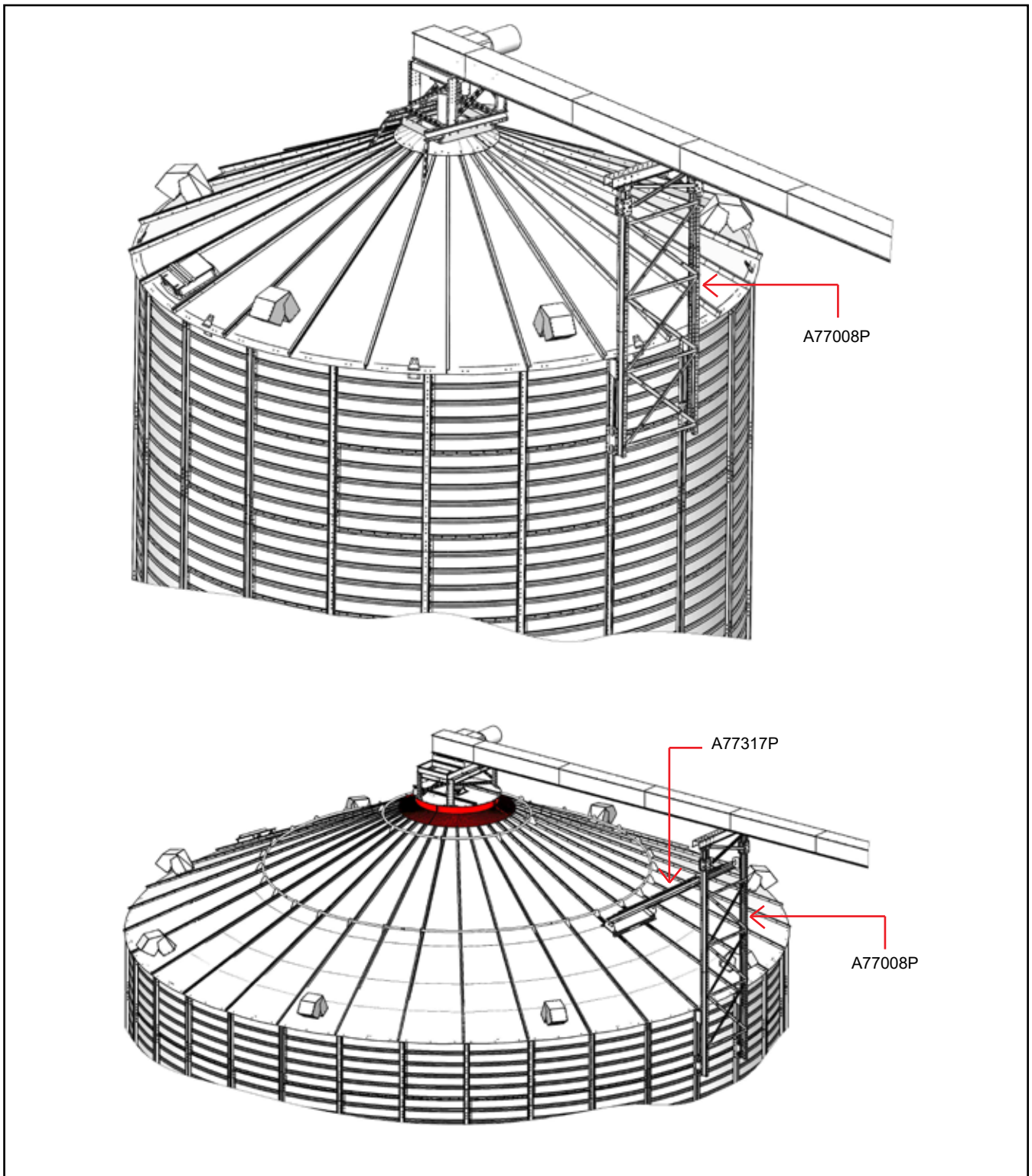
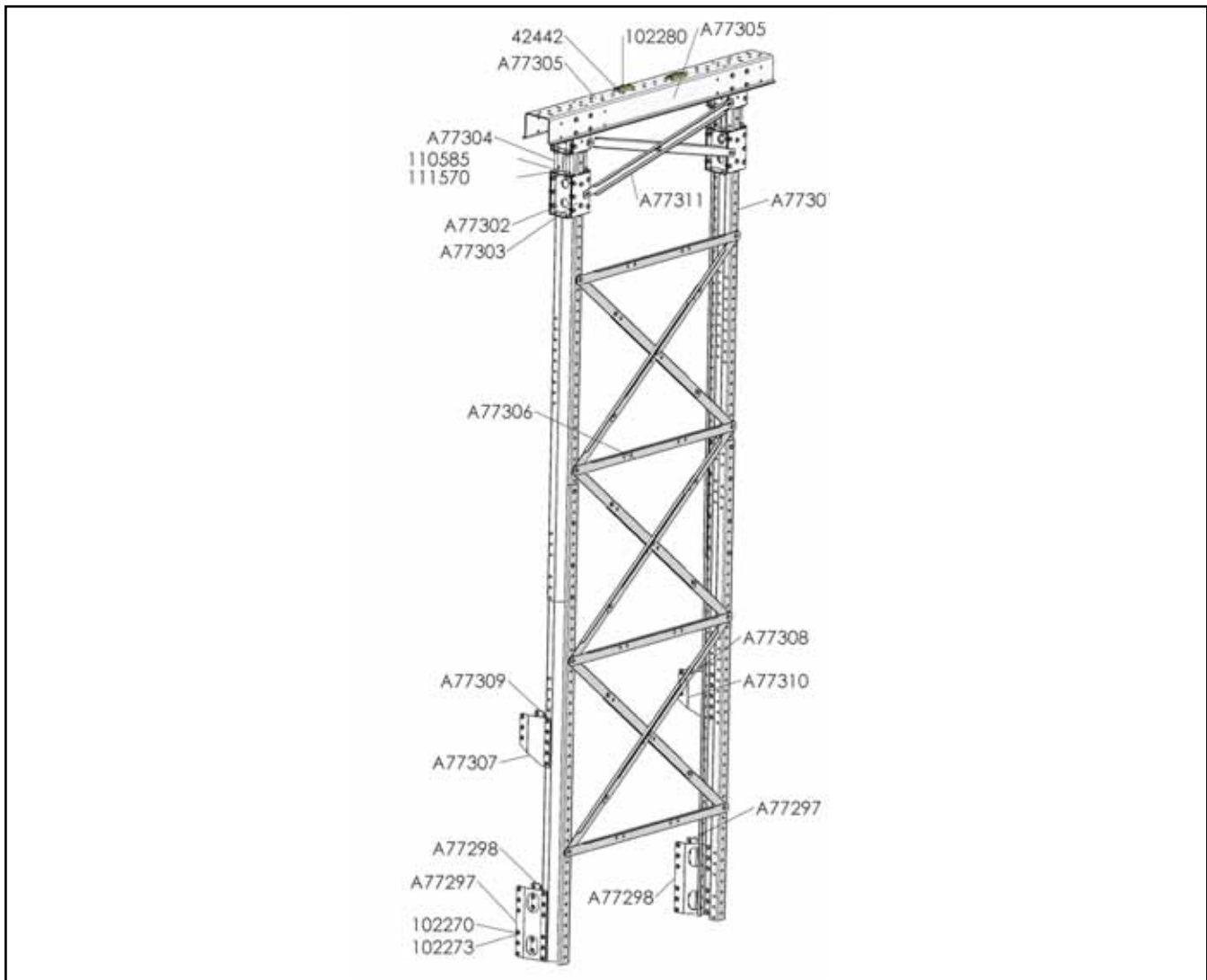


