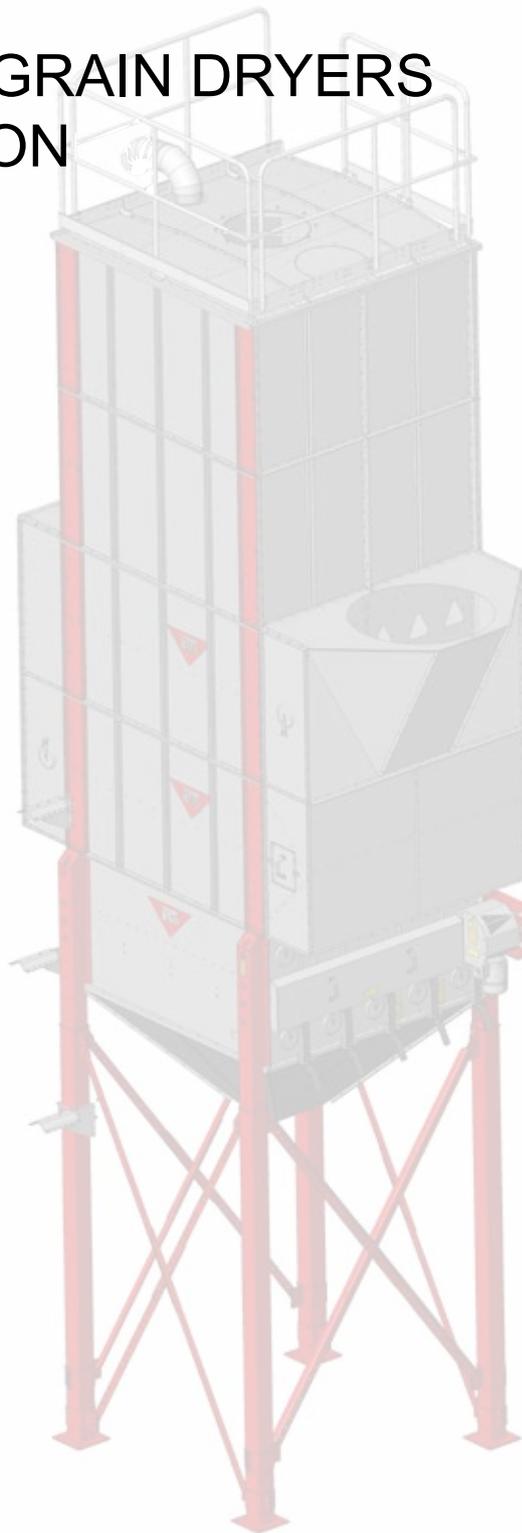


Assembly Instructions

ANTTI M06 2W GRAIN DRYERS DRYING SECTION

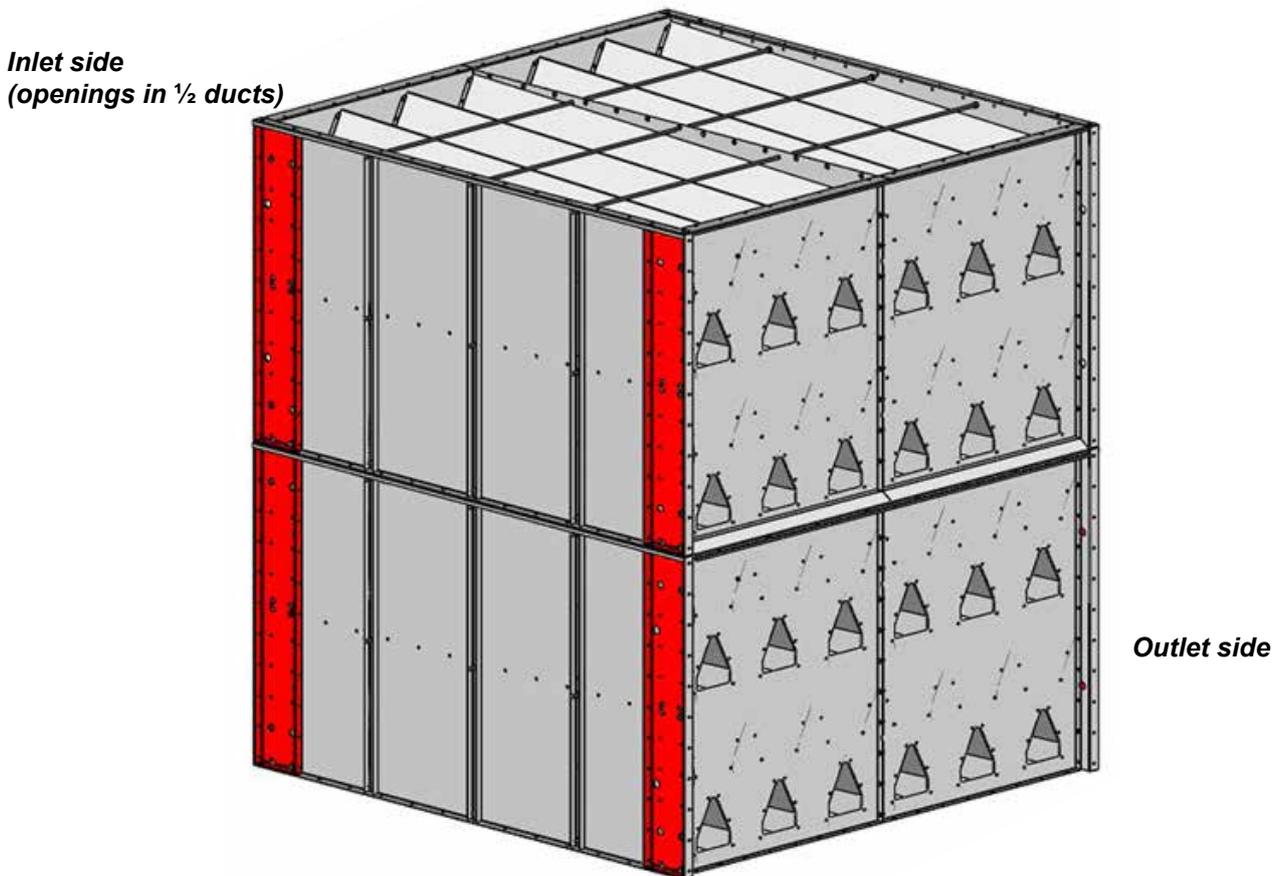
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You'll see the difference



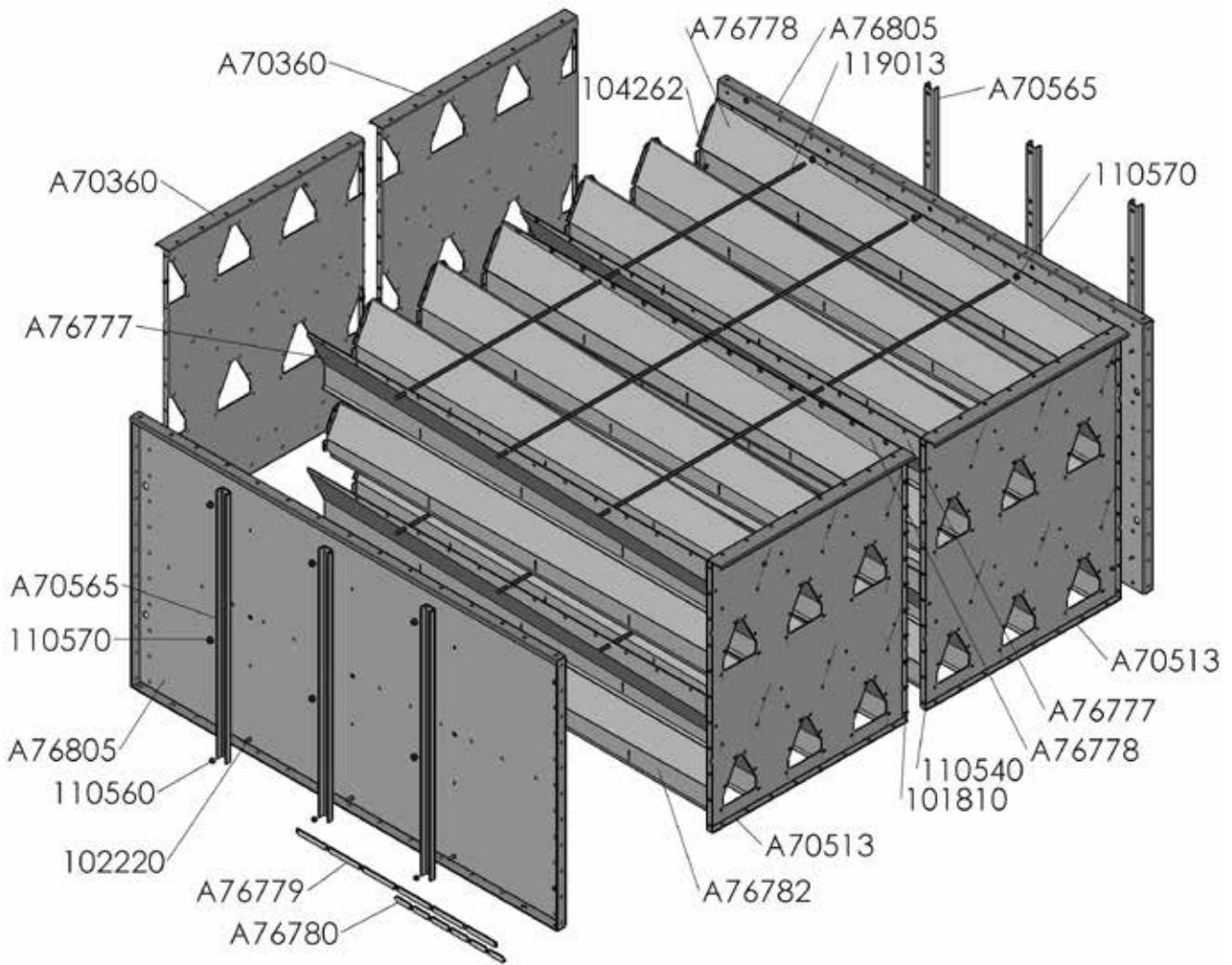
Drying section 2W assembled (A70443, A71228)



