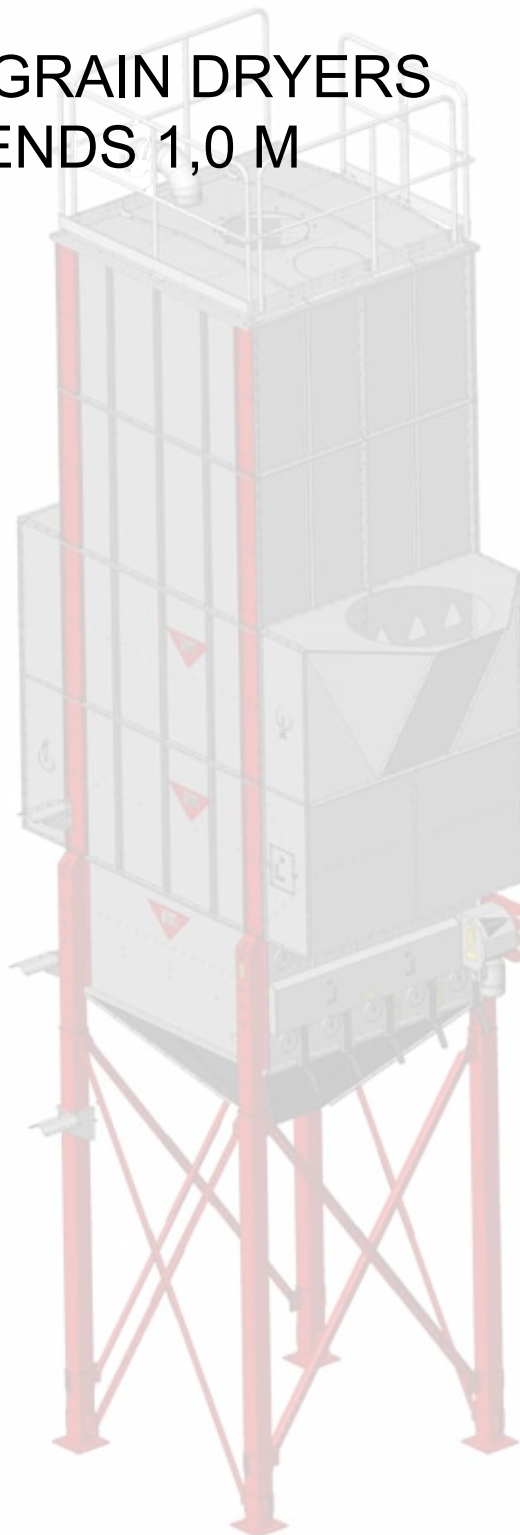


## Assembly Instructions

### ANTTI M06 2W GRAIN DRYERS AIR CHANNEL ENDS 1,0 M

408075 (en) 02-2022



*You'll see the difference*





Contents

Duct row shutters 2W (A70987) ..... 9  
Air pipe connectors Ø 1250 mm, 1000 mm, Ø 800 mm, Ø 630 mm ..... 12  
Assembling the air channel end ..... 13  
Air channel end 1,0 2W (A70813) - bottom shutter B..... 14  
Air channel end 1,0 2W (A70814) - channel shutter B ..... 22  
Air channel end 1,0 2W (A70879) - adjustment plates ..... 30  
Air channel end 1,0 2W (A70958) - upper shutter B..... 34  
Air channel end 1,0 2W (A70982) - spark net ..... 36  
Air channel end 1,0 2W (A71014) - return end B ..... 38  
Air channel end 1,0 2W (A70826) - centre-part B ..... 42  
Air channel end 1,0 2W (A71017) - intermediate part ..... 44  
Air channel end 1,0 2W (A71208) - centre-part S, Ø 1000 mm..... 46  
Air channel end 1.0 2W (A71220) - lower part / upper part DGL, Ø 1250 / 1000 mm..... 48  
Air channel end 1.0 2W (A73407) - lower part / upper part DGL, 2 x Ø 800 mm ..... 54  
Air channel end 1,0 (A76264) - fan mounting parts ..... 60  
Air channel end 1,0 2W (A70913) - lower shutter B ..... 62  
Air channel end 1,0 x 2 2W (A71015) - upper shutter B..... 64  
Air channel end 1,0 2W (A71332) - air channel extension ..... 66  
Air channel end 1,0 2W (A71376) - radiation shields ..... 68  
Air channel end 1,0 2W (A71393) - channel S, octagonal / Ø 1250 mm..... 78  
Air channel end 1,0 2W (A71402) - centre-part S, octagonal / Ø 1250 mm ..... 86  
Air channel end 2W / 3W / 4W (A71090) - centre-part L, ø 1250 / 1000 mm..... 92  
Air channel end 1,0 x 2 x 2 (A71245) - side opening, Ø 1250 mm / Ø 1000 mm ..... 96  
Air channel end 1,0 (A71560) - replacement air opening in the return bottom..... 98  
Air channel end 1,0 (A71562) - replacement air opening in the shutter-plate ..... 98  
Air channel end 1,0 (A71386), manhole hatch - sideplate ..... 101  
Air channel end (A71406), manhole hatch - end-plate..... 101  
Rain roof (A72231, A72232) for the 1,0 m air channel end of 2W..... 102  
Air channel end 0,5-1,0 2W (A75959) - diagon ..... 114  
Air channel end diagonal roof 2W (A75589) ..... 116  
Air channel end telescope 2W (A76734) ..... 118

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).

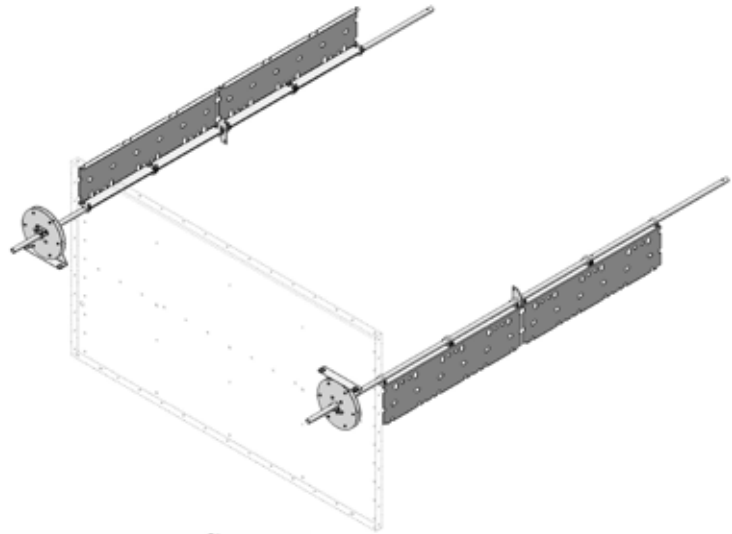
Usually the specifications include the adapter parts D1000, except the specifications 8/D1250 to be installed at the top, which are A71402 for the 2W model, A71403 for the 3W model A71404 for the 4W model.

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.



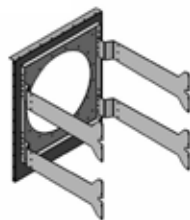
## Optional air channel ends 2W 1,0

Duct row shutters A70987

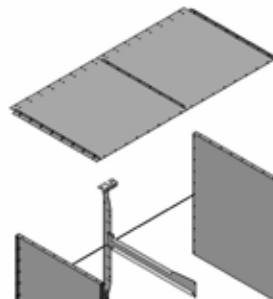


## Air channel ends

A76264 - fan mounting parts

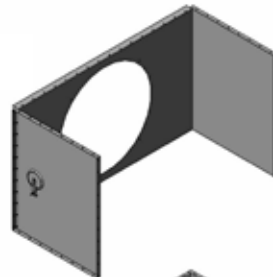


A70958- upper shutter B

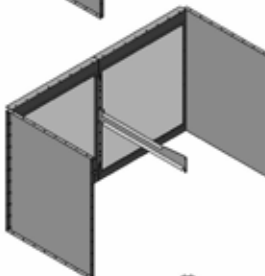


A71017 - intermediate part

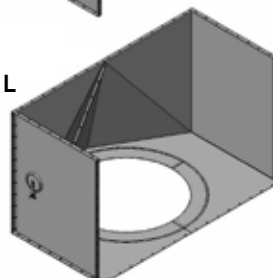
A71208 - centre-part S  
Ø 1000 mm



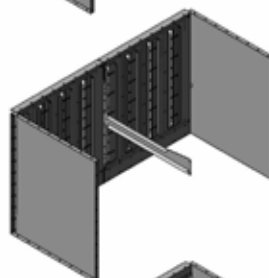
A70982 - spark net



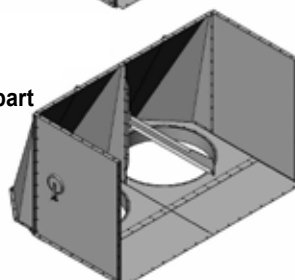
A71220 - lower part / upper part L  
Ø 1250 / 1000 mm



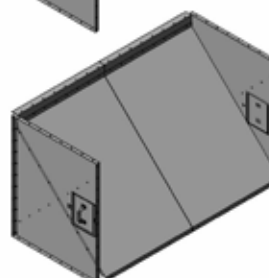
A70879 - adjustment plates



A73407 - lower part / upper part  
DGL  
2 x Ø 800 mm



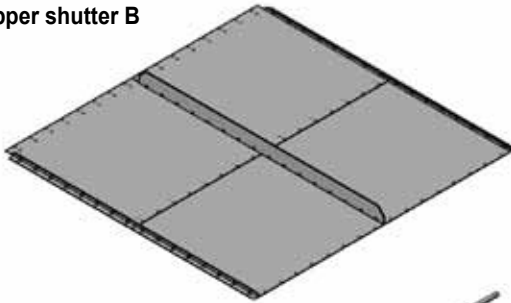
A71014 - return end B



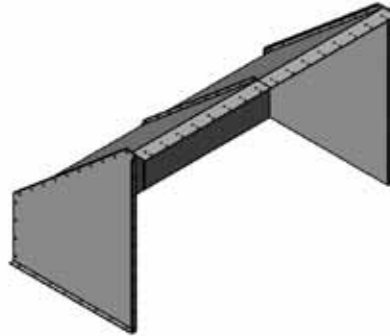


## Air channel ends

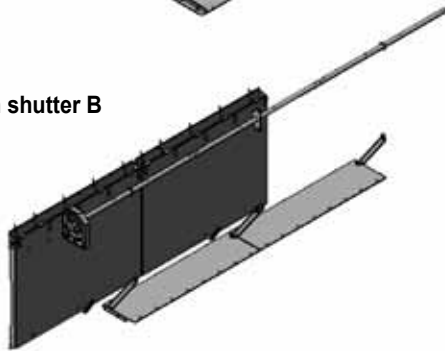
A71015 - upper shutter B



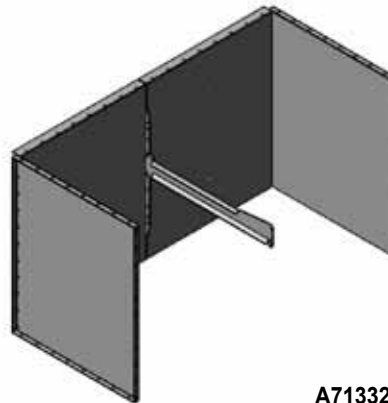
A75589 - diagonal roof B



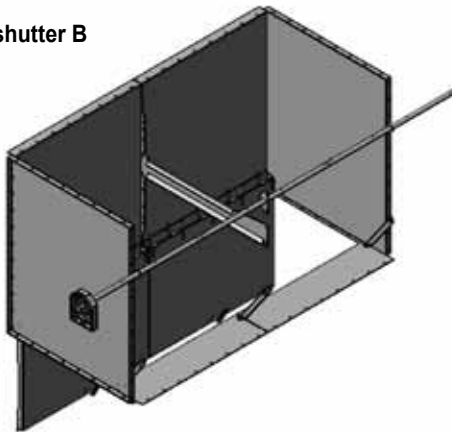
A70813 - bottom shutter B



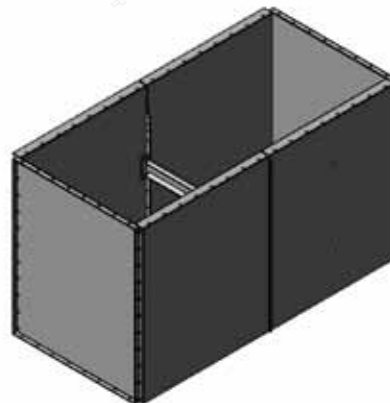
A70826 - centre-part B



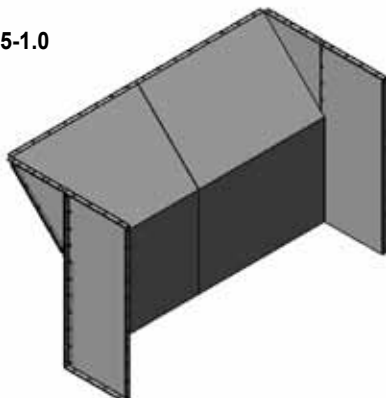
A70814 - channel shutter B



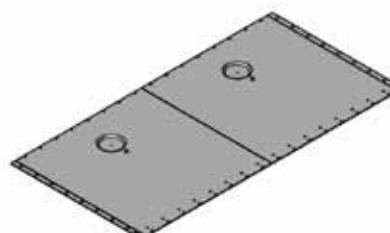
A71332 - air channel extension



A75959 - diagon 0.5-1.0



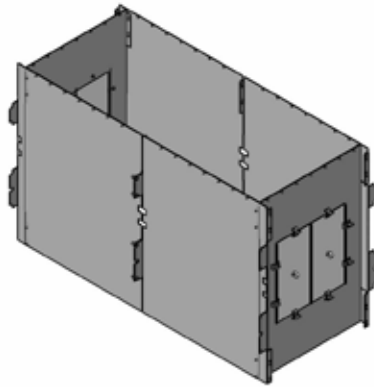
A70913 - lower shutter B



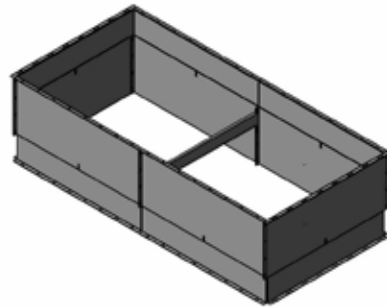


## Air channel ends

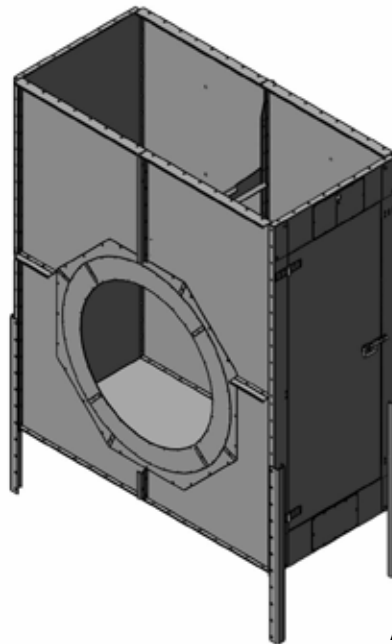
A71376 - radiation shields



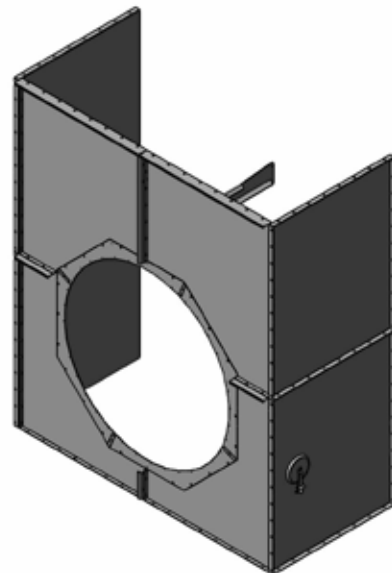
A76734 - telescope S



A71393 - channel S  
Octagonal / Ø 1250 mm



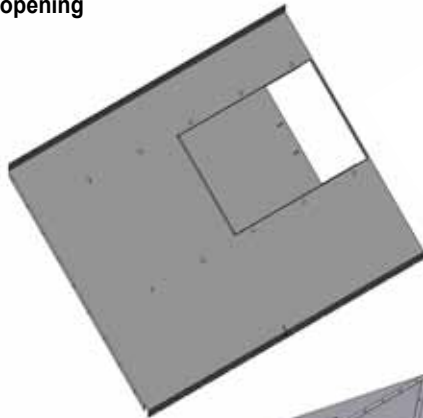
A71402 - centre-part S, octagonal / Ø 1250 mm