CONVEYOR SUPPORT A77008P



Diagonal A77317P is not included in the conveyor support A77008P structure.
(If required, order separately.)

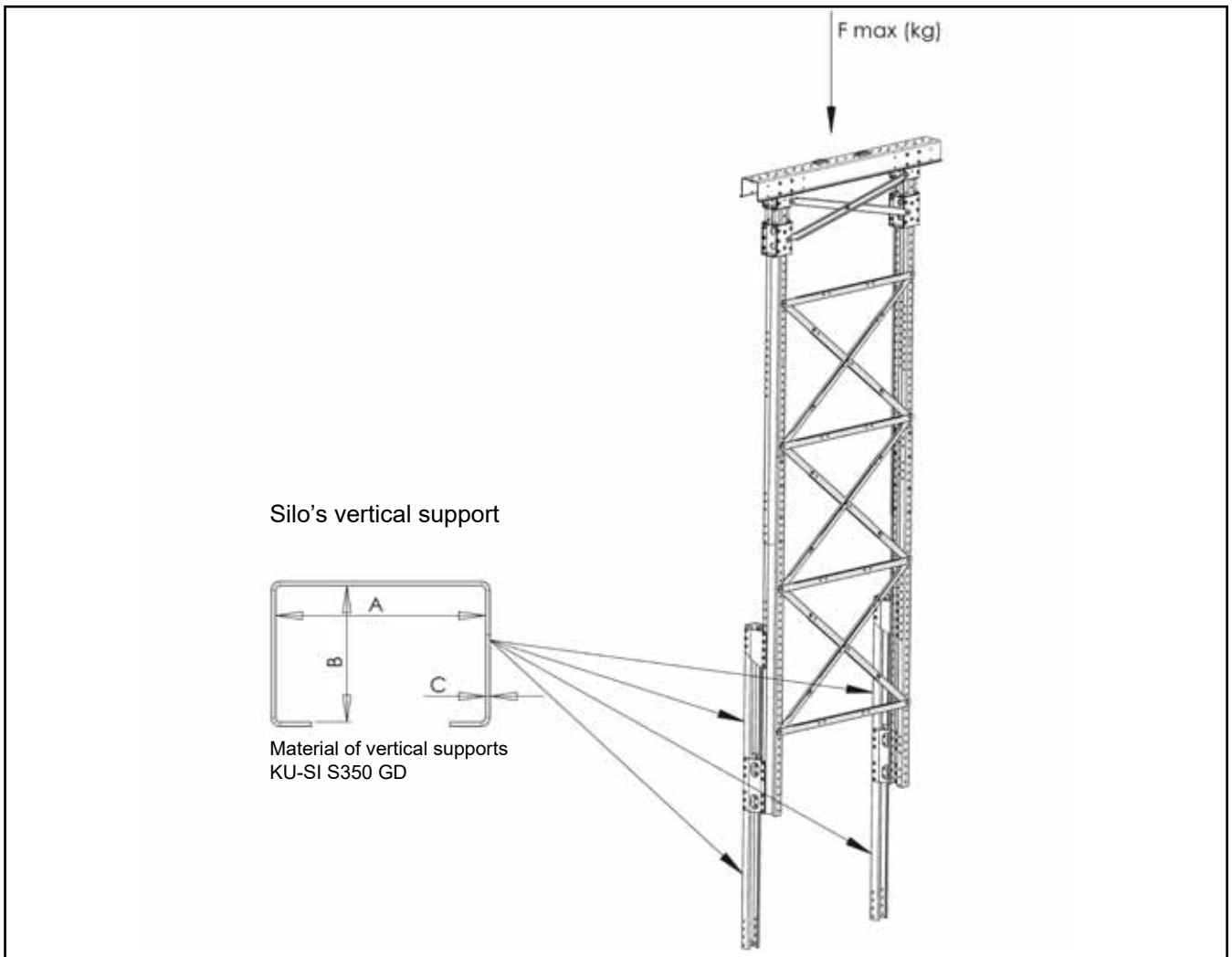
The diagonal A77317P can only be used in roofs with beam structure.
(Antti Grain silos D10,6 and D12,1)



Item	Denomination	Pcs
A77305	CONVEYOR SUPPORT HORIZONTAL BEAM M22	1
A77301	CONVEYOR SUPPORT Z-PROFILE L=2491 M22	4
A77306	CONVEYOR SUPPORT DIAGONAL M22	16
A77311	CONVEYOR SUPPORT DIAGONAL M22	2
A77297	CONVEYOR SUPPORT FASTENER A1 M22	2
A77298	CONVEYOR SUPPORT FASTENER A2 M22	2
A77307	CONVEYOR SUPPORT FASTENER B1 M22	1
A77308	CONVEYOR SUPPORT FASTENER B2 M22	1
A77309	CONVEYOR SUPPORT FASTENER B3 M22	1
A77310	CONVEYOR SUPPORT FASTENER B4 M22	1
A77302	CONVEYOR SUPPORT TRIM PLATE M22	8
A77303	CONVEYOR SUPPORT TRIM PLATE M22	8
A77304	STUDBOLT M16 8.8 ZN L=235	8
42442	CLAMP 4X38X100 M03	2
A77360	SCREW PACKAGE CONV. SUPPORT BAK M22	1
102270	HEXAGON FLANGE BOLTS 10X25 ZN 8.8 DIN 6921	154
102273	HEX FLANGE NUT M10 ZN 8 DIN 6923	156
102280	BOLT HEX ZN 8.8 10X50 AM DIN933	2
110585	NUT M16 ZN8 DIN934	32
111570	WASHER M 16 DIN125 ZN	32