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Uppermost drying section 2W assembled (A70443), spare parts

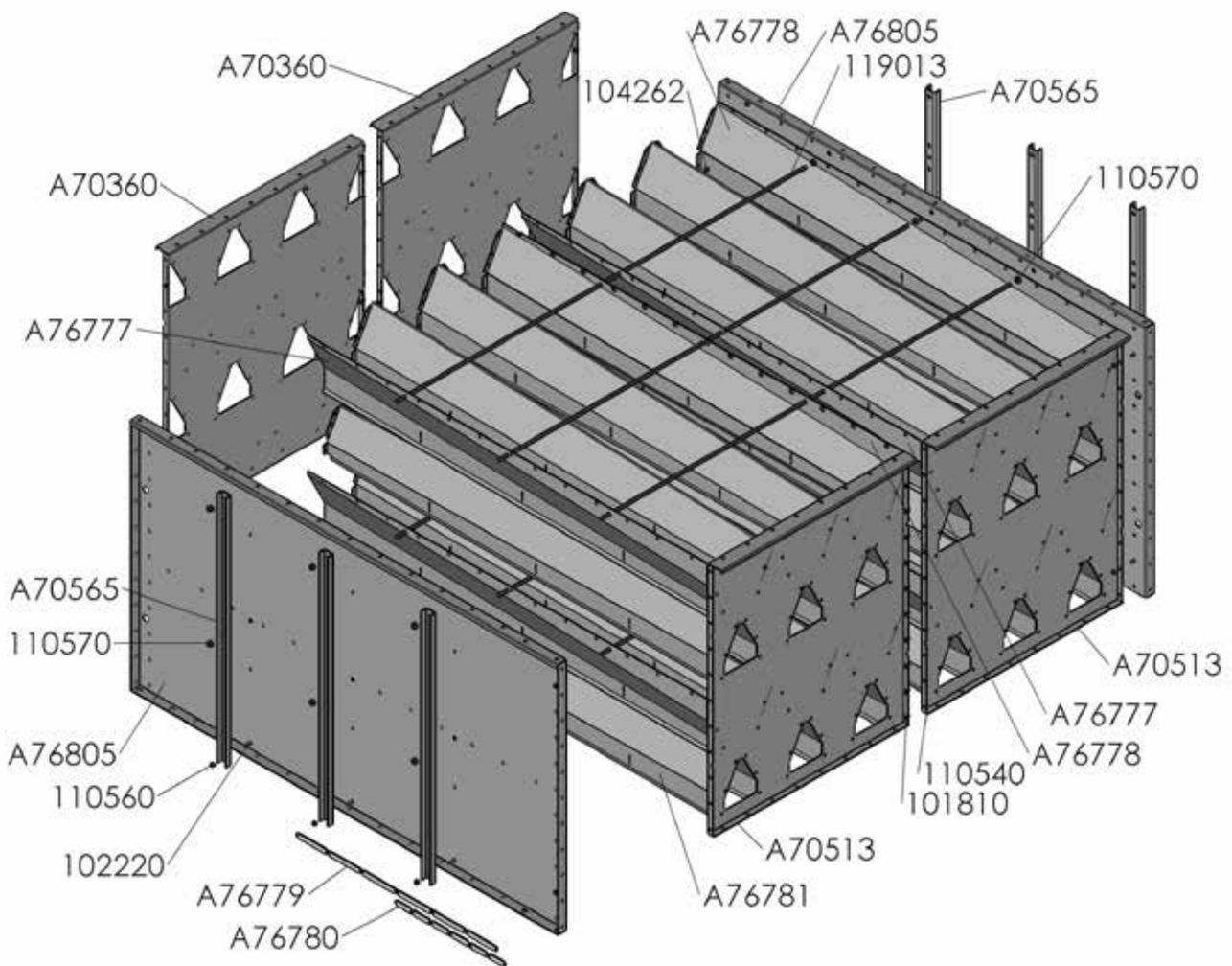




Part no	Denomination	Pcs.
A70360	SECTION WM06 END-PLATE INLET	2
A70513	SECTION WM06 END-PLATE OUTLET	2
A76805	SECTION SIDE-PLATE M21	2
A76777	SECTION DUCT 1/2 PL2 RIGHT M21	4
A76778	SECTION DUCT 1/2 PL2 LEFT M21	4
A76782	SECTION DUCT 1/1 PL2 M21	20
A76779	SECTION DUCT SUPPORTS X2 M21	12
A76780	SECTION DUCT SUPPORTS X2 1/2 M21	2
A70565	TOP SECTION WM06 VERTICAL SUPPORT	6
A70694	SECTION DUST STRIP 958 WM06	4
119013	THREADED ROD ZN M12X2000 MM 8.8	6
101810	BOLT HEX ZN 8.8 8X16 AM DIN933	120
102220	BOLT HEX ZN 8.8 10X30 AM DIN933	14
110540	NUT M8 ZN 8 DIN934	432
110560	NUT M10 ZN 8 DIN934	14
110570	NUT M12 ZN8 DIN934	24
104262	SOCK SCREW BALL-H ZN 10.9 8X12 AM ISO 7380-2	320
107720	SELF-TAP HEX SCREW DIN 7504K Zn 4,8x13	16
115570	SEALING STRIP 4X8 EKO-40	15



Intermediate and bottom drying sections, assembly 2W (A71228), spare parts





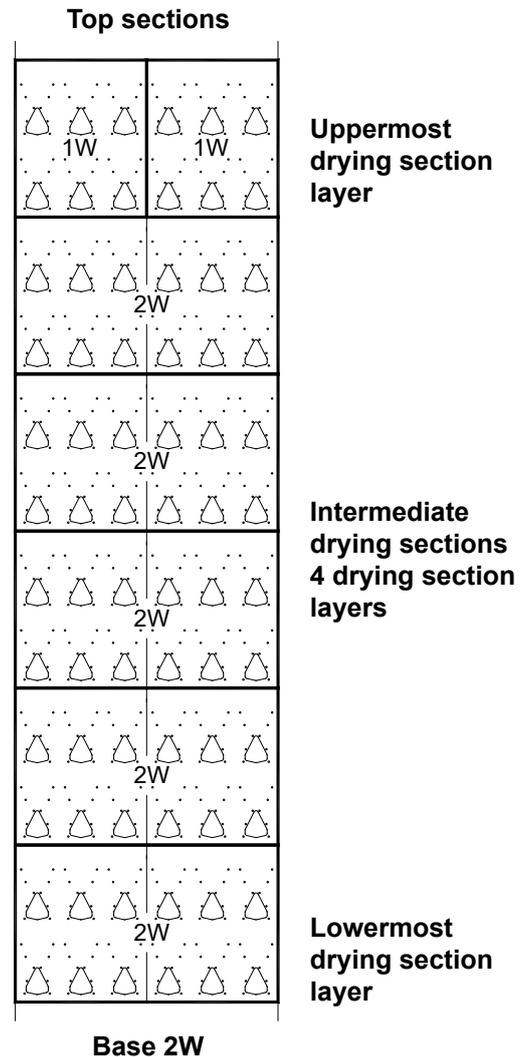
Part no	Denomination	Pcs.
A70360	SECTION WM06 END-PLATE INLET	2
A70513	SECTION WM06 END-PLATE OUTLET	2
A76805	SECTION SIDE-PLATE M21	2
A76777	SECTION DUCT 1/2 PL2 RIGHT M21	4
A76778	SECTION DUCT 1/2 PL2 LEFT M21	4
A76781	SECTION DUCT 1/1 1/1 PL1,5 M21	20
A76779	SECTION DUCT SUPPORTS X2 M21	12
A76780	SECTION DUCT SUPPORTS X2 1/2 M21	2
A70565	TOP SECTION WM06 VERTICAL SUPPORT	6
A70694	SECTION DUST STRIP 958 WM06	4
119013	THREADED ROD ZN M12X2000 MM 8.8	6
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110570	NUT M12 ZN8 DIN934	24
104262	SOCK SCREW BALL-H ZN 10.9 8X12 AM ISO 7380-2	320
107720	SELF-TAP HEX SCREW DIN 7504K Zn 4,8x13	16
115570	SEALING STRIP 4X8 EKO-40	15

