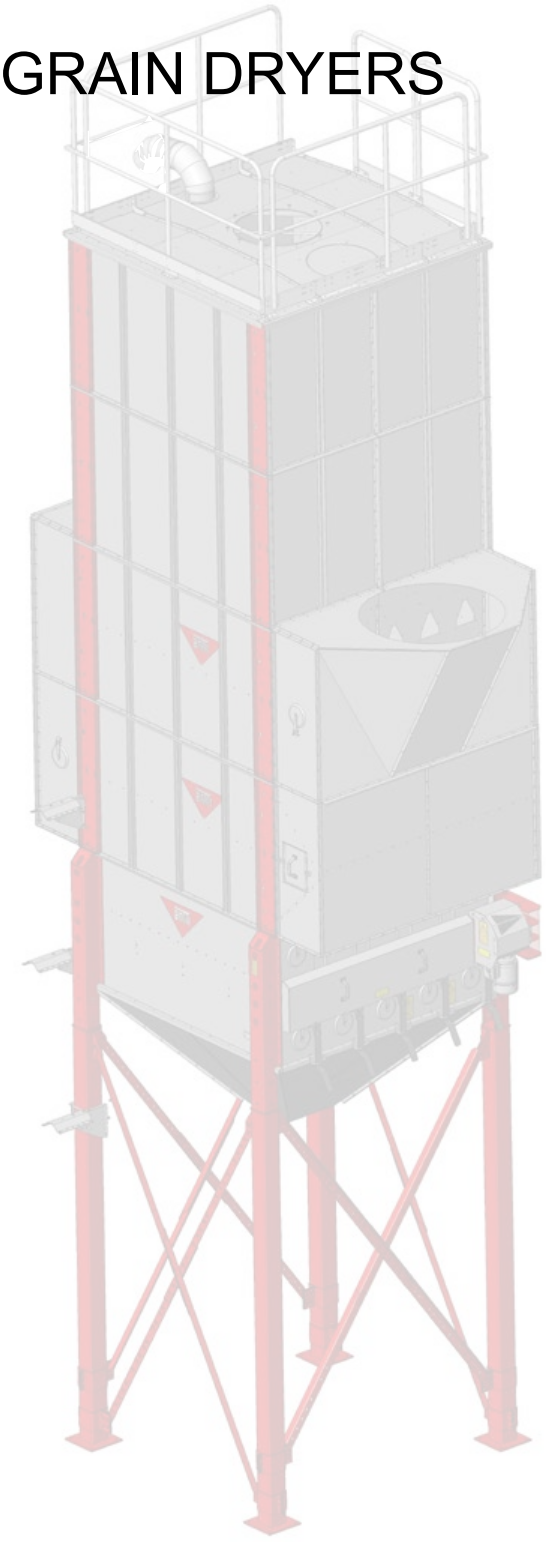
Assembly Instructions

ANTTI M06 2W GRAIN DRYERS BASE



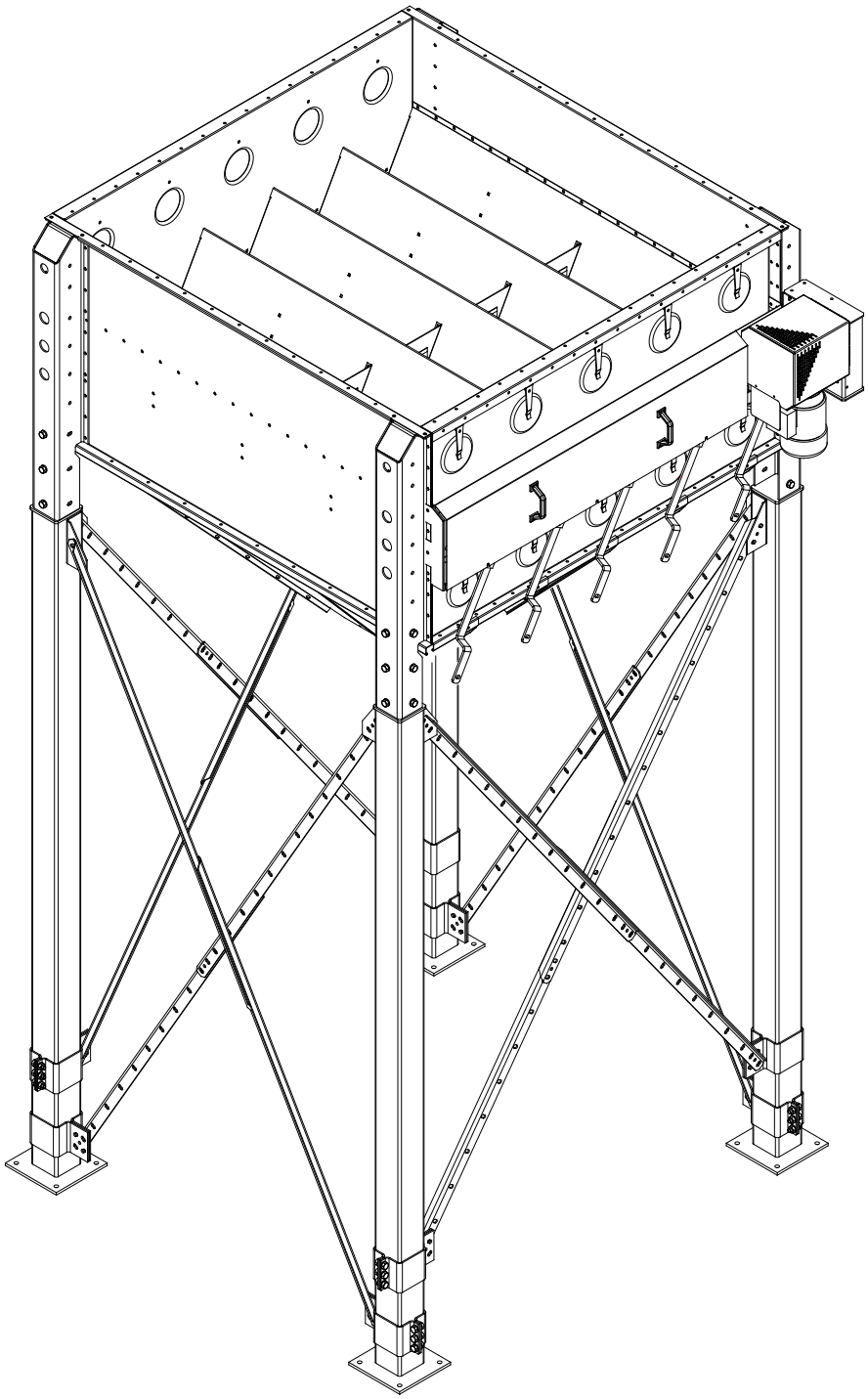
408070 (en) 05-2026

You'll see the difference

antti.fi

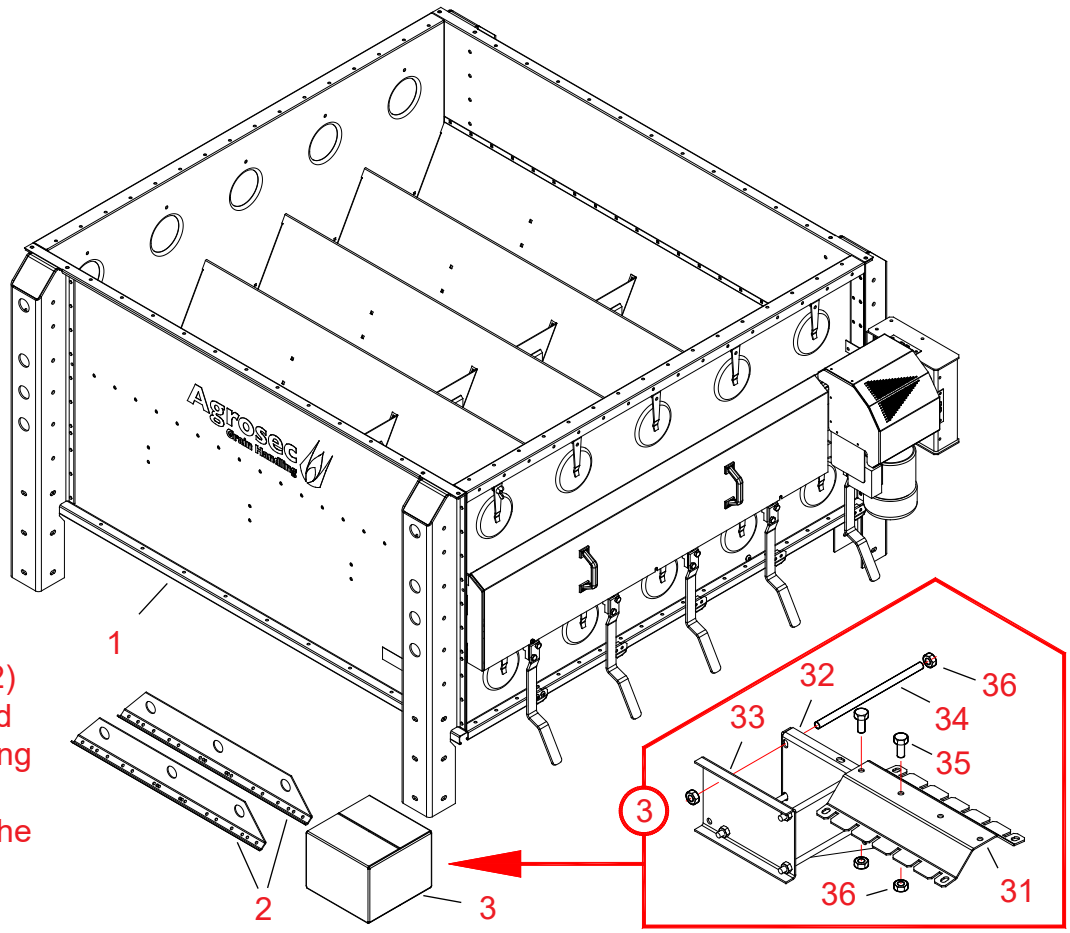
Base 2W assembled ... 3
Base with accessories 2W (A70390), spare parts ... 4
Base 2W assembled (A71516), spare parts ... 5
Base frame 2W (A70342), spare parts ... 6
Motor rack (A70416), spare parts ... 8
Feeding equipment 2W (A70398), spare parts ... 9
Extension leg set 2W (A70525), spare parts; L = 3100 mm ... 10
Cross-braces for extension legs 2W (A71522), spare parts; legs L = 3100 mm ... 11
Extension leg set 2W (A71563), spare parts; L = 1740 mm ... 12
Cross-braces for extension legs 2W (A71564), spare parts; legs L = 1740 mm ... 13
ASSEMBLING THE DRYER BASE ... 14
Optional ways to attach the lower ends of the extension legs ... 14
Attaching the extension legs to the base ... 15
Structure of the base cone 2W ... 19
Base cone (A70374), spare parts ... 20
Assembling the base cone 2W ... 22
Assembling the base cone 2W ... 23
Installing the base cone ... 29
Installing the cross-braces for the extension leg on 2W ... 31
Transferring the feeding equipment motor to another position ... 35
Structure of the service platform for the base 2W (optional) ... 39
Installing the service platform for the base 2W (optional) ... 41

Base 2W assembled



Base with accessories 2W (A70390), spare parts

NOTE!
The lifting lugs (2) may only be used for lifting the drying section and the top section, not the base.