A77360

Permissible load on the conveyor support



Silo vertical support Dimensions (mm)			Maximum permissible load
A	B	C	F_{max} (kg)
94	61	3	2260kg
94	61	2	1870 kg
94	44	3	1360 kg
94	44	2	1090 kg

- The material strengths and internal dimensions of the vertical supports in the silo wall determine the maximum load that can be applied to the conveyor support.
- The maximum permissible load directly from above on the carrier support is determined in the table above.
- In the table, select a row in which the dimensions of the vertical supports correspond to the dimensions of the vertical supports to which the conveyor support is attached.
- Note: If stronger vertical supports are selected on a case-by-case basis for the conveyor support than what is normal in the silo, the reinforcement must be done starting from the lower edge of the silo to its upper edge.
- The conveyor support must not be used to support a conveyor or conveyor bridge with an unsupported span of more than 13 metres.

Assembling the conveyor support

See positioning of the Z beams A77301 in the image corresponding to the silo diameter of the installation. The image shows the size of the crossing in the silo roof centre when using the Z beam lapping indicated in the image.

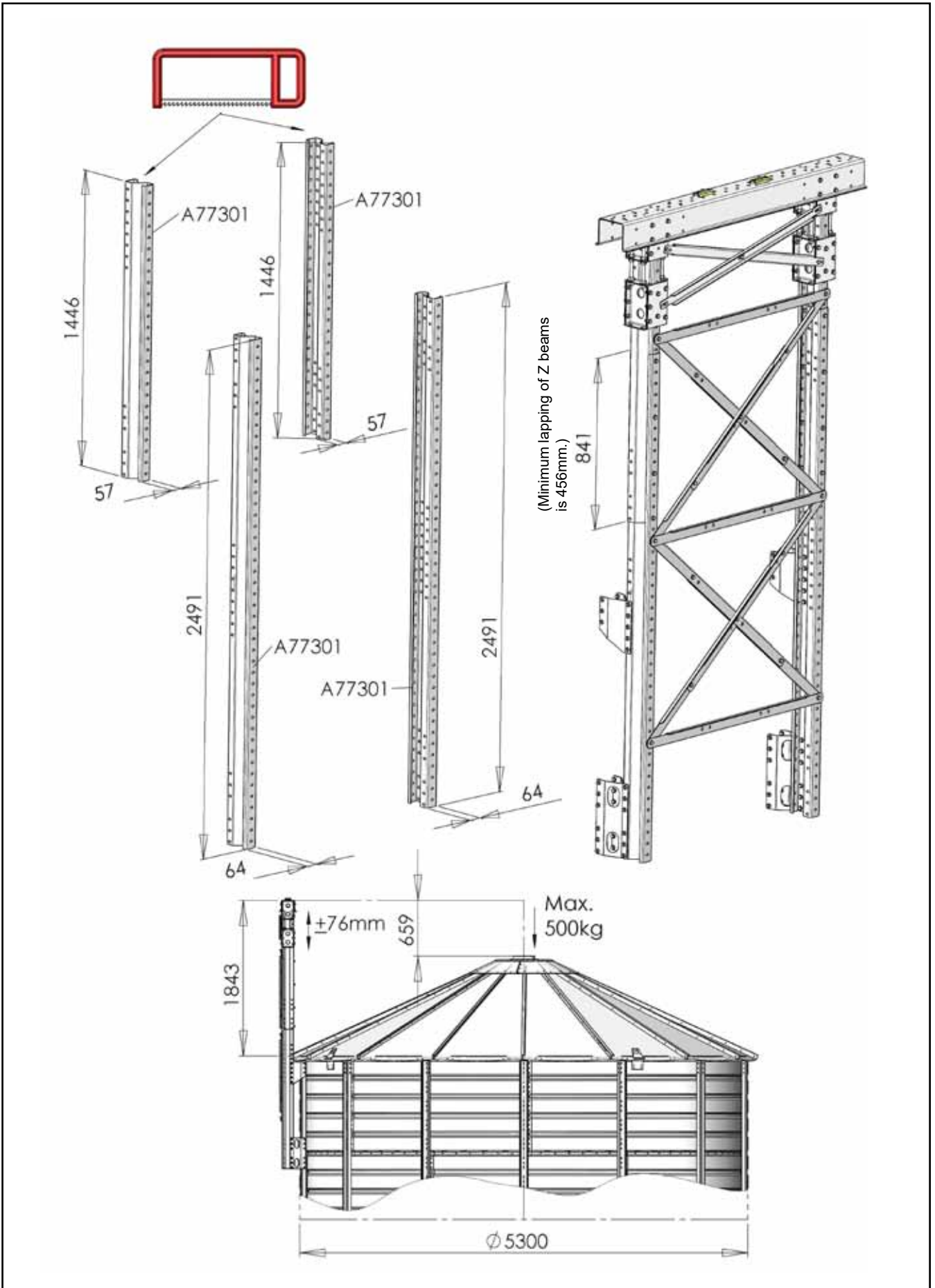
- Silo D5,3 page 5
- Silo D7,5 page 6
- Silo D10,6 page 7
- Silo D12,1 page 8

Note: The lapping between Z beams must be 456 mm at a minimum!!