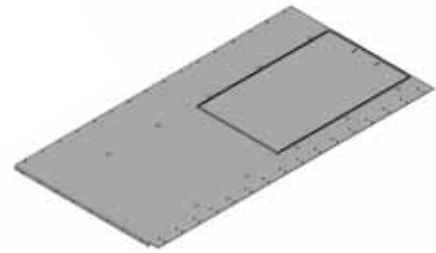


## Air channel ends A71090, A71245, A71560, A71562, manhole hatches A71386, A71406

A71560 - return bottom replacement air opening

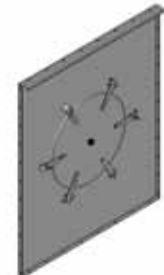
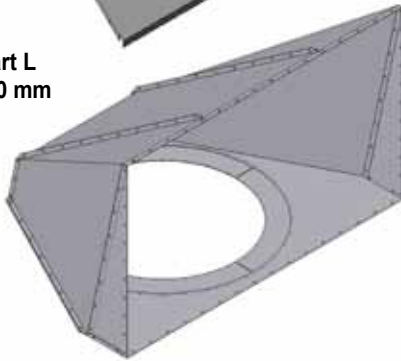


A71562 - shutter-plate replacement air opening



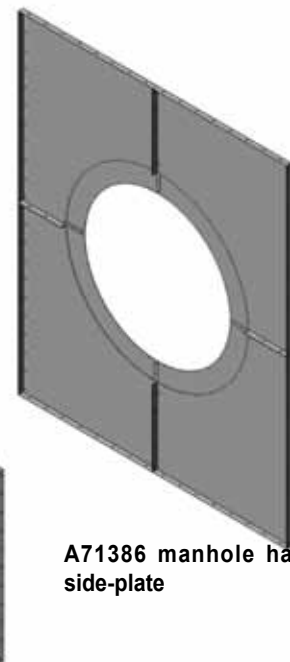
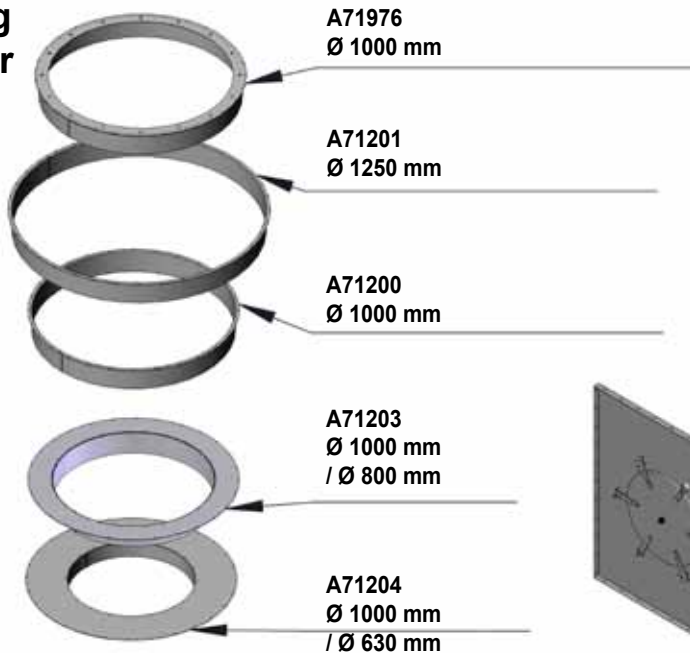
A71406 manhole hatch - end-plate

A71090 - centre-part L  
Ø 1250 mm / Ø 1000 mm



A71245 - side opening  
Ø 1250 mm / Ø 1000 mm

### Connecting parts for air pipe



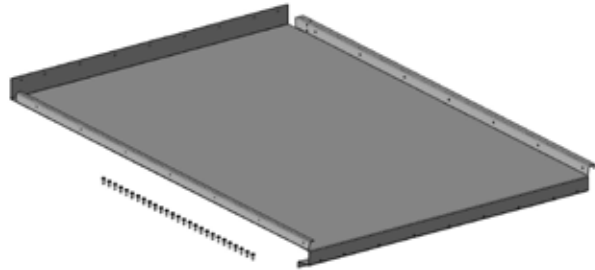
A71386 manhole hatch - side-plate



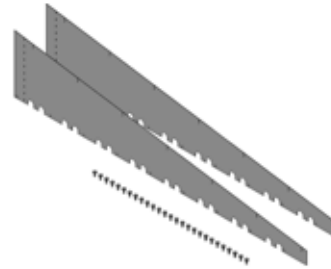
## Optional equipment for 2W 1,0

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

A72231 - air channel end, slanting roof  
2W: 2 pcs. of plates with bolts / 1,0 m air channel end

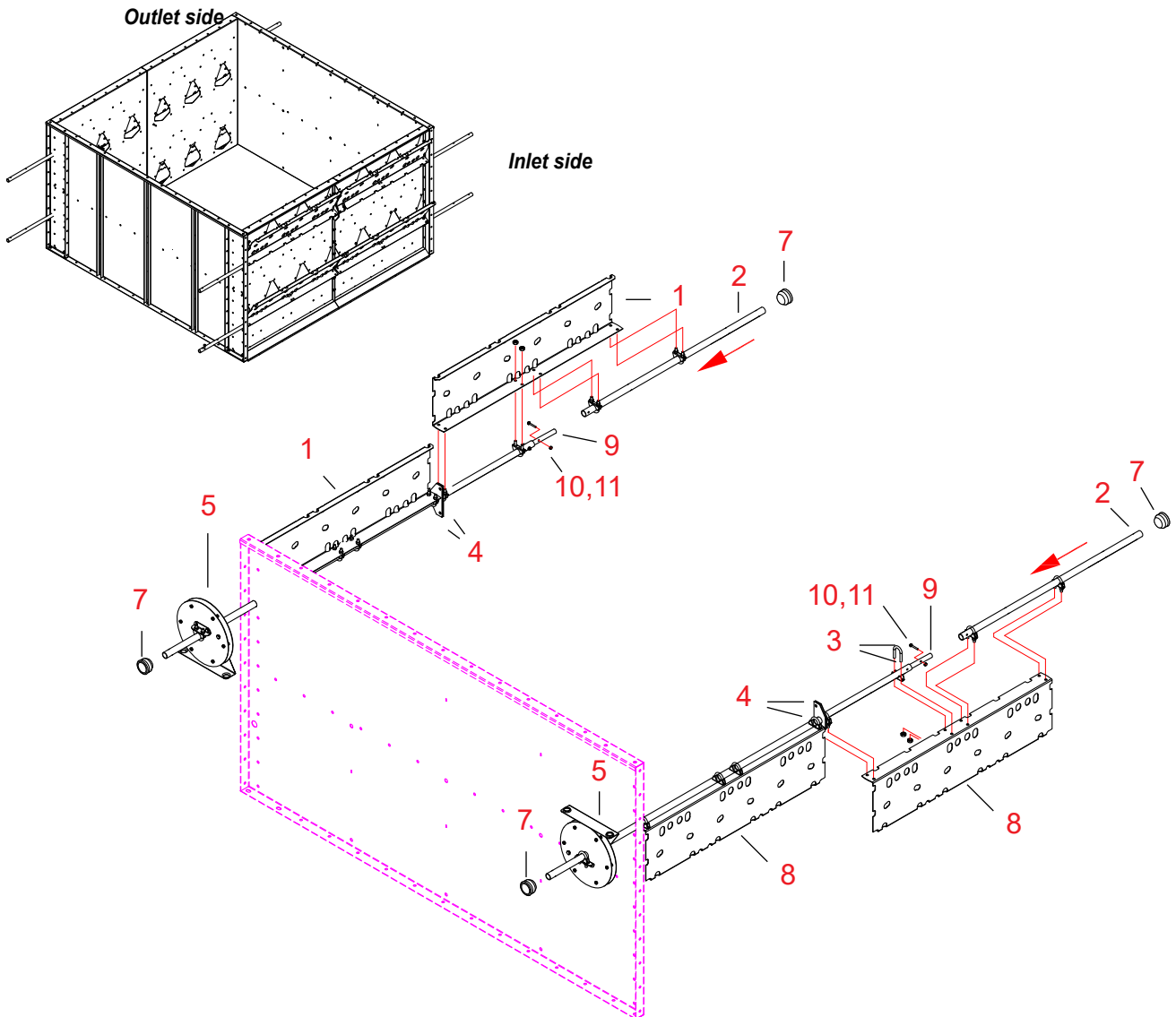


A72232 - air channel end, slanting roof - end cover  
2W: 1 pc. (2 ends with bolts) / 1,0 m air channel end





## Duct row shutters 2W (A70987) Spare parts

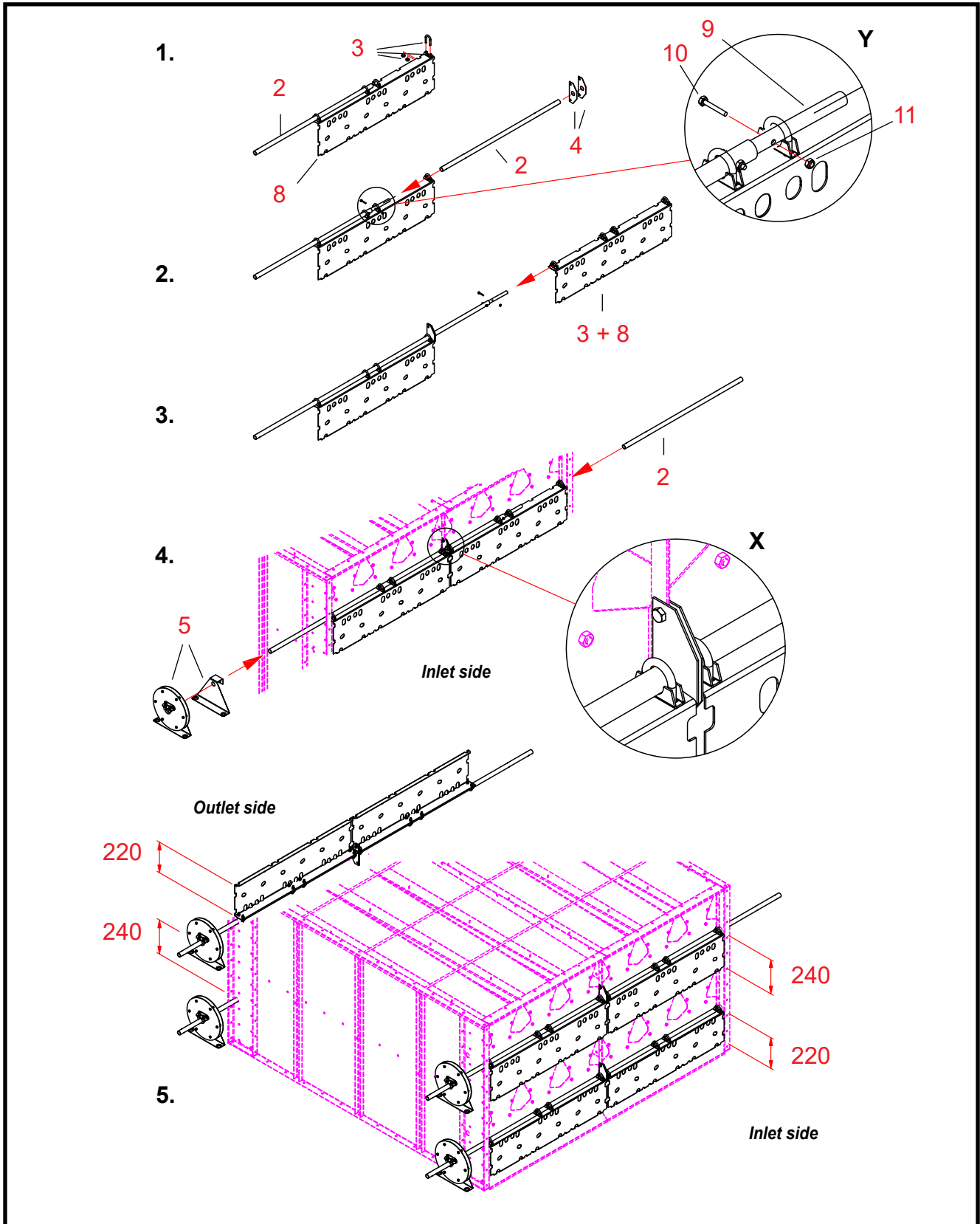


20061123

| Ref. | Part no. | Denomination 1        | Denomination 2           | Pcs. | Weight |
|------|----------|-----------------------|--------------------------|------|--------|
| 1    | A71283   | SECTION WM06 SHUTTER  | DUCT ROW PL H=220        | 2    | 4.48   |
| 2    | A70548   | SECTION WM06 SHUTTER  | D25-958 PIPE             | 6    | 42.34  |
| 3    | 107930   | U-BOLT FLUE PIPE BAND | M8 D=25 1883-25          | 16   | 0      |
| 4    | A70551   | SECTION WM06 SHUTTER  | GUIDE-LUG                | 4    | 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        | 2    | 4.48   |
| 9    | A70733   | SECTION SHUTTER       | EXTENSION PIPE D17,2-300 | 4    | 0,26   |
| 10   | 101520   | BOLT HEX ZN 8.8       | 6X35 AM DIN933           | 8    | 0      |
| 11   | 110789   | NUT NYLOC             | 6 ZN DIN985              | 8    | 0      |



## Installing the duct row shutters (A70987)





*Two sets of parts A70987 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 A70987 for the air channel end.

Fig. 1.

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

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

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

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

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 Y)

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** Thread another shutter-plate with 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.

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

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

Thread in the third 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.