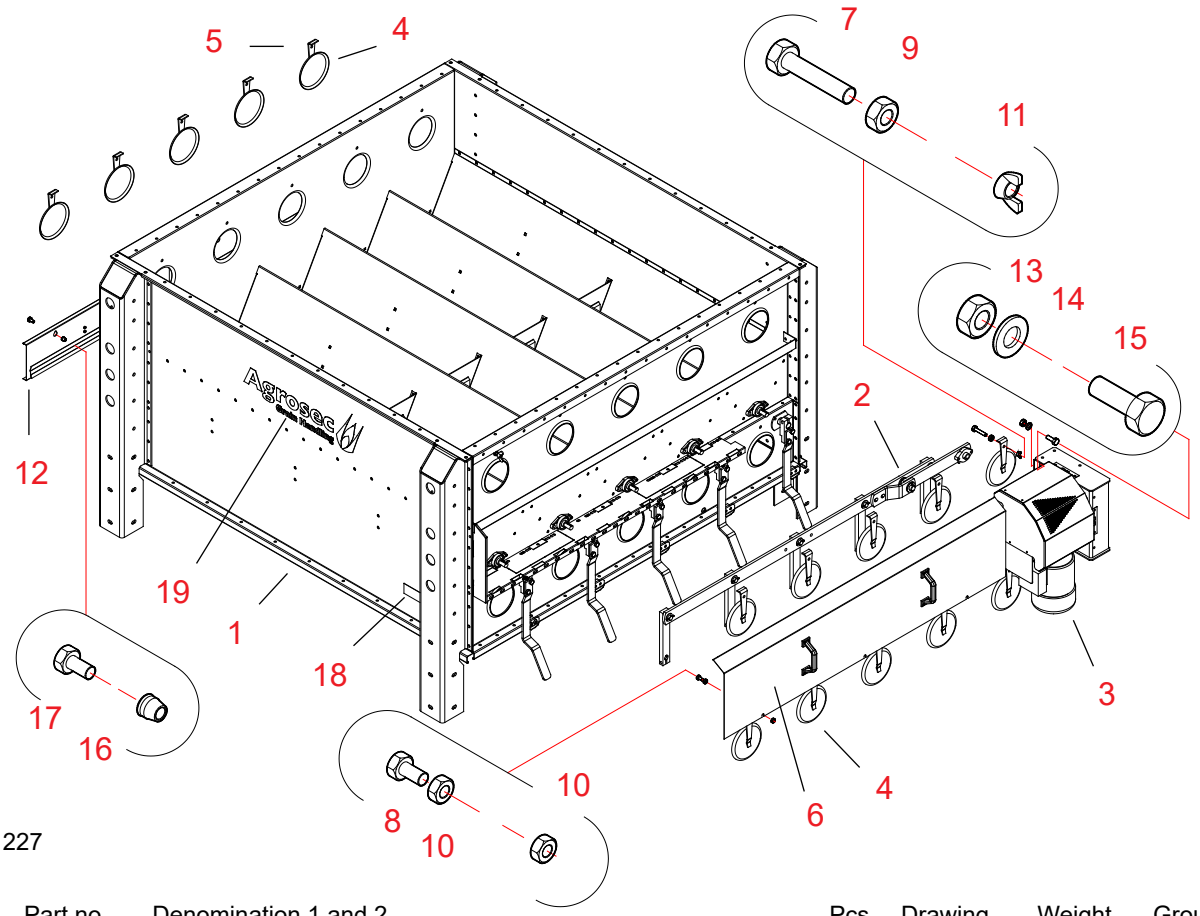
20061227

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

A71514

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

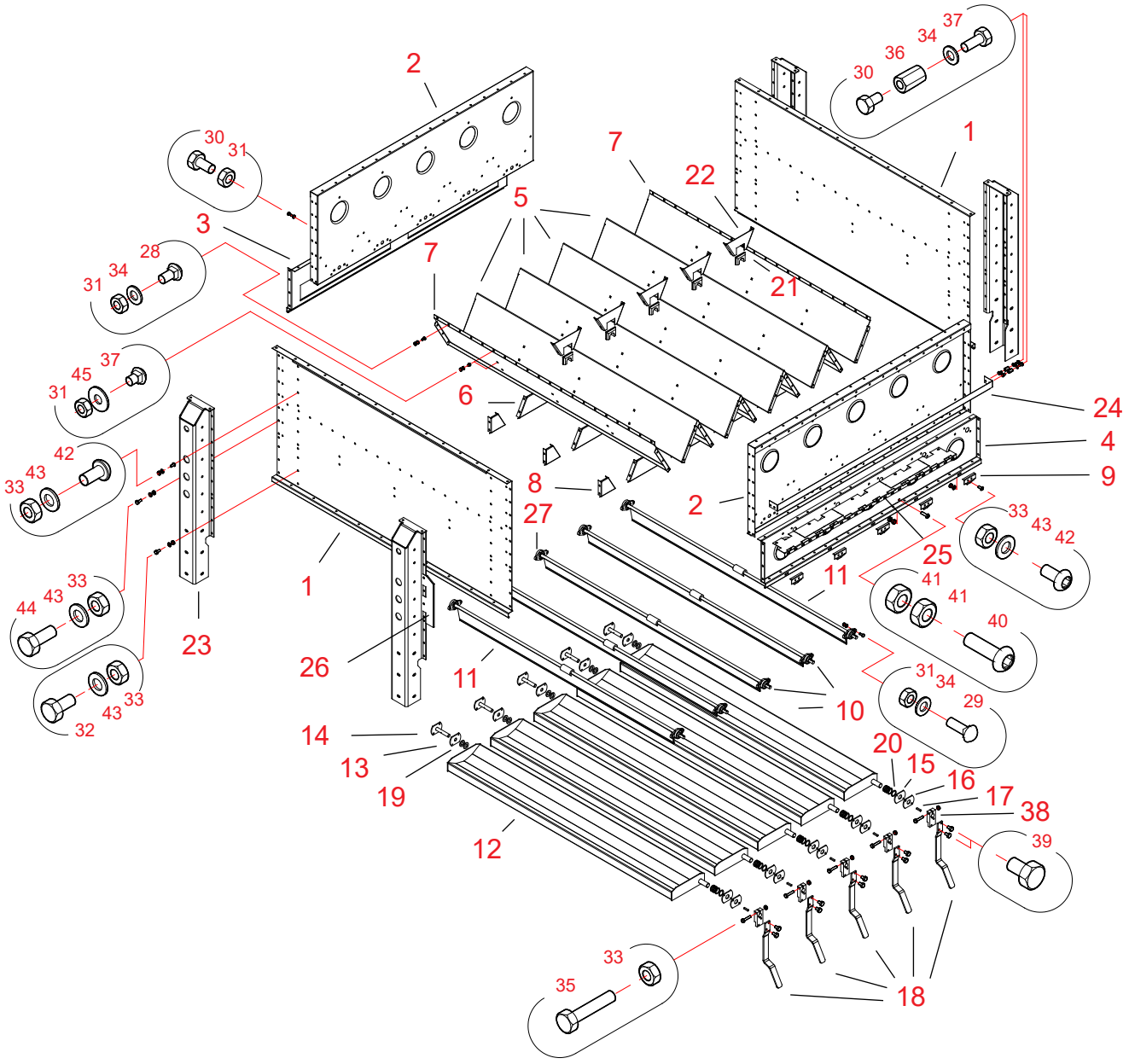
Base 2W assembled (A71516), spare parts



20061227

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

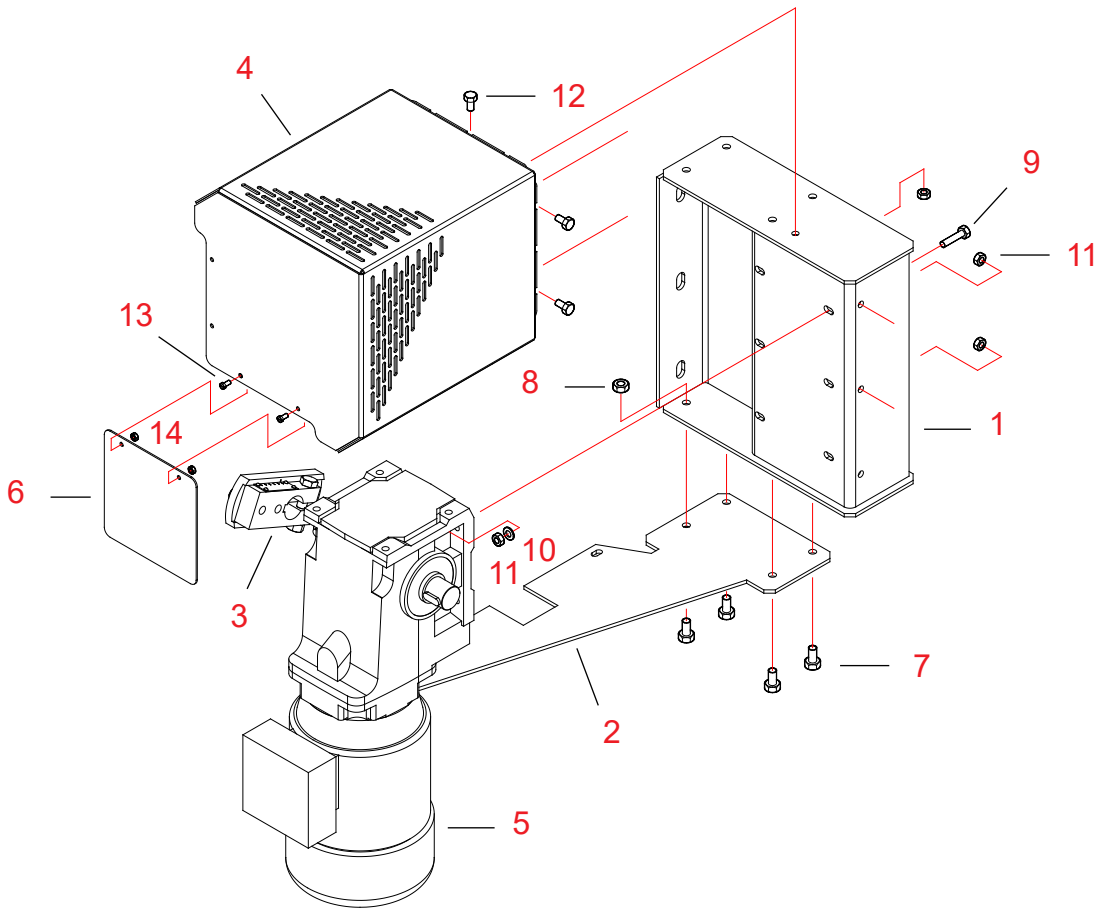
Base frame 2W (A70342), spare parts



20061106

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

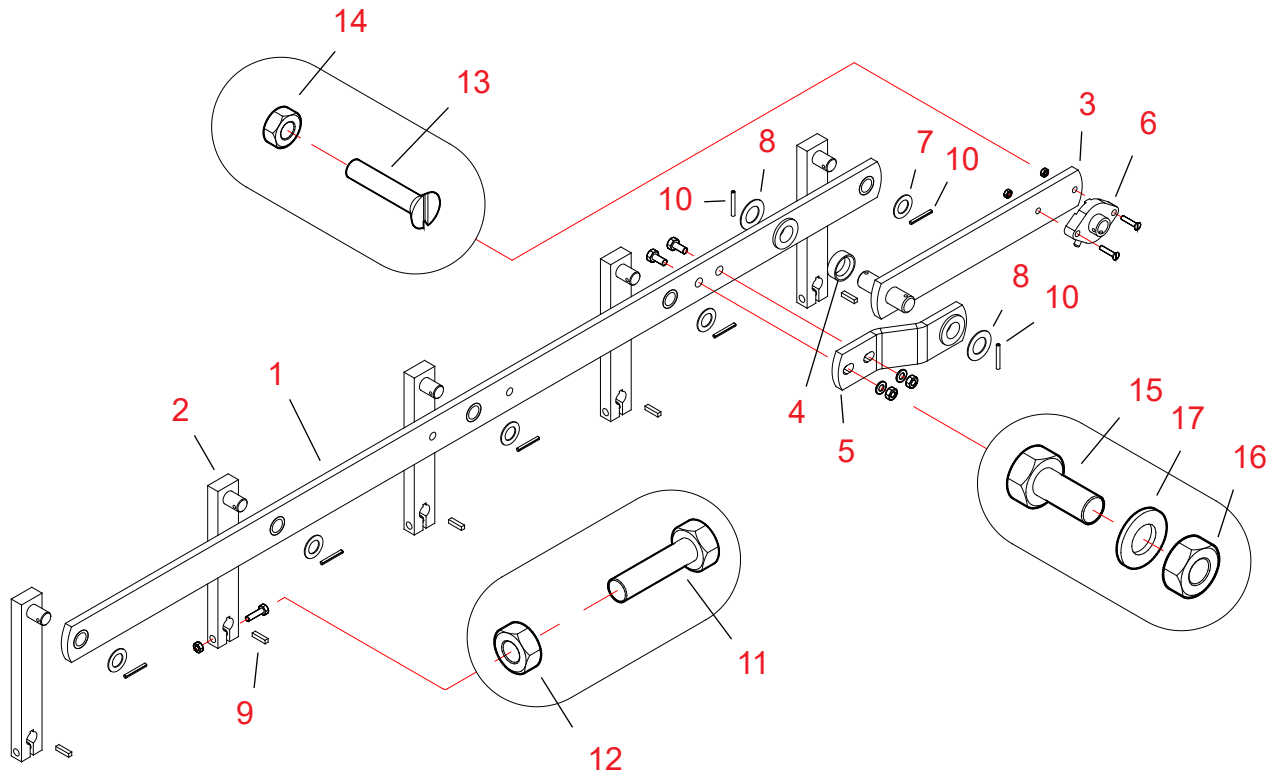
Motor rack (A70416), spare parts



20060921

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

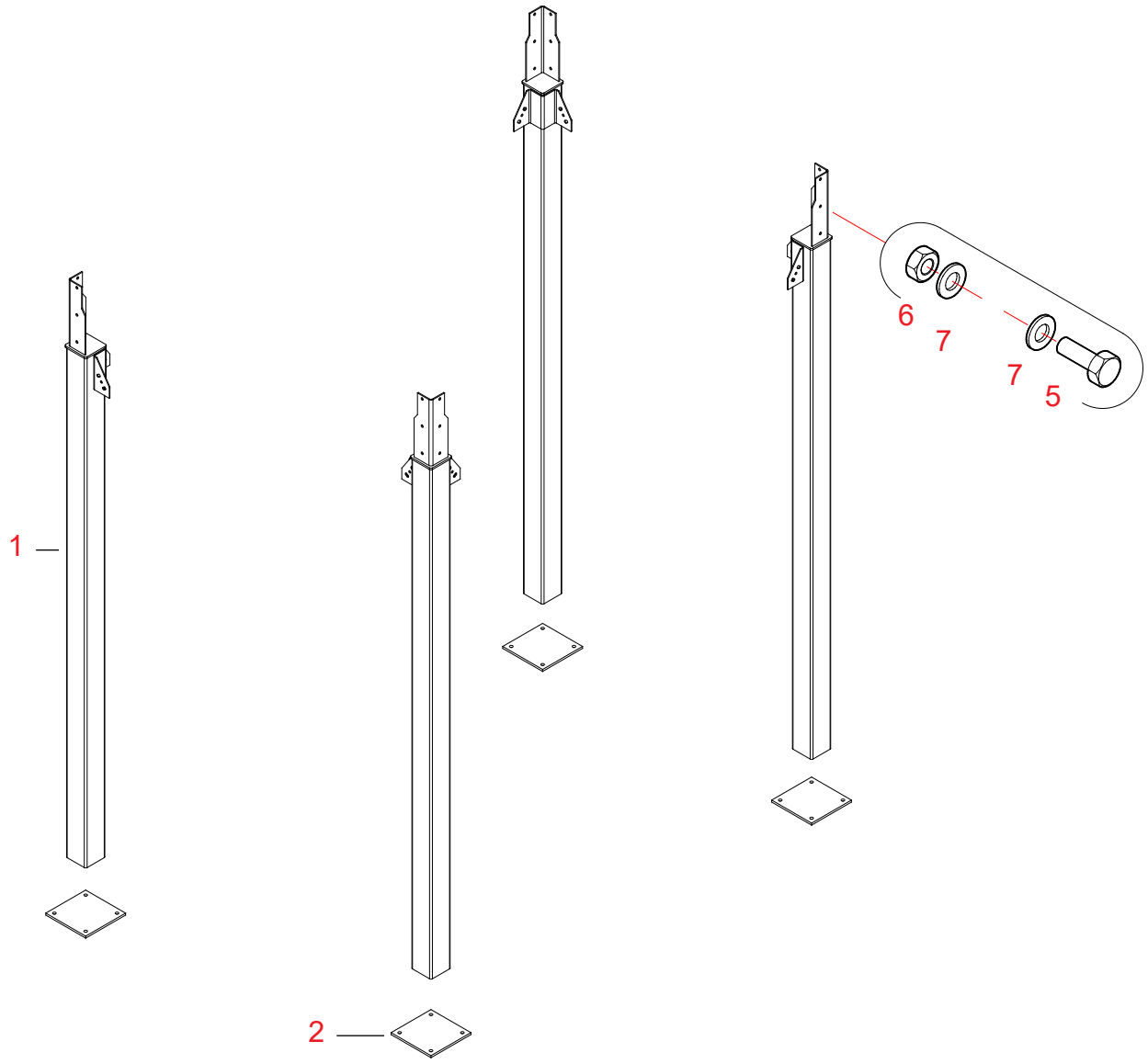
Feeding equipment 2W (A70398), spare parts



20060601

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

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



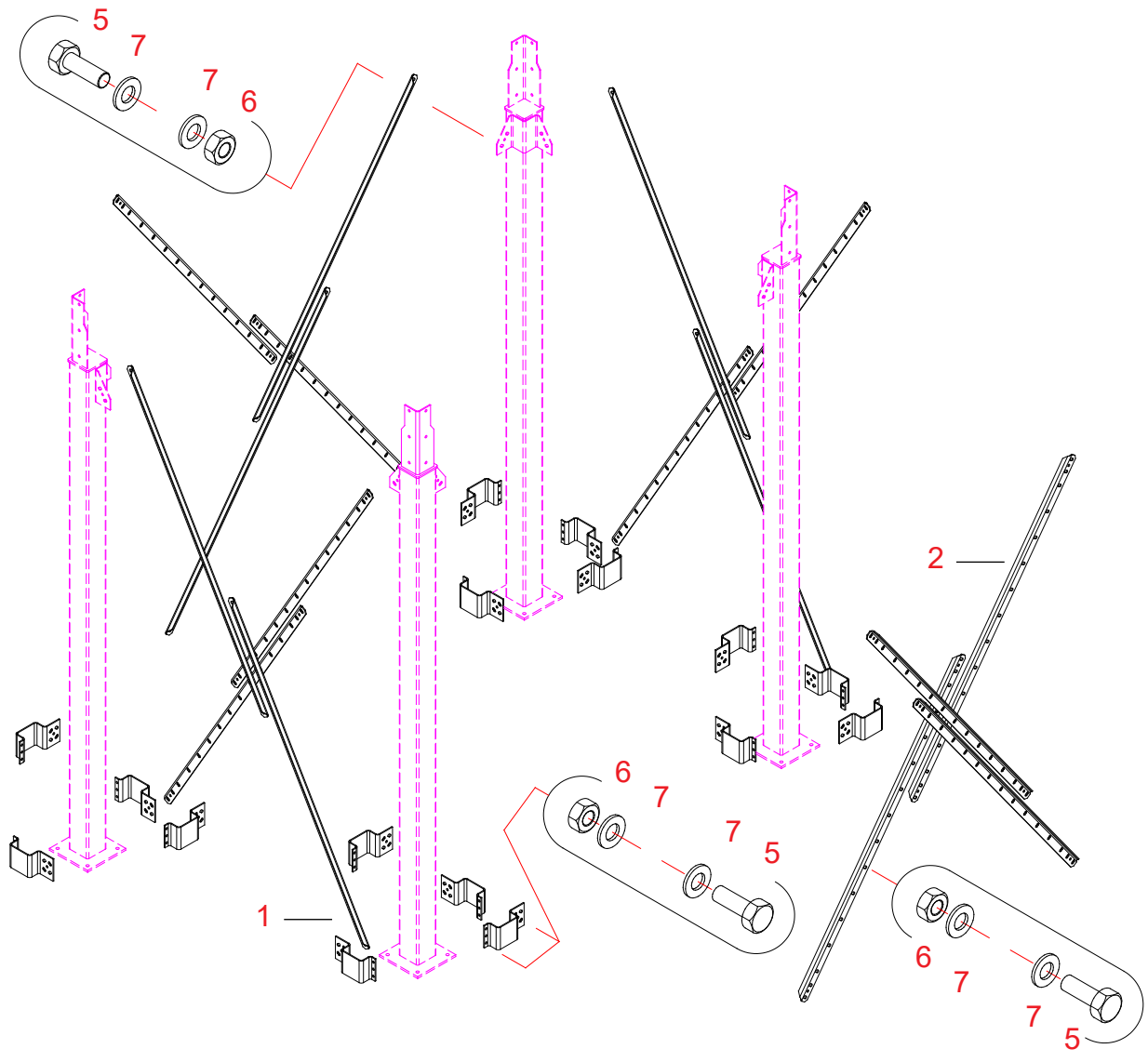
20060601

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
-	A70525	BASE WM06 LEGS 3100 PACK.	1	A70525		3000

THE SET INCLUDES:

1	A70424	BASE M06W EXTENSION LEG 2W	4	A70424	72.36	3000
2	A70561	LEGS WM06 END-PLATE 12X280X280	4	A70561	7.29	3000
5	102520	BOLT HEX ZN 8.8 - 12X35 AM DIN933	24		0.04	2010
6	110570	NUT ZN 8 - M12 DIN934	24		0.02	2010
7	111560	WASHER ZN - M12 DIN125	48		0	2010

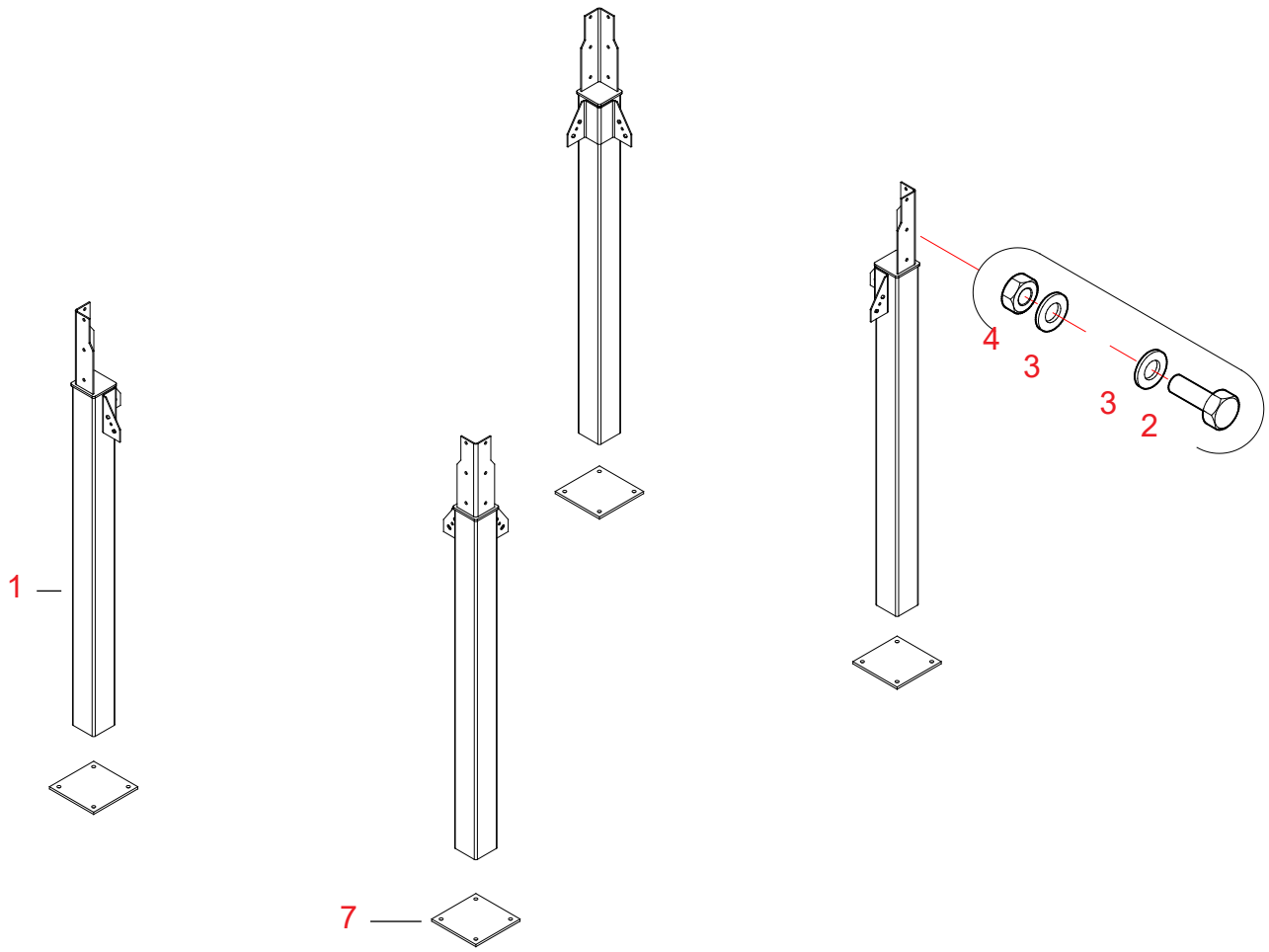
Cross-braces for extension legs 2W (A71522), spare parts; legs L = 3100 mm



20060601

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

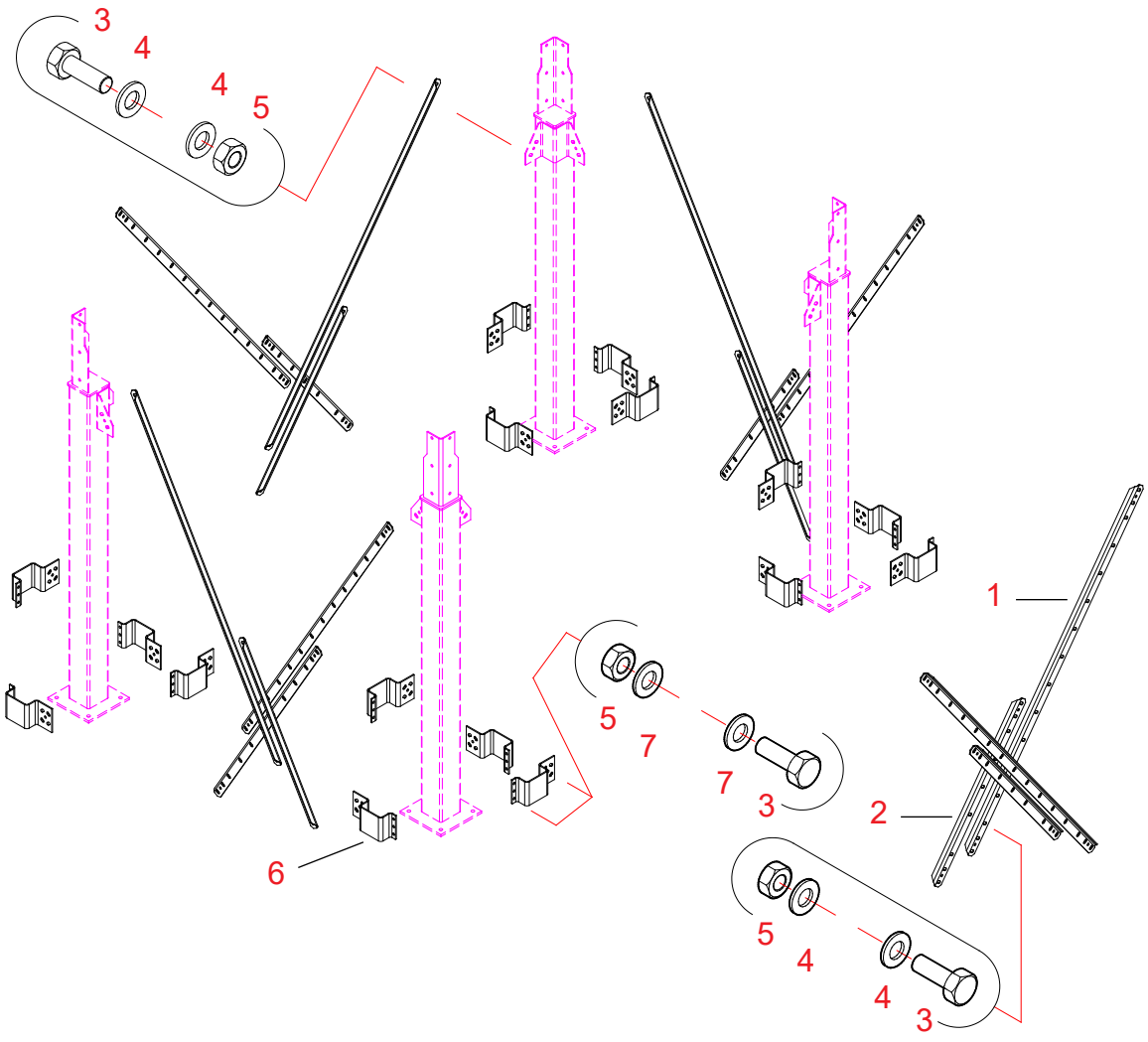
Extension leg set 2W (A71563), spare parts; L = 1740 mm



20080711

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
-	A71563	BASE WM06 LEGS 1740 PACK.	1	A71563	207.52	3000
THE SET INCLUDES:						
1	A71585	BASE M06W EXTENSION LEG 2W	4	A71585-A	43.98	3000
2	102520	BOLT HEX ZN 8.8 - 10X25 AM DIN933	25		0.04	2010
3	111560	WASHER ZN - M12 DIN125	50		0	2010
4	110570	NUT ZN 8 - M12 DIN934	28		0.02	2010
7	A70561	LEGS WM06 END-PLATE 12X280X280	4	A70561	7.29	3000

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



20080711

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

ASSEMBLING THE DRYER BASE

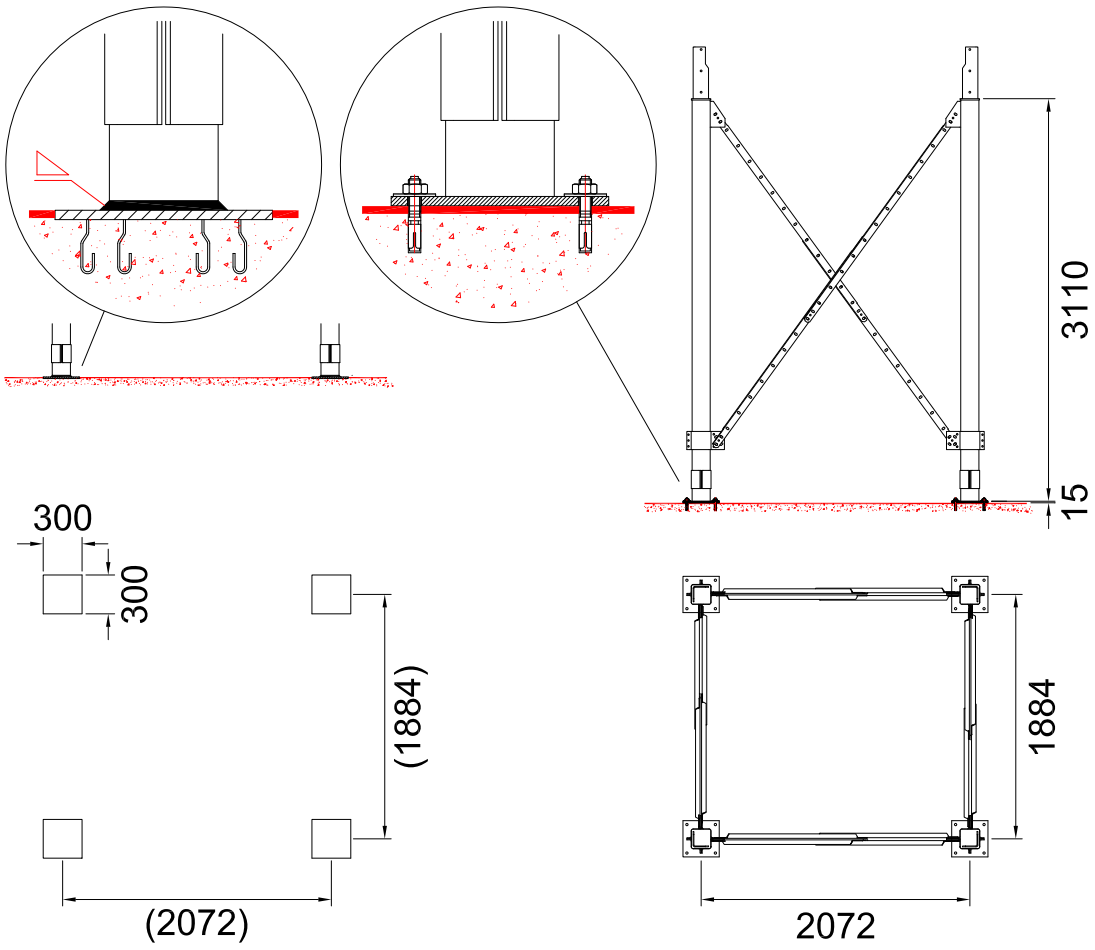
Optional ways to attach the lower ends of the extension legs

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

By welding to a steel plate set flush into the floor casting

By bolting the end-plates of the legs to floor casting using M16 wedge anchor bolts

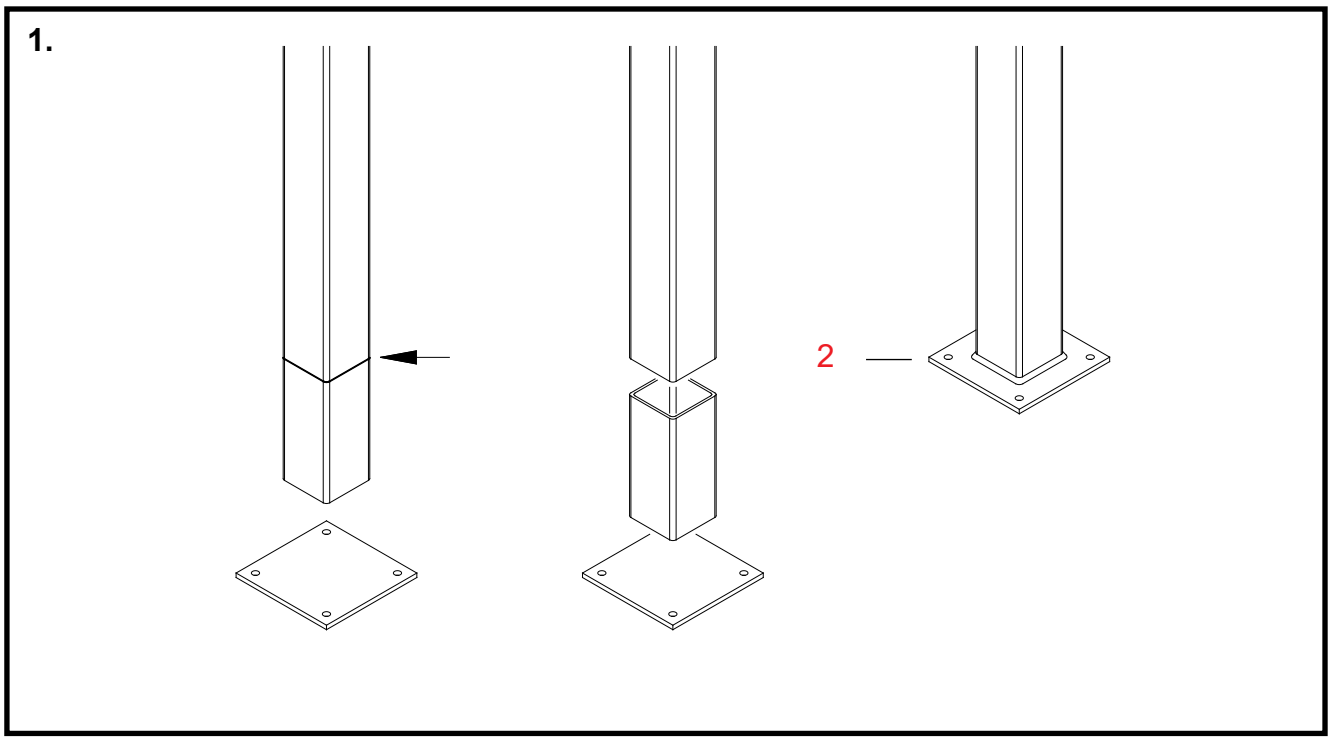
Dimensioning the extension legs



Places of plates in the floor casting (dimensions in mm)

If you wish to attach the extension legs by welding, you need to set steel plates (300 x 300, s = 15 mm) flush with the floor casting.