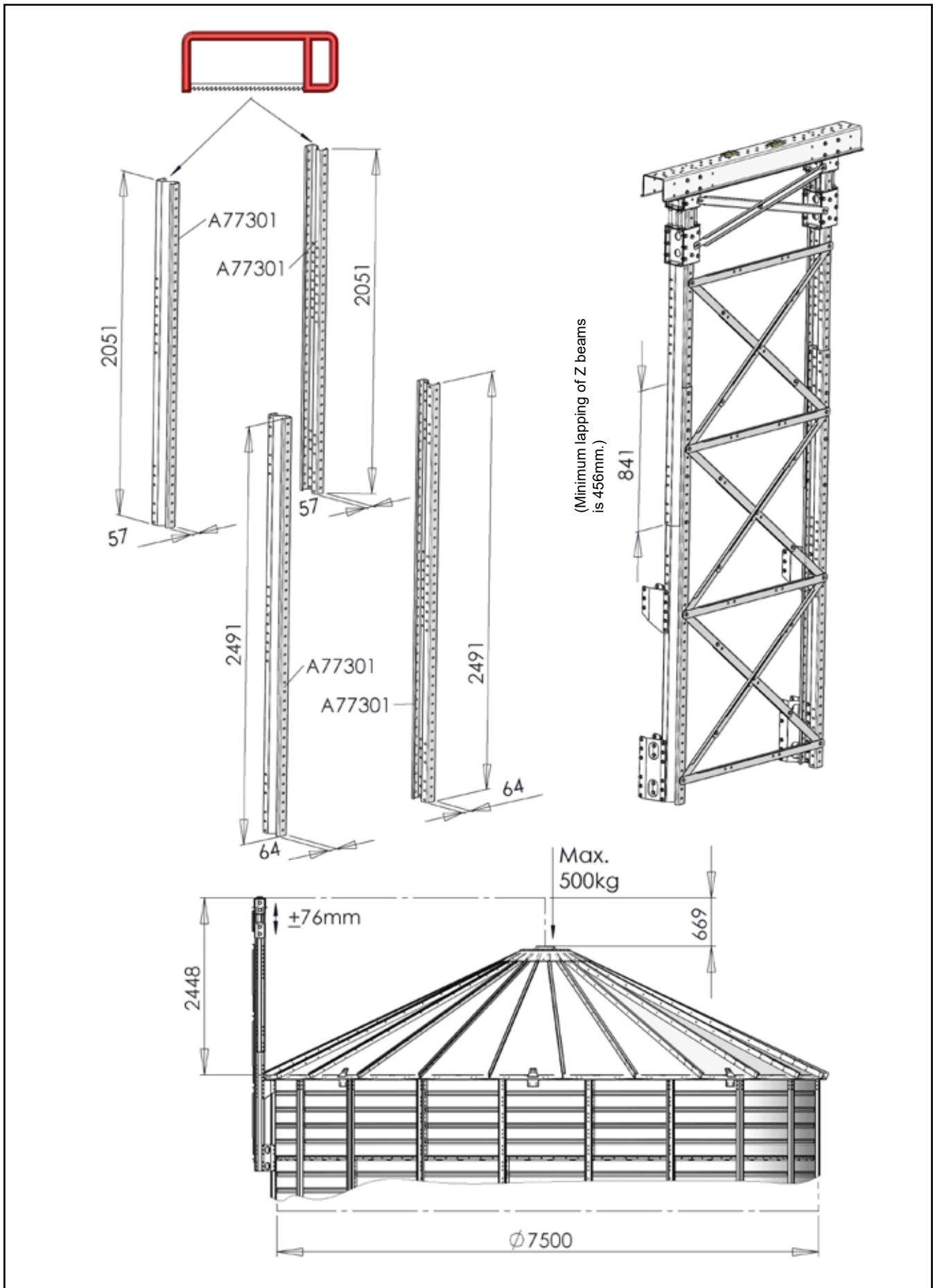
The upper Z beams must be cut to the length indicated in the image (Silos D5,3 and D7,5).

- The M10 fastening screws must be tightened to 50Nm.