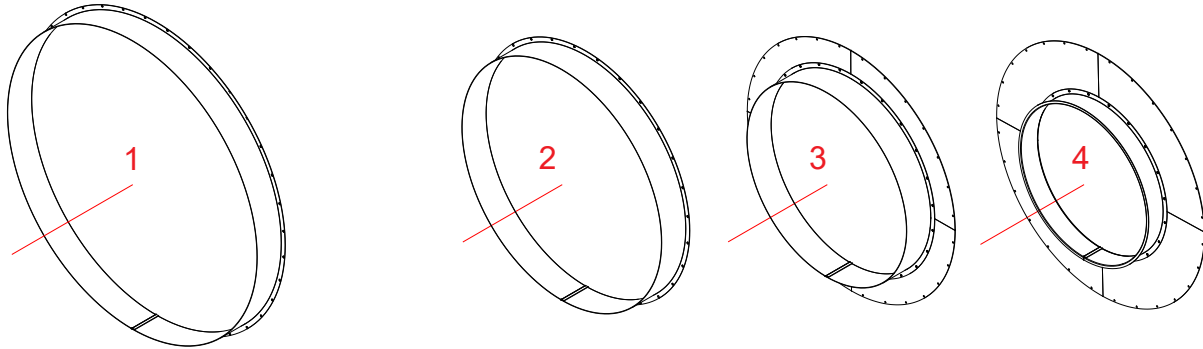
**2. Installing the shutter-plates on the outlet side (in both, or sometimes, in only one of the duct rows)**

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

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

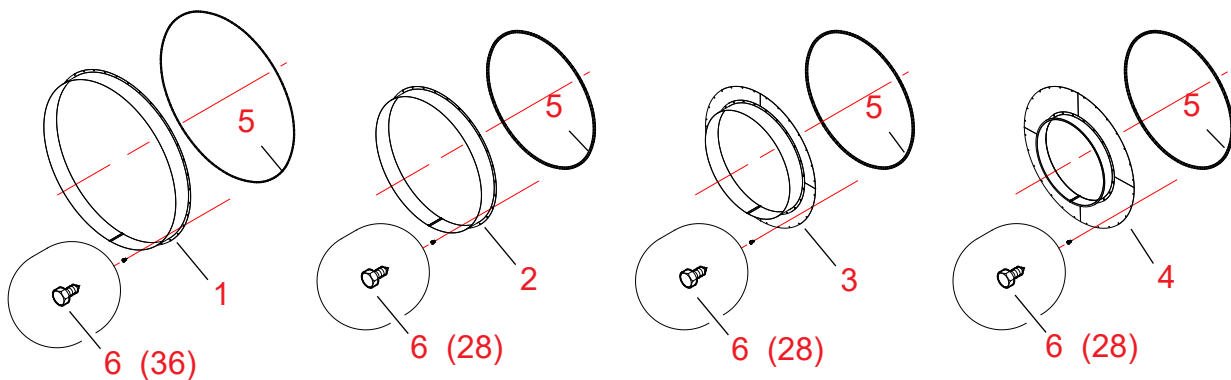


## Air pipe connectors Ø 1250 mm, 1000 mm, Ø 800 mm, Ø 630 mm



20061019

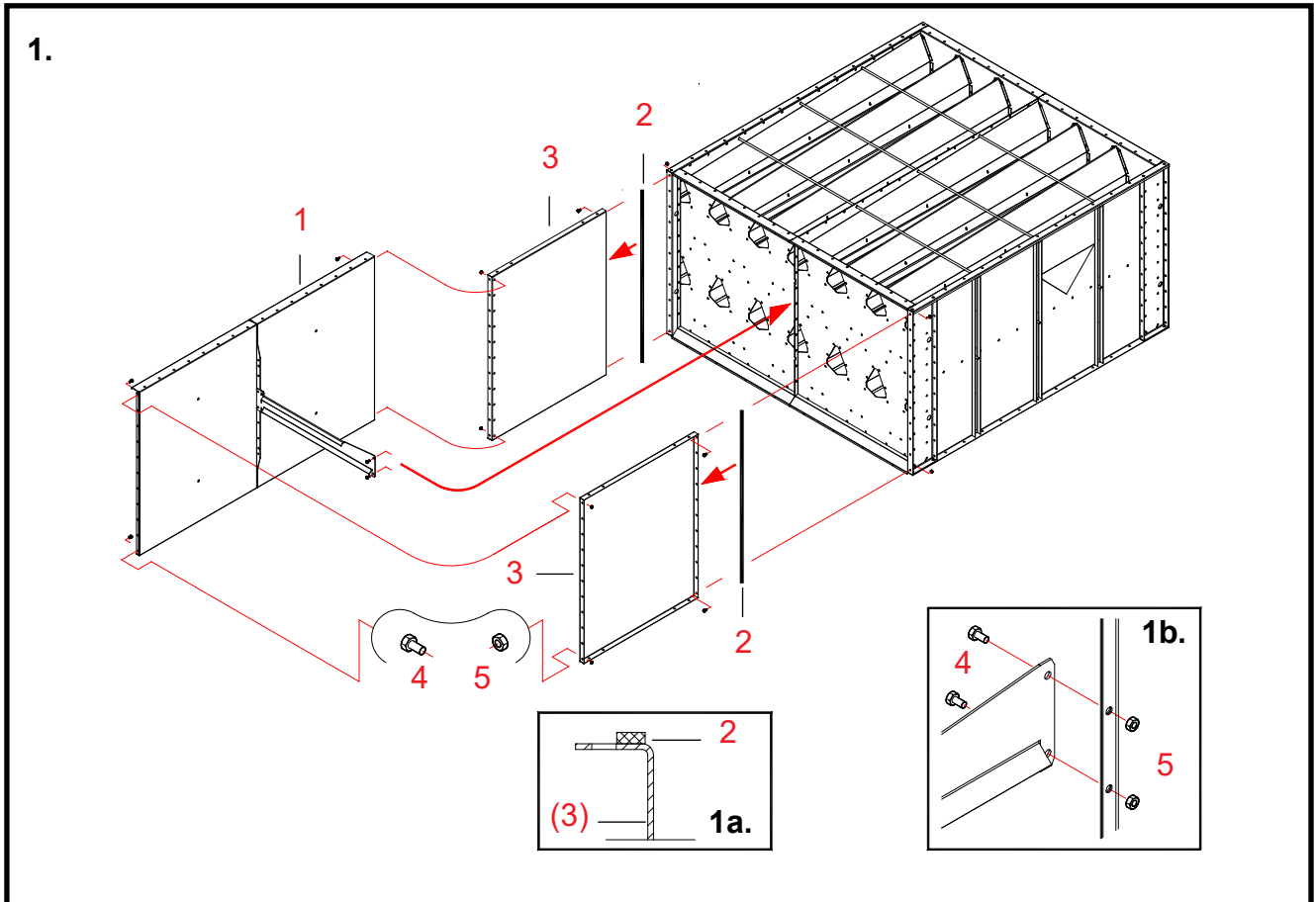
| Ref. | Part no. | Denomination 1  | Denomination 2       | Pcs. | Drawing No. | Weight | Group |
|------|----------|-----------------|----------------------|------|-------------|--------|-------|
| 1    | A71201   | AIR PIPE SLEEVE | D1250X120            | 1    | A71201      | 6.48   | 3500  |
| 2    | A71200   | AIR PIPE SLEEVE | D1000X120            | 1    | A71200      | 5.18   | 3500  |
| 3    | A71203   | AIR PIPE WM06   | CONV PART D1000/D800 | 1    | A71203      | 9.40   | 3000  |
| 4    | 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 / 4 Select the pipe connector in accordance with the size of the air pipe system.  
(1250 mm / 1000 mm / 800 mm / 630 mm)
- 5 Fix a sealing strip to the air pipe connector flange.  
Fix the sealing strip inside the screw hole row in the connector flange.
- 6 Fix the connector to the air channel end using self-tapping screws (4,8 x 13, 28 (36) pcs.).

## Assembling the air channel end



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

#### Parts

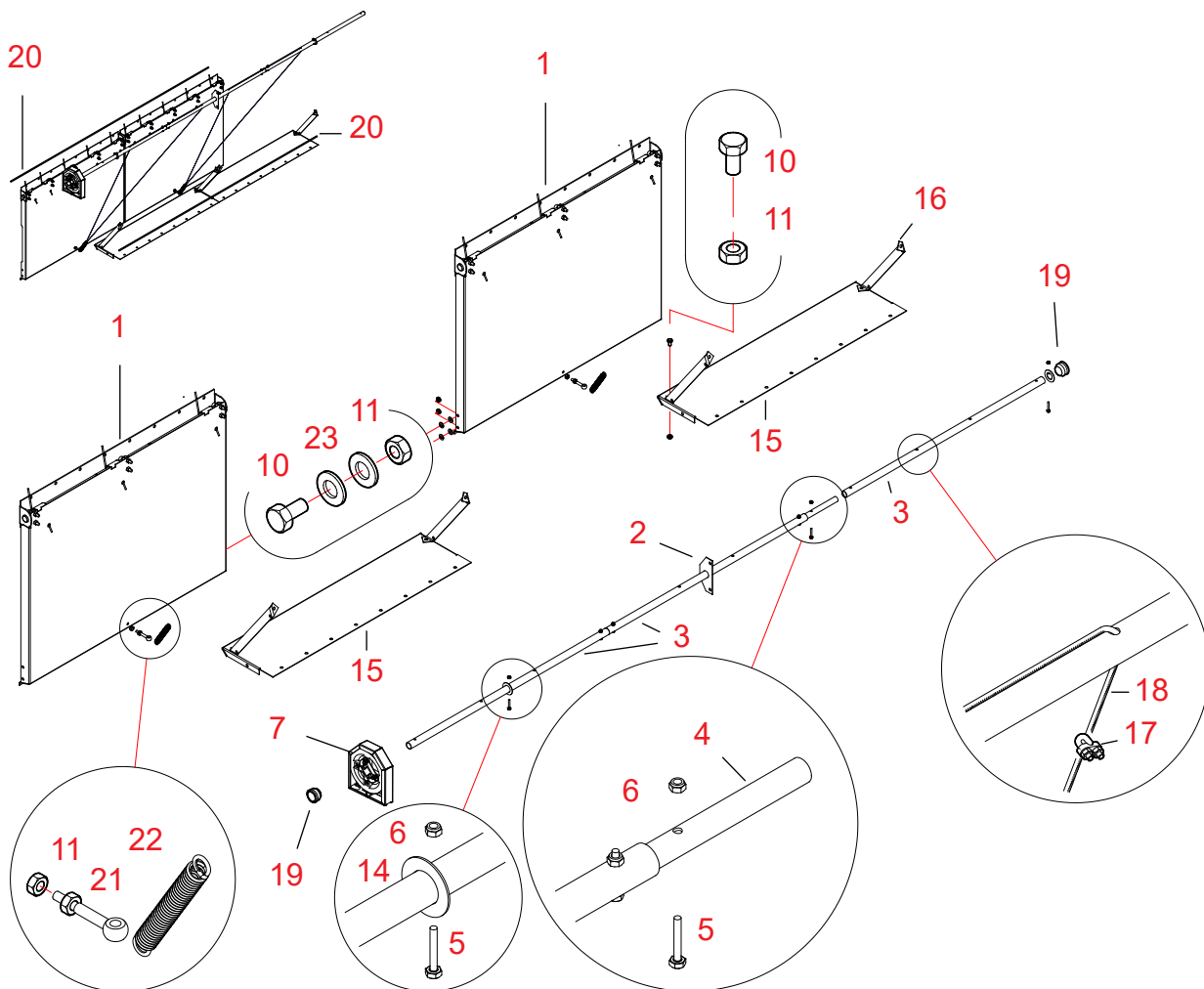
- 1 **Assemble a sub-assembly of the air channel end end-plates in accordance with separate instructions for each air channel end model.**  
If an upper or a lower shutter-plate are included in the set-up, make a separate sub-assembly of them as well.
- (4, 5) **Remove the bolts and nuts (2 pcs.) from 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 support 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 2W (A70813) - bottom shutter B

An accessory for air channel end A71329 (fan end PFS)

### Spare parts



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



20061019

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





## 1. Installing the shutter-plate set-ups in the air channel end (A71329) ready-assembled inside the section

Parts            The numbering of work stages refers to reference numbers in the spare parts drawing A70813 for the air channel end.

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

**10, 11            Fix the shutter-plates using bolts and nuts (M 8 x 16, 16 pcs. / shutter-plate).**

**10, 11, 23        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 two counter-plates (parts 15) together.**

**10, 11            Fix the joint using bolt and nuts (M 8 x 16).**

**16                    Install the counter-plate supports (4 pcs. of parts 16) in the counter-plates in position, shown in the picture.**

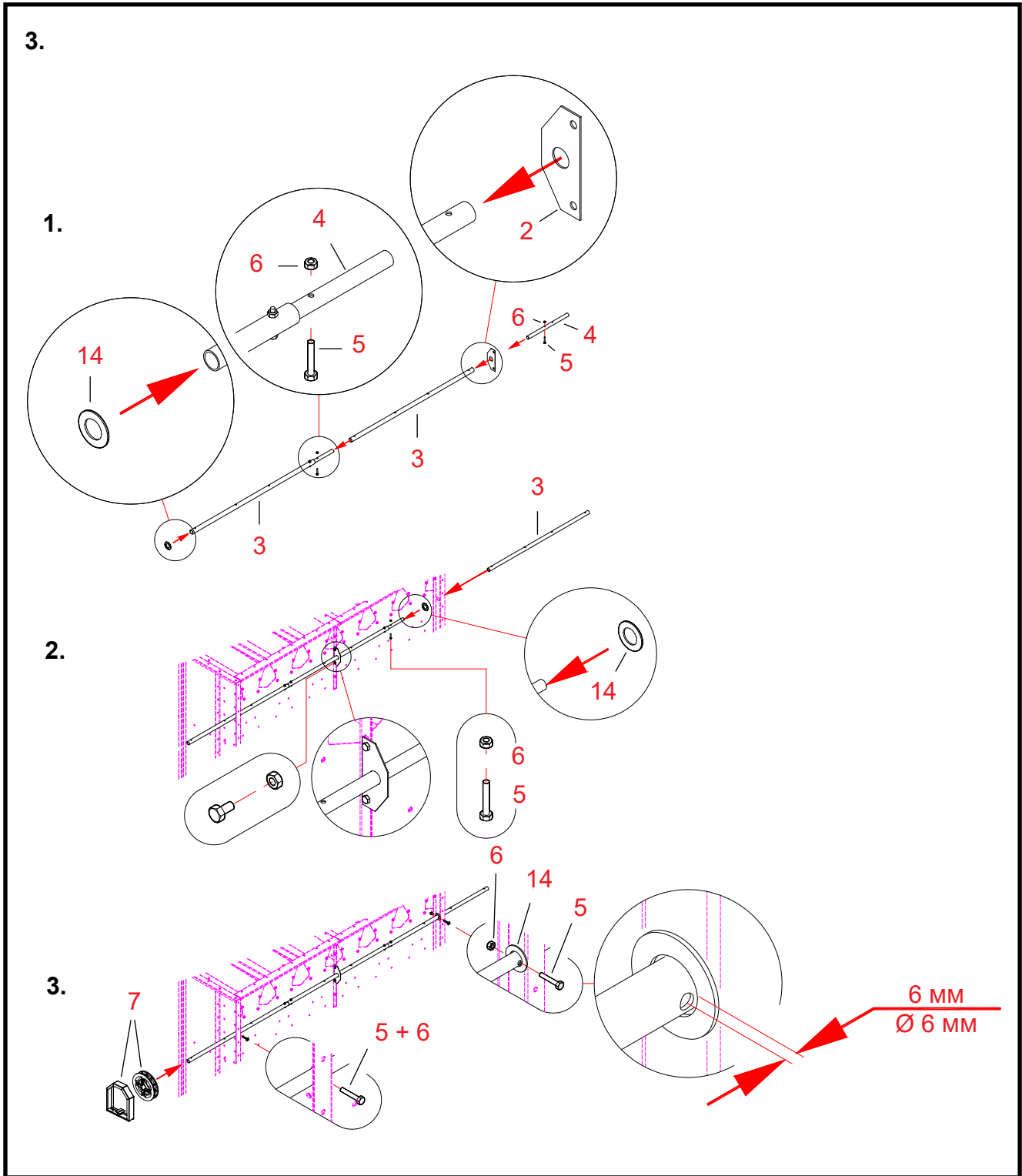
**10, 11            Fix the supports using bolt and nuts (M8 x 16, 1 pcs./support).**

**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).

**(10, 11)          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.***

**10, 11            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).**
- 14 **Thread washer (D45/25,5) onto the pipe from the opposite end of the pipe.**

Fig. 2.