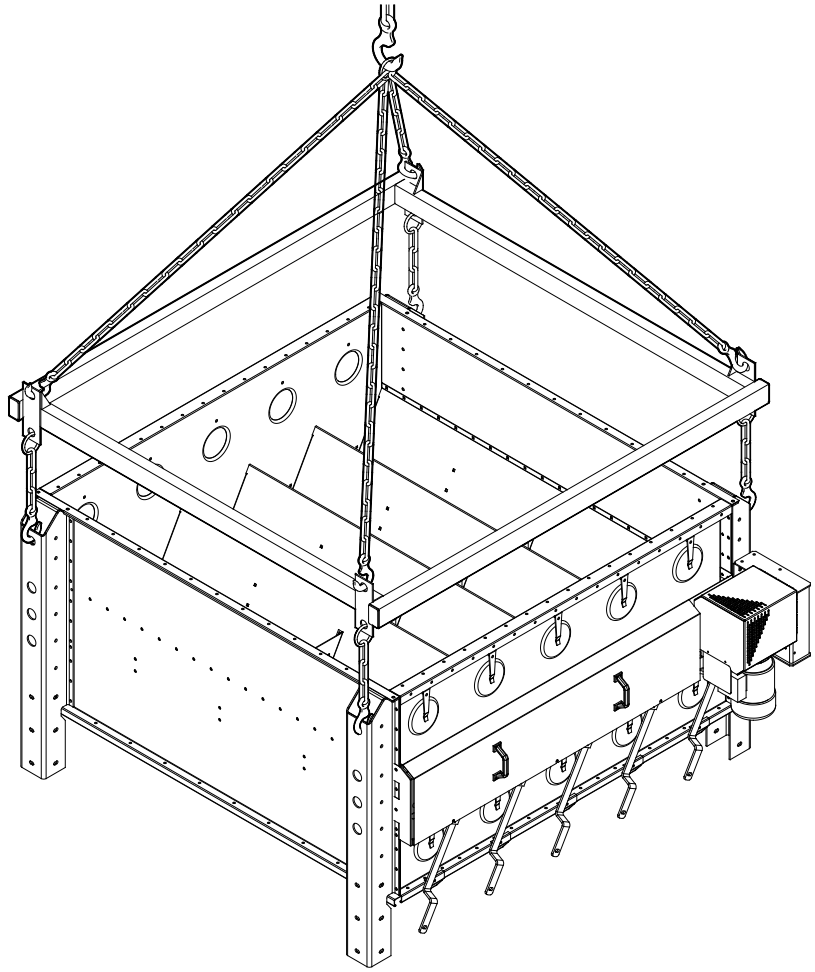
Attaching the extension legs to the base



1. Shortening the extension legs

Parts	The numbering of work stages refers to reference numbers in the spare parts drawing for the extension legs.
*	**At first, determine the length required for the extension legs.**
	If you attach the extension legs to the floor casting using wedge anchors, note the thickness of the extension leg end-plates (12 mm) when determining the length to be cut off.
	The main rule is that the angle of the pipe leading from the base cone to the elevator should be a minimum of 45 degrees to horizontal.
*	**Cut the lower ends of the extension legs to the appropriate length.**
2	**As required, attach the end-plates included in the delivery by welding to the lower ends of the legs.**

2.



2. Lifting the base frame 2W

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

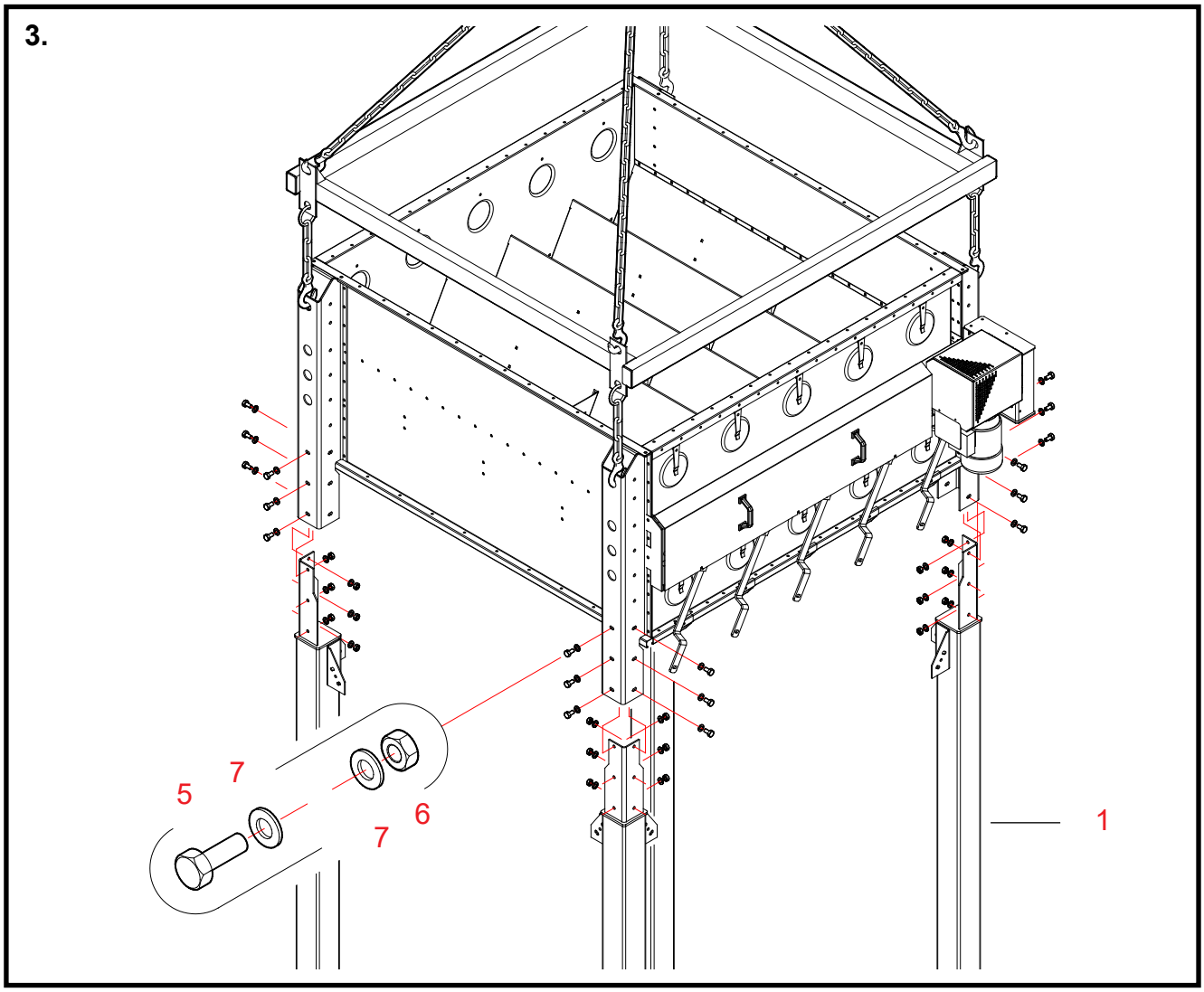
Simply tear off the plastic. Use knife, as necessary.

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

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

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

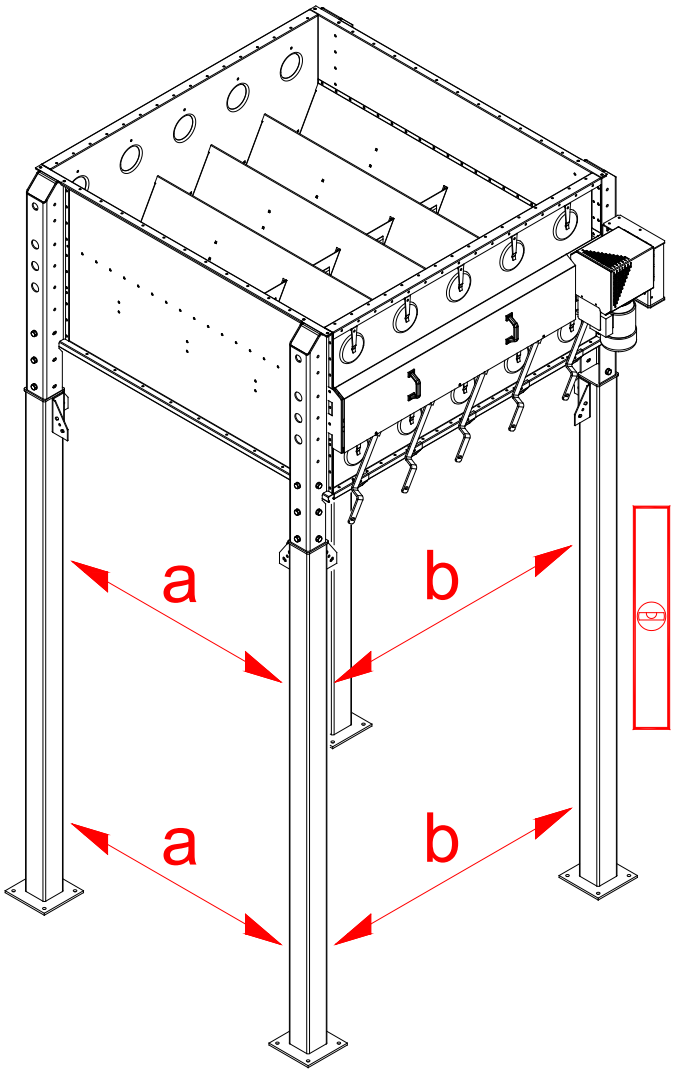
The weight of the base frame of 2 W is about 750 kg.



3. Installing the extension legs on 2W

Parts	The numbering of work stages refers to reference numbers in the spare parts drawing for the extension legs.
1	**Insert the extension legs in the base frame legs.** The upper part of the leg comes inside the base leg.
5, 6, 7	**Attach the extension legs to the base legs (bolts M12 x 35).** ***Note!*** ***Provide each leg with 6 bolts, washers and nuts!***
*	**Lower the dryer base onto the extension legs.**

4.

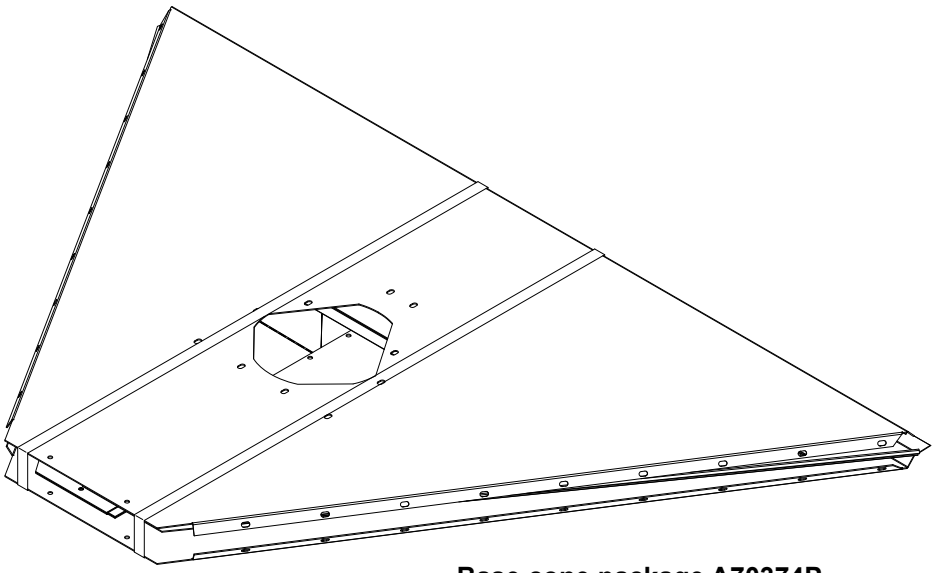


4. Checking alignment of the extension legs

* **Check that the extension legs are in an upright position and parallel to each other.**
  Carry out the measurement and perform the required corrections before attaching the legs to the floor.

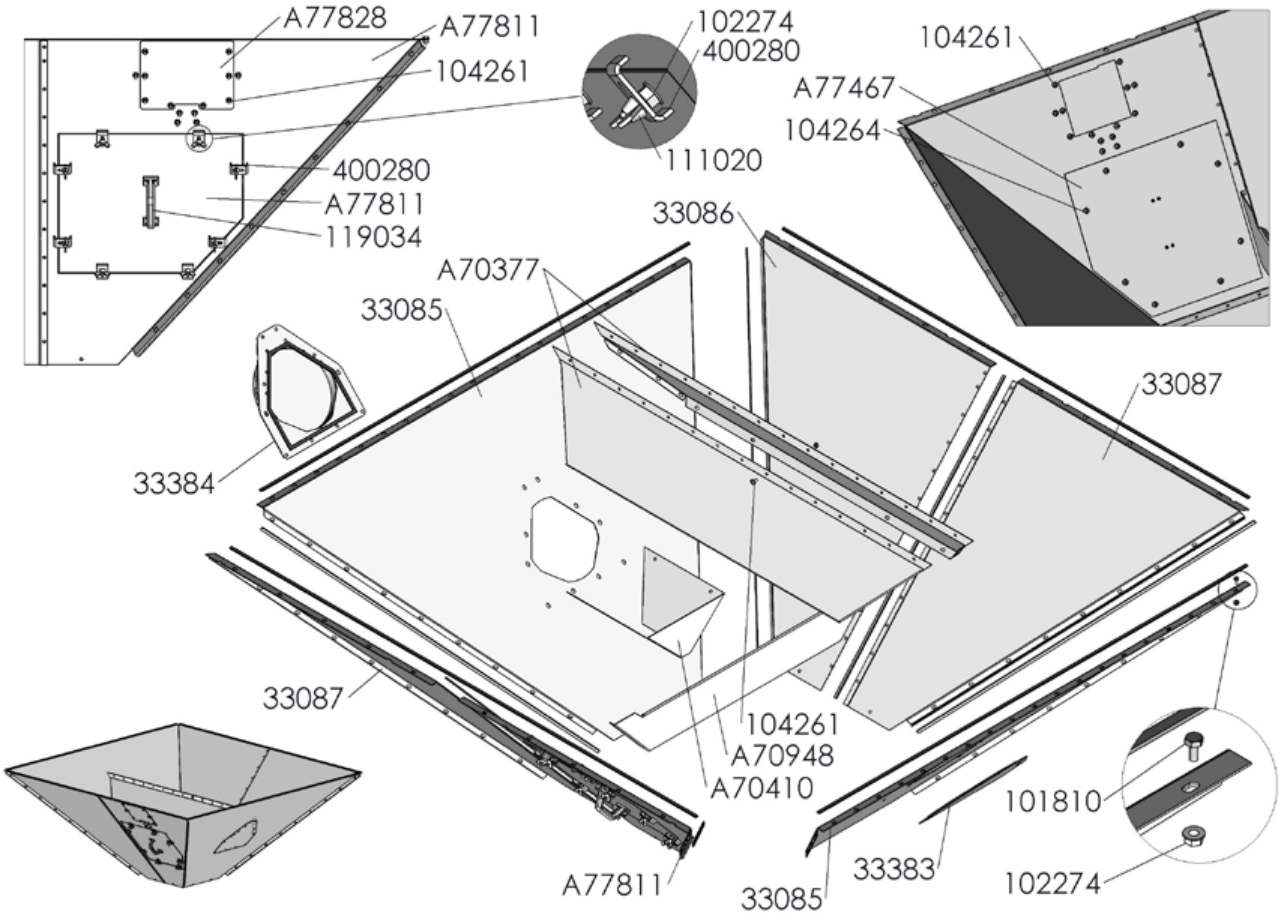
* **Attach the legs to the floor either by welding or using wedge anchors.**
  Attachment by welding is possible only if metal plates have been set into the floor during casting.

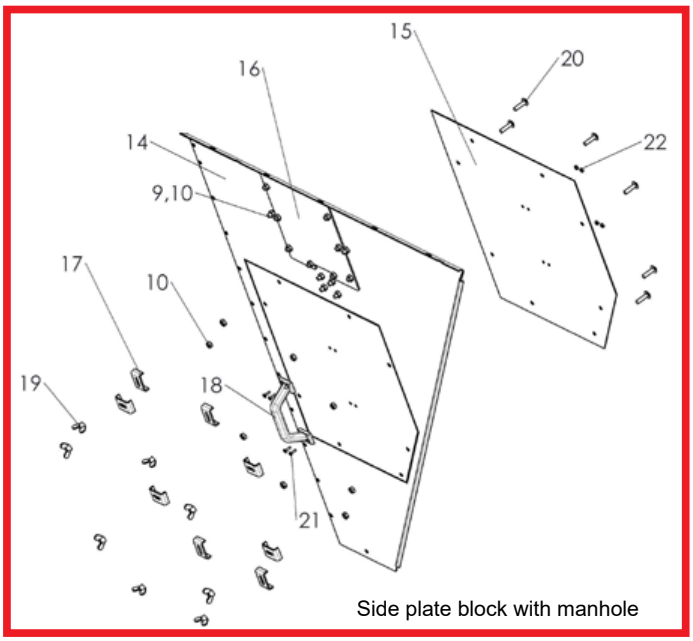
Structure of the base cone 2W



Base cone package A70374P
- **external dimensions 180 x 1240 x 1985 mm**
- **weight 132 kg**

Base cone (A70374), spare parts



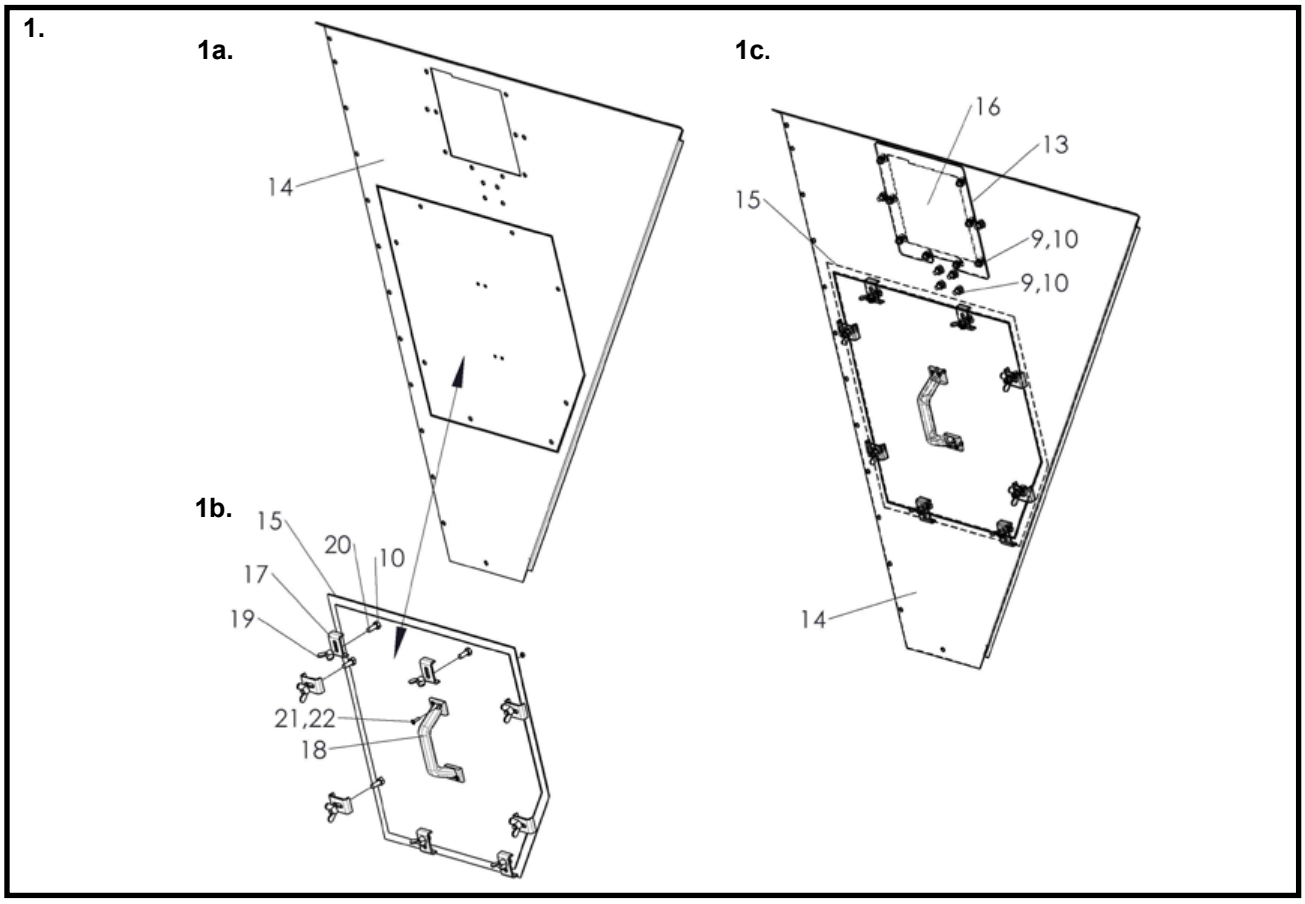


Side plate block with manhole

- Side plate block with manhole fits part 2 to the same points.
- The location of the manhole is always chosen on a case-by-case basis.
- If the grain dryer will be fitted with moisture measurement related sampler, so read also the sampler installation instructions before assembling the bottom cone.