Basic structure of drying section layers in a 2W dryer

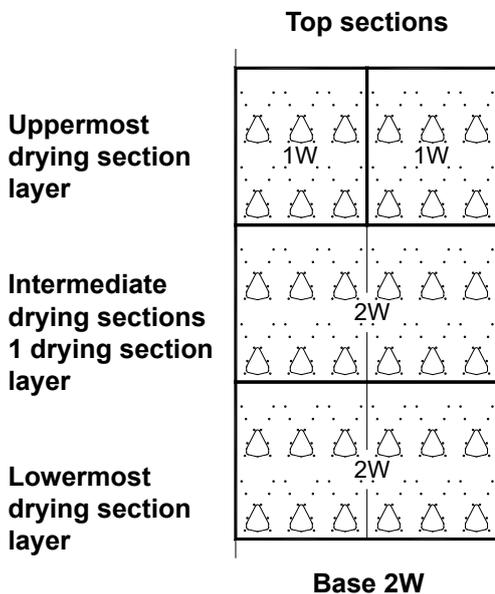
Number of layers in the dryer		Drying section packages pcs.	
		1W	2W
total			
3	1 pc. upper 2 pcs. interm / lower	2	-
4	1 pc. upper 3 pcs. interm / lower	2	-
5	1 pc. upper 4 pcs. interm / lower	2	-
6	1 pc. upper 5 pcs. interm / lower	2	-

Sample drawings: (drying sections seen from the outlet side)

The dryer has in all 6 drying section layers



The dryer has in all 3 drying section layers



In the uppermost drying section layer, the 1/1 ducts must always be of 2 mm thick material. Therefore, the layer is assembled of two 1W drying section packages.

In the lowermost and intermediate drying sections the material thickness of the the 1/1-ducts is 1,5 mm.

Material thickness of 1/2-ducts is always 2 mm.

Delivery packages of drying sections

The uppermost drying section of 2W comprises: 2 package of A70834, section 1W (ducts s = 2 mm) and 1 package of A71002, drying section sides

The lowermost / intermediate drying sections of 2W comprise: 1 packages of A70835, section 2W (ducts s = 1,5 mm) and 1 package of A71002, drying section sides

In addition, as required:(included in the dryer delivery as separate items) 4 pcs. of support legs A70359, s = 4 mm or 4 pcs. of support legs A70382, s = 6 mm

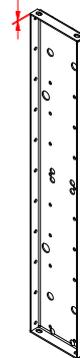
The way the legs are installed in the section depends on location of the section in the ready-assembled dryer.

Table presenting position of the support legs in different layers of the 2W dryer

Layers are enumerated starting from top to bottom

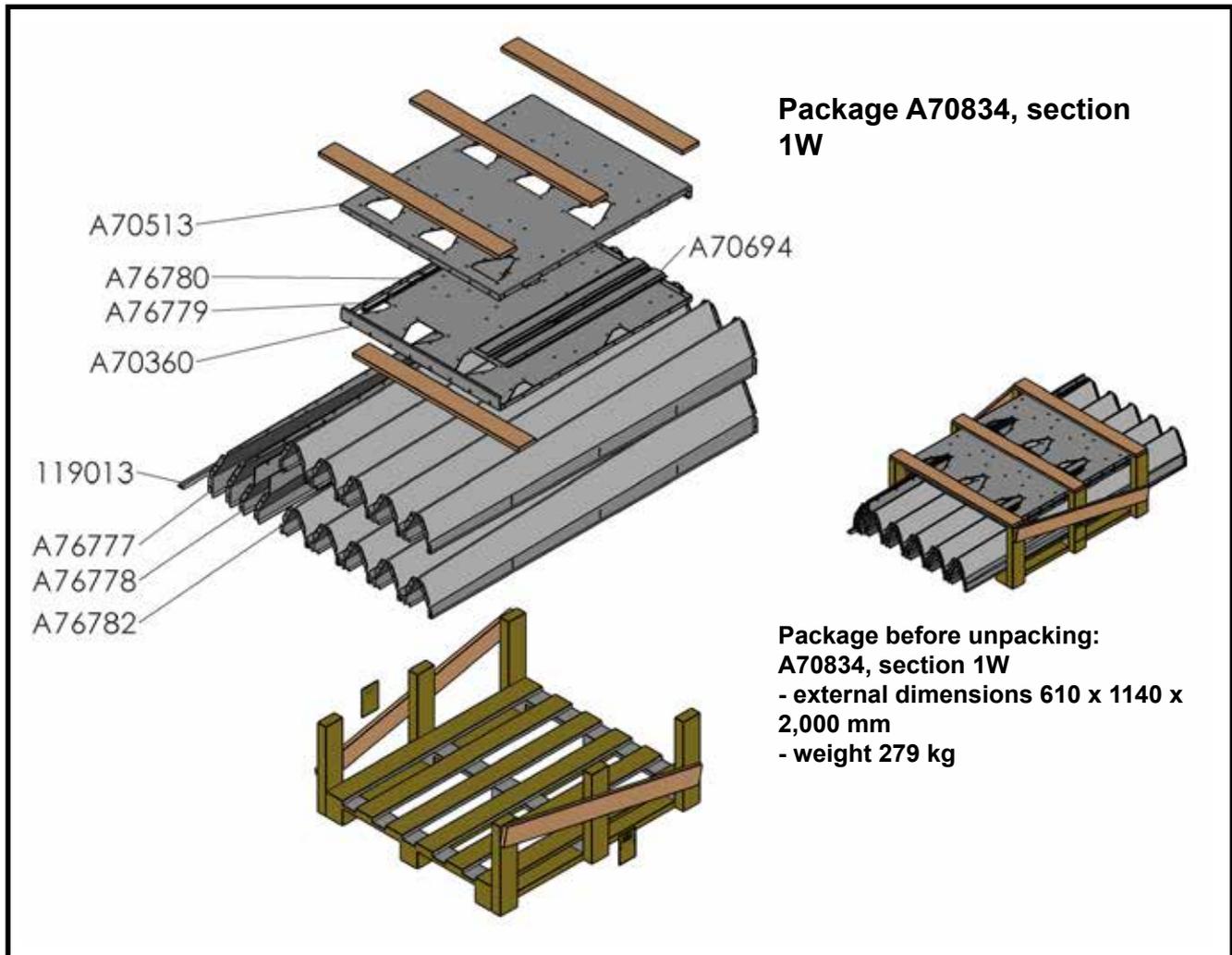
Layer	Support leg
LAYER FROM THE TOP	-
2nd LAYER FROM TOP	-
3. LAYER FROM THE TOP	-
4. LAYER FROM THE TOP	A70359, s = 4 mm
5. LAYER FROM THE TOP	A70359, s = 4 mm
6. LAYER FROM THE TOP	A70359, s = 4 mm
7. LAYER FROM THE TOP	A70359, s = 4 mm
8. LAYER FROM THE TOP	A70359, s = 4 mm
9. LAYER FROM THE TOP	A70359, s = 4 mm
10. LAYER FROM THE TOP	A70359, s = 4 mm
11. LAYER FROM THE TOP	A70382, s = 6 mm
12. LAYER FROM THE TOP	A70382, s = 6 mm
13. LAYER FROM THE TOP	A70382, s = 6 mm