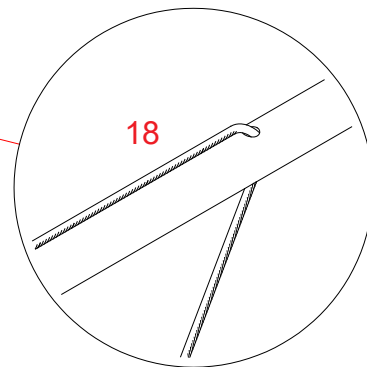
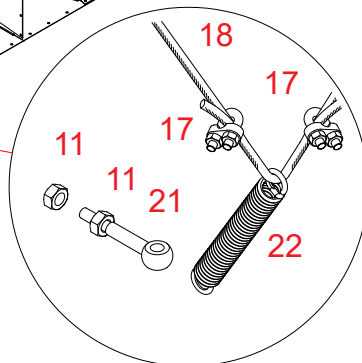
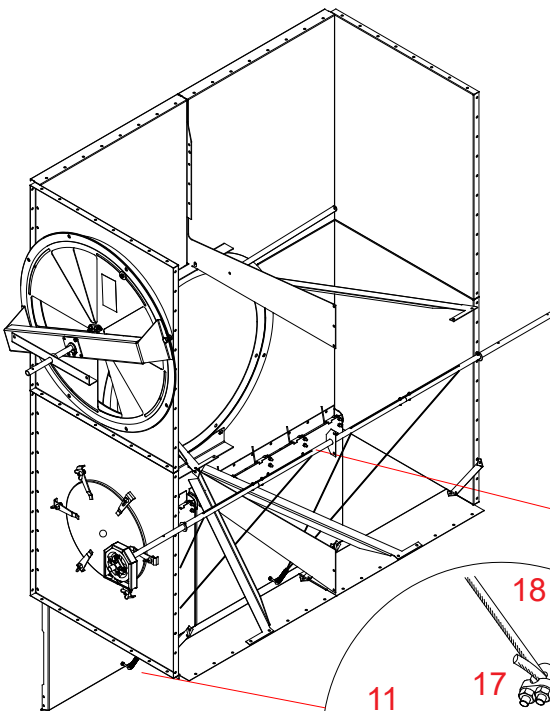
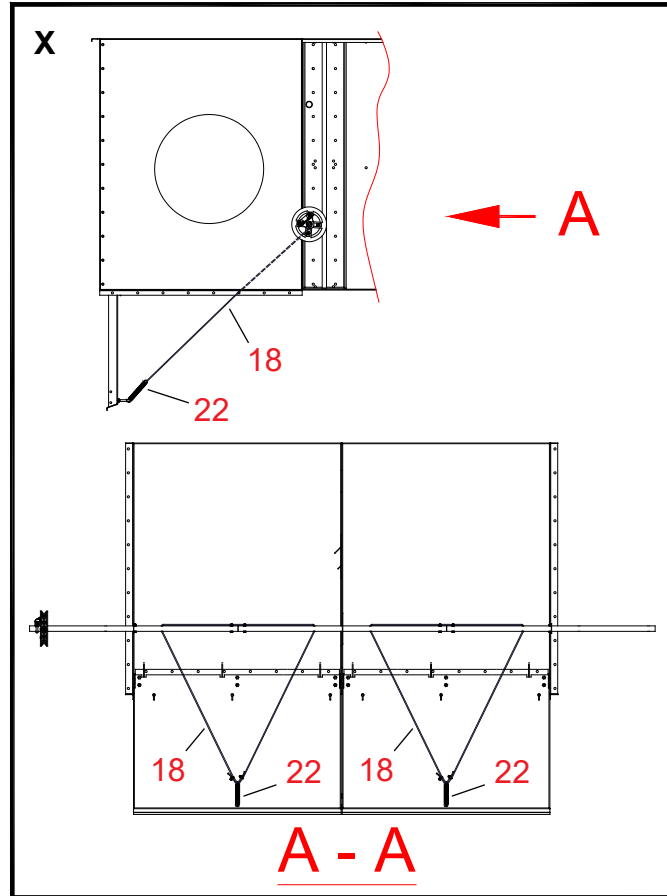
- (1) **Insert the shaft, assembled in accordance with Fig. 1, in the upper  $\varnothing$  25,5 mm holes in the section's side-plates.**  
Remove two bolts from the centre-seam of the section's end-plates at the guide-lugs.  
Place the guide-lug against the flanges of the end-plate and insert the bolts back in place.
- 14 **Thread another washer (D45/25,5) onto the shaft-pipe.**
- 3 **Push the third shaft-pipe through the side-plate and the leg of the section against the extension pipe of 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.





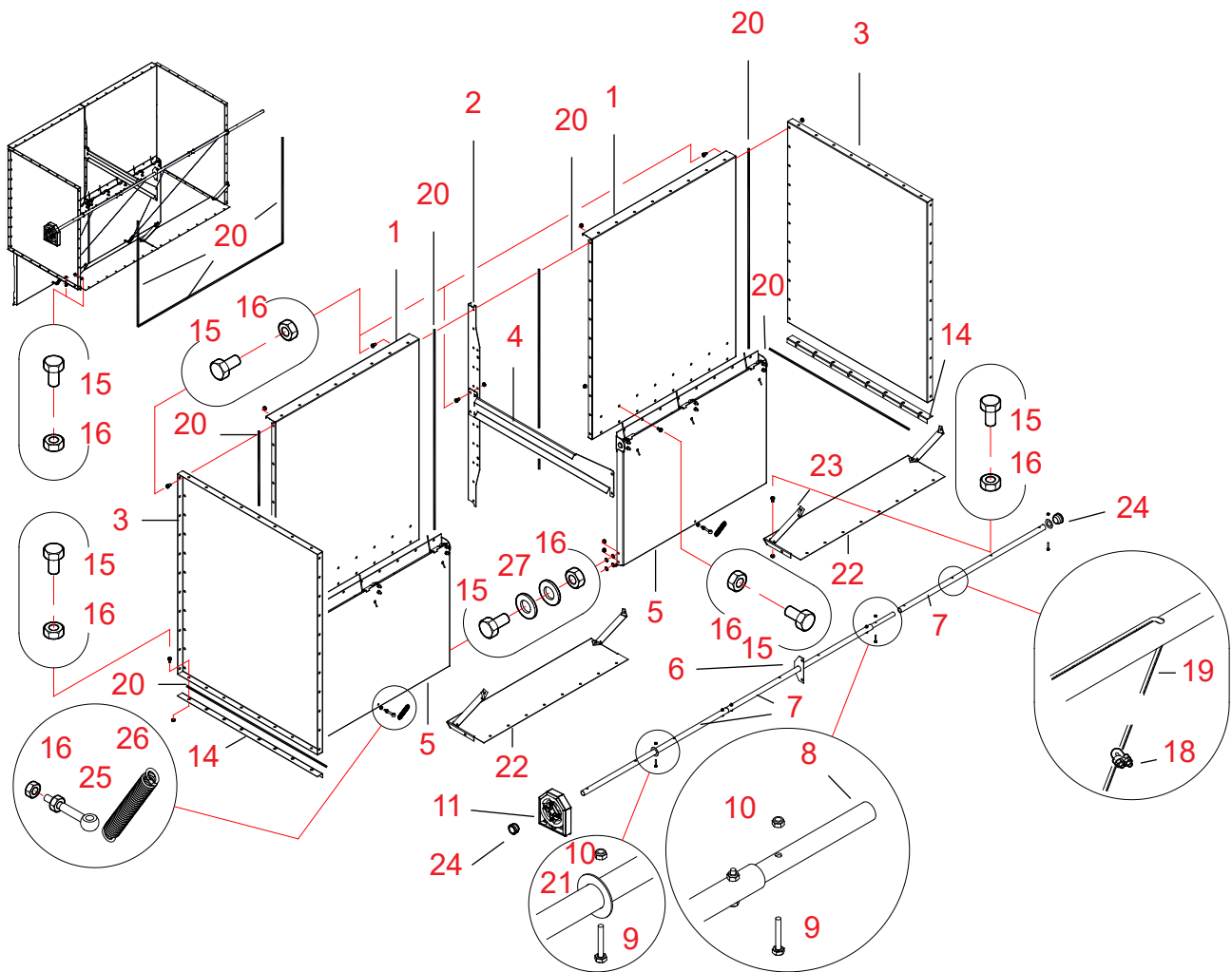
#### 4. Installing the actuator wires for the plates

- 11, 21      **Provide both shutter-plates with an eye-bolt. Fix them using two nuts (M8).**
- 22            **Thread in a draw-spring through both 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 2W (A70814) - 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 24.



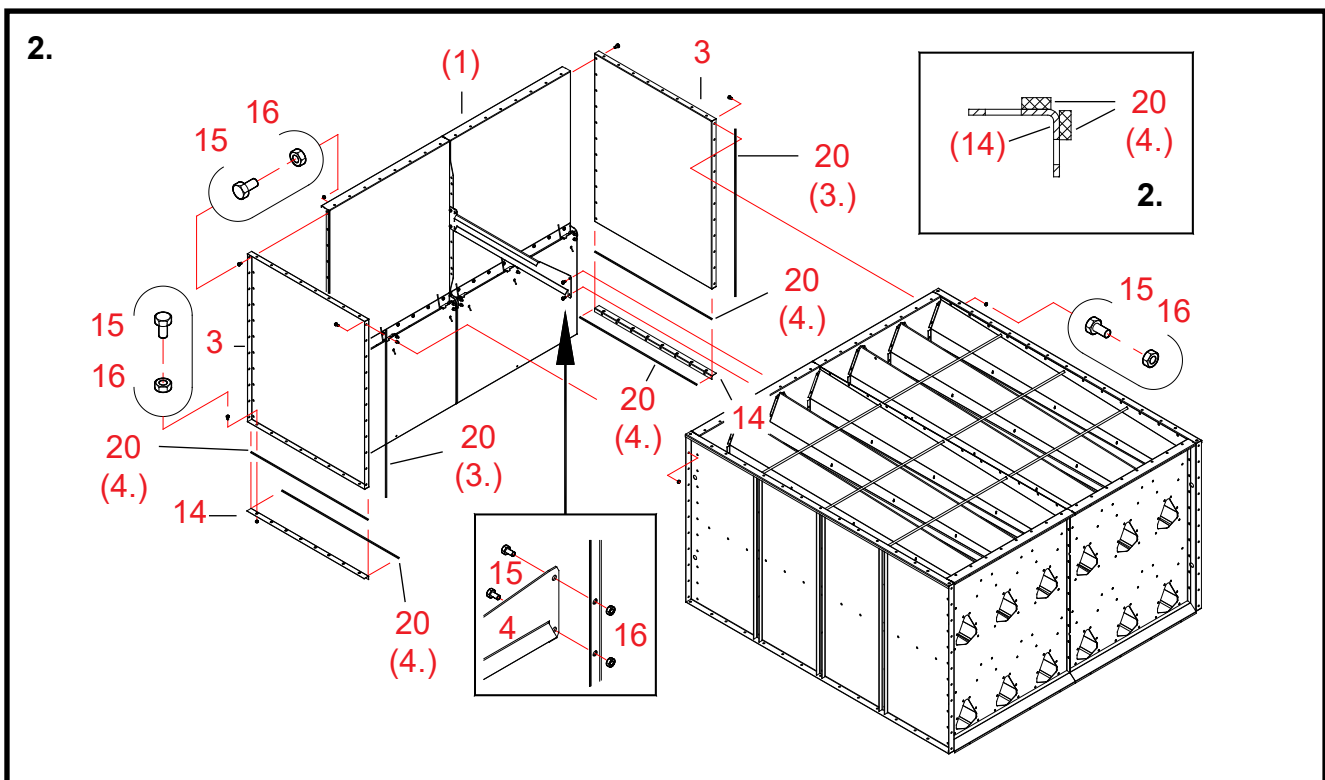
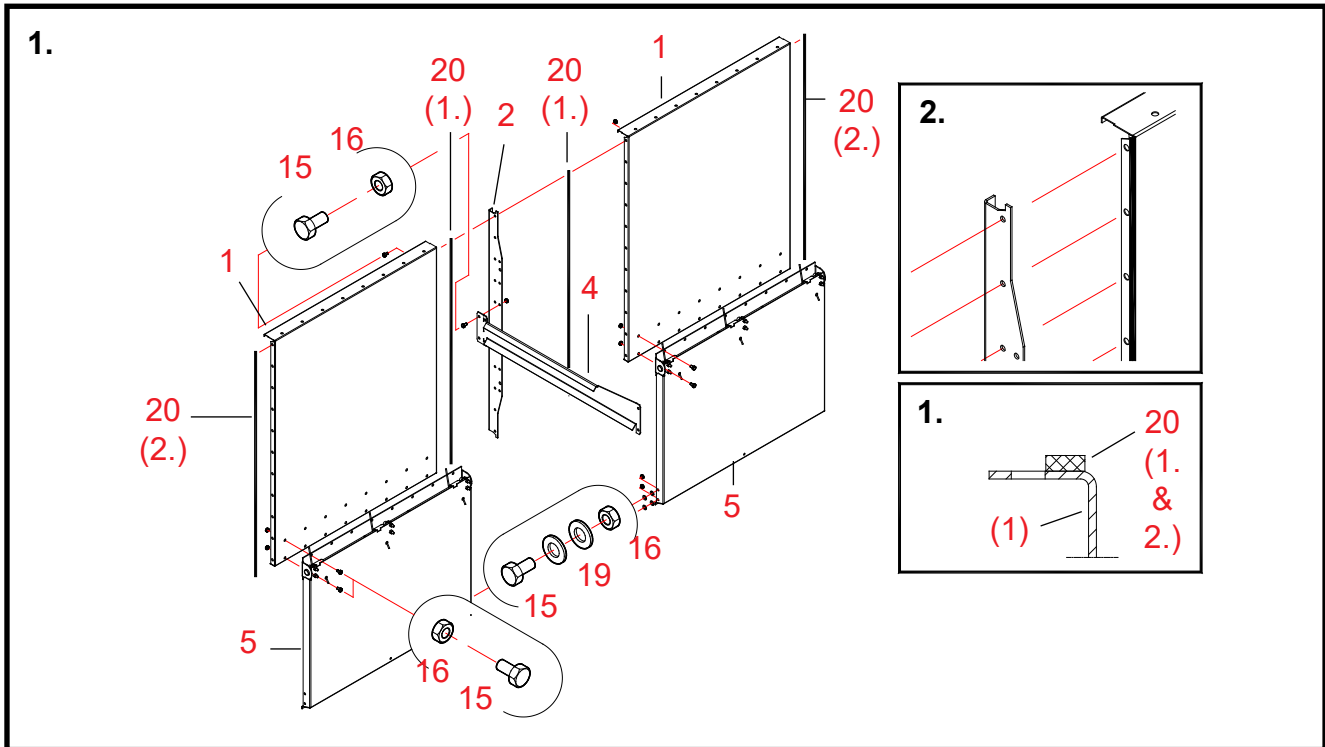
20080901