Ref.	Part no.	Denomination	Pcs.
1	33085	BASE CONE SIDE PLATE XL BOLT	2
2	33086	BASE CONE SIDE PLATE XL BOLT LEFT	1
3	33087	BASE CONE SIDE PLATE XL RIGHT	2
4	A70377	BASE INTAKE DUCKT 1/2 WM06	2
5	A70410	BASE INTAKE DUCKT SHUTTING PLATE WM06	1
6	33384	BASE CONE SIDE PLATE XL, MEGA COVER PLATE D280	1
7	33383	BASE CONE COVER PLATE	1
8	A70948	BASE CONE ADD. SUPPORT WM06 2W	1
9	104261	SCREW HEX, DOME NUT 8X16 AM ISO 7380-2	54
10	102274	HEX FLANGE NUT M8 ZN 8 DIN 6923	180
11	101810	BOLT HEX ZN 8.8 8X16 AM DIN933	118
12			
13	115570	SEALING STRIP 4X8 EKO-40	11
14	A77811	BASE CONE SIDE PLATE WITH MANHOLE	1
15	A77467	BASE CONE BACKPLATE FOR MANHOLE	1
16	A77828	BASE CONE COVER PLATE 252x243 M25	1
17	400280	TOP SECTION COVER HOLDER	8
18	119034	HANDLE PLASTIC LIGHTGREY PISLA 805 10100550	1
19	111020	NUT WING M8 ZN DIN315	8
20	104264	SCREW HEX, DOME NUT 8X30 AM ISO 7380-2	8
21	103611	SUNK SCREW CROSS GROOVE 5 X 16 AM ZN 5X16 AM ZN	4
22	110520	NUT M5 ZN 8 DIN934	4

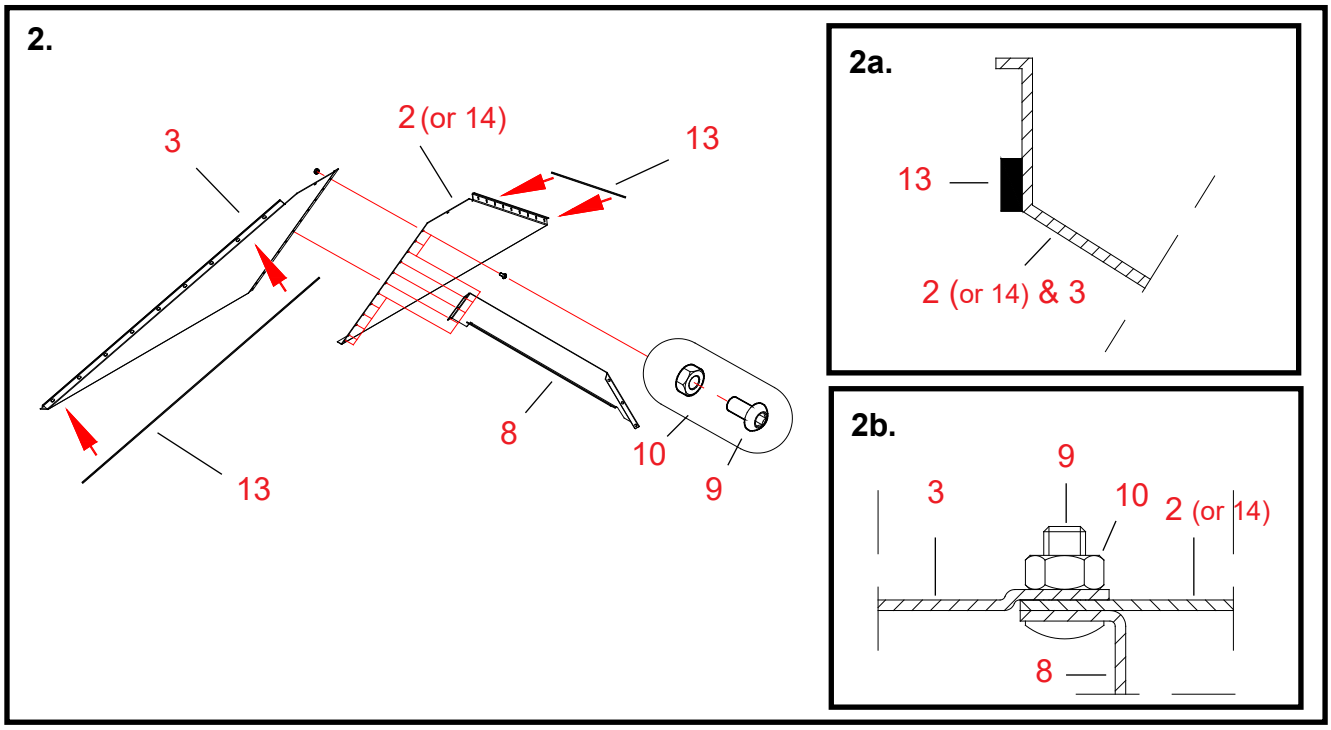
Assembling the base cone 2W



1. Side plate block with manhole; assembly instruction

Parts	The numbering of work stages refers to reference numbers in the spare parts drawing of the base cone.
14	**Remove the plate in section 14..**
14-15	Connect the detached plate to part 15 with dome head screws and nuts (M8x30; 8pcs). Place the screw domes on the grain farm side (see picture 1b)
17-19	**Connect the parts as shown in Figure 1b.**
18	**Connect the handle with screws and nuts (M5x16; 4pcs). as shown in figure 1b.**
14	Attach the assembly according to figure 1b. to the cone block (fig. 1c.) The larger plate (part 15) is on the inside of the cone.
13	Attach the sealing strip around the upper opening (see picture 1c).
16	Attach the cover plate to the outer surface of the cone plate with dome head screws and nuts. Also put the screws into the underneath holes near the cover plate. (M8x16; 12pcs.) Place the screw dome heads on the grain farm side (see picture 1c).

Assembling the base cone 2W



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

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

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

13 — **Fix sealing strip to the corner flange of the plate with straight edge (part 2).**
Fix the sealing strip inside the bolthole row in the plate (see drawing 2a).

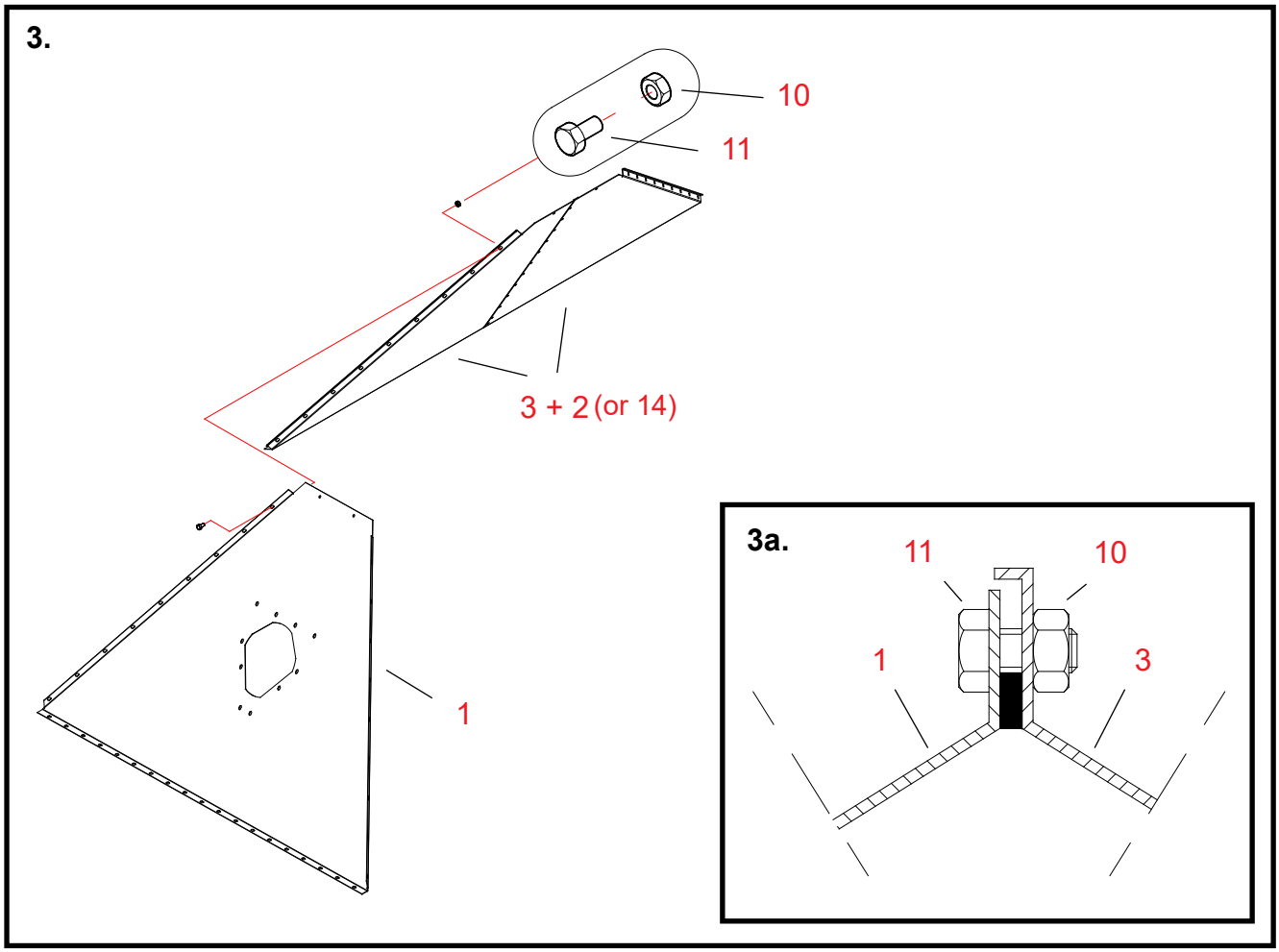
13 — **Fix a sealing strip to the corner flange of the shouldered side-plate (part 3).**
Fix the sealing strip inside the bolthole row in the plate (see drawing 2a).
Note: no sealing strip is required at the centre seam of the base cone.
Be careful not to damage the sealing strips while joining the plates.

2 + 3 — **Place the shouldered side-platetight against the side-plate with straight edge.**
The shouldered edge of plate 3 shall remain outside plate 2.

8 — **Place the additional support for the cone inside the side-plates.**
Look up the correct position and attachment point for the support in the drawing.

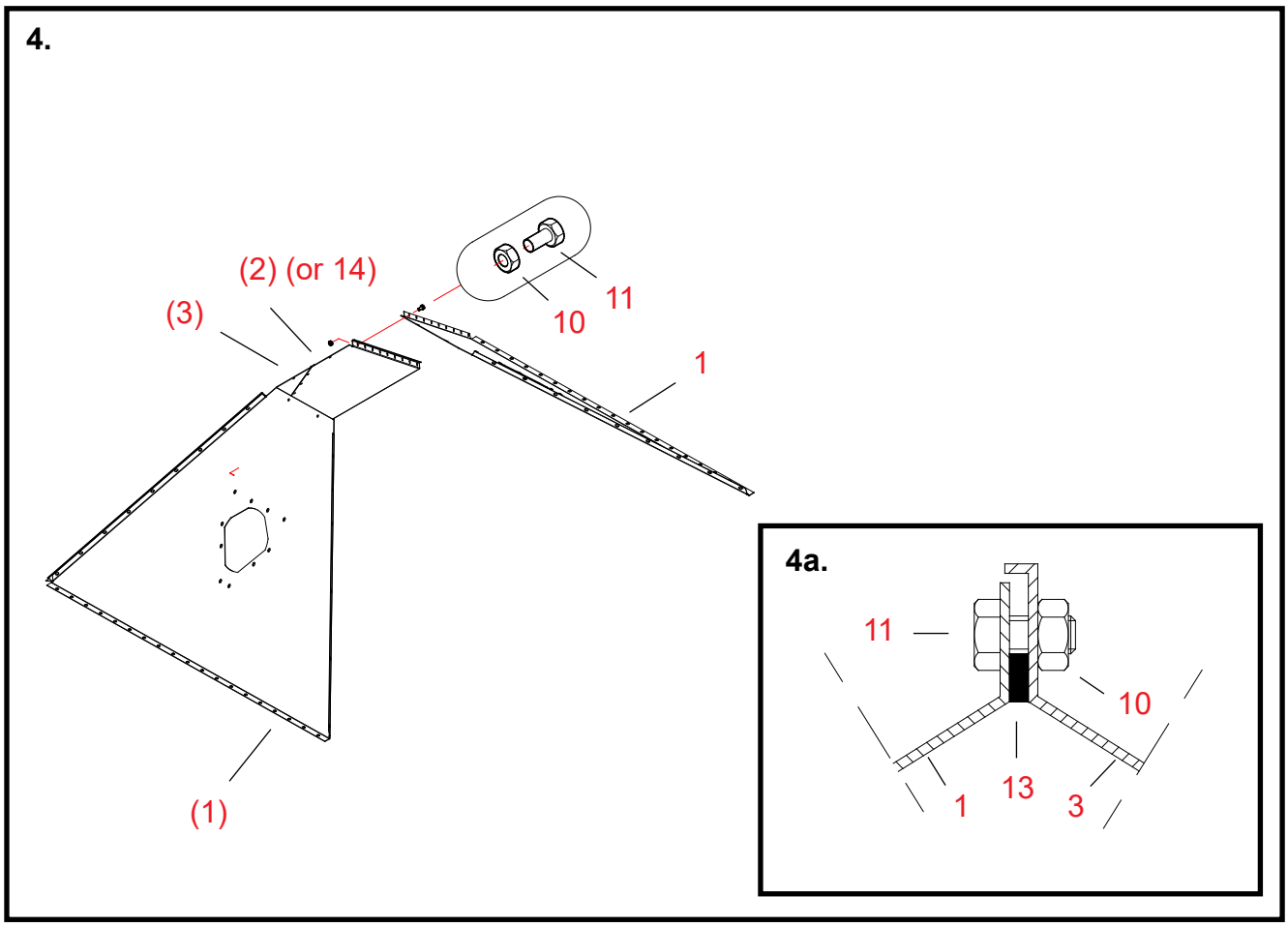
9, 10 — **Fix the seam using ball-headed nuts and bolts (M8 x 16, 12 pcs.).**
Place the bolt heads on the grain space side (see Fig. 2b).

2 + 3 — **Assemble another similar side-plate without additional support (part 8) of parts 2 and 3.**
Do not put bolts into the three holes in the additional support at this stage.



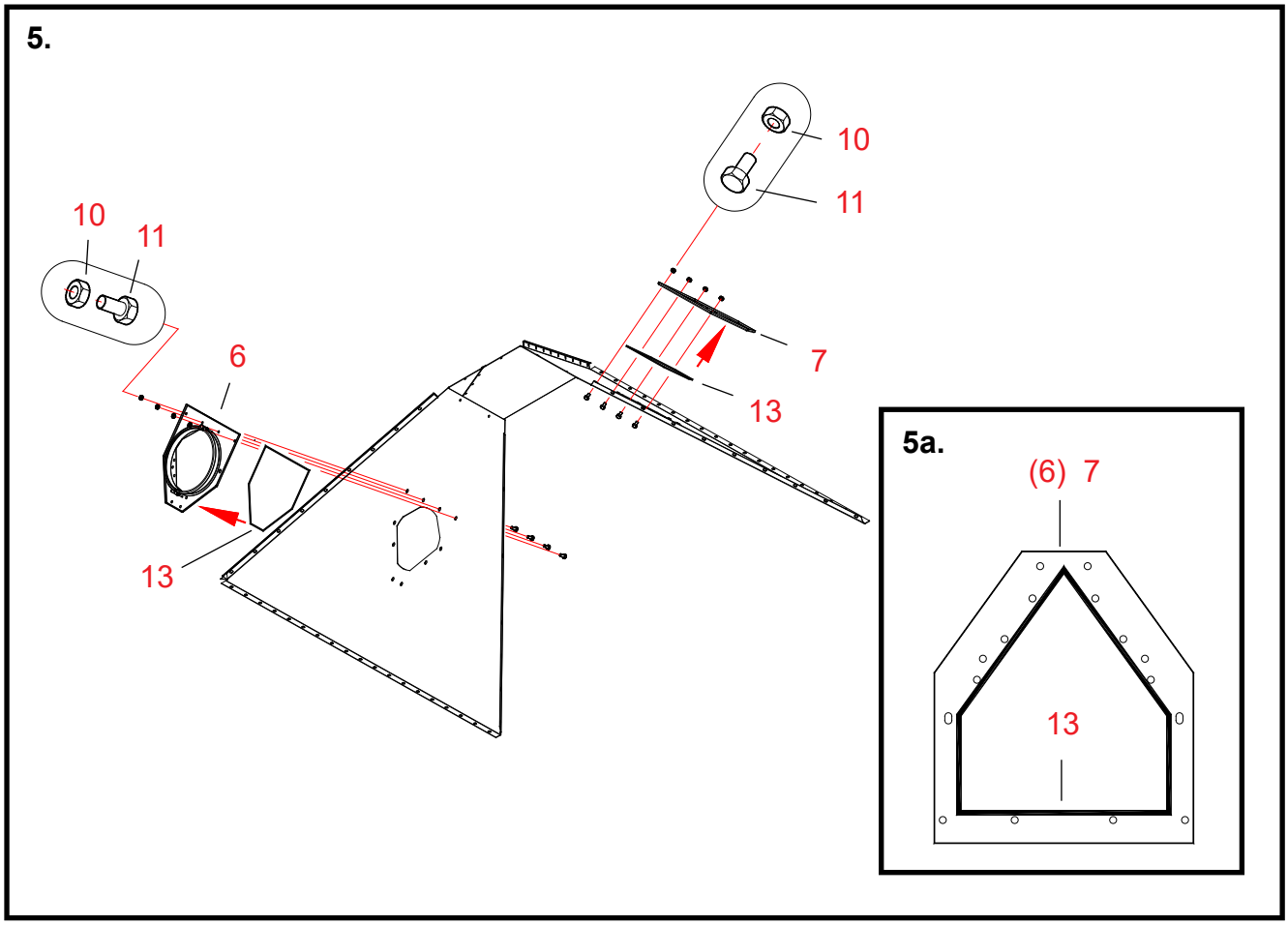
3. Fixing the third side-plate for the base cone

Parts	The numbering of work stages refers to reference numbers in the spare parts drawing of the base cone.
1	**Lift the side-plate with opening for the base cone onto the assembly plane.** Place the flange of the plate with 19 holes against the plane.
2 + 3	**Lift one of the recently assembled side-plates, the one without additional support, against the side-plate with opening.** Carefully align the corner joint between the plates. Check that the flanges of the plates are lying tight against the assembly plane.
10, 11	**Fix the seam using nuts and bolts (M8 x 16, 9 pcs.).** See dwg. 3a. Do not tighten the bolts yet.



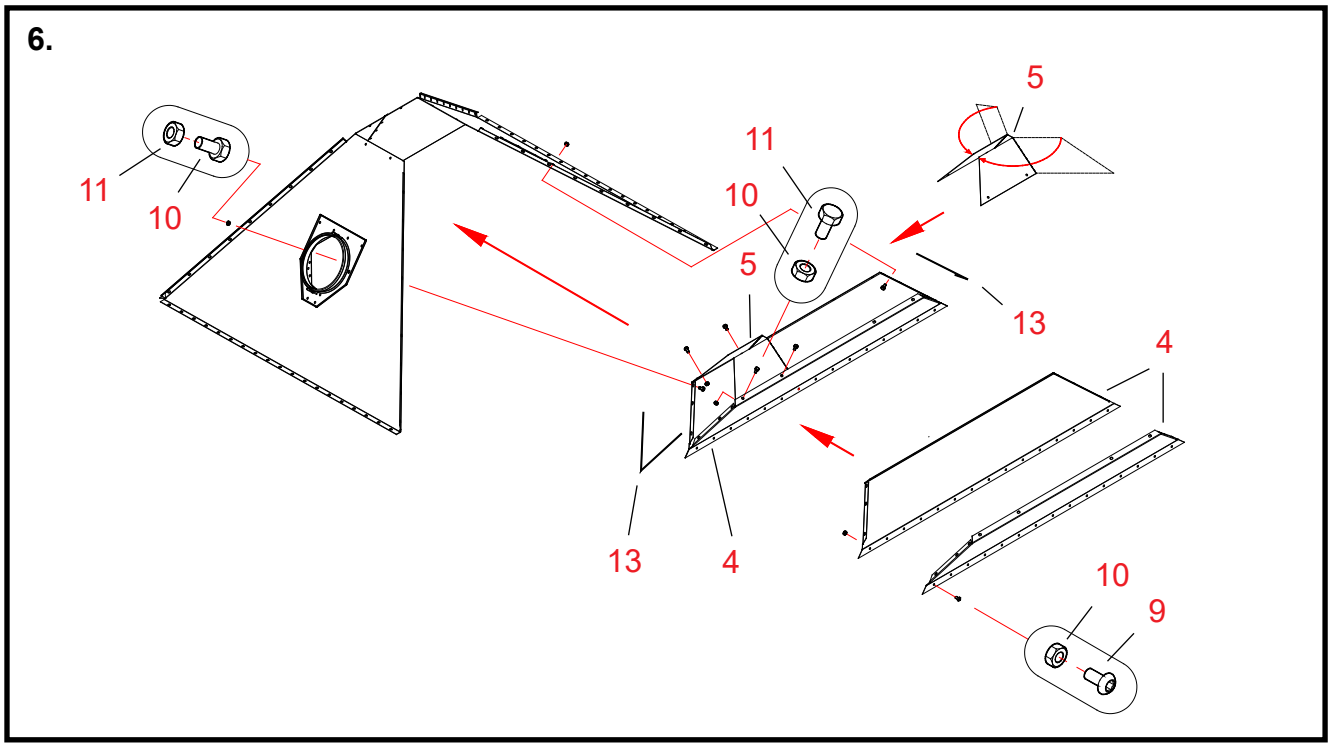
4. Fixing the fourth side-plate for the base cone

Parts	The numbering of work stages refers to reference numbers in the spare parts drawing of the base cone.
1	**Lift the other side-plate with opening for the base cone onto the assembly plane.**
1, 3	**Carefully align the corner joint between the plates.** Check that the flanges of the plates are lying tight against the assembly plane.
10, 11	**Fix the seam using nuts and bolts (M8 x 16, 9 pcs.).** Fig. 4a. Do not tighten the bolts yet.