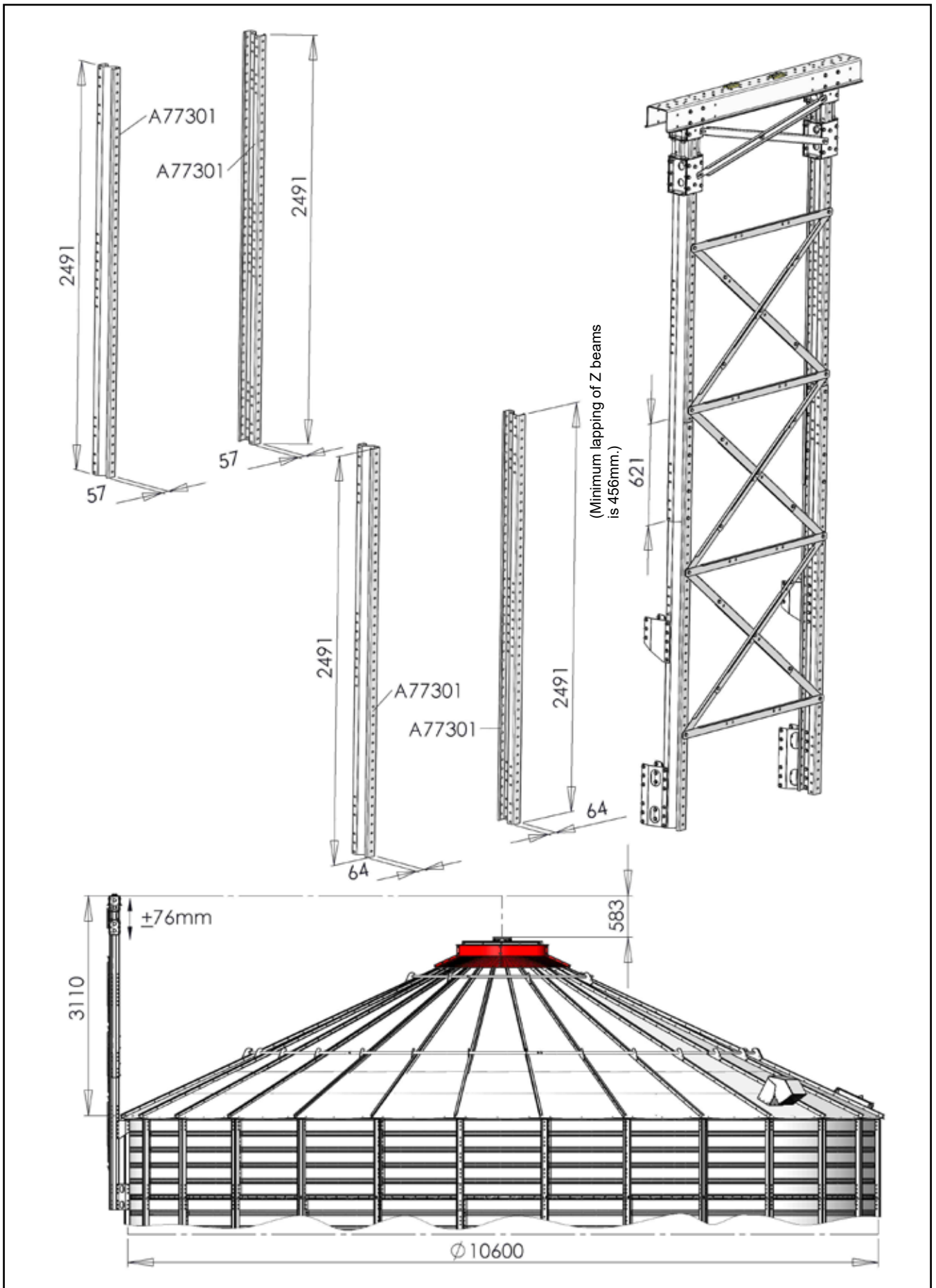
Installing to silo D5,3m



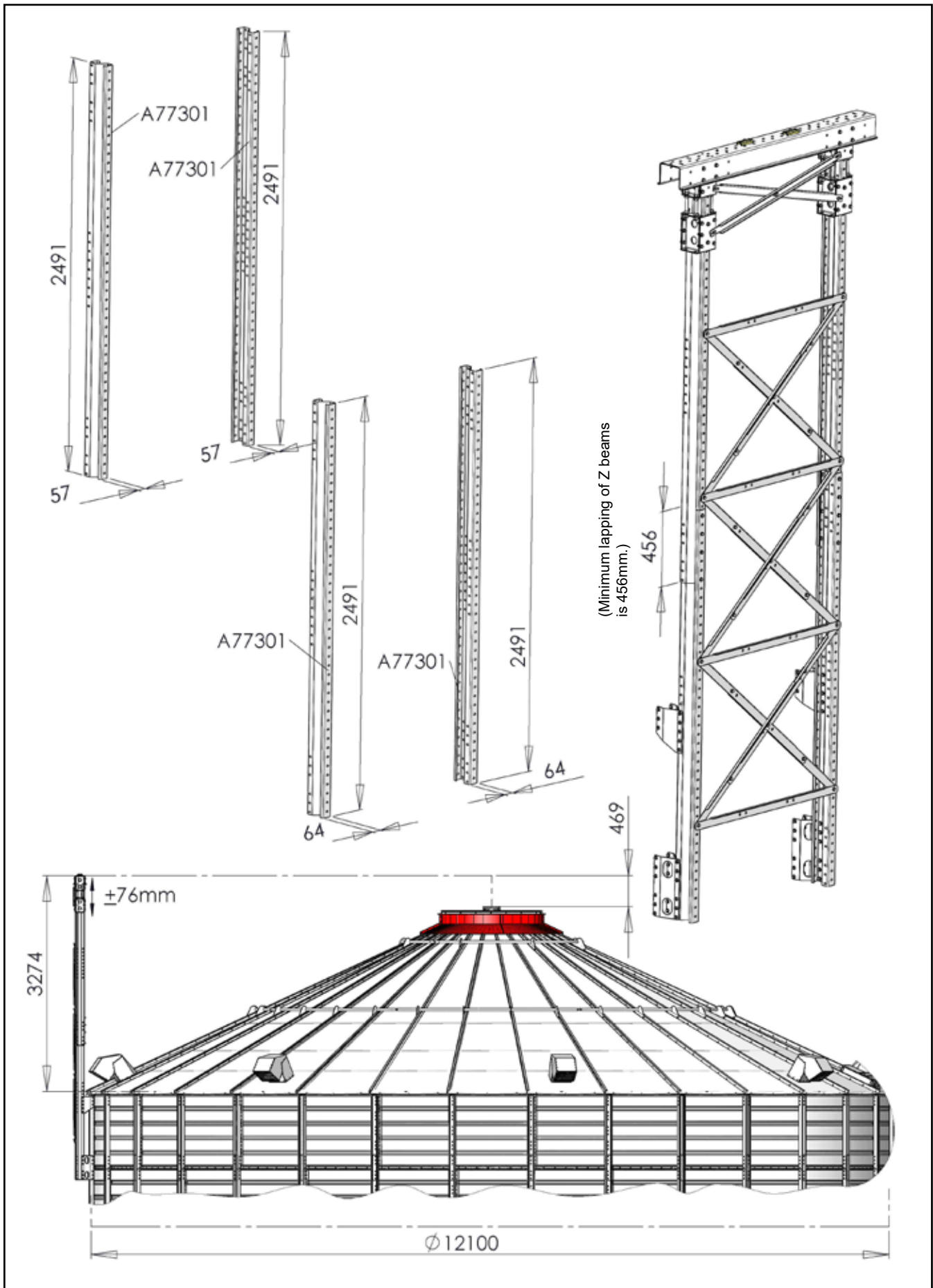
Installing to silo D7,5m



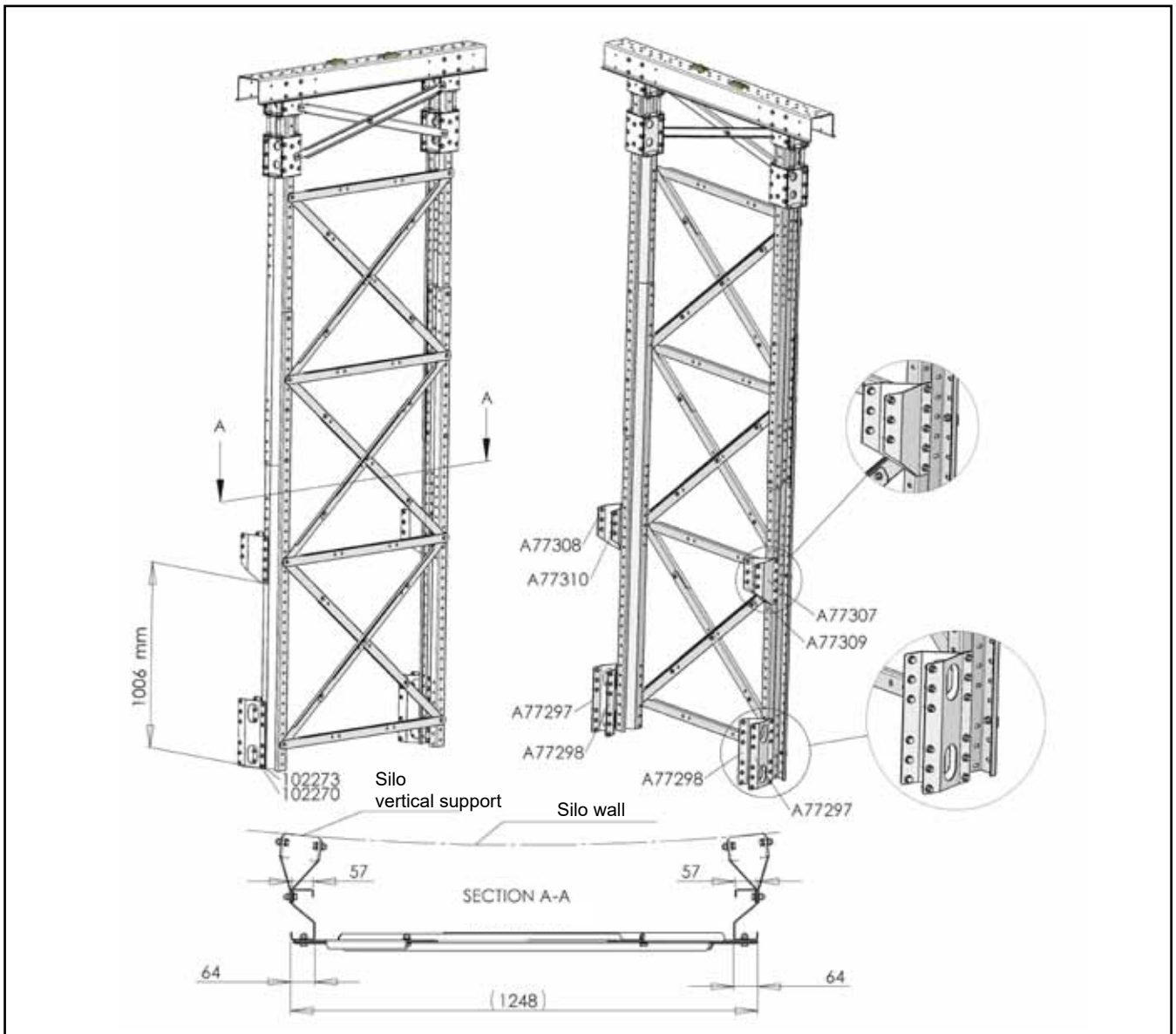
Installing to silo D10,6m



Installing to silo D12,1m