A70359
s = 4 mm

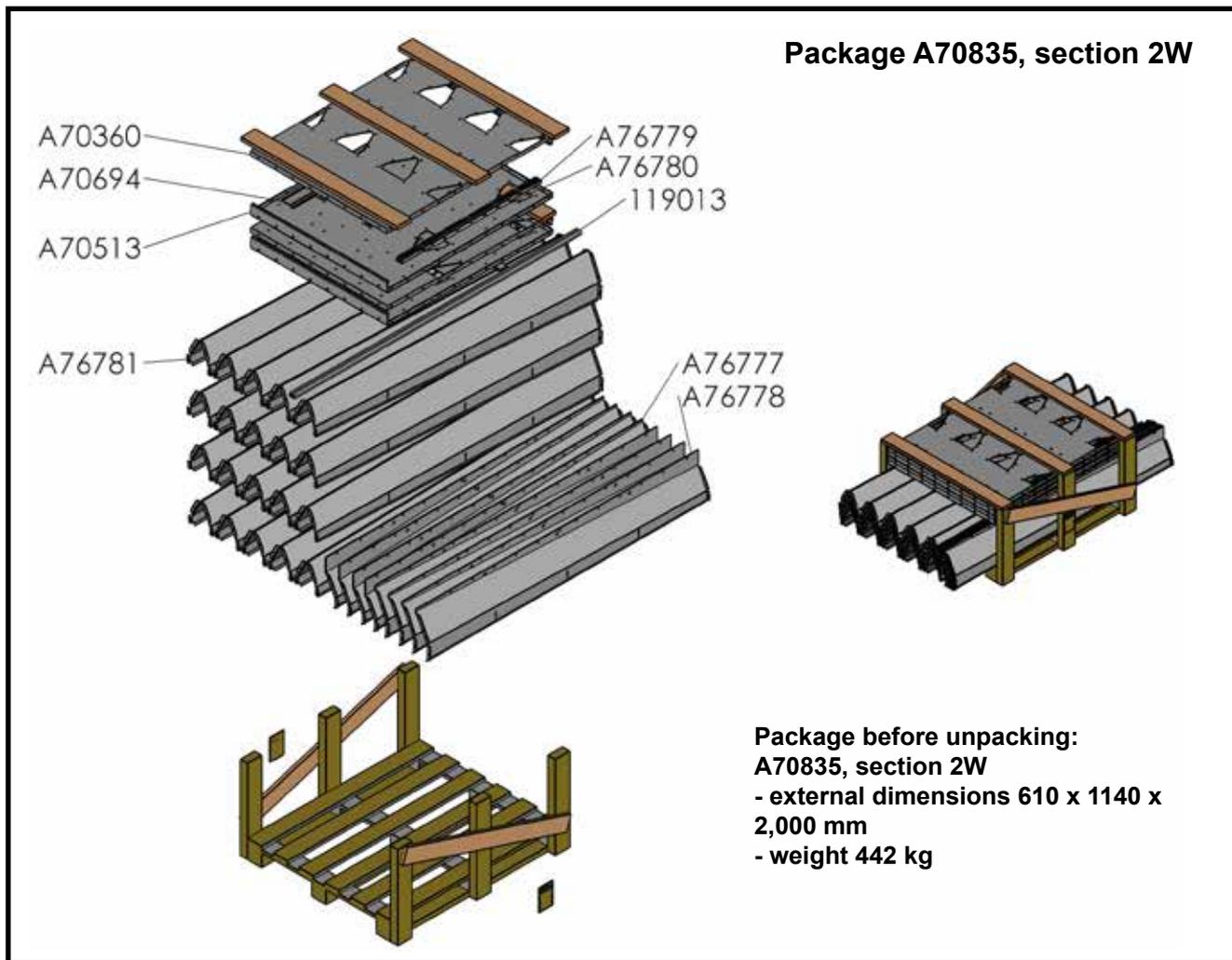


A70382
s = 6 mm





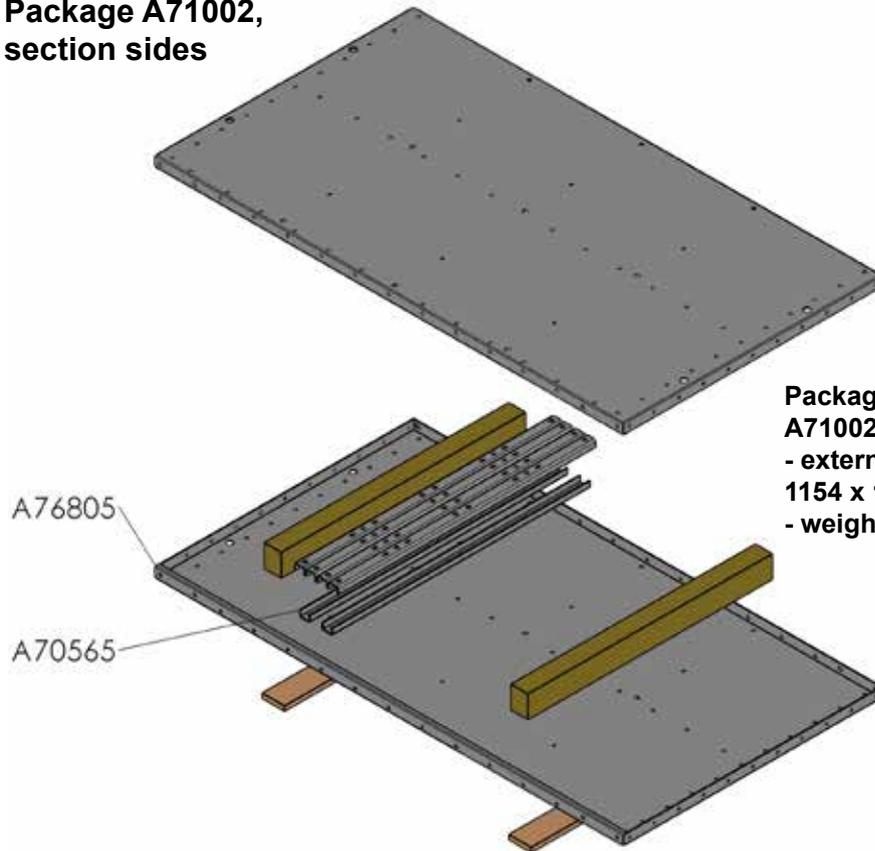
Part no.	Denomination	Pcs.
A70360	SECTION END-PLATE INLET WM06	1
A70513	SECTION END-PLATE OUTLET WM06	1
A76777	SECTION DUCT 1/2 PL2 RIGHT M21	2
A76778	SECTION DUCT 1/2 PL2 LEFT M21	2
A76782	SECTION DUCT 1/1 PL2 M21	10
A76779	SECTION DUCT SUPPORTS X2 M21	6
A76780	SECTION DUCT SUPPORTS X2 1/2 M21	1
A70694	SECTION DUST STRIP 958 WM06	2
119013	THREADED ROD M12X2000 MM 8.8 ZN	3
A70912	SECTION 1W BOLT PACK	1



Part no.	Denomination	Pcs.
A70360	SECTION END-PLATE INLET WM06	2
A70513	SECTION END-PLATE OUTLET WM06	2
A76777	SECTION DUCT 1/2 PL2 RIGHT M21	4
A76778	SECTION DUCT 1/2 PL2 LEFT M21	4
A76781	SECTION DUCT 1/1 PL1,5 M21	20
A76779	SECTION DUCT SUPPORTS X2 M21	12
A76780	SECTION DUCT SUPPORTS X2 1/2 M21	2
A70694	SECTION DUST STRIP 958 WM06	4
119013	THREADED ROD M12X2000 MM 8.8 ZN	6
A70912	SECTION 1W BOLT PACK	2



**Package A71002,
section sides**

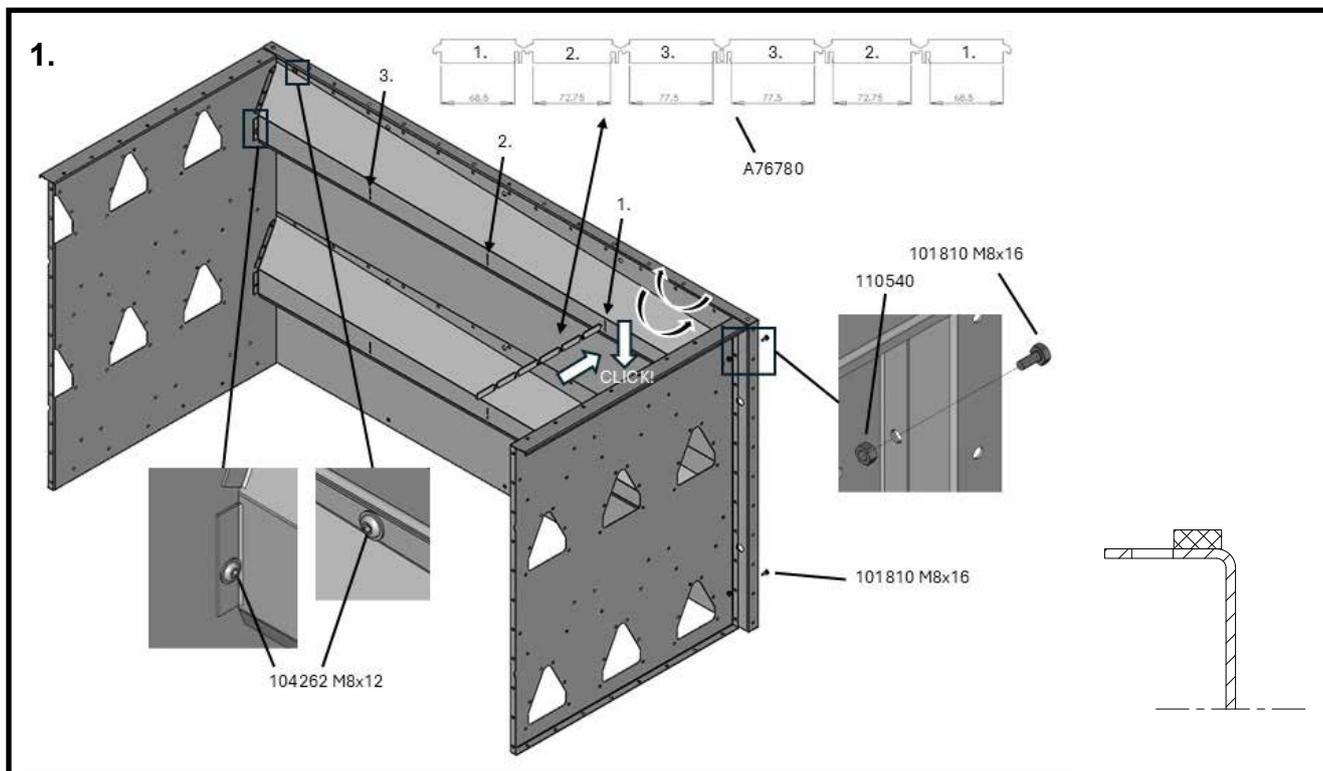


**Package before unpacking:
A71002, section sides**
- external dimensions 2088 x
1154 x 179 mm
- weight 126 kg

Part no	Denomination	Pcs.
A76805	SECTION SIDE-PLATE M21	2
A70513	TOP SECTION WM06 VERTICAL SUPPORT	6

Assembling the drying section

Select packages in accordance with the tables on previous pages depending on which of the drying sections, the uppermost, the intermediate or the lowest one, you are assembling.