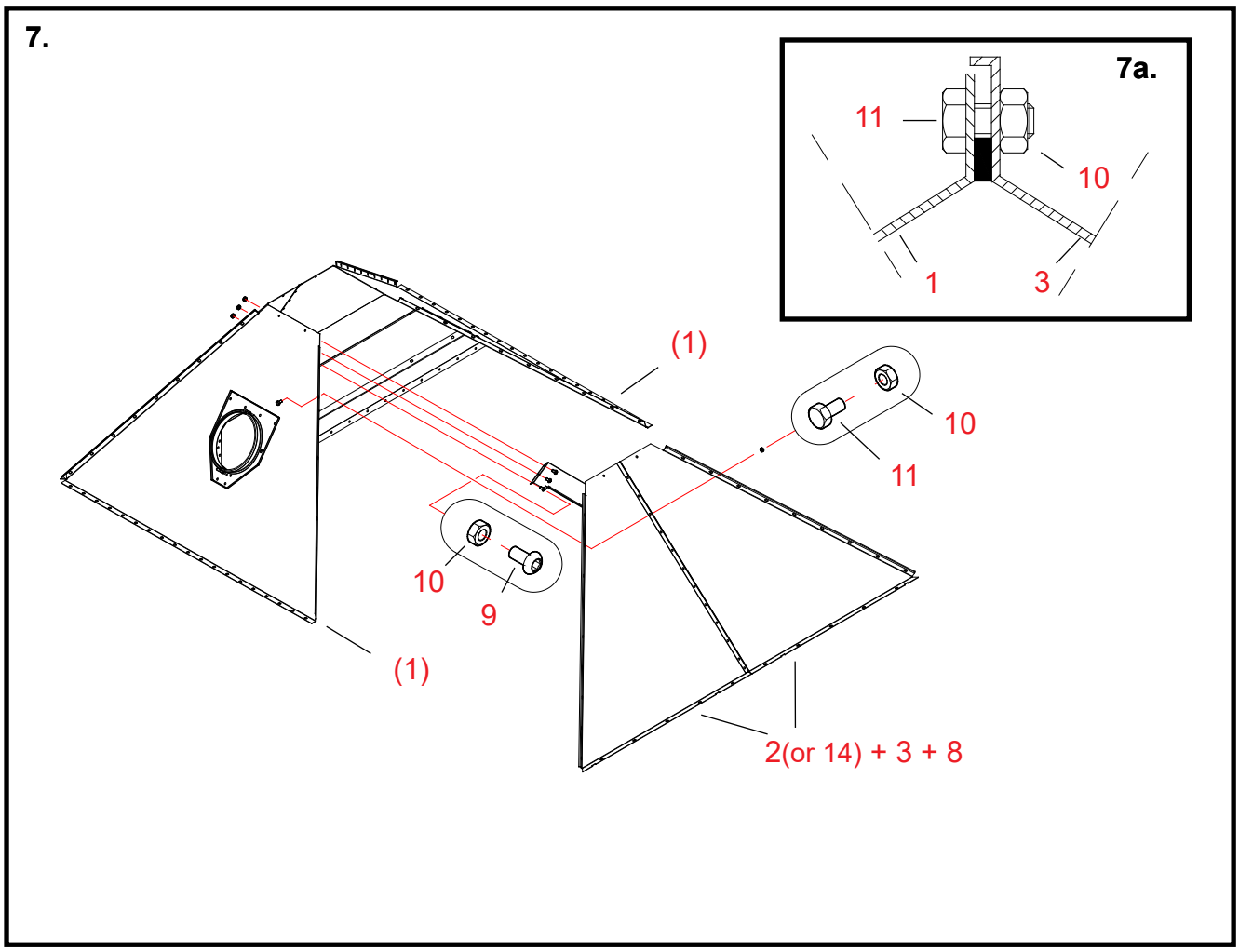
5. Attaching the connecting part and the cover-plate to the base cone

Parts	The numbering of work stages refers to reference numbers in the spare parts drawing of the base cone.
13	**Fix a sealing strip onto the inner surface of the connecting part with opening (part 6).**
13	**Fix a sealing strip onto the inner surface of the cover plate (part 7).** Fix the sealing strips inside the bolthole row in the plates (see drawing 5a).
6	**Install the connecting part with opening to the base cone on the bottom suction fan side.** Make yourself clear about on which side the bottom suction fan is to be installed.
7	**Install the cover plate on the opposite side.**
10, 11	**Fix the connecting part and the cover plate to the base cone using nuts and bolts (M8 x 16).** Place hexagon nuts and bolts (4 + 4 pcs) at this stage only in holes in straight line at the lower edge of the connecting part and cover plate.



6. Installing the suction air duct in the base cone

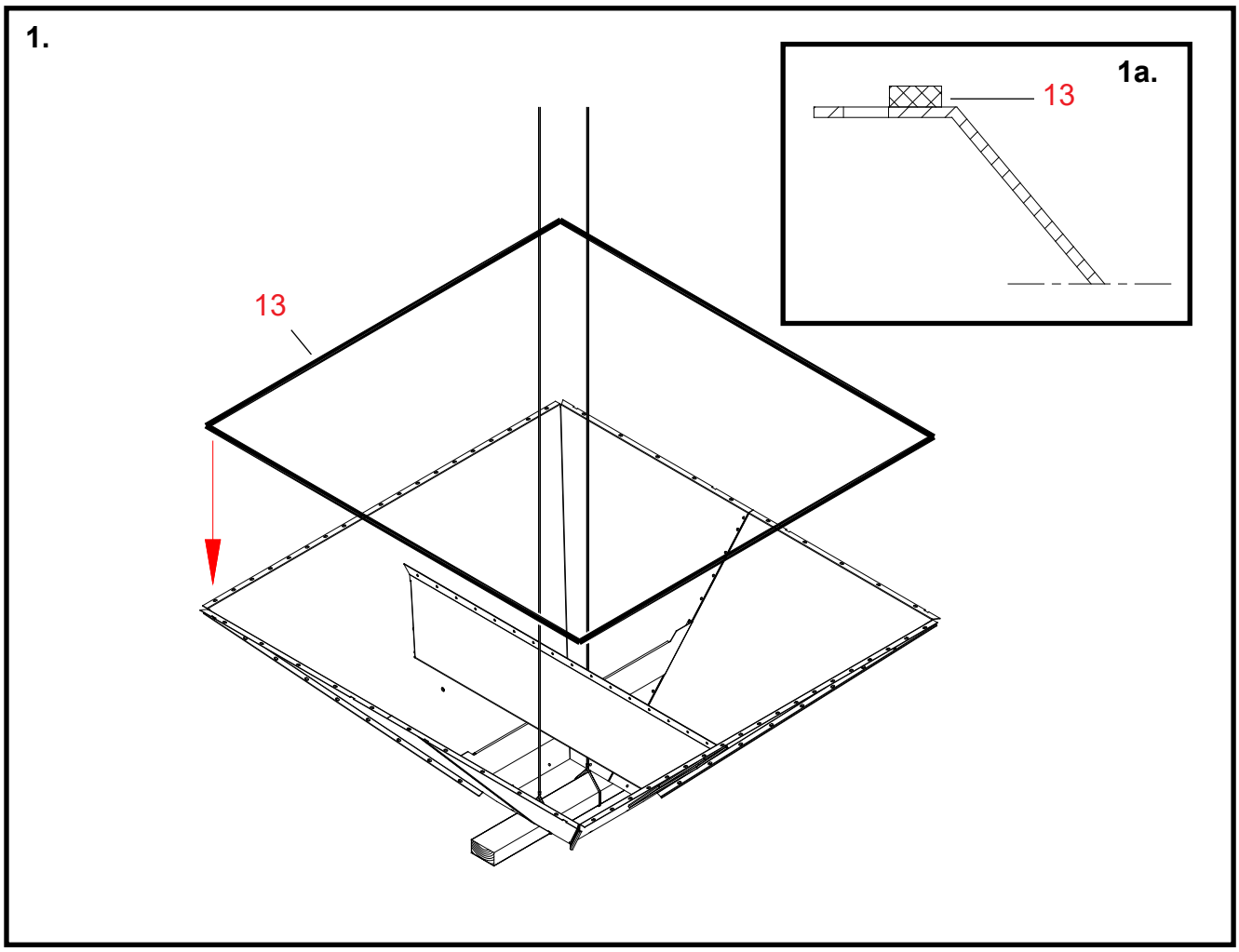
Parts	The numbering of work stages refers to reference numbers in the spare parts drawing of the base cone.
4	**Place the suction air duct halves face to face.** Make sure that the end flanges of the air duct do not "indent".
9, 10	**Join the halves together using ball-headed nuts and bolts (M8 x 16, 15 pcs.).**
5	**Attach the stop plate to the lower edge of the suction air duct (i.e. to the upper edge while the cone lies upside down during assembly).** The stop plate is straight when delivered. Bend the plate along the row of holes to the shape illustrated in the drawing. Place the stop plate in the duct at the end where the bottom suction fan is to be installed. The open end of the plate comes against the cone wall. Place its edges inside the flanges of the suction air duct.
10, 11	**Fix the stop plate using hexagon bolts and nuts (M8 x 16, 4 pcs).**
13	**Fix sealing strips to the end flanges of the suction air duct.**
4	**Place the suction air channel with the stop plate attached inside the base cone.**
10, 11	**Fix the air channel by its end-flanges using bolts and nuts (M8 x 16, 6 + 6 pcs.).** These bolts are also used for fixing the connecting part and the cover plate in their final positions. ***Ensure that the joint between the stop plate and the base cone wall is tight.*** If necessary, seal with butyl compound (the compound and the press are included in the delivery).



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

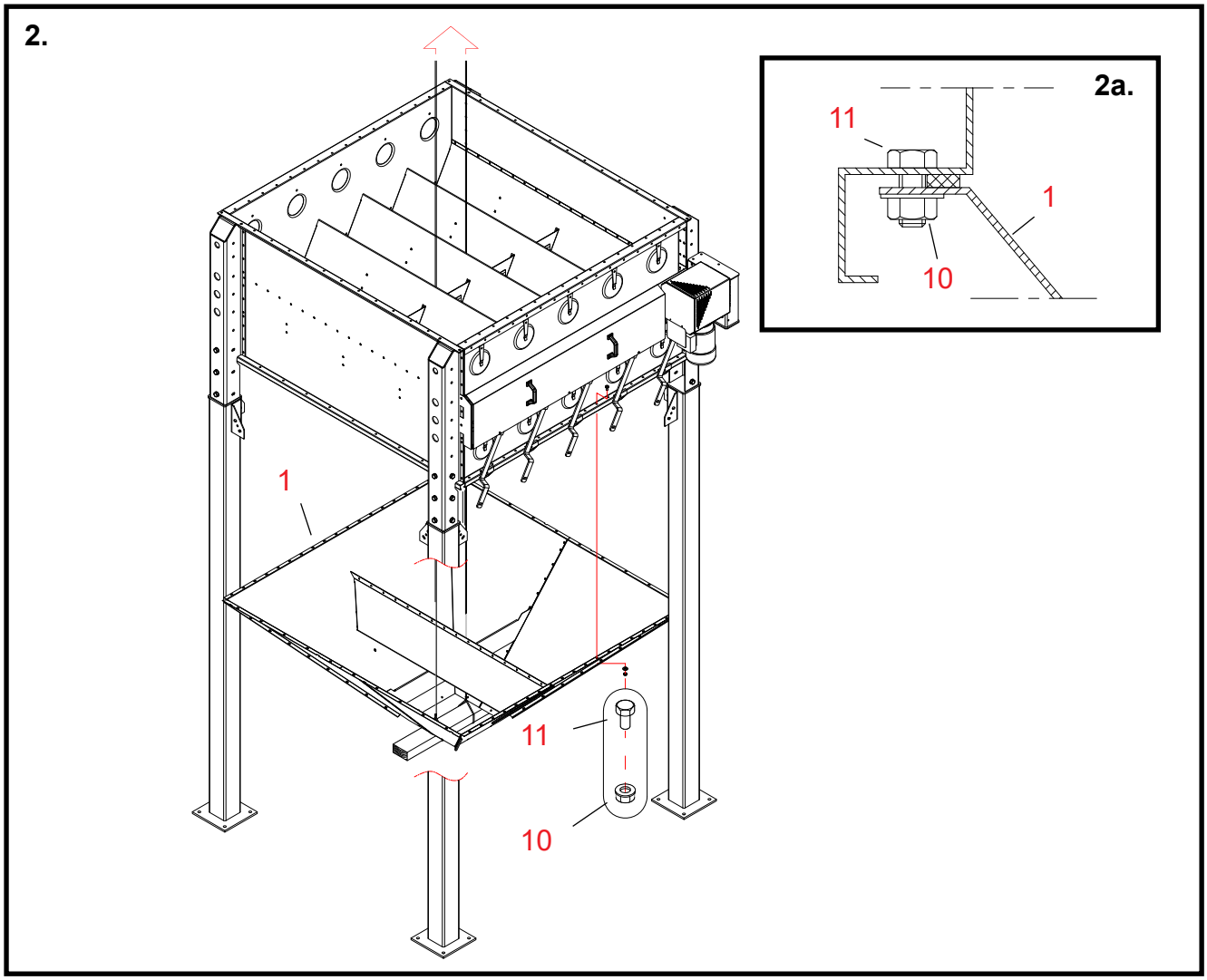
Parts	The numbering of work stages refers to reference numbers in the spare parts drawing of the base cone.
2 + 3 + 8	**Close the ready-assembled base cone using the joined-together fifth and sixth side-plates.**
1, 2, 3	**Carefully align the corner joints between the plates.** Check that the flanges of the plates are lying tight against the assembly plane. Align the bolt holes in the additional support with the three unused holes in the opposite side-plate.
10, 11	**Fix the corner joints using nuts and bolts (M8 x 16, 9 + 9 pcs.).**
9, 10	**Fix the intermediate support using ball-headed nuts and bolts (M8 x 16, 3 pcs.).**
	Finally, ensure that the whole cone is lying tight against the assembly plane.
*	**Tighten all bolts in the corner joints.**

Installing the base cone



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

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

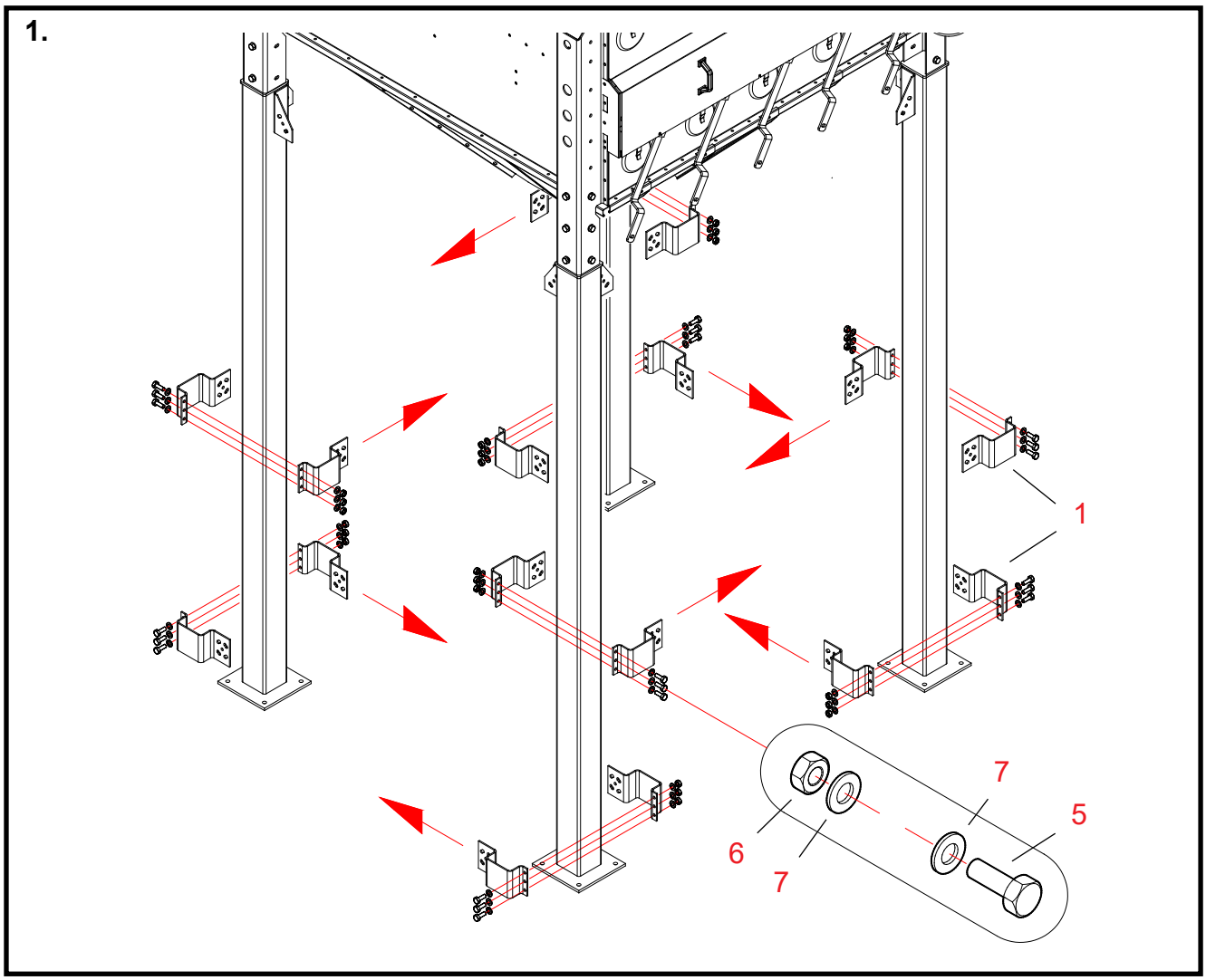


2. Lifting and fixing the base cone

Parts	The numbering of work stages refers to reference numbers in the spare parts drawing of the base cone.
	Be careful not to damage the sealing strips when lifting the cone.
*	**Move the base cone under the base.**
*	**Lift the cone using the wire rope threaded in between the air ducts in the base.**
*	**Thread in the cone carefully between the lugs in the extension legs.**
1	**Lift the base cone tight against the bottom surface of the base.**
10, 11	**Attach it using screws and flange nuts. (M8 x 16, 58 pcs.).** See dwg. 2a.

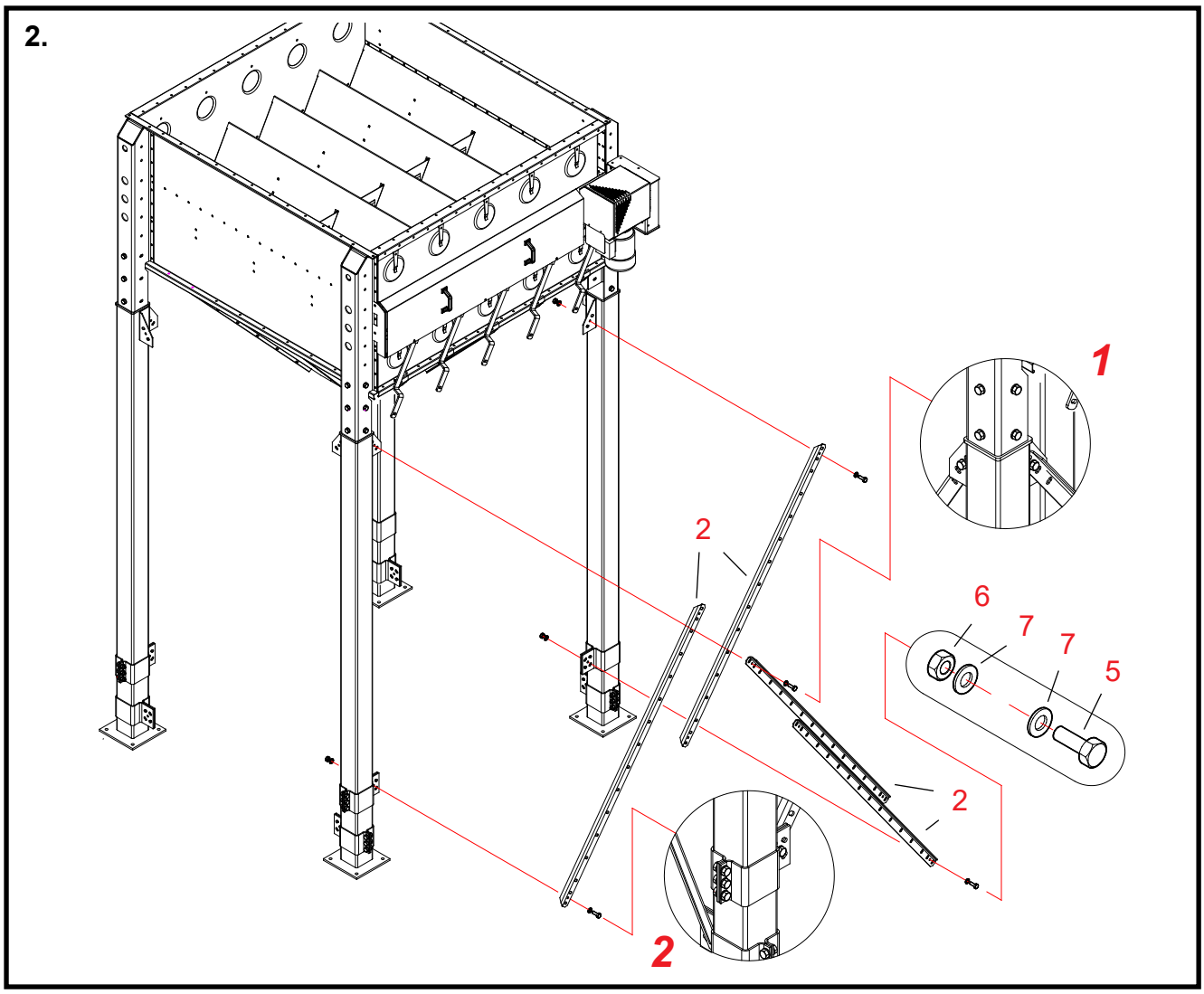
Fasten with screws and flange nuts

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



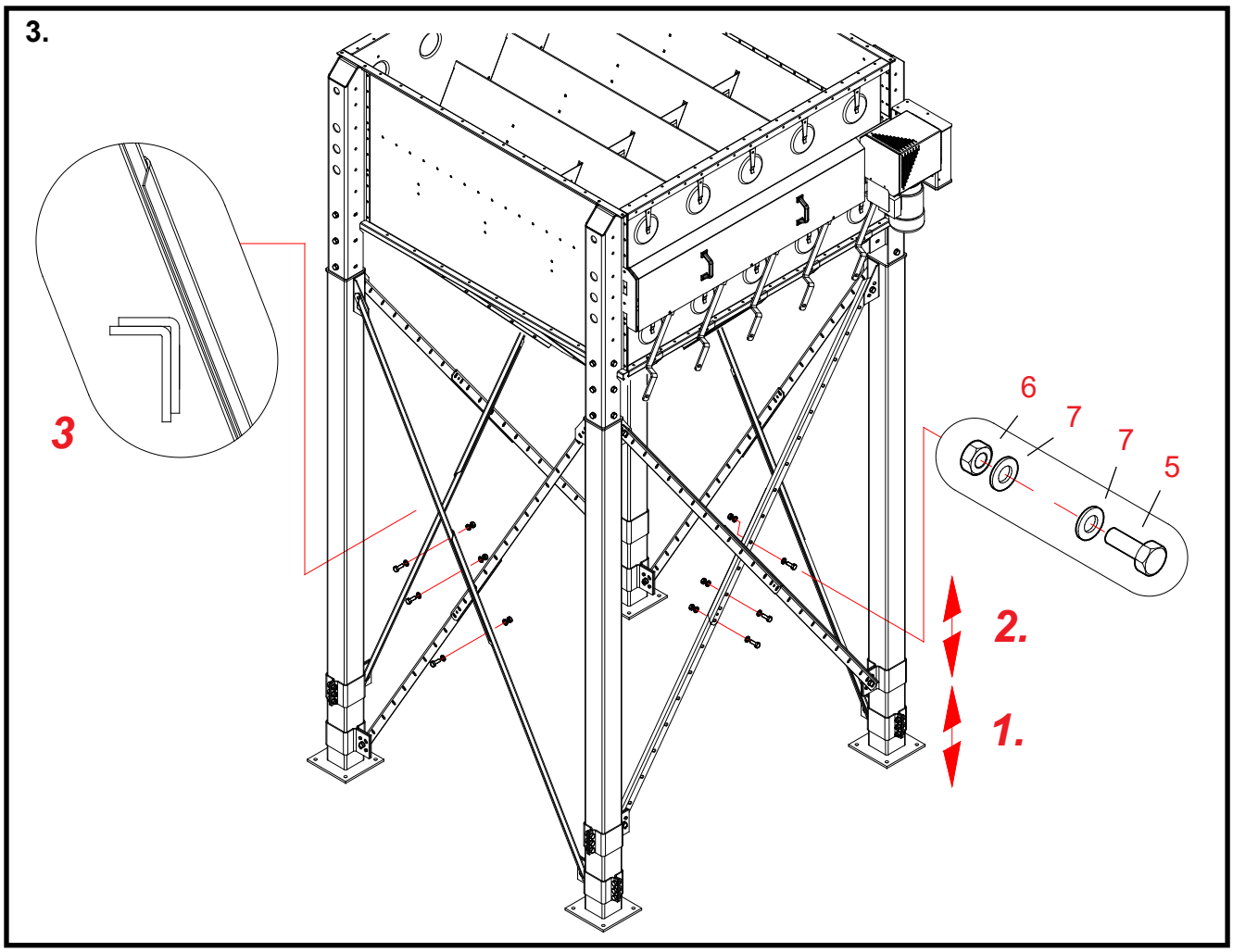
1. Installing the adjustable cross-brace brackets on the extension legs