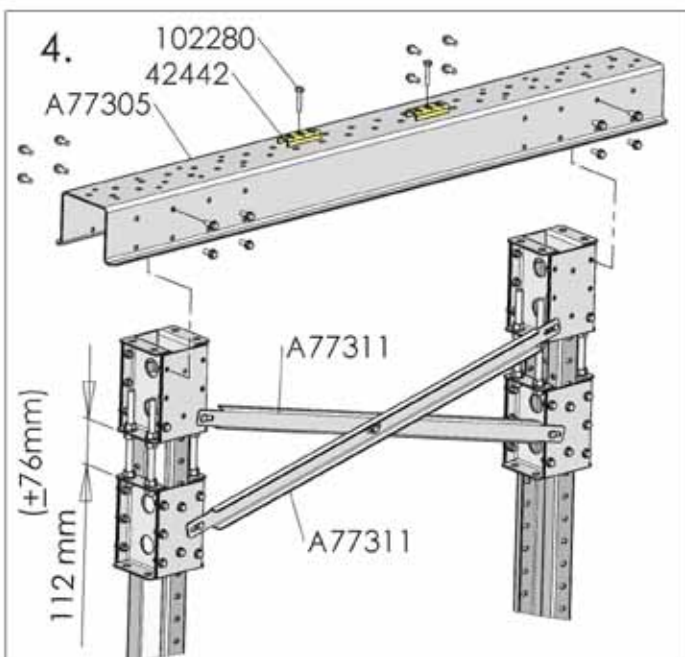
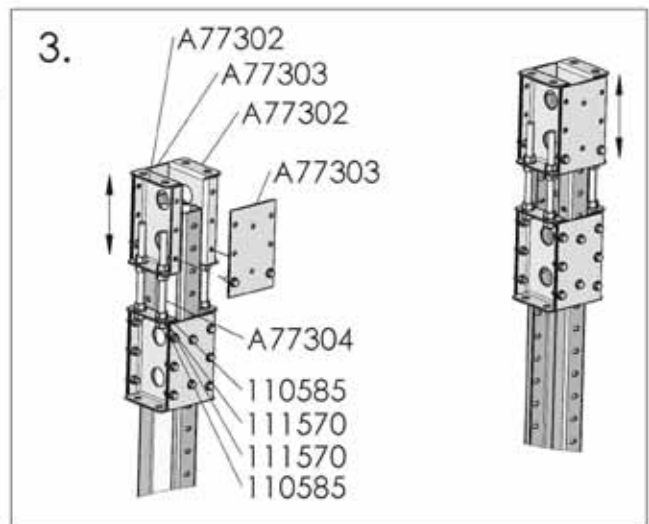
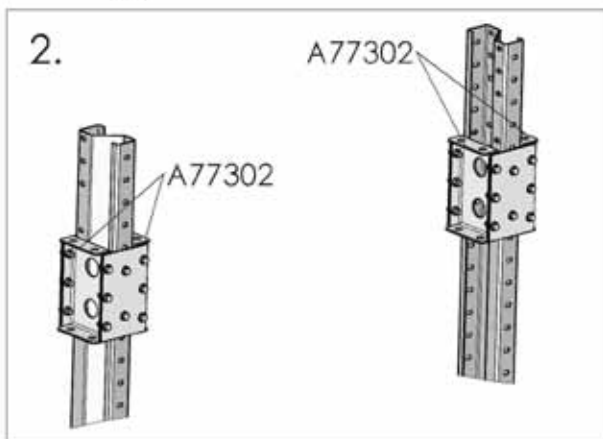
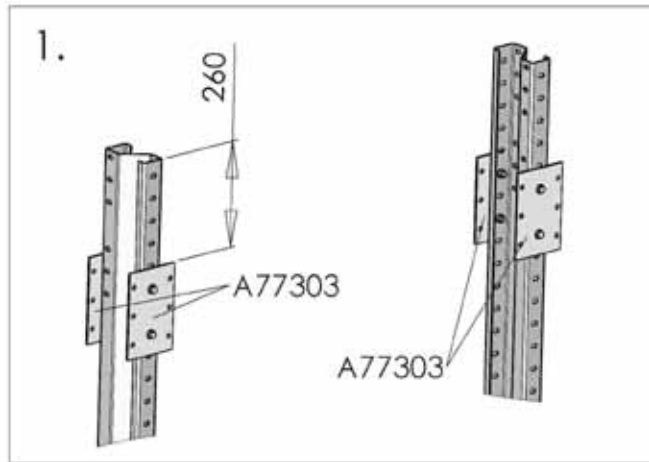
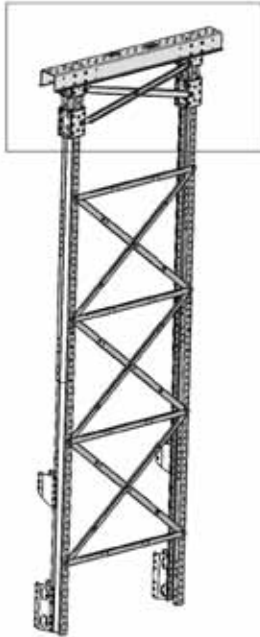
Assembling the fastener