| Ref. | Part no. | Denomination 1         | Denomination 2        | Pcs. | Drawing No. | Weight | Group |
|------|----------|------------------------|-----------------------|------|-------------|--------|-------|
| 1    | A70682   | AIR CHANN END WM06     | END-PLATE W SHUTTER   | 2    | A70682      | 14.64  | 3000  |
| 2    | A70810   | TOP SECTION WM06       | VERTICAL SUPPORT PL3  | 1    | 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      | 1    | A70678-B    | 1.79   | 3000  |
| 5    | A70668   | AIR CHANN END WM06     | TURN SHUTT PL 1M ASSY | 2    | A70668      | 15.08  | 3000  |
| 6    | A70551   | SECTION WM06 SHUTTER   | GUIDE-LUG             | 1    | A70551      | 42.34  | 3000  |
| 7    | A70548   | SECTION WM06 SHUTTER   | D25-958 PIPE          | 3    | A70548-C    | 42.34  | 3000  |
| 8    | A70733   | SECTION WM06 SHUTTER   | D19-300 EXTENS PIPE   | 2    | A70733      | 0.25   | 3000  |
| 9    | 101520   | HEX BOLT ZN 8.8        | 6X35 AM DIN933        | 6    |             | 0      | 2010  |
| 10   | 110789   | NUT NYLOC ZN           | M 6DIN985             | 6    |             | 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  |
| 15   | 101810   | HEX BOLT ZN 8.8        | 8X16 AM DIN933        | 110  |             | 0      | 2010  |
| 16   | 110540   | NUT ZN 8 M 8           | DIN934                | 114  |             | 0      | 2010  |
| 18   | 114055   | WIRE-LOCK              | D 5                   | 4    |             | 0      | 2900  |
| 19   | 114067   | WIRE-ROPE              | D3/D5 MM PLAST P      | 8    |             | 0      | 2900  |
| 20   | 115570   | SEALING STRIP          | 4X10 MAPA             | 24   |             | 0      | 2600  |
| 21   | 400344   | WASHER AISI            | PL1,5 D45/25,5        | 2    | 21175.4     | 0      | 4500  |
| 22   | A71156   | AIR CHANN END WM06     | COUNT PL FOR HATCH    | 2    | A71156      | 15.08  | 3000  |
| 23   | A71157   | AIR CHANN END WM06     | HATCH SUPP            | 4    | A71157      | 15.08  | 3000  |
| 24   | 116065   | PLASTIC PLUG           | DBI 42                | 2    |             | 0      | 2600  |
| 25   | 107821   | EYE-BOLT               | M8X60                 | 2    |             | 0      | 2000  |
| 26   | 120014   | DRAW-SPRING            | 3,0X17 140            | 2    | 41529       | 0      | 2900  |
| 27   | 111550   | WASHER ZN              | M 10 DIN125           | 4    |             | 0      | 2010  |



## Assembling air channel end A70814

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

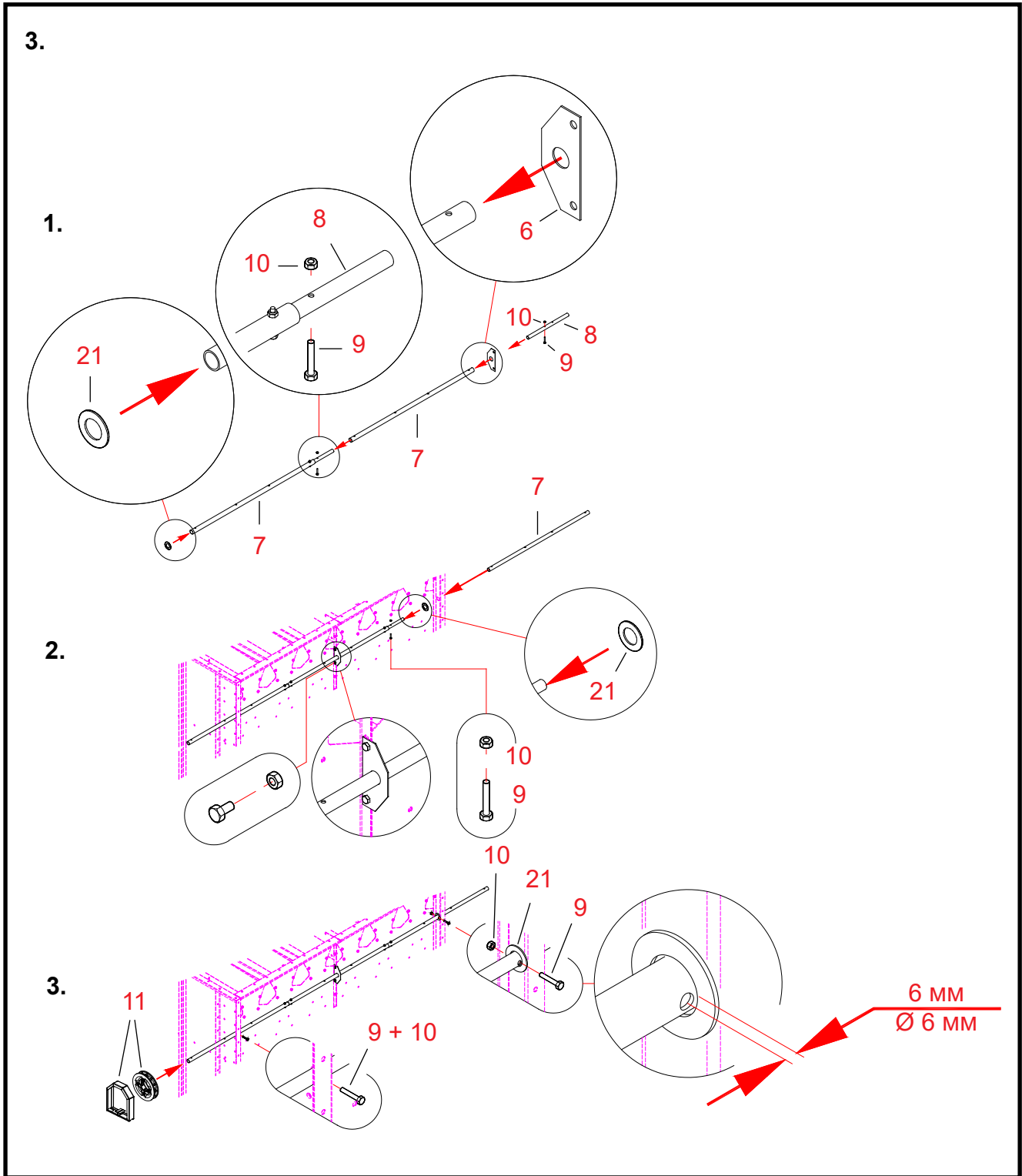
Parts The numbering of work stages refers to reference numbers in the spare parts drawing A70814 for the air channel end.

- 20 (1.)** Fix sealing strips to the flanges of the two 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 support 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.*
- 15, 16** Fix the end-plates and the vertical support 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** Install the straight air channel end support in the vertical support (part 2).  
Look up correct position for the support in the drawing.
- 15, 16** Fix the support using bolts and nuts (M8 x 16, 2 pcs.).
- 5** Attach the shutter-plate set-ups (parts 5) to the holes in the end-plate set-up.
- 15, 16** Fix the shutter-plates using bolts and nuts (M 8 x 16, 16 pcs. / shutter-plate).
- 15, 16, 19** 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.
- 20 (2.)** Fix sealing strips to the end-flanges of the end-plates (parts 1 joined together).  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).

## 2. Assembling the air channel end

- 20 (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.*
- 15, 16** 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.*
- 15, 16** Fix the set-up, assembled at stage 1, using bolts and nuts (M8 x 16, 11 + 11 pcs.).
- 15, 16** 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.

Continues on next page >>>





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

- 20 (4.) **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.**
- 15, 16 **Fix the corner-strips using bolts and nuts (M8 x 16, 4 + 4 pcs.).**

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

Fig. 1.

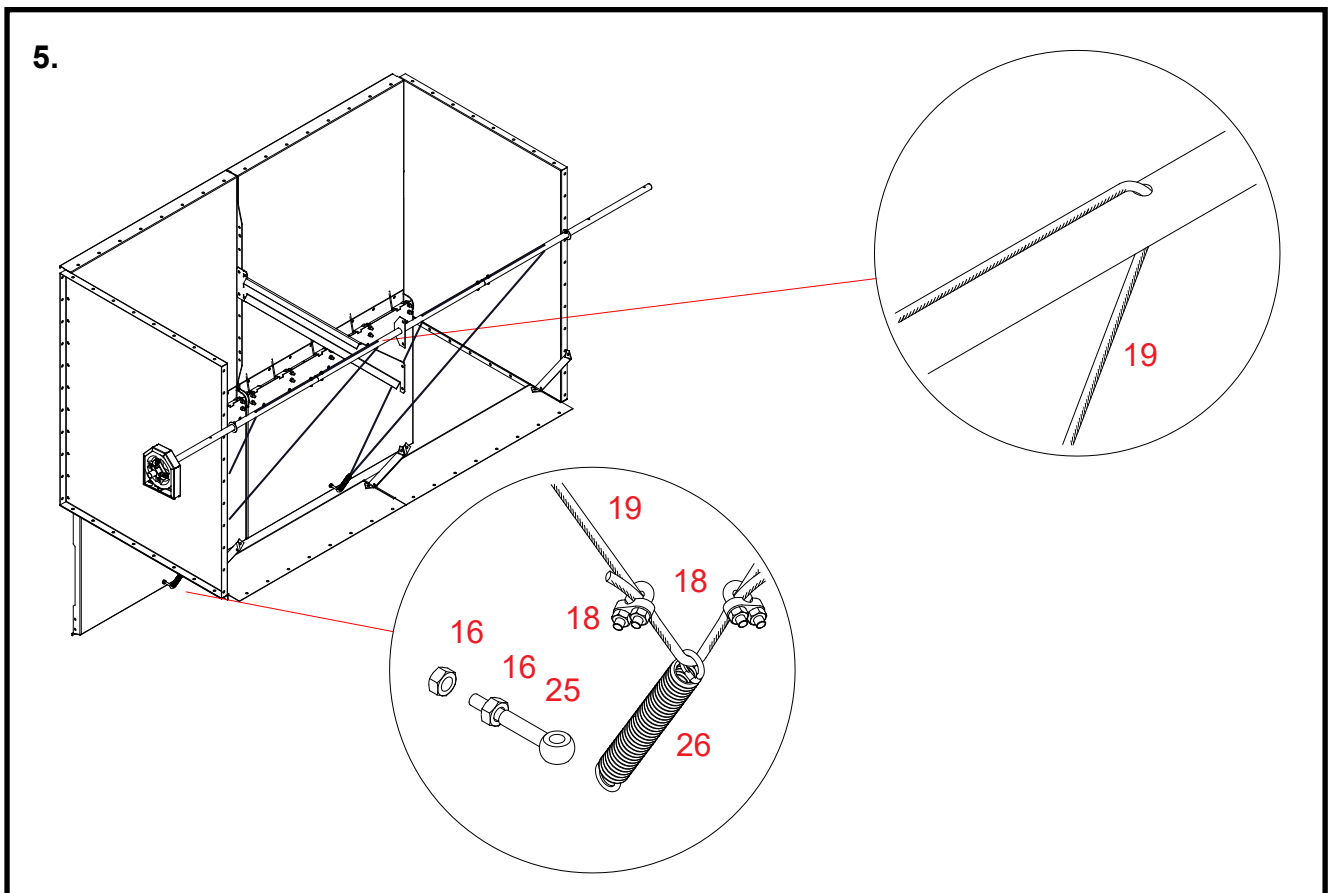
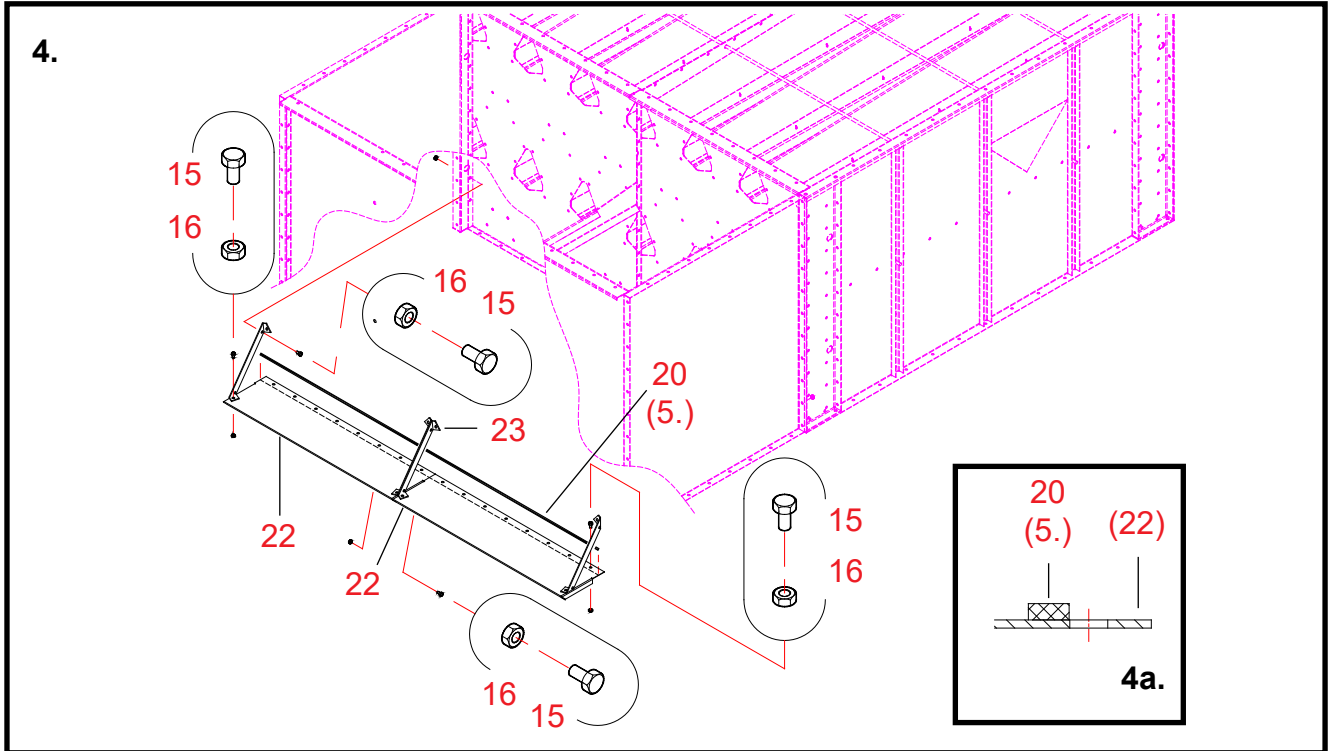
- 8 **Join together two shaft-pipes (parts 7) using the extension pipe.**
- 9, 10 **Fix the joint using two bolts and Nyloc-nuts (M 6 x 35).**
- 6 **Push the guide-lug for the shaft on the pipe.**
- 8 **Attach another extension pipe to the same end of the shaft-pipe, on which you threaded the guide-lug.**
- 9, 10 **Fix the extension pipe using bolt and Nyloc-nuts (M 6 x 35).**
- 21 **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-seam of the section's end-plates at the guide-lugs.  
Place the guide-lug against the flanges of the end-plate and insert the bolts back in place.
- 21 **Thread another washer (D45/25,5) onto the shaft-pipe.**
- 7 **Push the third shaft-pipe through the side-plate and the leg of the section against the extension pipe of 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 21) 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