Parts	The numbering of work stages refers to reference numbers in the spare parts drawing for cross-braces for the extension legs.
1	**Put the halves of the adjustable brackets on the extension legs.** Install two pieces of brackets, consisting of two halves each, on each leg. Check the correct direction for the bracket flange with 5 holes in the drawing.
5, 6, 7	**Attach the brackets to the extension legs (bolts M12 x 35).** Look up the correct position for the bolts in the drawing. At this stage, attach the brackets only by their flanges with 3 holes. Leave the bolt attachments loose in order to be able to move the brackets without damaging the surface treatment of the legs.



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

Parts	The numbering of work stages refers to reference numbers in the spare parts drawing for cross-braces for the extension legs.
2	**Put in place the cross-brace parts in the upper and lower brackets on one side of the base.** Select the direction and position for the cross-braces at the side of the bracket, as illustrated in drawings ***1*** and ***2***.
5, 6, 7	**Fix the ends of the cross-braces to the brackets in the extension legs (bolts M12 x 35).** Look up the correct position for the bolts in the drawing. Fix the cross-braces at both their ends at this stage only with one bolt. Put the bolt, the washers and the nut in place in the round hole in the brace and the bracket. Do not wrench the bolts to their final tightness yet.
*	**Install the upper and lower parts of the cross-braces in the same way on the other three sides of the base.**



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

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

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

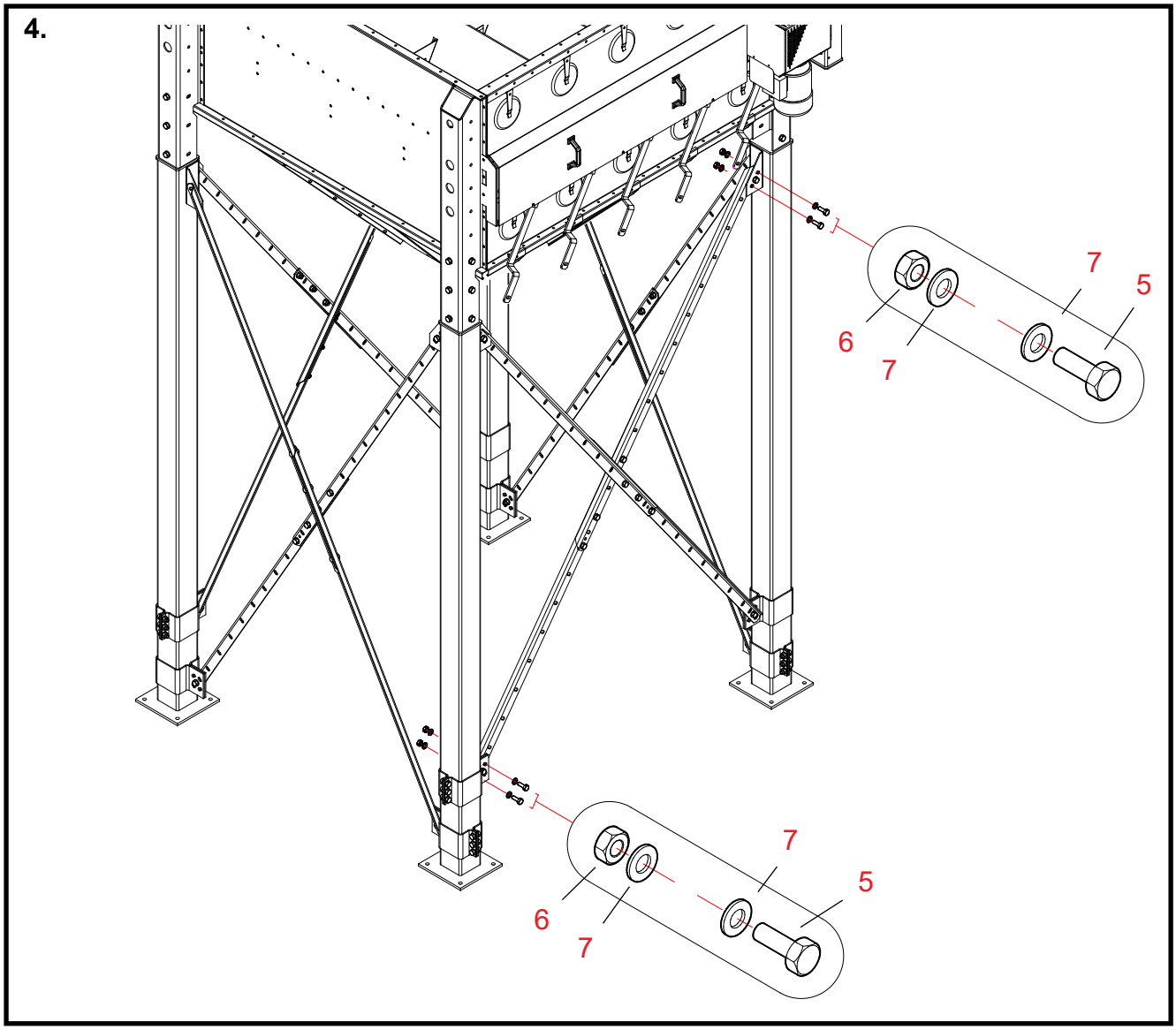
Place the parts one inside the other, as shown in detail drawing ***3***.

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

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

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

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



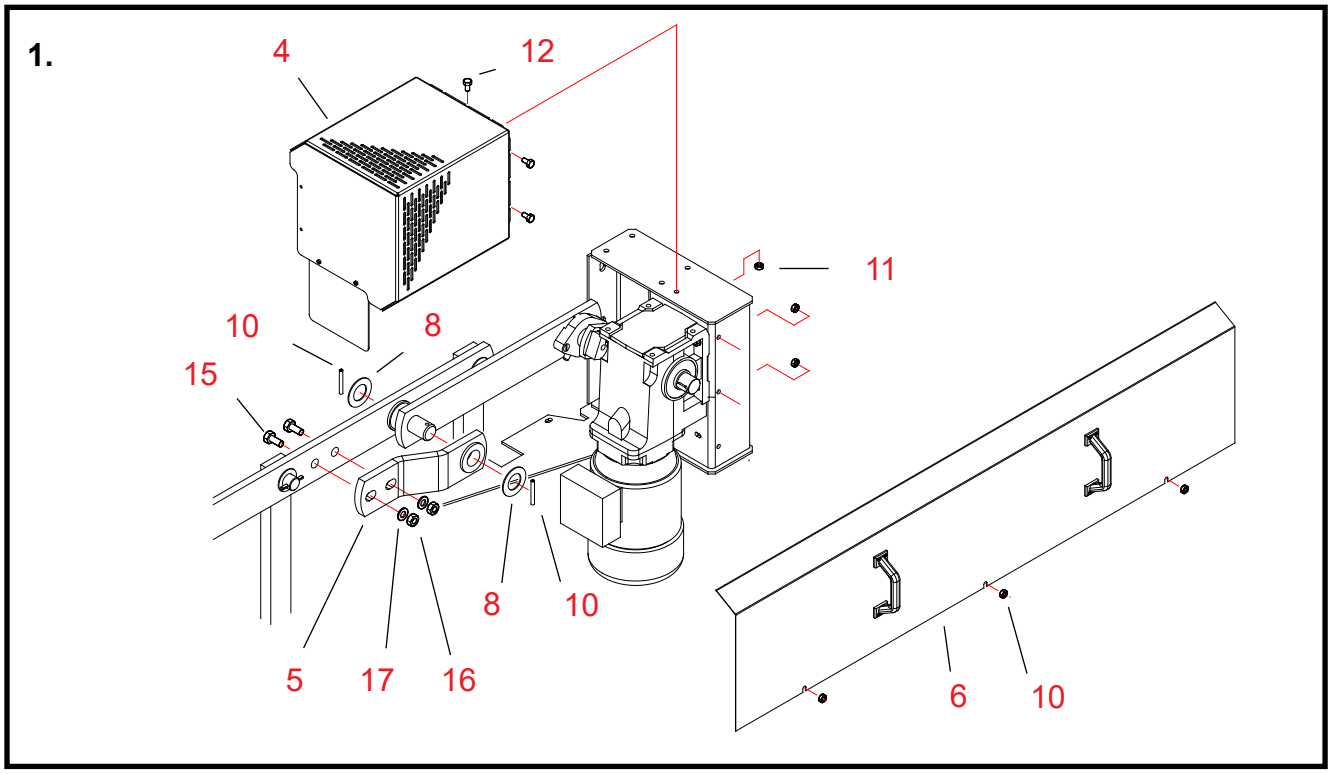
4. Fixing the upper and lower ends of the cross-braces for the extension legs in their final positions

Parts	The numbering of work stages refers to reference numbers in the spare parts drawing for cross-braces for the extension legs.
5, 6, 7	**Put in place the missing bolts (M12 x 35) in the upper and lower ends of each cross-brace.**
	Every cross-brace must be attached to the bracket on the extension leg by three bolts, washers and nuts at its lower and upper ends.
*	**Tighten all bolt attachments at the upper and lower ends of the cross-braces.**

Transferring the feeding equipment motor to another position

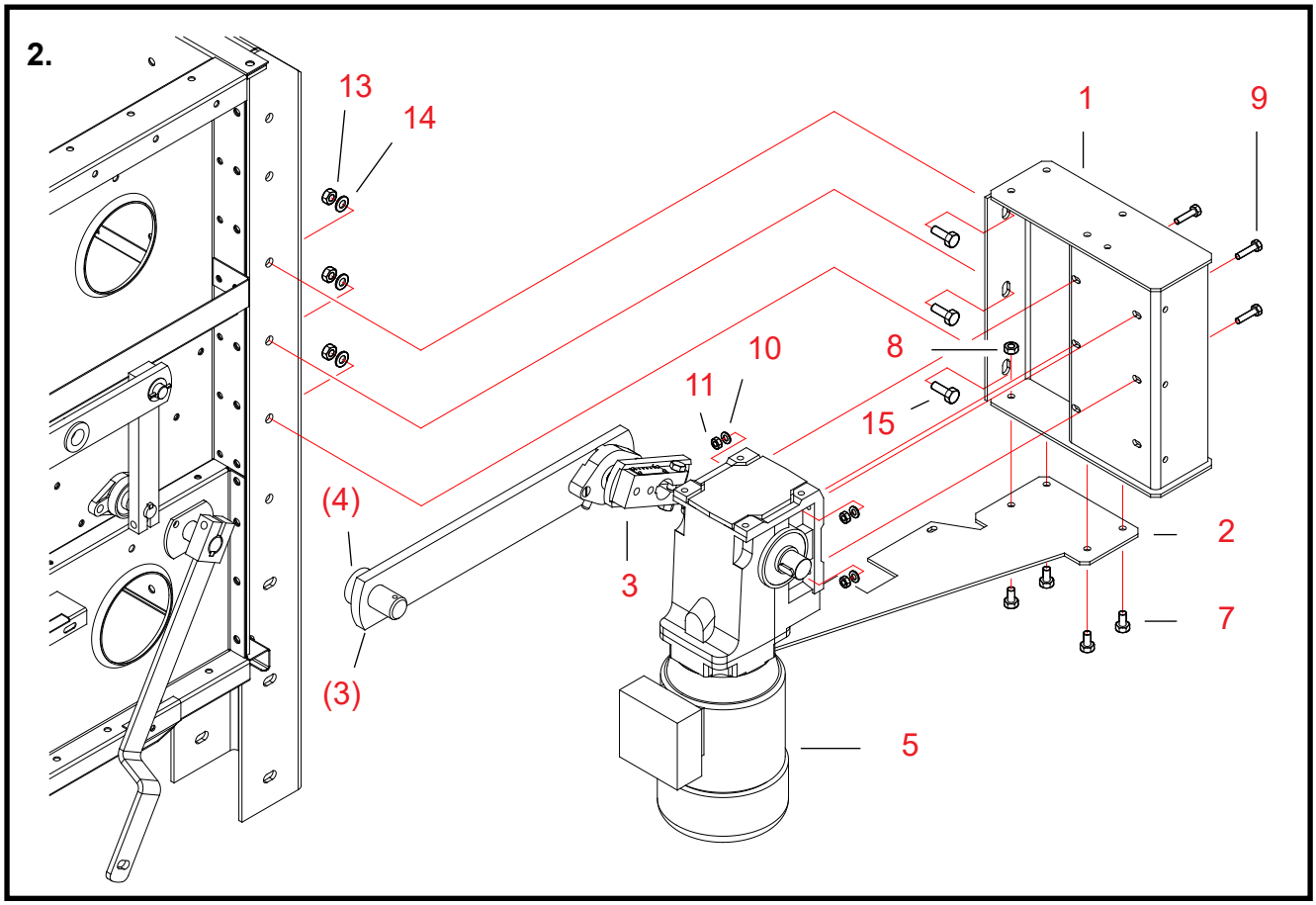
The shape of the dryer building or some other space-related issue may sometimes require transferring the motor to the opposite side of the dryer base.

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



1. Dismantling the eccentric piece cover and the transmission rod

Parts	The numbering of work stages refers to reference numbers in the spare parts drawings of the motor rack, feeding equipment and base assembly.
10	**Remove the three attachment nuts for the protective cover of the feeding equipment.**
6	**Remove the protective cover for the feeding equipment.**
11, 12	**Remove the three attachment nuts and bolts for the eccentric piece cover.**
4	**Dismantle the eccentric piece cover with its additional cover from the motor rack.**
8, 10	**Remove the spring cotters and washers from both ends of the transmission of the feeding equipment.**
15, 16, 17	**Remove the two bolts and washers from the connecting rod support.**
5	**Dismantle the connecting rod support from the connecting rod and the transmission rod.**



2. Dismantling the motor and the motor rack

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

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

5 — **Dismantle the motor, the eccentric piece and the transmission rod from the rack.**
As required, use a pry-bar for removal of the transmission rod shaft (part 3).
Leave the spacer (part 4) on the transmission rod shaft.
Lift the dismantled unit onto a suitable work plane.

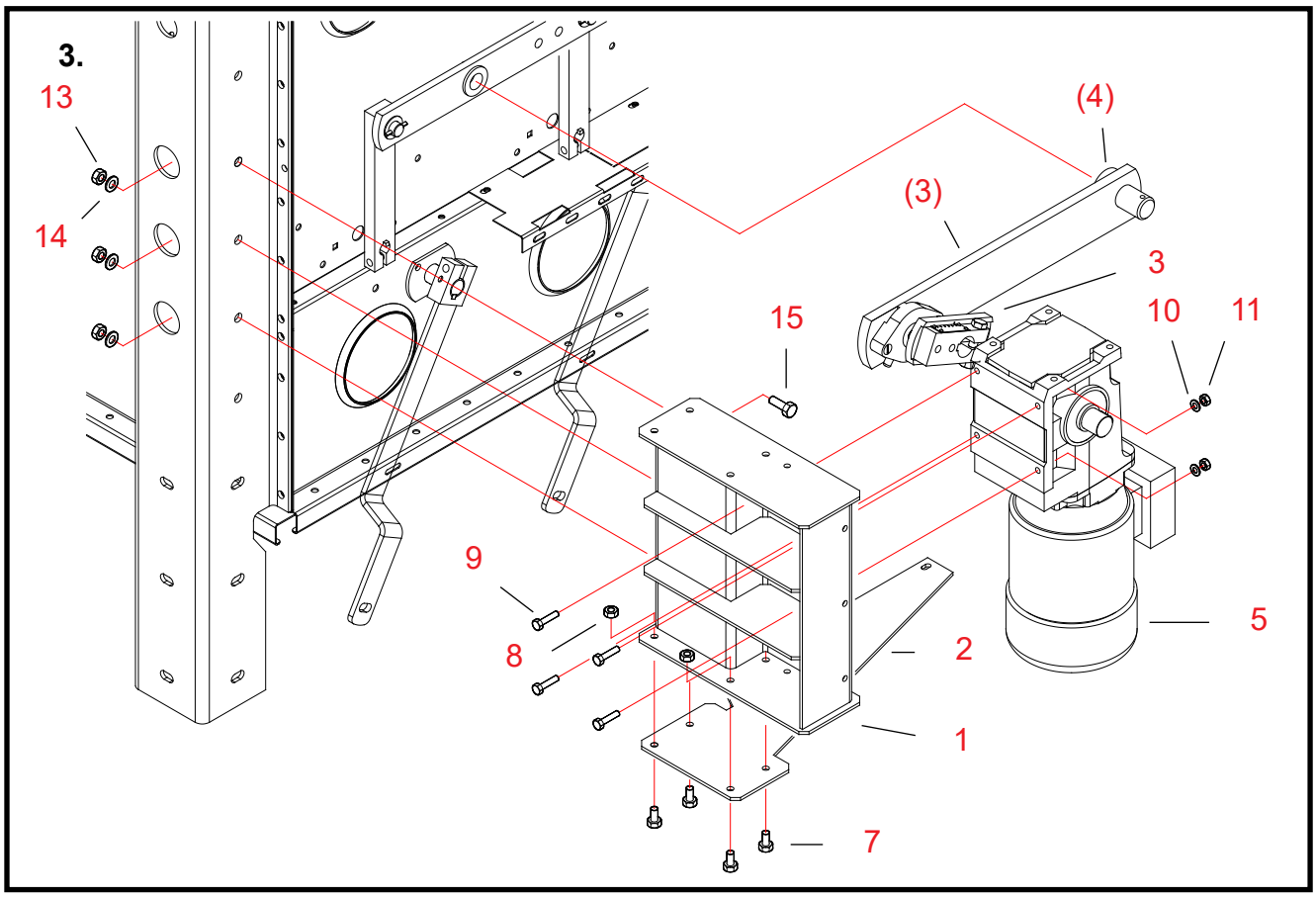
13, 14, 15 — **Remove the three attachment bolts, nuts and washers for the motor rack.**

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

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

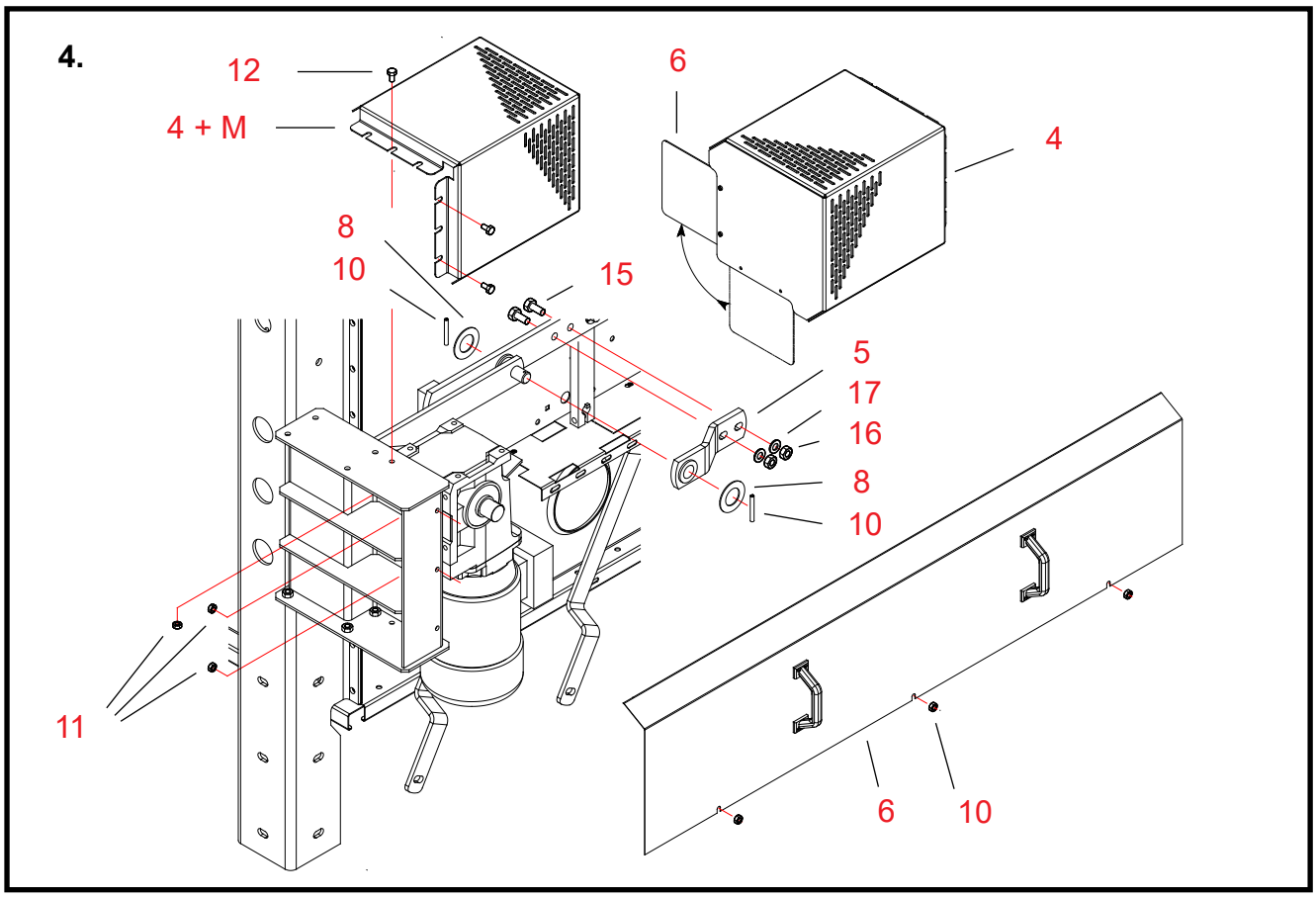
2 — **Disconnect the torque arm from the motor rack.**