Item	Denomination
A77297	CONVEYOR SUPPORT FASTENER A1 M22
A77298	CONVEYOR SUPPORT FASTENER A2 M22
A77307	CONVEYOR SUPPORT FASTENER B1 M22
A77308	CONVEYOR SUPPORT FASTENER B2 M22
A77309	CONVEYOR SUPPORT FASTENER B3 M22
A77310	CONVEYOR SUPPORT FASTENER B4 M22
102270	HEXAGON FLANGE BOLTS 6K 10X25 ZN 8.8 DIN 6921
102273	HEX FLANGE NUT M10 ZN 8 DIN 6923

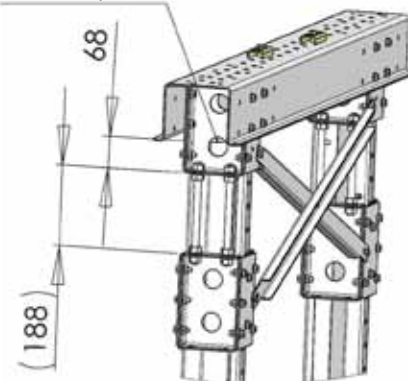
- The fastenings must be installed precisely as shown in the image.
- The fastenings are marked with a product number to help identification.
- The fastenings are installed with M10x25 8.8 flange screws. The number of screws indicated in the images must be used for the joints.

Installing the horizontal beam



Horizontal beam maximum height

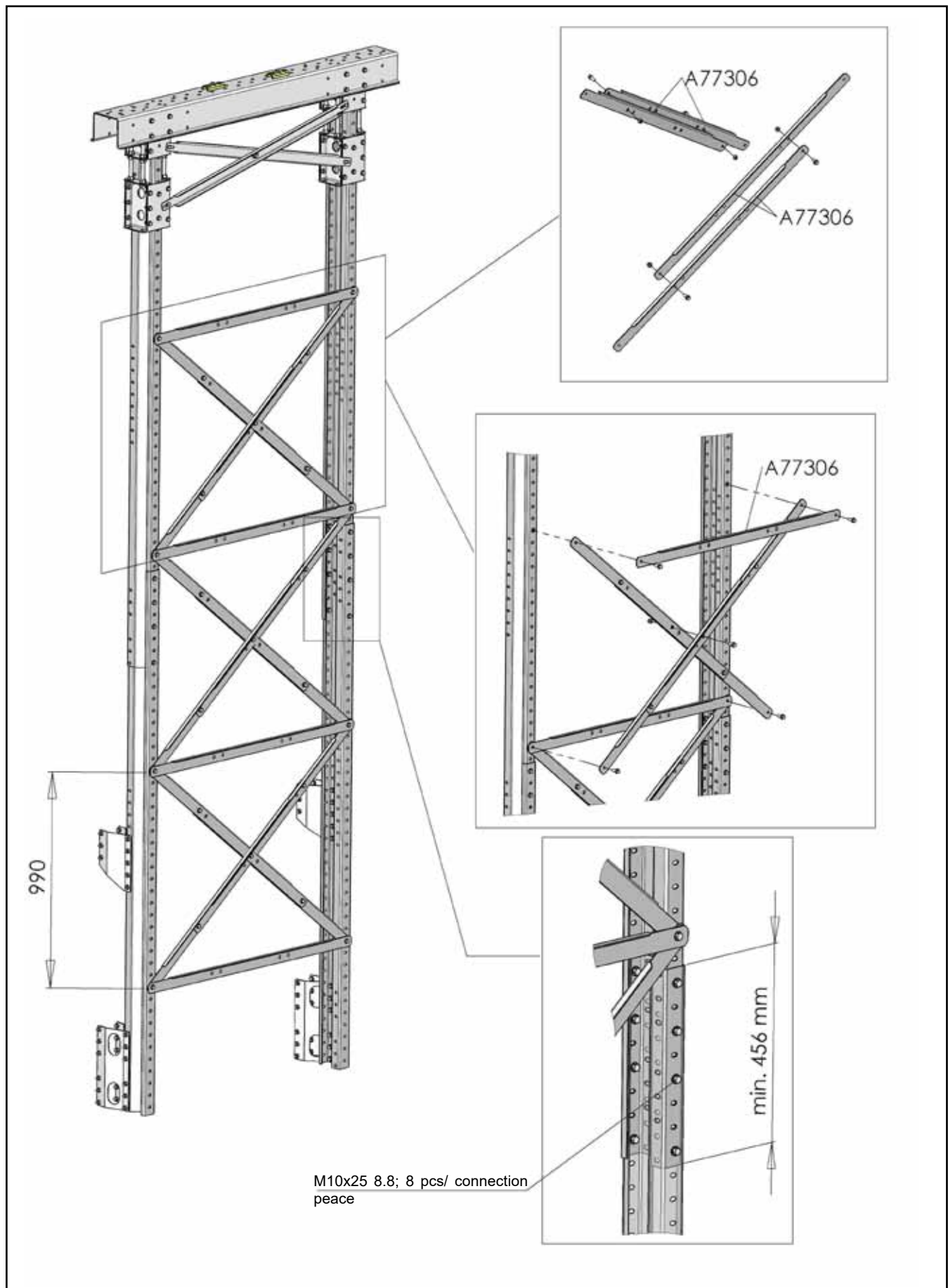
Z-Beam top surface



Item	Denomination
A77305	CONVEYOR SUPPORT HORIZONTAL BEAM M22
A77311	CONVEYOR SUPPORT DIAGONAL M22
A77302	CONVEYOR SUPPORT TRIM PLATE M22
A77303	CONVEYOR SUPPORT TRIM PLATE M22
A77304	STUDBOLT M16 8.8 ZN L=235
42442	CLAMP 4X38X100 M03
102270	HEXAGON FLANGE BOLTS 10X25 ZN 8.8 DIN 6921
102273	HEX FLANGE NUT M10 ZN 8 DIN 6923
102280	BOLT HEX ZN 8.8 10X50 AM DIN933
110585	NUT M16 ZN8 DIN934
111570	WASHER M 16 DIN125 ZN