- 22            **Join the two counter-plates (parts 22) together.**
- 15, 16        **Fix the joint using bolt and nuts (M 8 x 16).**
- 23            **Install the counter-plate supports (4 pcs. of parts 23) in the counter-plates in position, shown in the picture.**
- 15, 16        **Fix the supports using bolt and nuts (M8 x 16, 1 pcs./support).**
- 20 (5.)       **Fix a sealing strip to the upper surface of the counter-plate set-up (parts 22).**  
Fix the sealing strip inside the screw hole row (see Fig. 4a).
- (15, 16)      **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.
- (22 + 22)     **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.
- 15, 16        **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.***
- 15, 16        **Fix the counter-plate supports using the removed bolts and nuts (M 8 x 16).**

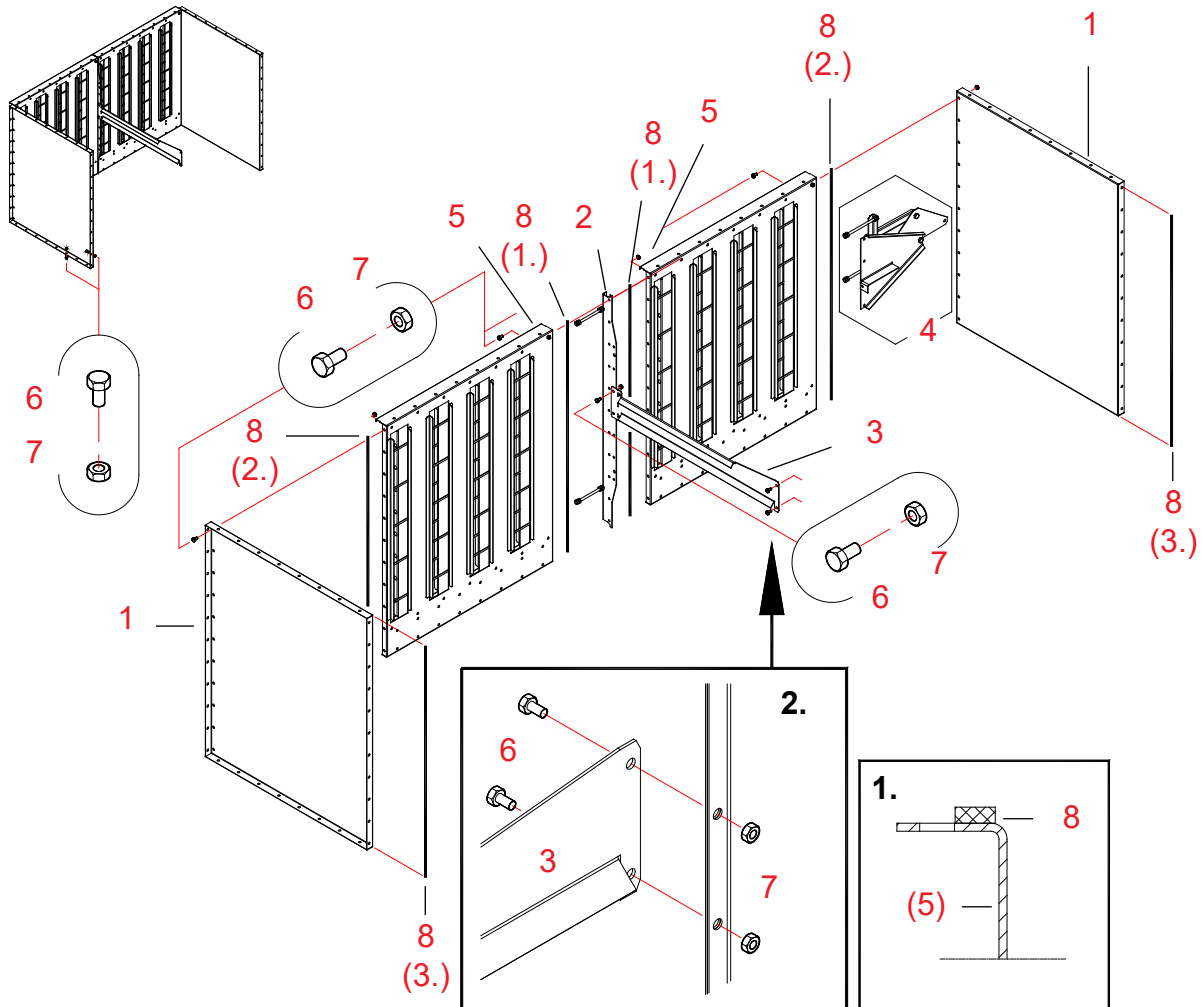
#### 5. Installing the actuator wires for the plates

- 16, 25        **Provide both shutter-plates with an eye-bolt. Fix them using two nuts (M8).**
- 26            **Thread in a draw-spring through both eye-bolts.**
- 19            **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.  
Look up also the picture X above in the assembly instructions drawing 4 for the air channel end A70813.
- 18            **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 2W (A70879) - 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 | 1    | A70810-C    | 2.34   | 3000  |
| 3    | A70678   | AIR CHANN END WM06 1.0 | STRAIGHT SUPPORT     | 1    | 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      | 2    | A71351      | 32.1   | 3000  |
| 6    | 101810   | HEX BOLT ZN 8.8        | 8X16 AM DIN933       | 121  |             | 0      | 2010  |
| 7    | 110540   | NUT ZN 8 M 8           | DIN934               | 121  |             | 0      | 2010  |
| 8    | 115570   | SEALING STRIP          | 4X10 MAPA            | 20   |             | 0      | 2600  |



## Assembling air channel end A70879

### 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 A70879 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 two end-plates (parts 5) to be joined together.**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).

2                 **Place the vertical support 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 support using bolts and nuts (M8 x 16, 11 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.

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

6, 7             **Fix the support using bolts and nuts (M8 x 16, 2 pcs./support).**

8 (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

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.*

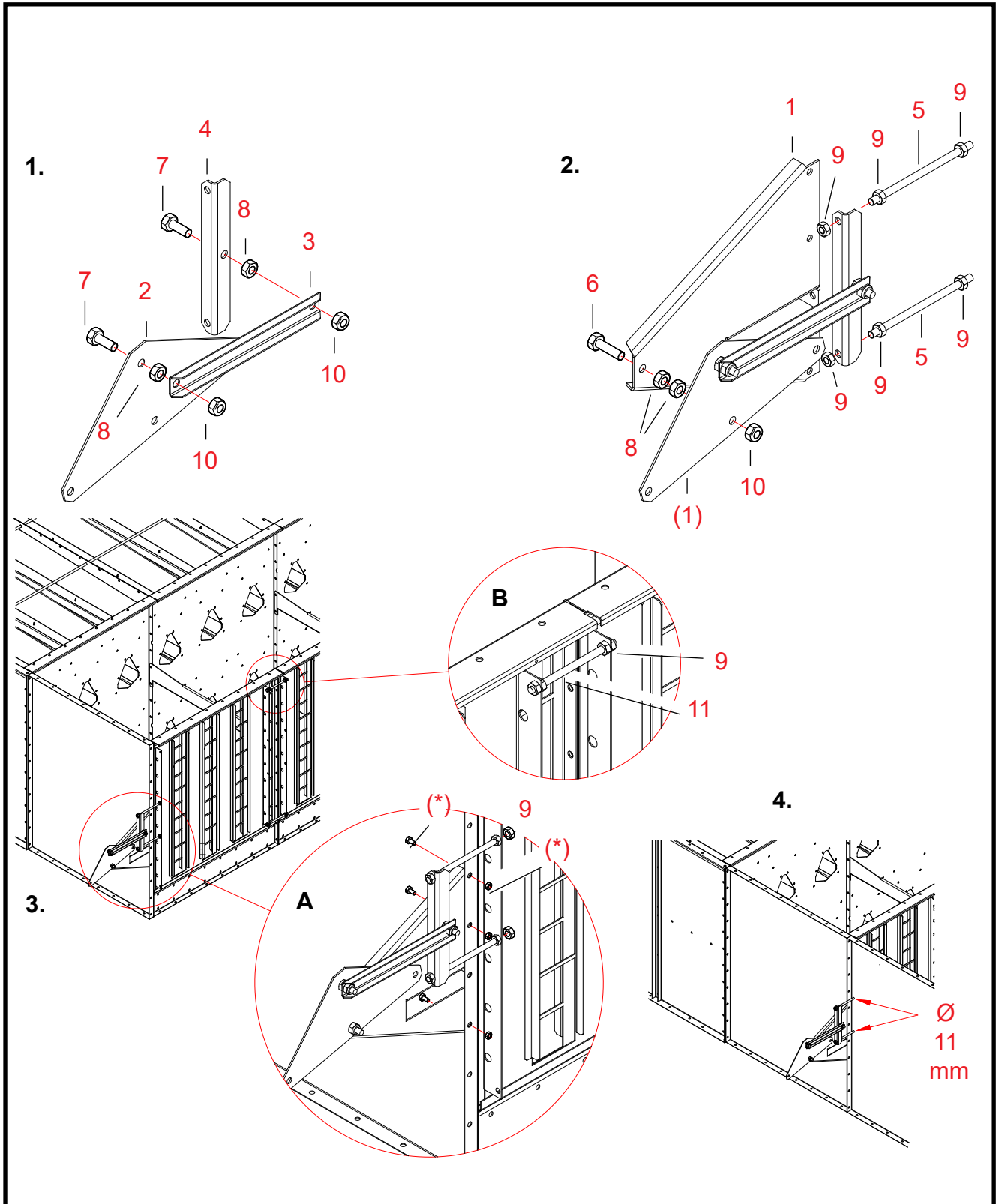
6, 7             **Fix the side-plates using bolts and nuts (M8 x 16, 11 pcs. /side-plate).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.

(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             **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 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).**

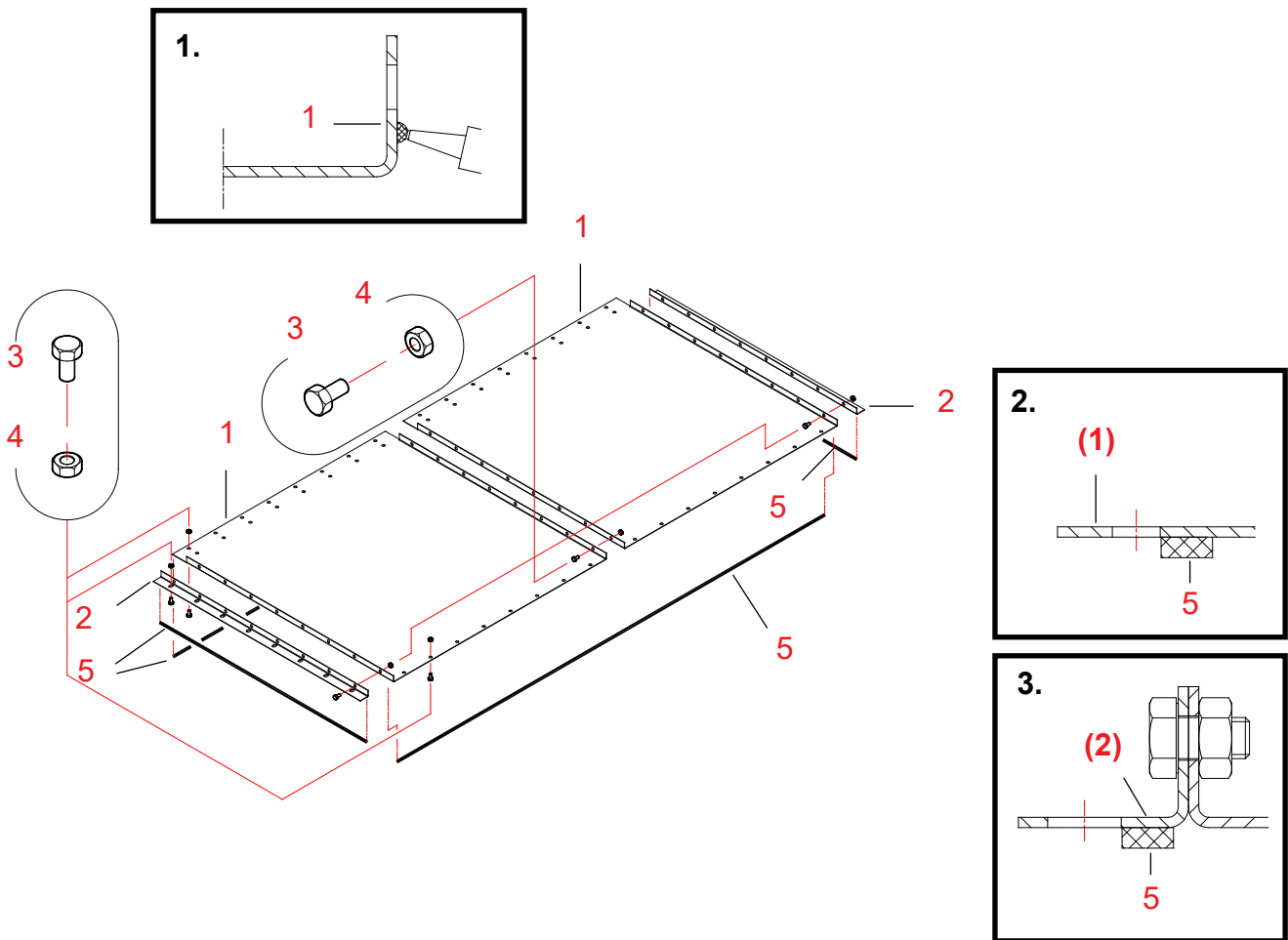
### 2. Installing the adjuster set-up

- 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 2W (A70958) - 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  | 2    | 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 | 56   |             | 0      | 2010  |
| 4    | 110540   | NUT ZN 8 M 8           | DIN934         | 56   |             | 0      | 2010  |
| 5    | 115570   | SEALING STRIP          | 4X10 MAPA      | 4    |             | 0      | 2600  |
| 6    | 800271   | MASTIC SEALING/GLUE    | GREY 310 ML    | 1    |             |        | 2600  |