1. Attaching the 1/2-ducts to the side-plates of the drying section

We recommend carrying out the assembly on an even plane.

The 1/2-ducts are mounted onto the side-plates and end plates before installing the duct supports.

Attach the sealing strips to the flanges that will be joined on the end plates.
Fix the sealing strips inside the screw hole rows in the flange (see the picture).

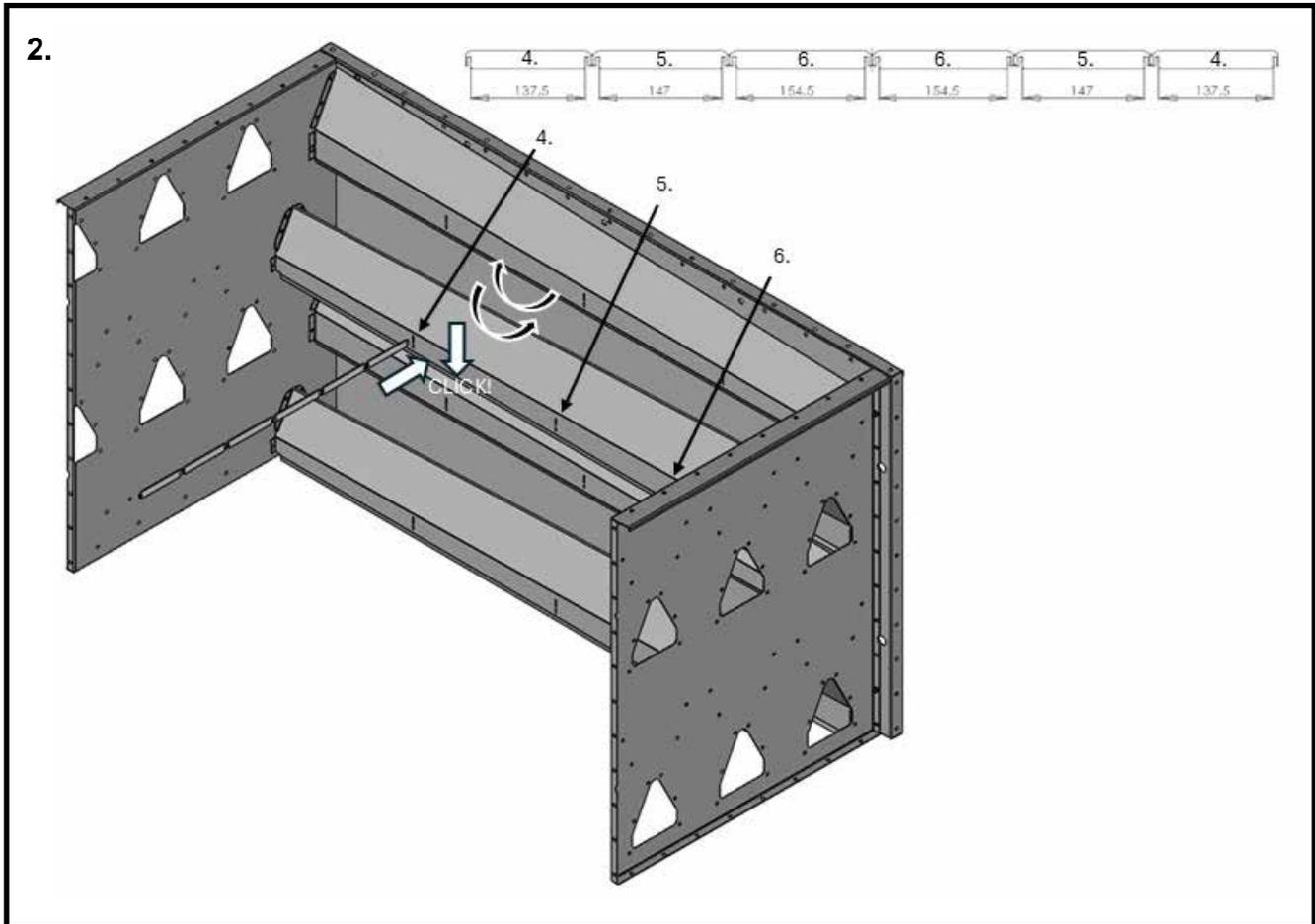
When attaching the end plates to the side-plate, install only the second-uppermost and second-lowest screw in each row of holes.

The rest of the bolts will be installed in connection with the final assembly of the drying section.
The need for support legs and their type is decided during the final assembly (see page 9).

The 1/2-ducts are installed using button head bolts, with the bolt heads facing the grain space side.. Tighten the bolts only lightly so that the ducts can settle as the drying section is assembled.

The first support is inserted through the support opening at the narrow end of the 1/2-duct (position 1).
Feed the upper end of the support through the hole in the side-plate. Press the support downward into position inside the 1/2-duct, all the way to the bottom. Once the support is in place, break off the excess by bending it sideways several times from edge to edge

Next, install the supports in positions 2 and 3 in the same manner.
Install all supports in each 1/2-duct.



2. Installation of the 1/1-ducts between the end-plates of the drying section

Install two 1/1-ducts between the end-plates.

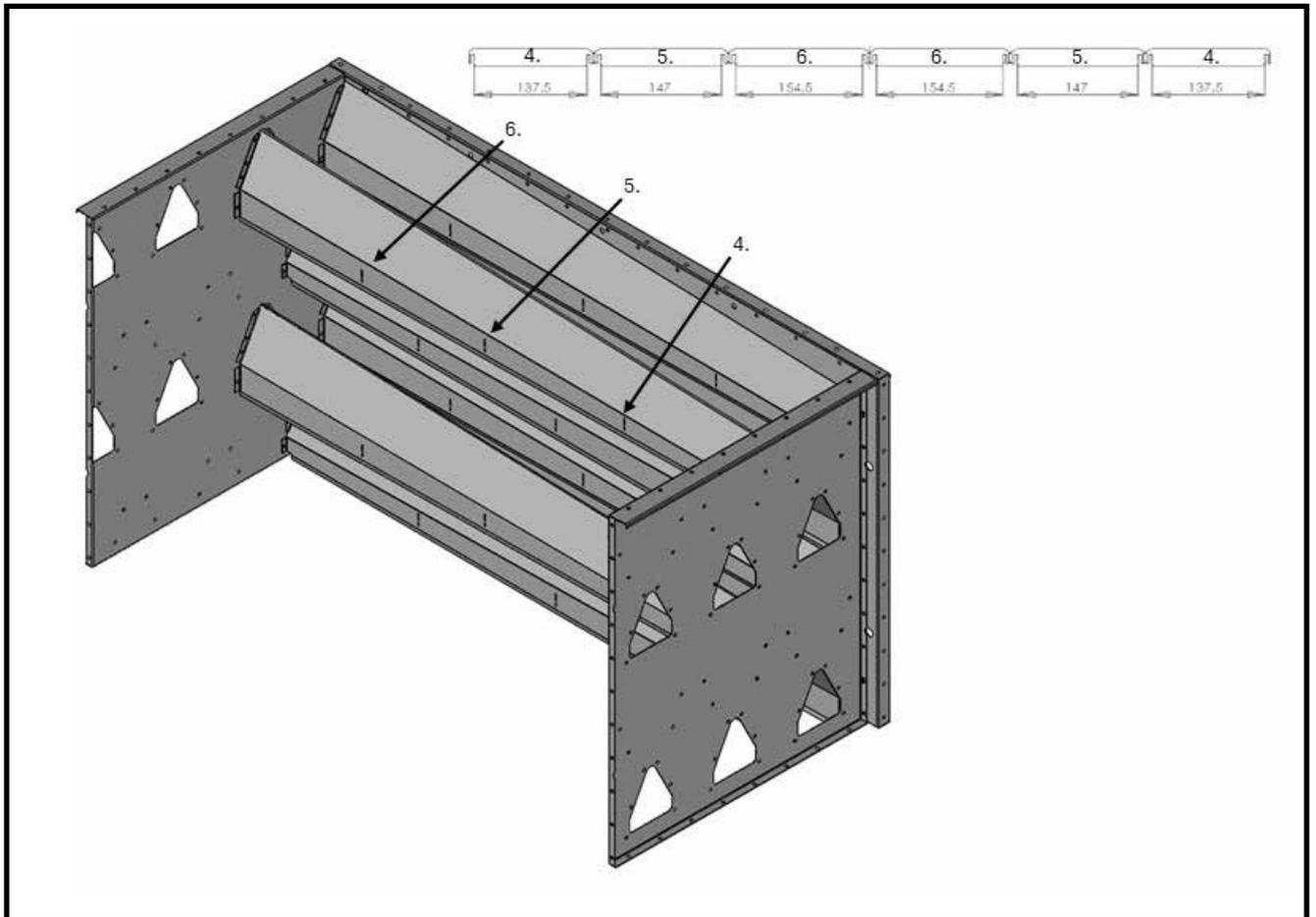
The 1/2-ducts are installed using button head bolts, with the bolt heads facing the grain space side. Tighten the bolts only lightly to allow the ducts to settle during the assembly of the section.