- The horizontal beam and the components connected to it are installed precisely in accordance with the images.
- The installation sequence is as per the numbering of the image series.
- Fastening is done with M10x25 8.8 flange screws. The number of screws indicated in the images must be used for the joints.
- Fixed plate parts are fastened to moving plate parts with threaded pins (M16x235mm 8.8). A total of 8 threaded pins are needed for the structure. Images 3 and 4
- The lapping between the Z beam and the adjustment plate must be 68mm minimum. The horizontal beam must not be adjusted higher than this. See the image for the maximum height of the horizontal beam.
- The horizontal beam must be installed laterally precisely as shown in image 4. The lateral position may only be changed if the centre of gravity of the conveyor / conveyor bridge is shifted towards the centre of the conveyor support structure.

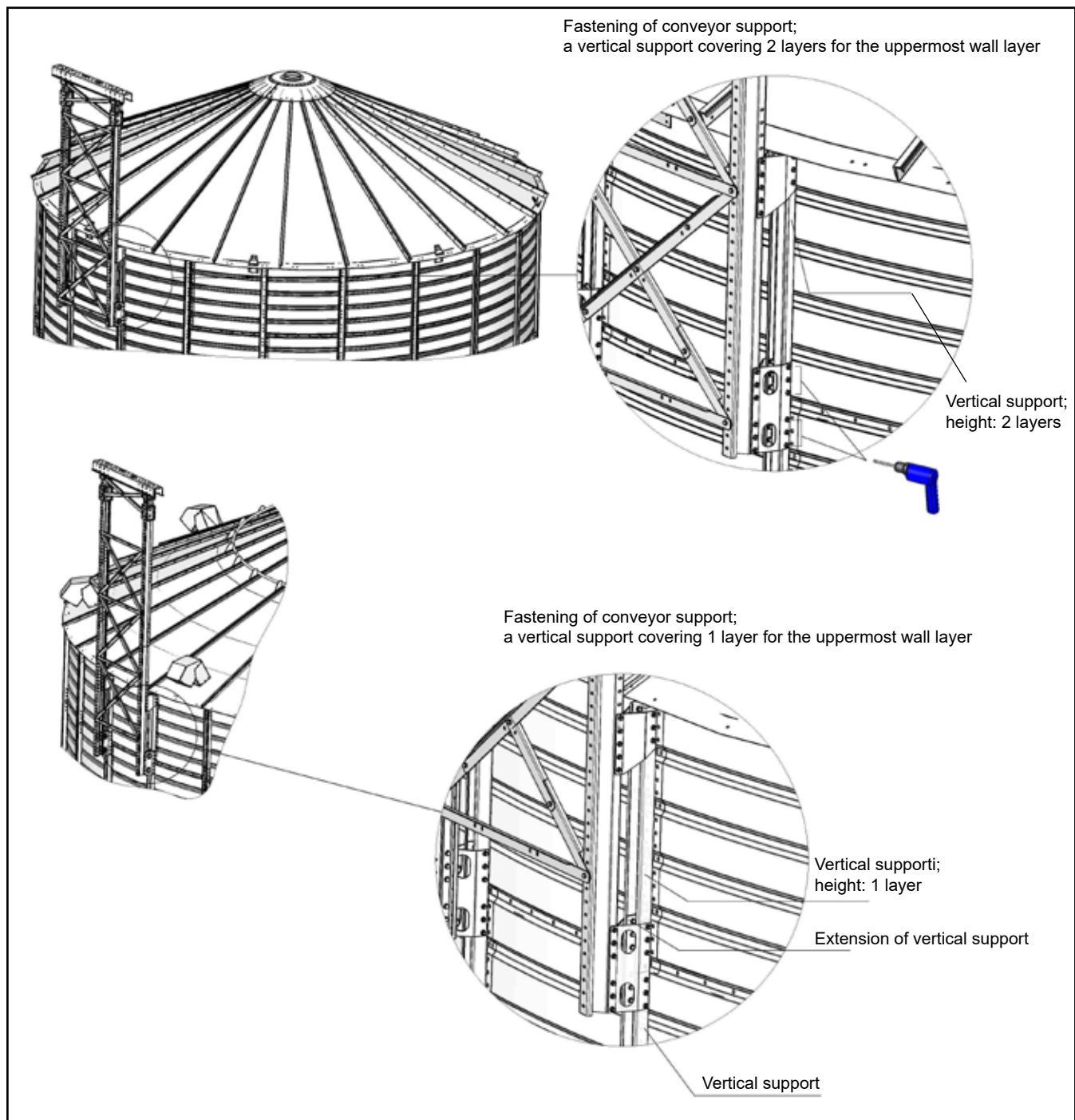
Installation of cross supports, bolting of Z beams together



Item	Denomination
A77306	CONVEYOR SUPPORT DIAGONAL M22
102270	HEXAGON FLANGE BOLTS 10X25 ZN 8.8 DIN 6921
102273	HEX FLANGE NUT M10 ZN 8 DIN 6923

- Note: The lapping between Z beams must be 456 mm at a minimum!!
- A minimum of 8 M10x25 8.8 flange screws must be used for the extension joint of the Z beams.
- The X pattern of the cross support is always 990mm high. If the conveyor support is adjusted so low that three X patterns cannot be on top of each other, only two are installed.
- The cross supports are installed with M10x25 8.8 flange screws.

Fastening of conveyor support to vertical supports of silo



- The conveyor support is fastened to the vertical supports of the silo with M10x25 8.8 flange screws.
- The number of screws indicated in the images must be used.
(See also page 7 which shows the numbers of screws for the fastenings.)