## Installing upper shutter A70958 in the air channel end

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

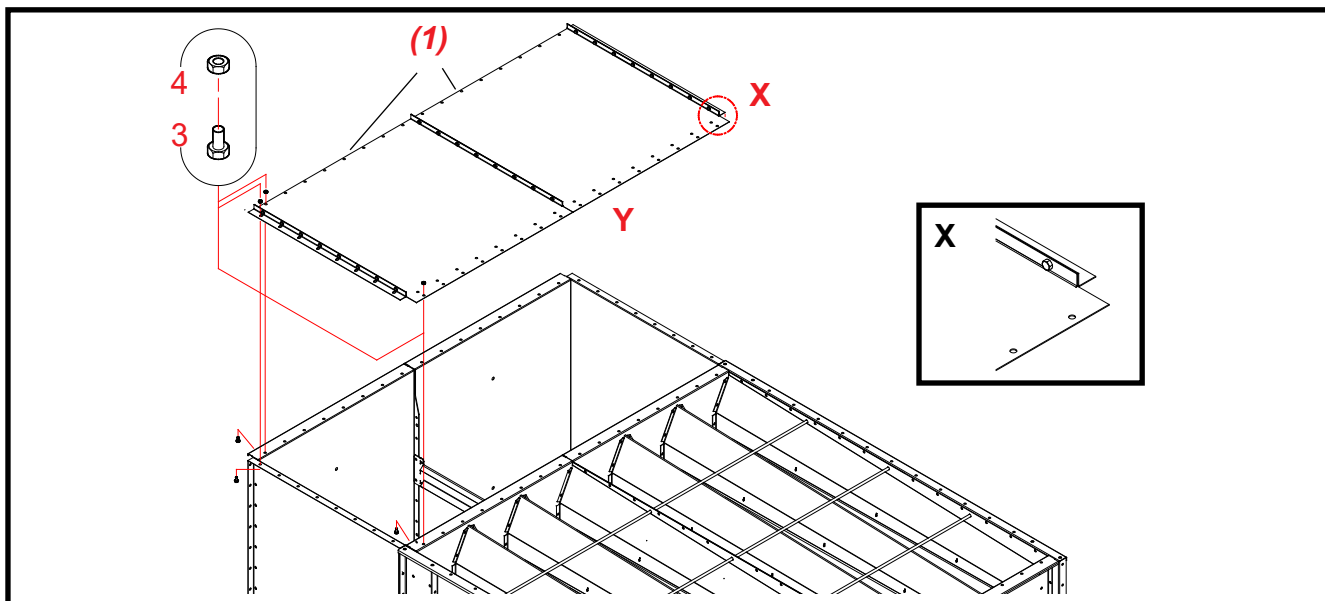
Parts The numbering of work stages refers to reference numbers in the spare parts drawing A70958 for the upper shutter.

- \* **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.
- 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.**  
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 A70958 of the air channel end.

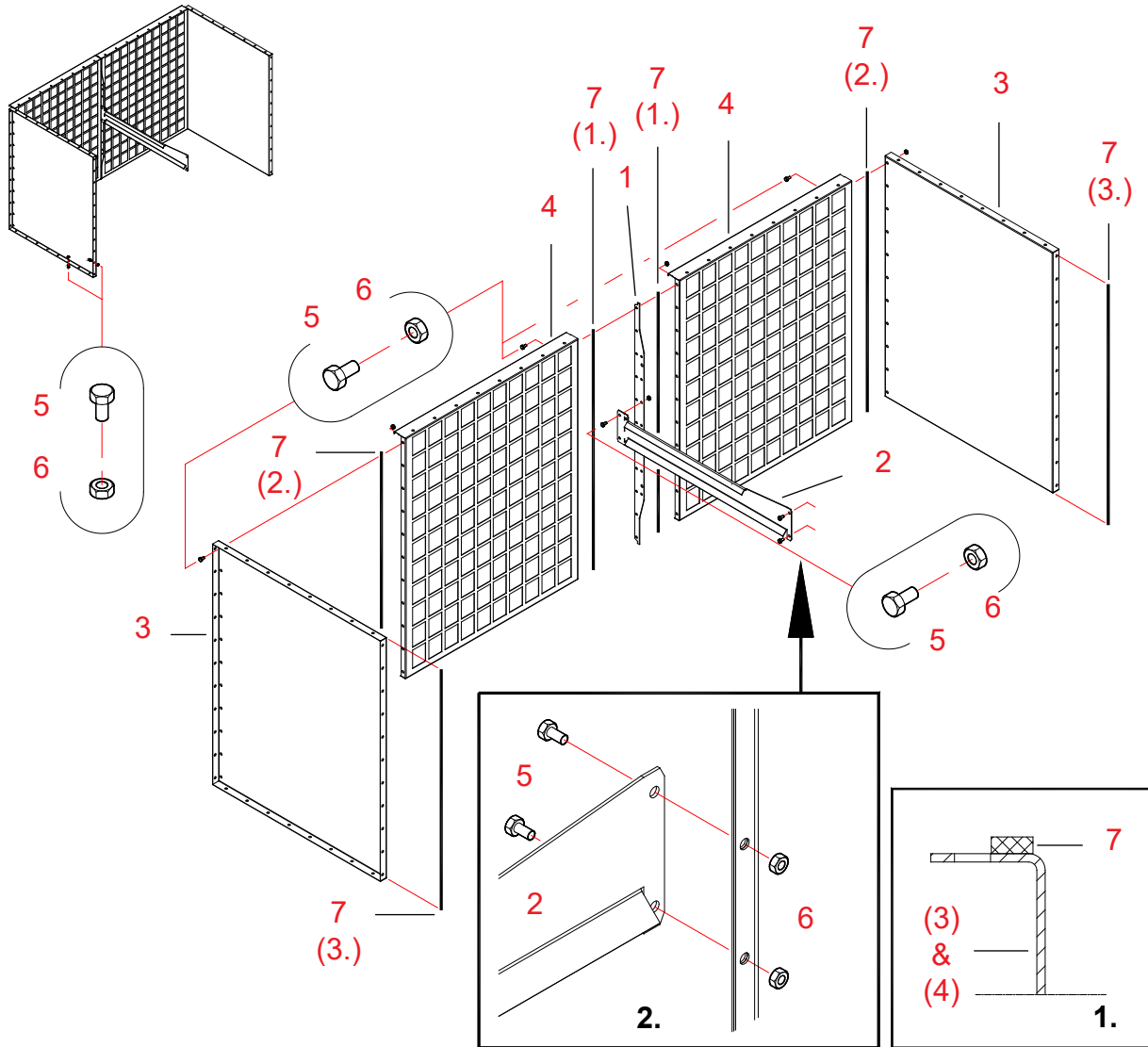
- (1) **Move the assembly against the flanges at the upper end of the air channel end.**  
*Be careful not to damage the sealing strips while installing the plate.*  
Check correct position for the assembly in detail drawing X.
- 3, 4 **Fix the shutter-plate using bolts and nuts (M 8 x 16, 48 pcs.).**  
*Note! Do not install the bolts on the other long side (Y) until the dryer is being assembled.*





## Air channel end 1,0 2W (A70982) - 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 | 1    | A70810-C    | 2.34   | 3000  |
| 2    | A70678   | AIR CHANN END WM06 1.0 | STRAIGHT SUPPORT     | 1    | 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            | 2    | A70978      | 6.45   | 3000  |
| 5    | 101810   | HEX BOLT ZN 8.8        | 8X16 AM DIN933       | 97   |             | 0      | 2010  |
| 6    | 110540   | NUT ZN 8 M 8           | DIN934               | 97   |             | 0      | 2010  |
| 7    | 115570   | SEALING STRIP          | 4X10 MAPA            | 15   |             | 0      | 2600  |



## Assembling air channel end A70982

### 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 A70982 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 at the ends of the two 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 the vertical support between the spark nets.**  
*Be careful not to damage the sealing strips while installing the vertical support.*

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

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

5, 6             **Fix the support 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.).**

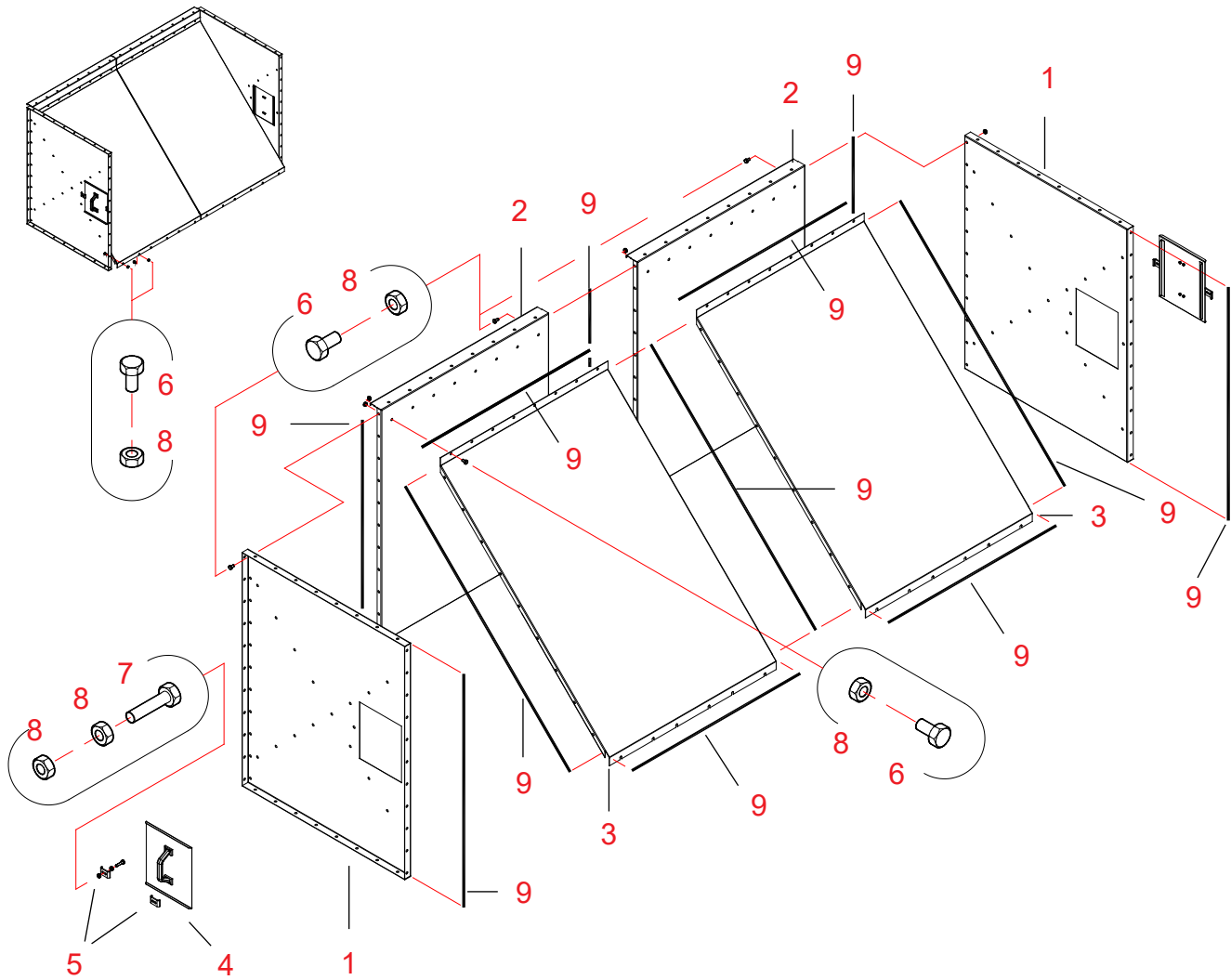
5, 6             **Fix the straight support for the air channel end to the section using bolts and nuts (M 8 x 16, 2 pcs.).**  
See detail drawing 2. Tighten the bolts only lightly so that you can straighten the air channel end later.

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



## Air channel end 1,0 2W (A71014) - return end B

## Spare parts



20061019

| 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 | 2    | A70680-A    | 14.66  | 3000  |
| 3    | A70681   | AIR CHANN END WM06 1.0 | RETURN BOTTOM        | 2    | 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       | 131  |             | 0      | 2010  |
| 7    | 101860   | HEX BOLT ZN 8.8        | 8X35 AM DIN933       | 4    |             | 0      | 2010  |
| 8    | 110540   | NUT ZN 8 M 8           | DIN934               | 139  |             | 0      | 2010  |
| 9    | 115570   | SEALING STRIP          | 4X10 MAPA            | 23   |             | 0      | 2600  |



## Assembling air channel end A71014

### 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 A71014 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 end-flange of one 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 seam using bolts and nuts (M8 x 16, 11 pcs).**

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

9 (3.)            **Fix sealing strips to upper flanges of both 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 one 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).**

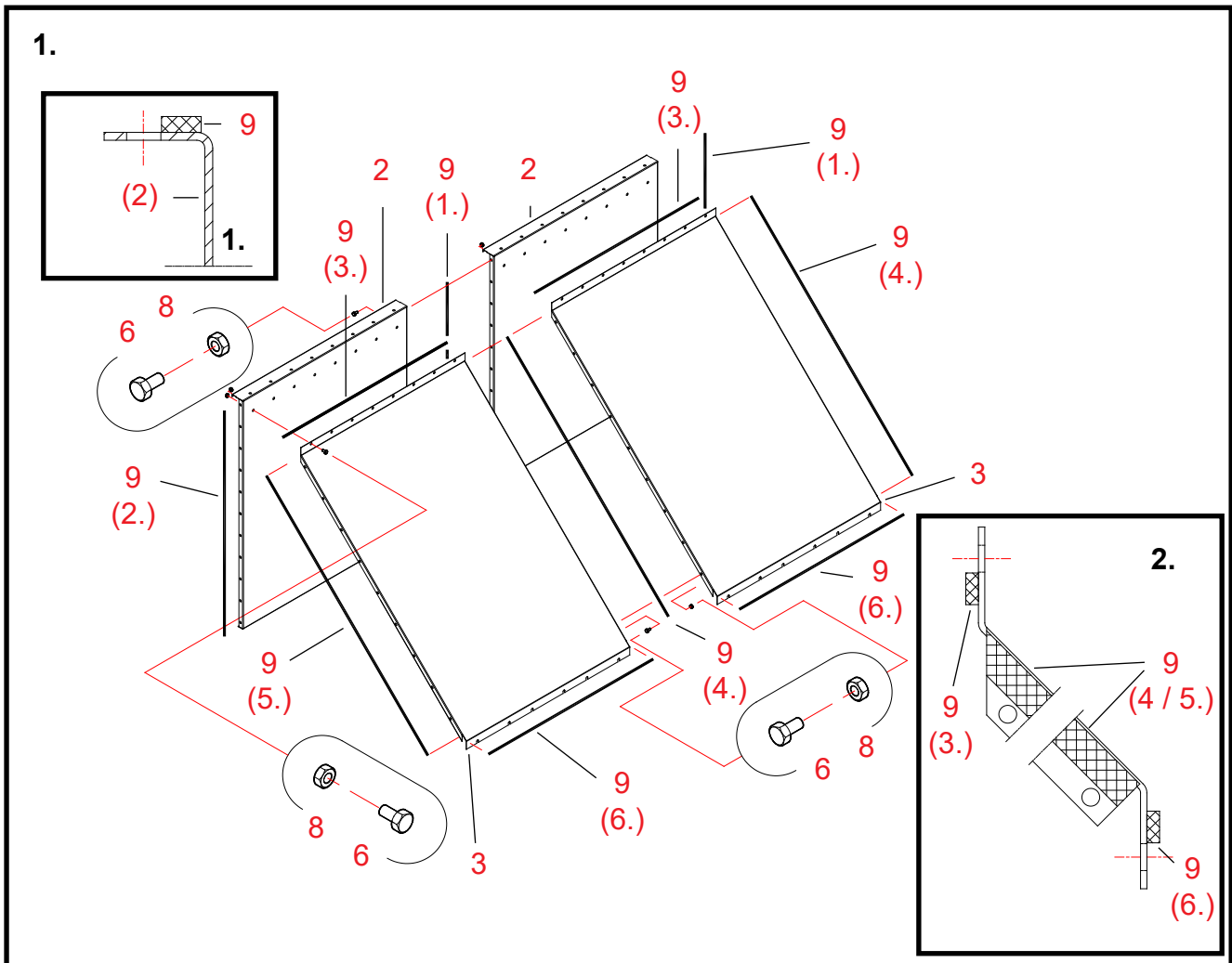
Place the bolt caps on the return bottom side.