The first support is inserted through the support opening at the narrow end of the duct (position 4).

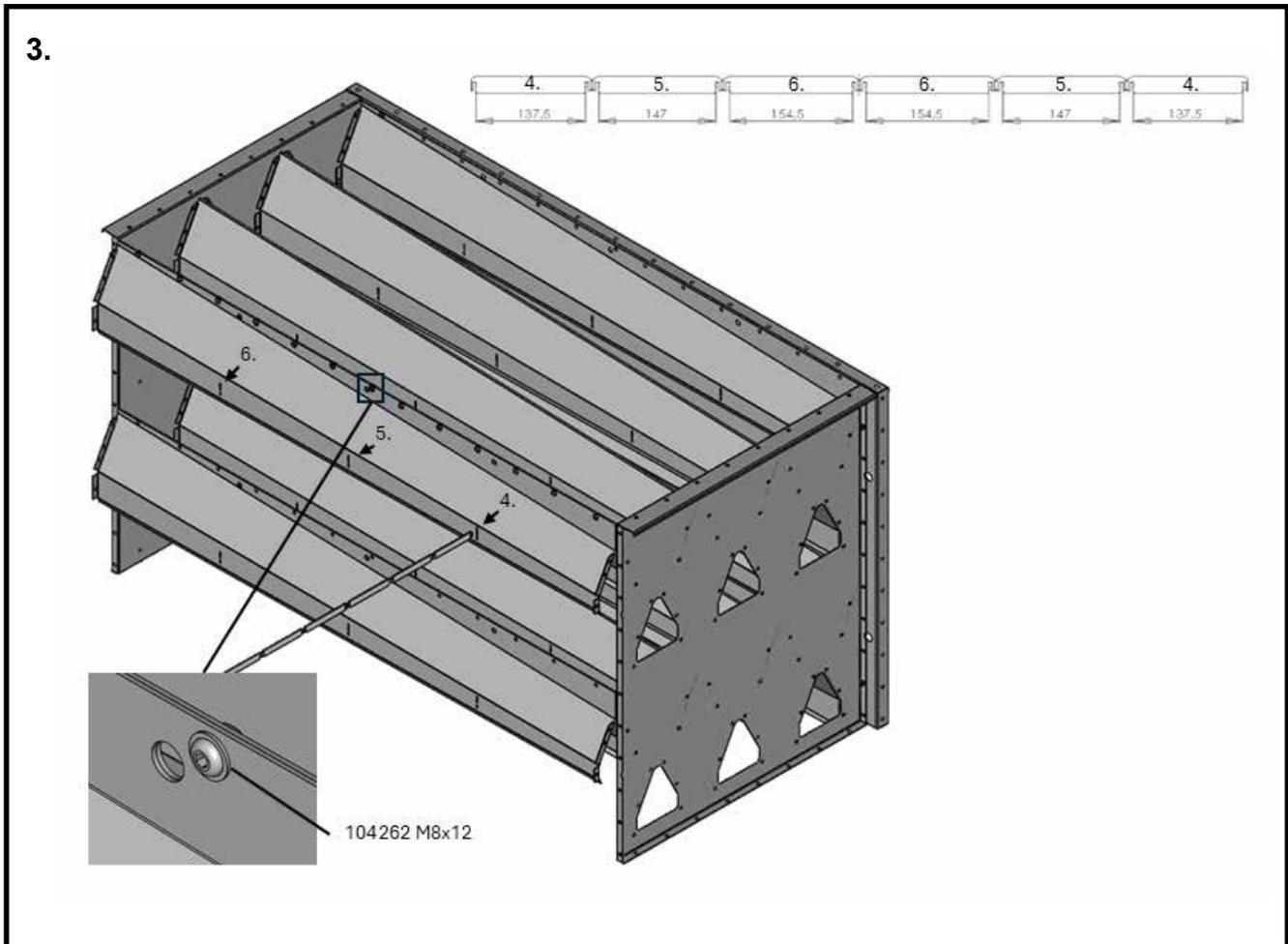
Feed the end of the support through the hole on the opposite side of the duct. Press the support downward into place inside the duct, all the way to the bottom. Once the support is in position, break off the excess by bending it sideways several times from edge to edge.

Next, install the supports in positions 5 and 6 in the same manner.

Install all supports in each duct.



The following ducts are installed using the same procedure.
At the joint between the end-plates, 1/2-ducts are used; see the next picture.



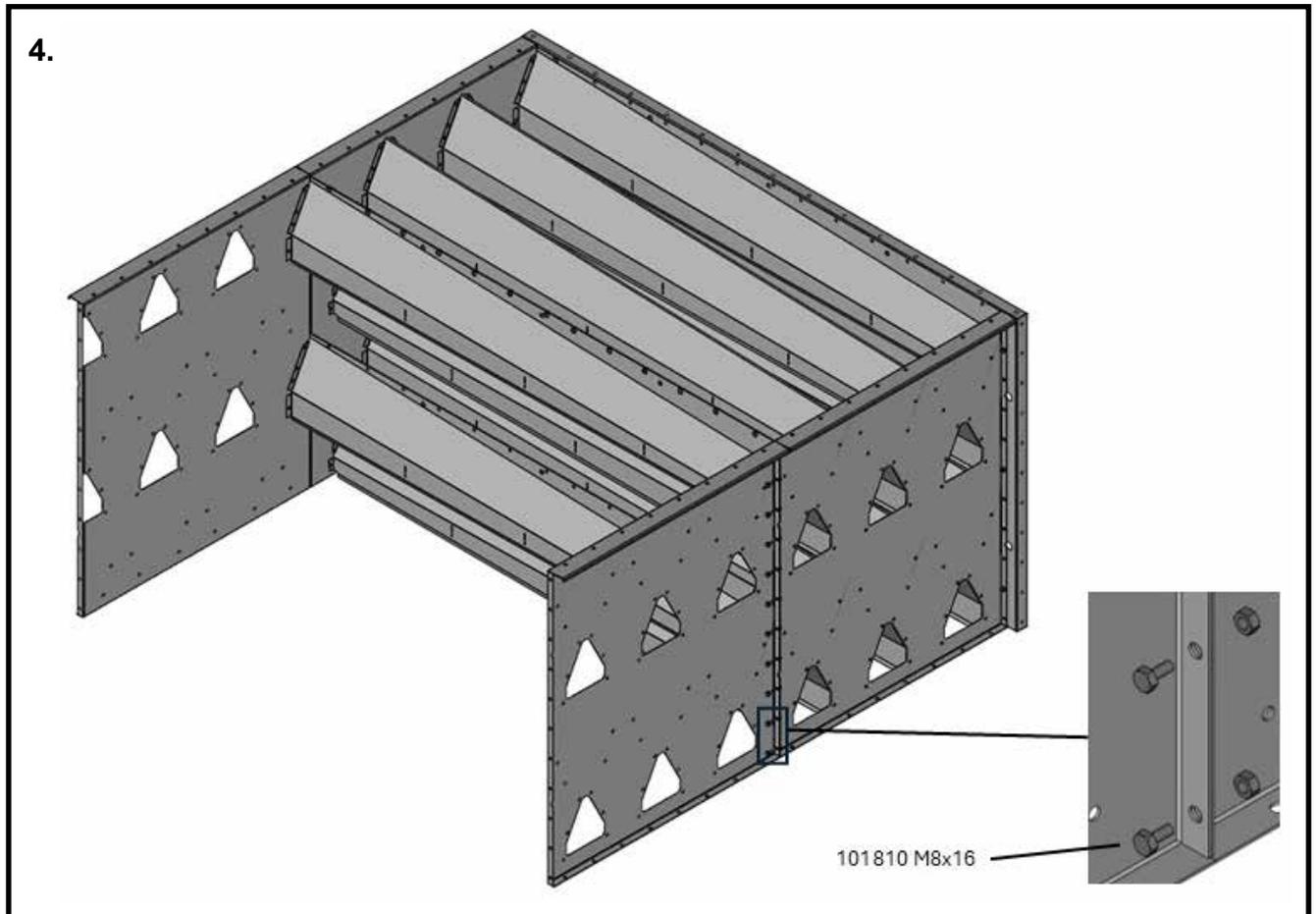
3. Installation of the duct at the end-plate joint

1/2-ducts are used at the end-plate joint.