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



3. Re-installing the motor and the motor rack

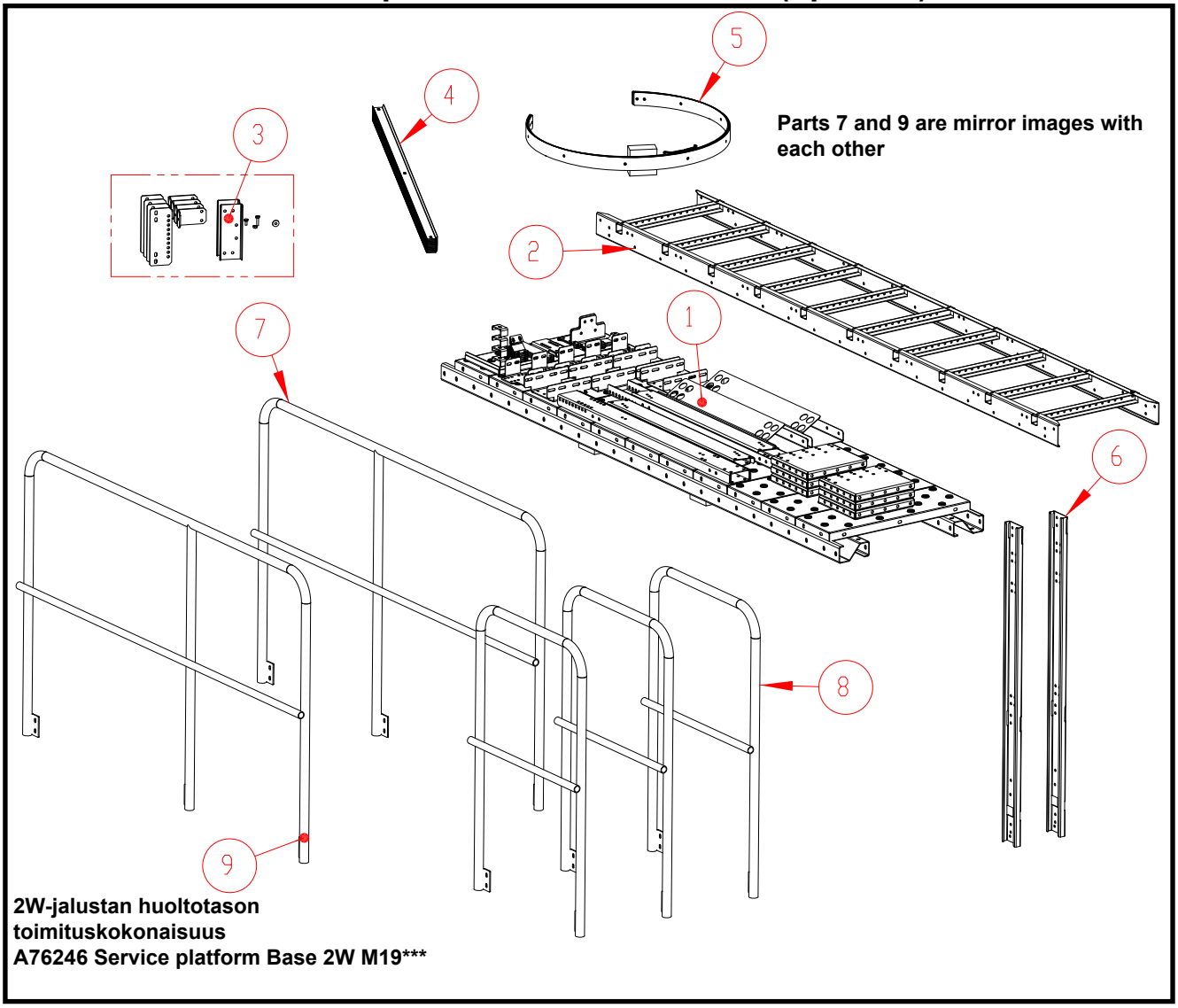
Parts	The numbering of work stages refers to reference numbers in the spare parts drawings of the motor rack, feeding equipment and base assembly.
2	**Put the torque arm in place in the motor rack.**
7, 8	**Attach the torque arm using nuts and bolts (M10 x 20, 4 pcs.).**
1	**Attach the motor rack and the torque arm to the dryer base leg.**
13, 14, 15	**Attach the motor rack using bolts, washers and nuts (M12 x 35, 3 pcs.).**
	Check that the relevant end of the motor shaft is equipped with a key.
3	**Place the eccentric piece onto the motor shaft.** Push the eccentric piece on the shaft to as far it as goes. Tighten the bolt for the eccentric piece.
5	**Put the motor with the eccentric piece and transmission rod back on the rack.** Check that the spacer (part 4) is still in place on the transmission rod shaft. Align the transmission rod shaft (part 3) with the bearing sleeve for the connecting rod.
9, 10, 11	**Attach the motor to the rack using bolts, washers and nuts (M8 x 35, 4 pcs.).**



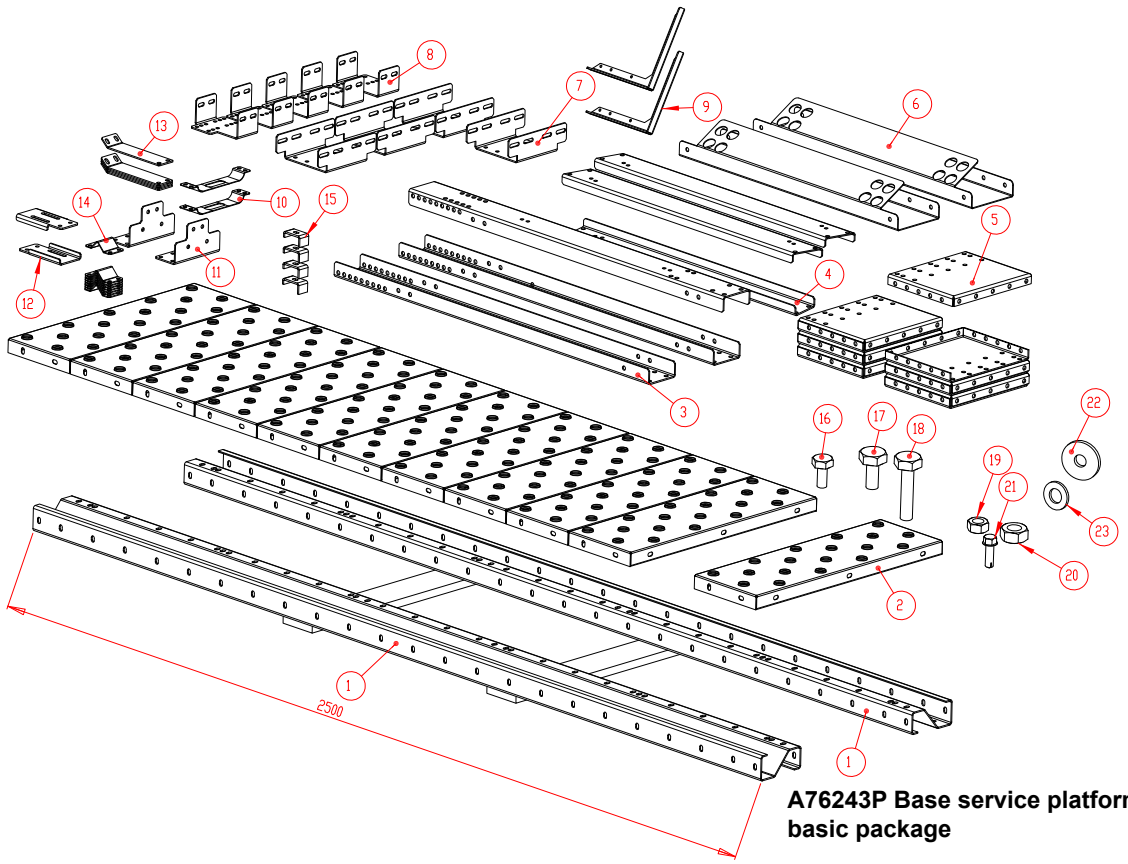
4. Installing the eccentric piece cover and the transmission rod

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

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



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

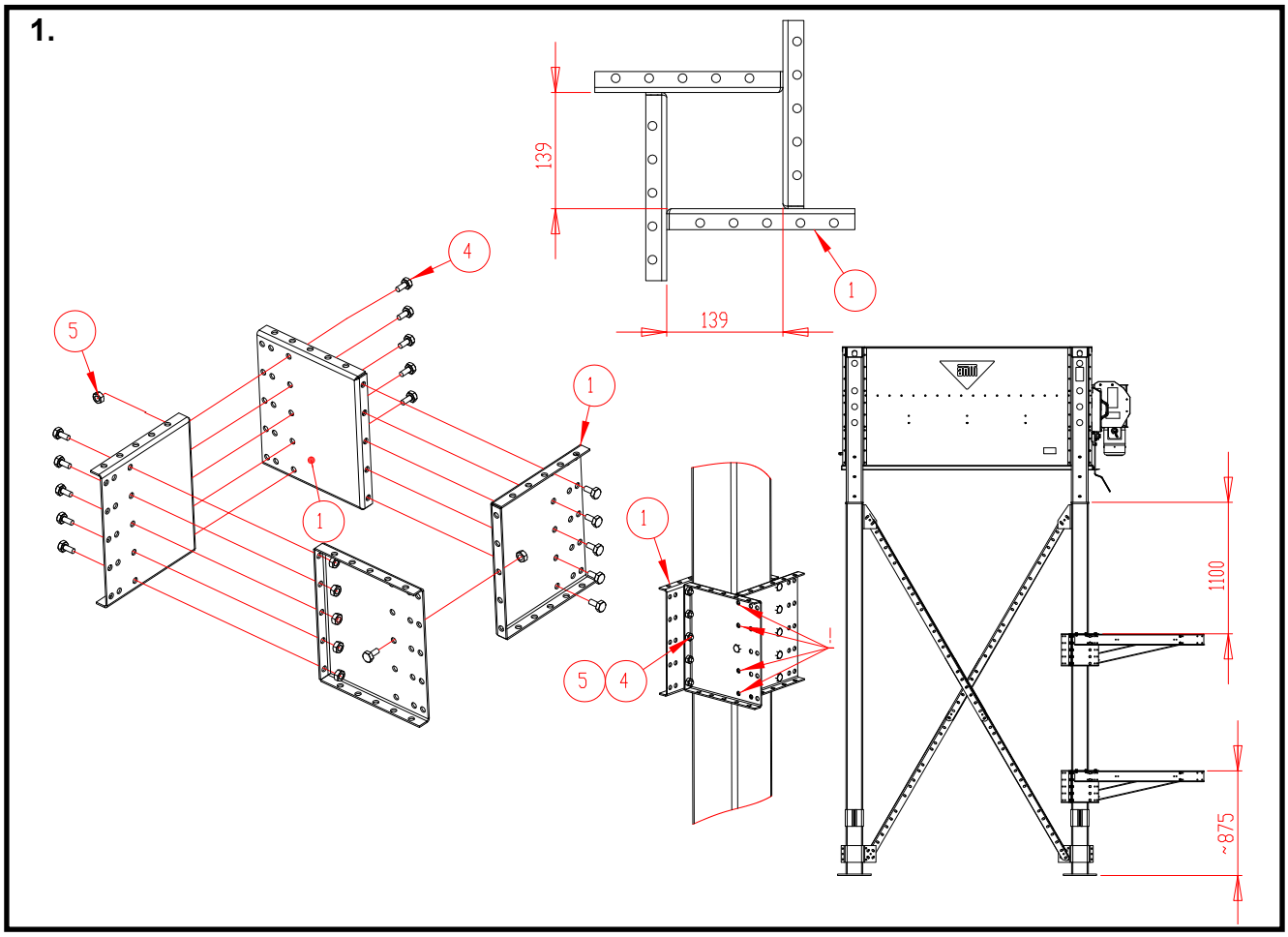


A76243P Base service platform basic package

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

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

The base cone has been hidden in the instructional drawings to make reading of the drawings easier



Assemble the bands for the service platform bearer (from parts 1) around the two extension legs of the base.

Assemble one band on both extension legs on the side of the base with the feeding equipment.(The upper bands). Assemble also one band lower on the leg, which is closest to the end of the service platform on the same side with the ladder.

Position the upper edges of the upper bands at a distance of 1,100mm from the lower end of the base's leg.

Position the upper edge of the lower band at a distance of about 875mm from the lower end of the extension leg of the base.

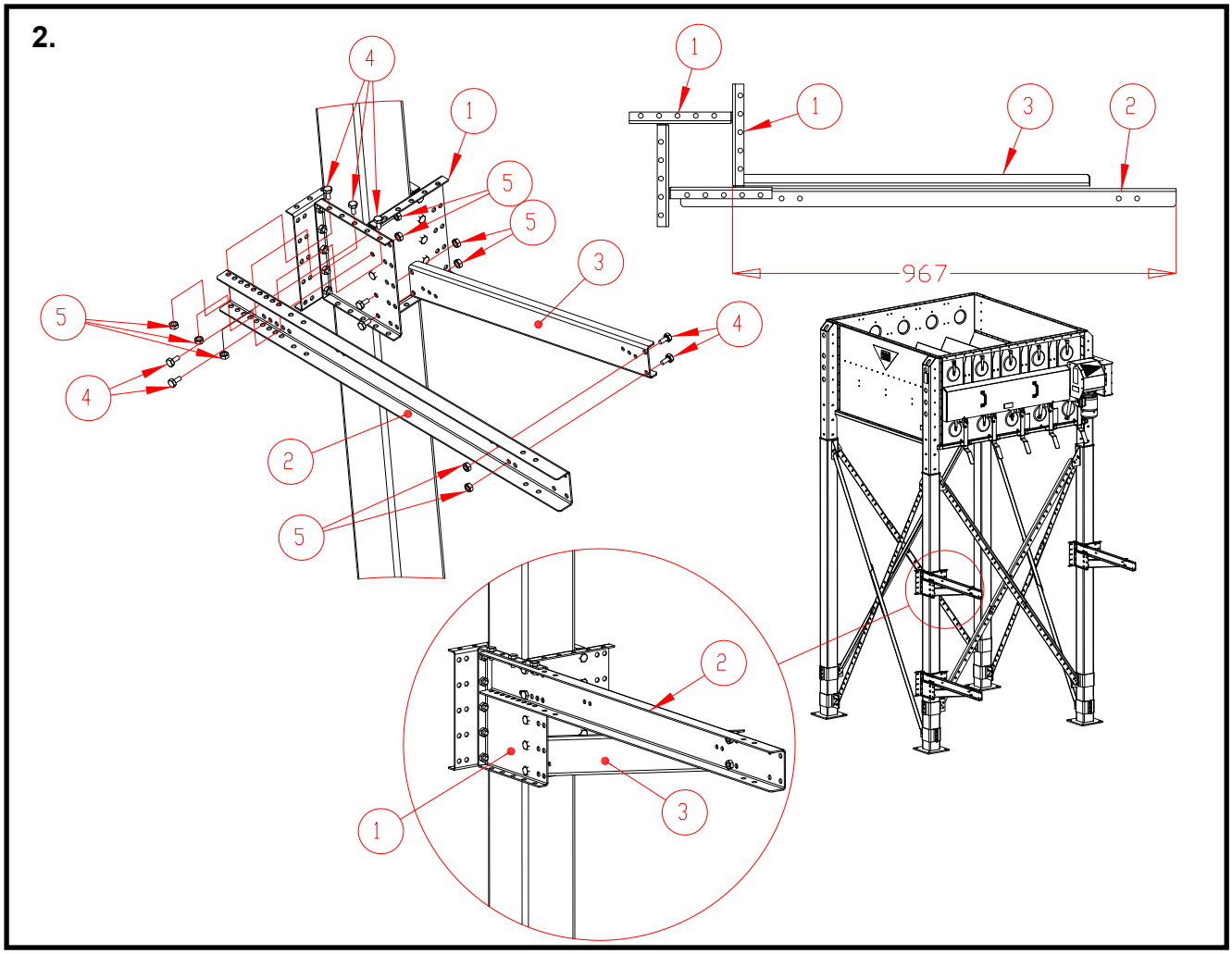
Fix the parts of the bands using nuts and bolts (M10x20,16 pcs./set-up).

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

Note, that four bolts on one of the band's sides shall not yet be installed at this stage (from places marked in the drawing with an exclamation mark).

Also the crossbar and the parts of the cross-brace (parts 2 and 3) shall be attached using these same bolts. The bolts will be installed in the next stage. (see next page)

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



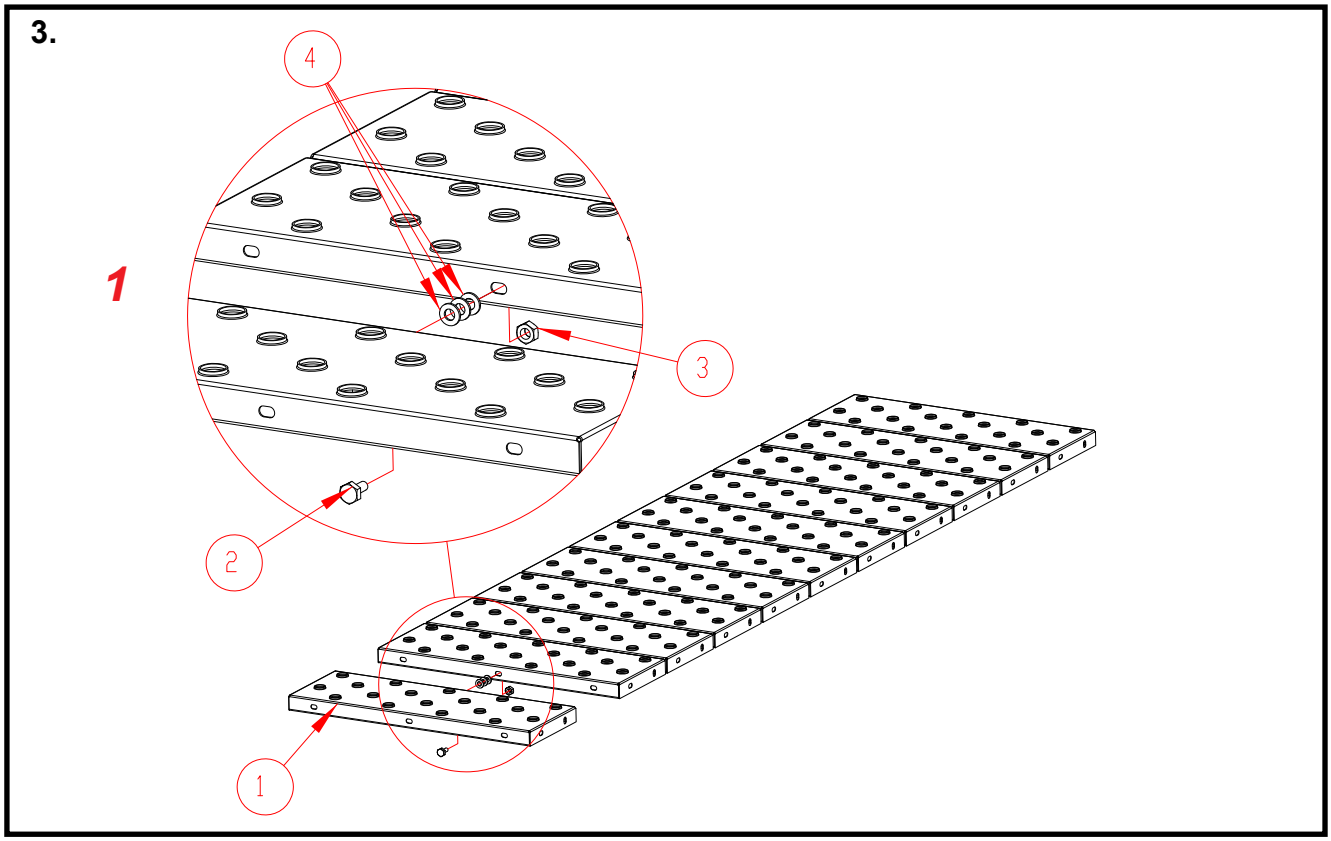
Installing the crossbar on the service platform bearers and its support 2W

Place the crossbars of the platform bearers (parts 2) in the bands for the bearers.
Position the crossbars so that the distance from the end of the crossbar to the tube of the extension leg will be 947 mm.