The 1/2-ducts can be pre-assembled and placed between the end-plates as a complete unit; tighten the screws along the upper edge of the 1/2-ducts.

Use the supports intended for the 1/1-ducts.

Check the squareness of the section. All screws are tightened at this stage; thereafter, once the ducts for the next end-plate module have been installed, tighten the screws.

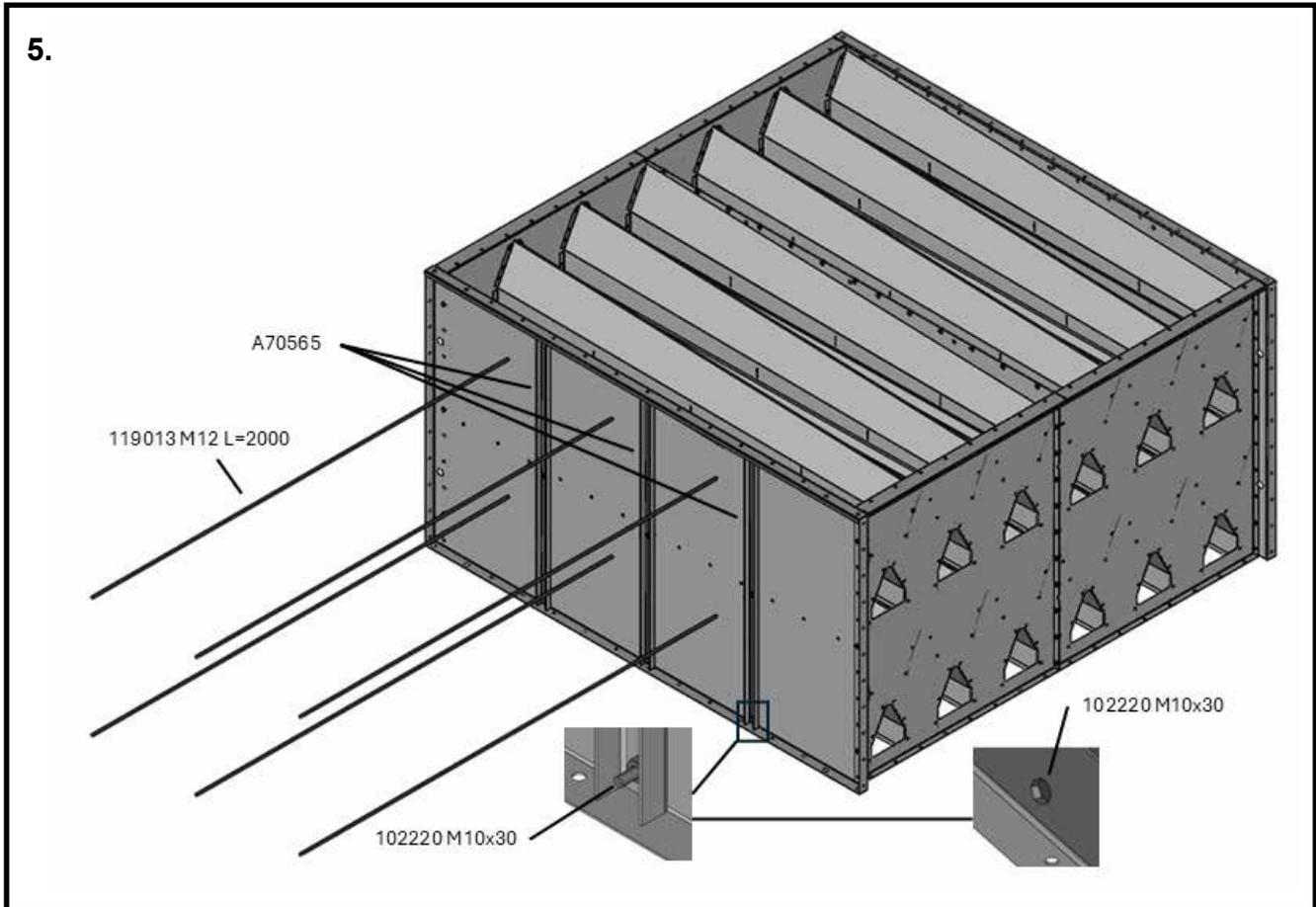


4. Connecting the end-plates to each other

Attach the sealing strips to the flanges of the end-plates that will be joined together.

Attach the seals on the inner side of the flange screw-hole rows (see picture).

Insert screws into every hole along the vertical seam of the end-plates.

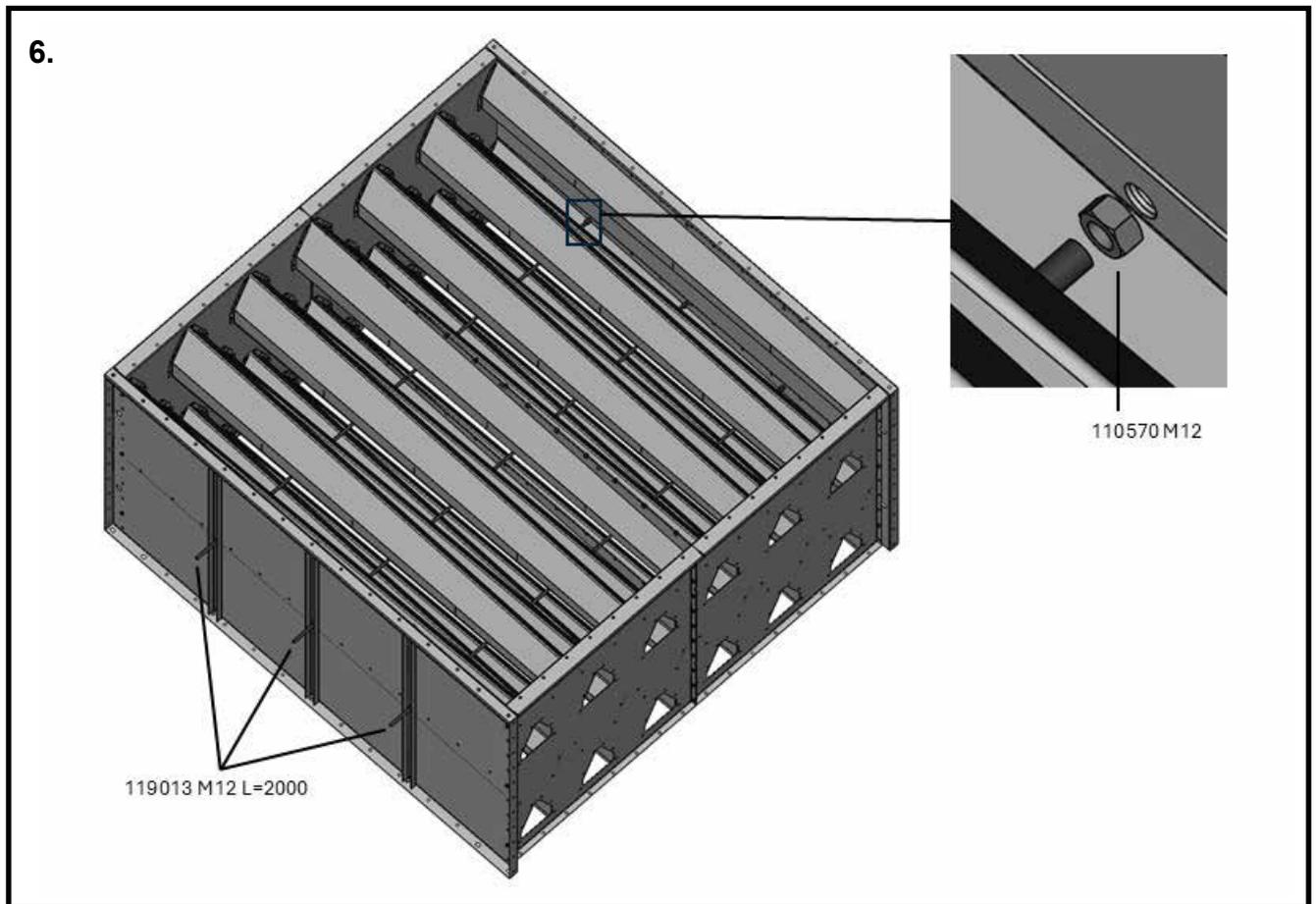


5. Installation of vertical supports and threaded rods

Attach the vertical supports to the side-plate.

At the lower edge, fasten with an M10x30 bolt, with the bolt head on the inside.

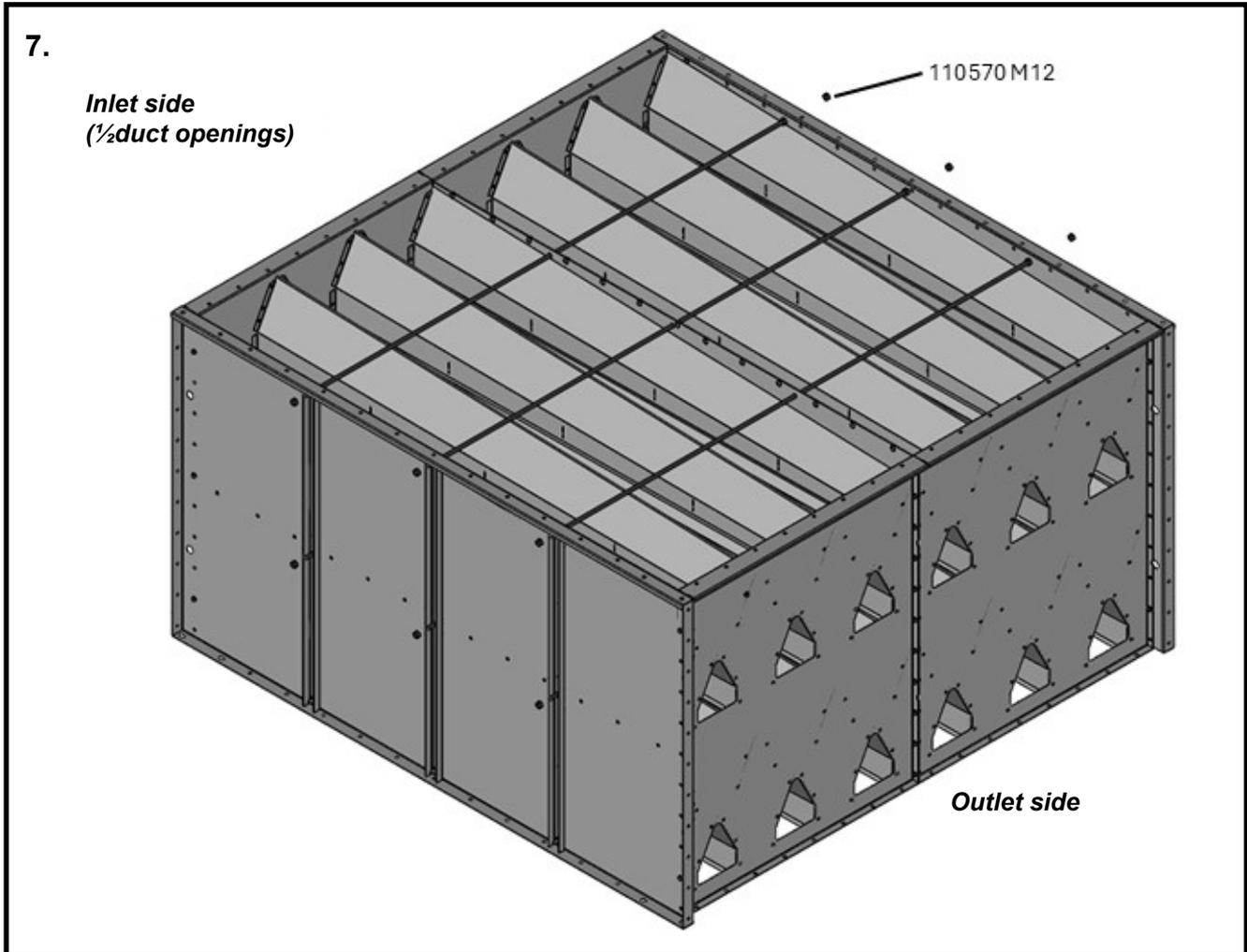
Insert the threaded rods through the holes in the side-plate and through the holes of the center duct



6. Installation of the inner nuts on the threaded rods

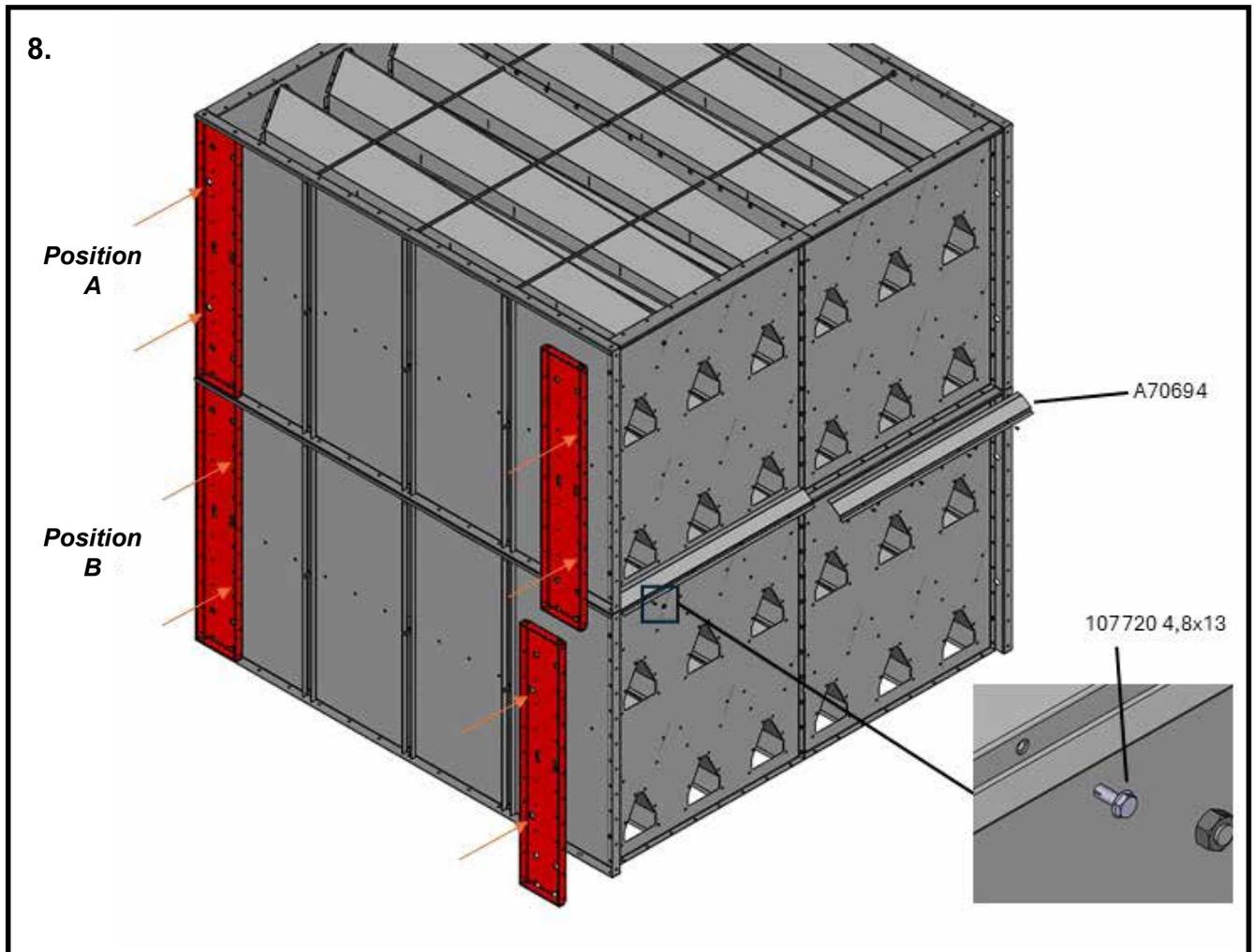
Before inserting the threaded rod through the opposite side-plate, install a nut onto the threaded rod. Thread the nut approximately 10 cm from the end of the rod. Insert the threaded rod through the side-plate. Then install a nut on the opposite side of the threaded rod and push the rod fully into position.

Tighten the nuts against the 1/2-ducts of the side-plate to remove any clearance.



7. Installation of the outer nuts on the threaded rods

Install the nuts onto the threaded rods and tighten them. If necessary, cut off any excess length from the threaded rods.



8. Dust strips and support legs for the section corners

When the sections have been installed on top of each other, install the dust strips (A70694) using self-drilling screws. If necessary, install support legs at both ends of the section. See the support leg selection instructions on page 9.

The installation direction of the support leg depends on whether duct closure plates are used. If only one closure hatch is installed in the section, close the unused shaft holes with plastic plugs. The plugs are included in the dryer delivery.

Align the holes of the end-plate flange, the side-plate, and the support leg.

Fasten the side-plate, end-plates and support legs with screws and nuts (M8 × 16, 9 pcs per side). Two of these screws were already installed during the assembly of the section.

Square the section. Tighten all screws.