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

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

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



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

Joining the platform elements 2W

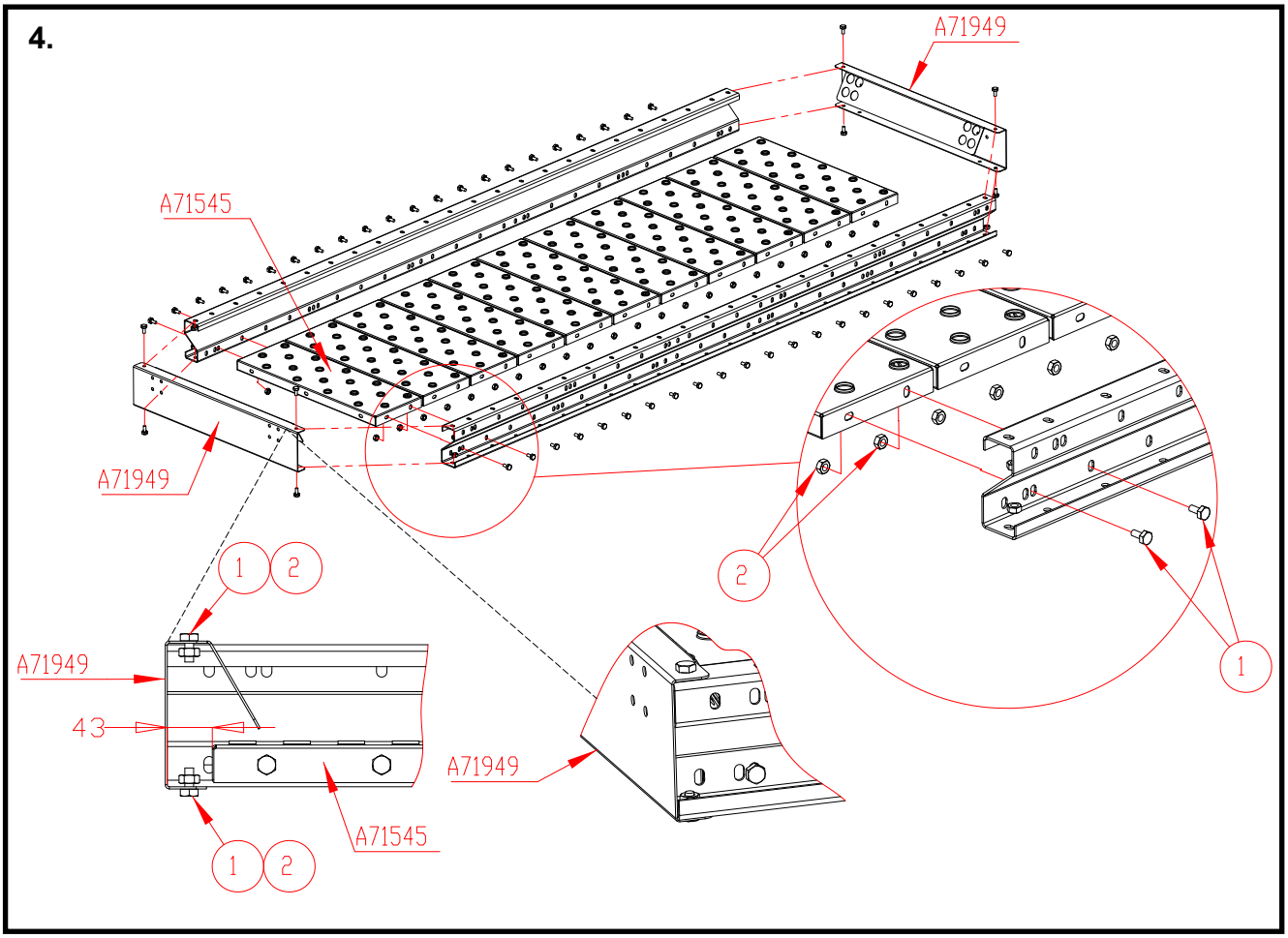
Start by joining all the 11 platform elements (A71545) together.
The platform package for the base A76243P includes 11 pcs of platform elements.

Join the platform elements together using nuts and bolts (M10x20, 1 pcs./element joint).
Put an M10x20 bolt and an M10 nut in the midmost boltholes in the longer edges of the elements.

In addition, install in the seams between the elements 3 pcs of M10 washers to achieve desired distribution of the elements.

See detail drawing 1.

It is advisable to wrench the attachment bolts of the platform elements to their final tightness only after the elements have been attached to the Z-beams. (see stage ”Installing the Z-beams and the end-beams of the service platform of 2W”) on page 44.



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

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

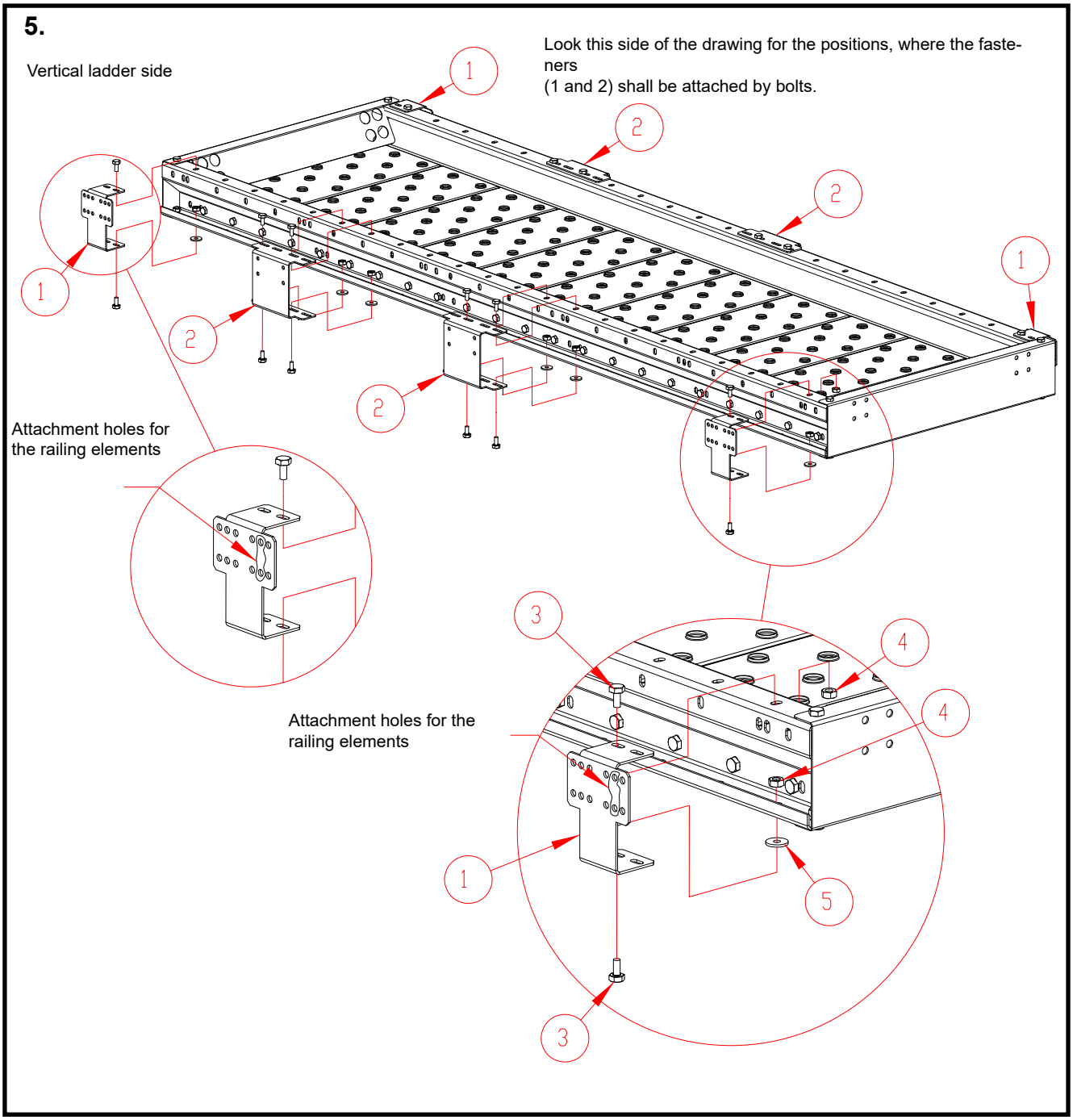
Install a Z-beam (A71919) on both sides of the service platform.
Check the position of the platform elements and the Z-beams with respect to one another in the detail drawings 1 and 2.

Fix the Z-beams to the sides of the platform element set-ups.
Attach them to either end of each platform element using two nuts and bolts (M10x20).

Install an end-beam (A71949) in both ends of the service platform.
Check the position of the end-beam and the Z-beam with respect to one another in the detail drawings 2 and 3.

Fix the end-beams to the ends of the Z-beams.
Fix each end-beam by its both ends using two nuts and bolts (M10x20).

5.



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

Installation of the attachment plates for the railing elements

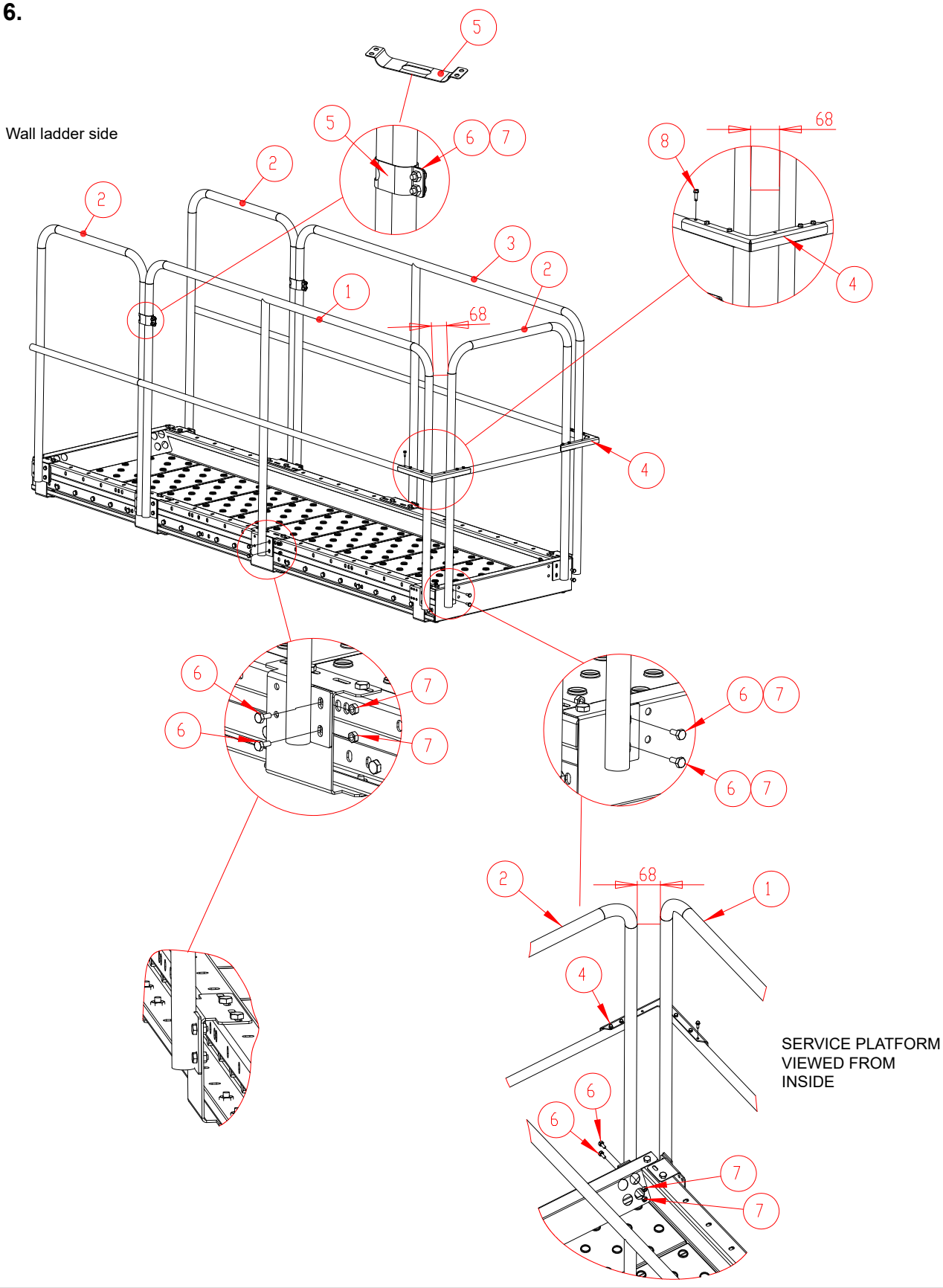
Install the attachment plates (parts 1 and 2) exactly in the positions shown in the drawing.
Look up the correct positions in the drawing by counting the holes in the Z-beams to be left unused between the fasteners.

Put a fender washer (part 5) between the fastener plate and the lower edge of the Z-beam in each bolt joint.

Attach the fastener plates using M10 nuts and M10x25 bolts.
The wider fasteners shall be fixed with 4 bolts/fastener and the narrower ones with 2 bolts/fastener. So, in the narrower fastener the other attachment holes will be left unused.

It is advisable to wrench the attachment bolts of the fasteners to their final tightness only after the railings have been attached to their fasteners. (see the next work stage) That will enable you to pull the fastener plates slightly away from the Z-profiles (as much as the long holes allow) Pulling the fastener plates temporarily away from the Z-profile leaves more space for putting the attachment bolts for the railings in place.

6.



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

Installing the service platform railings

The installation order presented in these instructions follows the pattern, where the railings will first be attached to the service platform, and after that, the service platform will be lifted in place on their crossbar bearers. If the space at the installation location is limited, it may be necessary to first attach the service platform to its crossbar bearers, and only after that, install the railings in place.

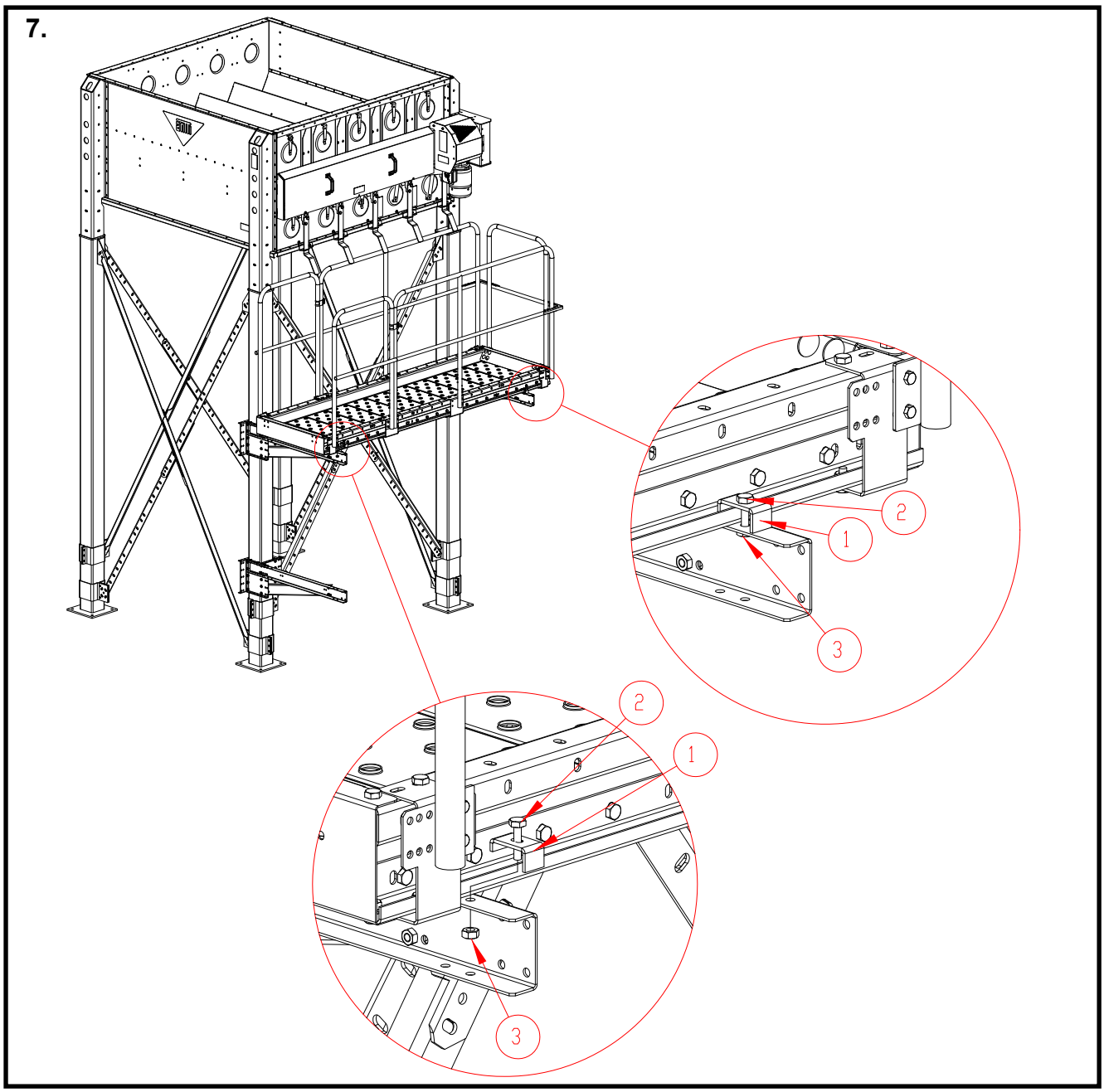
Assemble the parts of the railing as shown in the drawing. Check that all the railing sections are in line. A gap of about 68mm shall be left between the railing pipes at the end and between the railing elements on the long side.

Twine the fasteners (part 5) around the railing pipes and fasten them using M8x16 bolts.

Fix the part 4 to the railing pipes using self-tapping screws. There are holes for the self-tapping screws in the part 4. The railing pipes have no ready holes, but the screw will drill a hole for itself in the pipe. The corner support (part 4) shall be attached to the railing pipes by self-tapping screws (5 pcs). One of the corner support's attachment holes will be left unused.

To avoid making excess holes in the railing pipes, do not fix the parts 4 by self-tapping screws until you have first ensured that all the parts have been installed correctly in their right places.

NOTE! Parts 1 and 3 are mirror images.



Installing the service platform on the bearers 2W

Put the ready-assembled service platform onto its bearers.
See the detail drawings for the correct position of the platform with respect to the crossbar bearers.

Fix the service platform to the bearers using clamps (400282), nuts and bolts (M10x40).
Fix the shorter end of the clamp on top of the Z-beam of the service platform.
Fix the service platform at four points (at every corner), see detail drawings.

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

Installing the service platform ladder

Install the ladder as shown in the drawings (see pages 52-53).

Attach all the joints according to the drawings; it pays to choose the work order case-by-case, taking into account the installation conditions. It is possible to the assemble the ladder and the guard-arc parts ready on the ground, and only after that, attach the assembly to the service platform. It is also possible to fix parts of the ladder to the service platform and to the lower crossbar bearer in smaller sub-assemblies.

Attach the upper fasteners of the ladder element (parts 2) and the upper exit rails beforehand under the uppermost rung of the ladder element, before attaching the ladder to the service platform.

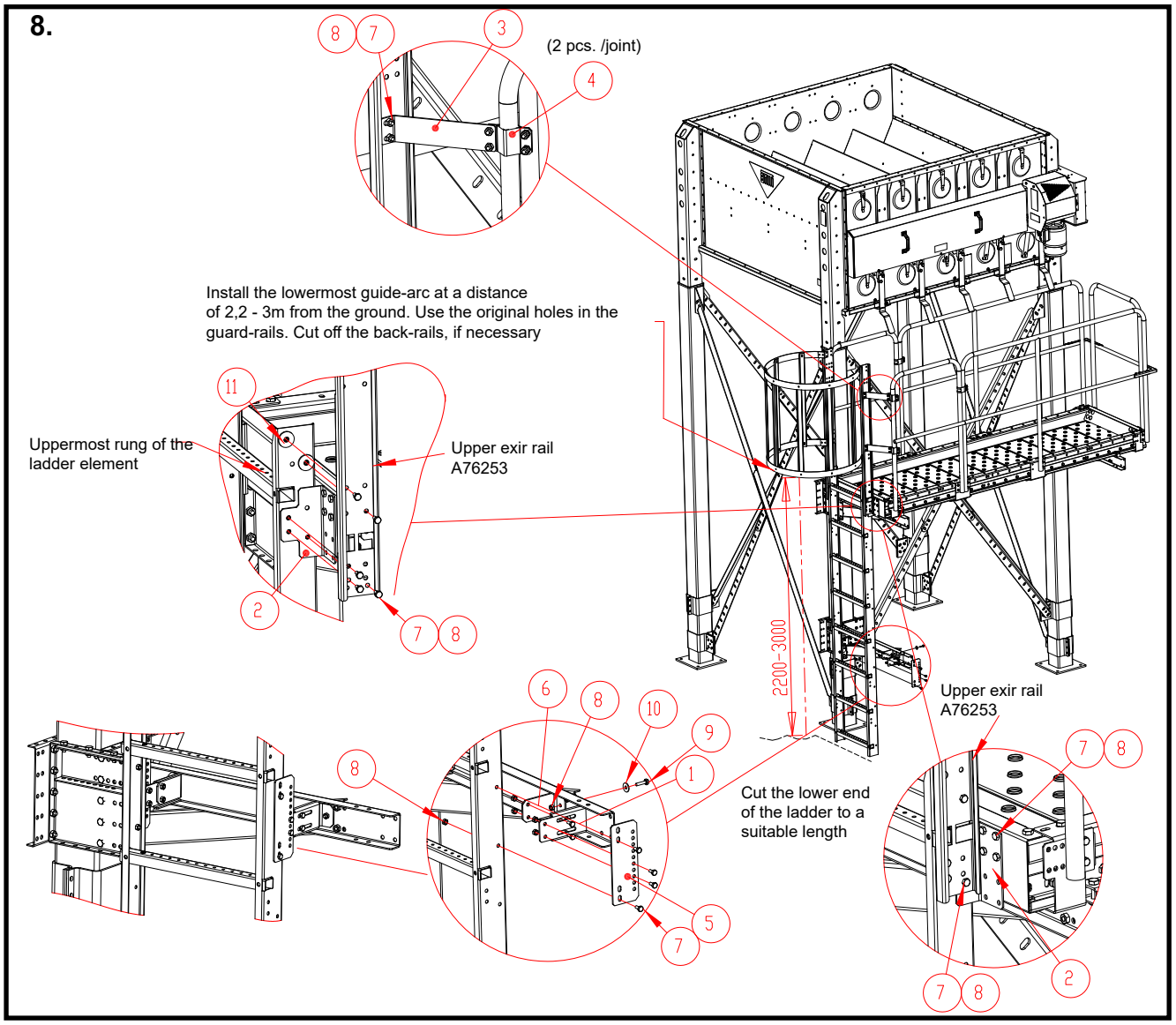
Attachment using M8x16 bolts. Also put two fender washers (part 11) in the joint between the upper exit rail and the ladder element. See detail drawing. Install the fastener and the upper exit rail on the other side of the ladder element as shown in the detail drawing.

The bolt attachment of the ladder fasteners (part 2) to the platform can be done through the large installation holes in the end beam of the platform, using a socket wrench with an extension shaft (see detail drawing).

Cut off the lower end of the ladder element at a suitable length.

The lower end of the ladder element must be at a height of at least about 35mm from the floor level. this is particularly important, if the dryer machinery is equipped with scale sensors.

Installing the ladder on the service platform of 2W



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

( ) Parts in the basic package for the service platform A76243P

* Parts in the ladder package A76251

Assembly of the ladder; overview

9.