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

9 (6.)            **Fix sealing strips to lower flanges of both 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.

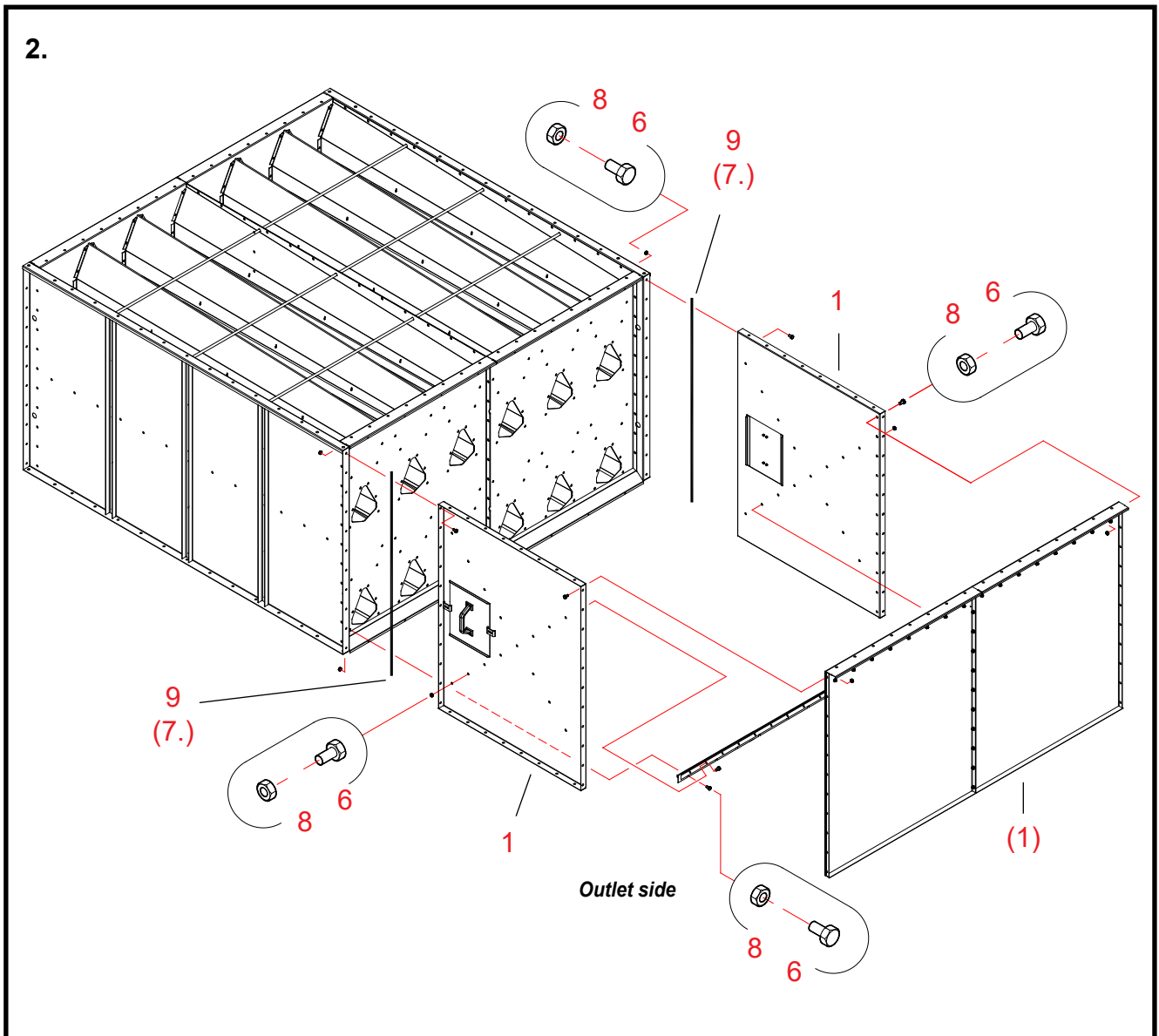


Assembling air channel end A71014, continues

## 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 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.

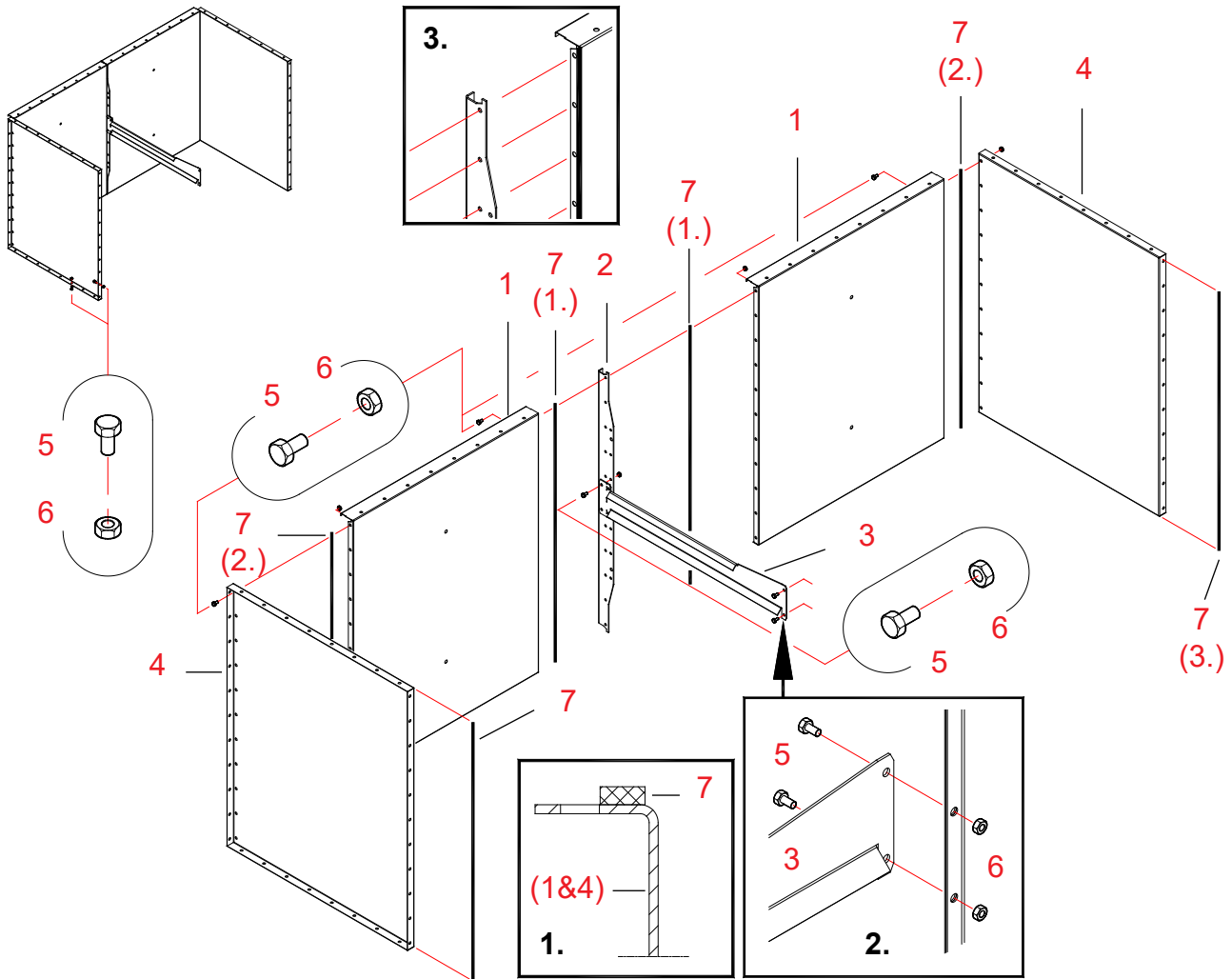
\* **Check the joints and rectangular shape of the air channel end. Tighten all bolts.**

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



## Air channel end 1,0 2W (A70826) - 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            | 2    | A70563-B    | 14.65  | 3000  |
| 2    | A70810   | TOP SECTION WM06       | VERTICAL SUPPORT PL3 | 1    | A70810-C    | 2.34   | 3000  |
| 3    | A70678   | AIR CHANN END WM06 1.0 | STRAIGHT SUPPORT     | 1    | 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       | 93   |             | 0      | 2010  |
| 6    | 110540   | NUT ZN 8 M 8           | DIN934               | 93   |             | 0      | 2010  |
| 7    | 115570   | SEALING STRIP          | 4X10 MAPA            | 19   |             | 0      | 2600  |



## Assembling air channel end A70826

### 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 A70826 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 (parts 1 + 9) of the two 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 support 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 support using bolts and nuts (M8 x 16, 11 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.

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

5, 6             **Fix the support 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 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.

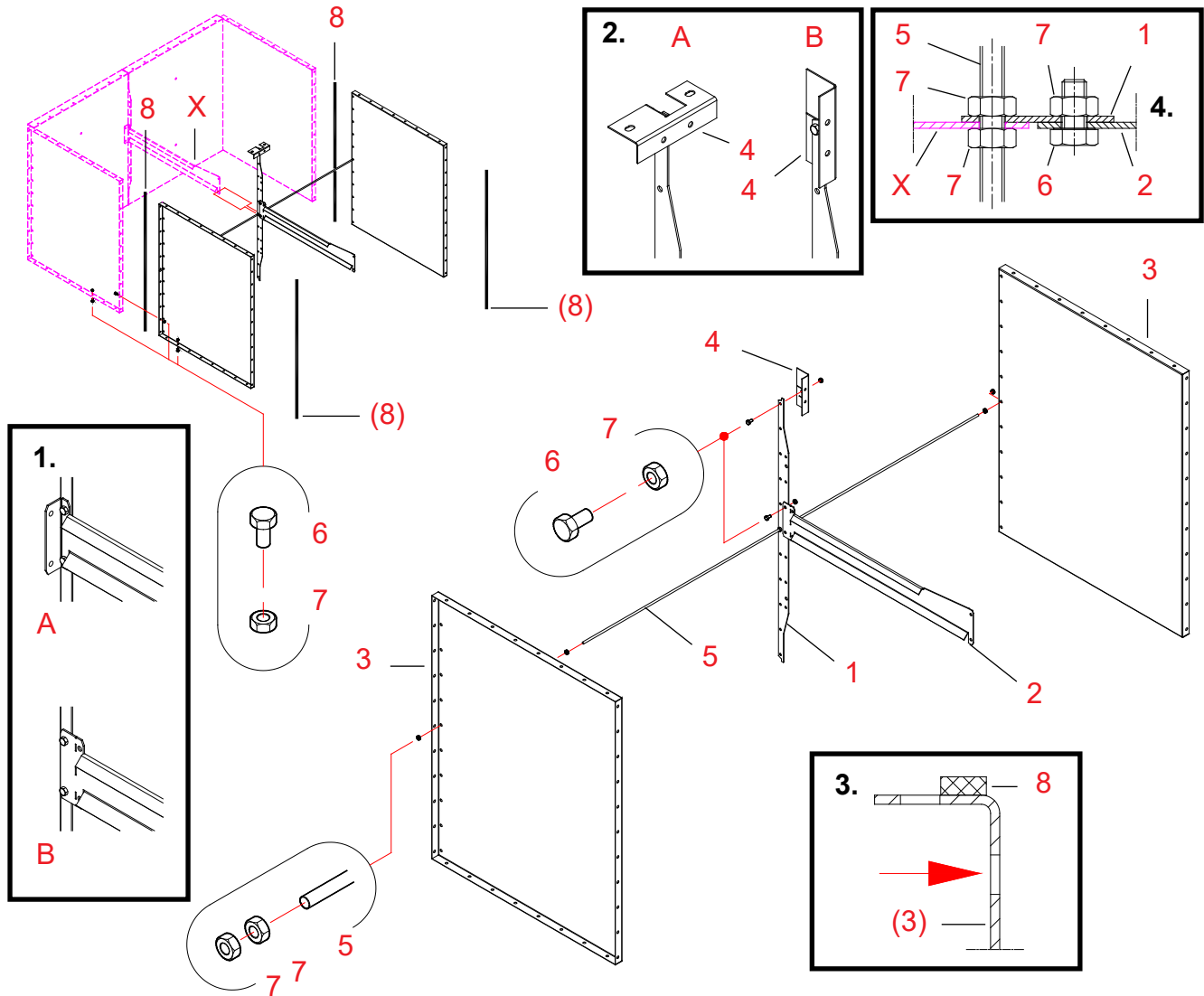
\*                 **Check the joints and rectangular shape of the air channel end. Tighten all bolts.**



## Air channel end 1,0 2W (A71017) - intermediate part

### Spare parts

### An accessory for air channel end A70826 (centre-part B)



20080901

| Ref. | Part no. | Denomination 1         | Denomination 2       | Pcs. | Drawing No. | Weight | Group |
|------|----------|------------------------|----------------------|------|-------------|--------|-------|
| 1    | A70810   | TOP SECTION WM06       | VERTICAL SUPPORT PL3 | 1    | A70810-C    | 2.34   | 3000  |
| 2    | A70678   | AIR CHANN END WM06 1.0 | STRAIGHT SUPPORT     | 1    | 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    | 1    | A70977      | 0.22   | 3000  |
| 5    | 119006   | THREADED ROD ZN        | M 8X2000 MM 8.8      | 1    |             | 0      | 2000  |
| 6    | 101810   | HEX BOLT ZN 8.8        | 8X16 AM DIN933       | 62   |             | 0      | 2010  |
| 7    | 110540   | NUT ZN 8 M 8           | DIN934               | 68   |             | 0      | 2010  |
| 8    | 115570   | SEALING STRIP          | 4X10 MAPA            | 4.5  |             | 0      | 2600  |



## Assembling air channel end A71017

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

Parts The numbering of work stages refers to reference numbers in the spare parts drawing A71017 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.*

**!!!** *Note the way, the straight support (part X) is attached to the vertical support at the air channel end A70826 (see detail dwg. 1).*

Alternative A, if air channel end A71017 is used - (otherwise alternative B).

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

- 7 Turn a M8 nut to the centre-point of the threaded rod (part 5).
- 1 Place the vertical support against the nut on the threaded rod.
- 5 Insert the threaded rod with the attached vertical support in the lower hole in the straight support (part X) of the air channel end A70826.
- 7 Turn another M8 nut on the threaded rod against the part X.
- \* Centre the threaded rod with respect to the air channel end A70826 and tighten the nuts lightly.
  
- 4 **Attach the bracket of the vertical support to the vertical support (part 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).
  
- 6, 7 Fix the support using bolt and nuts (M 8 x 16).

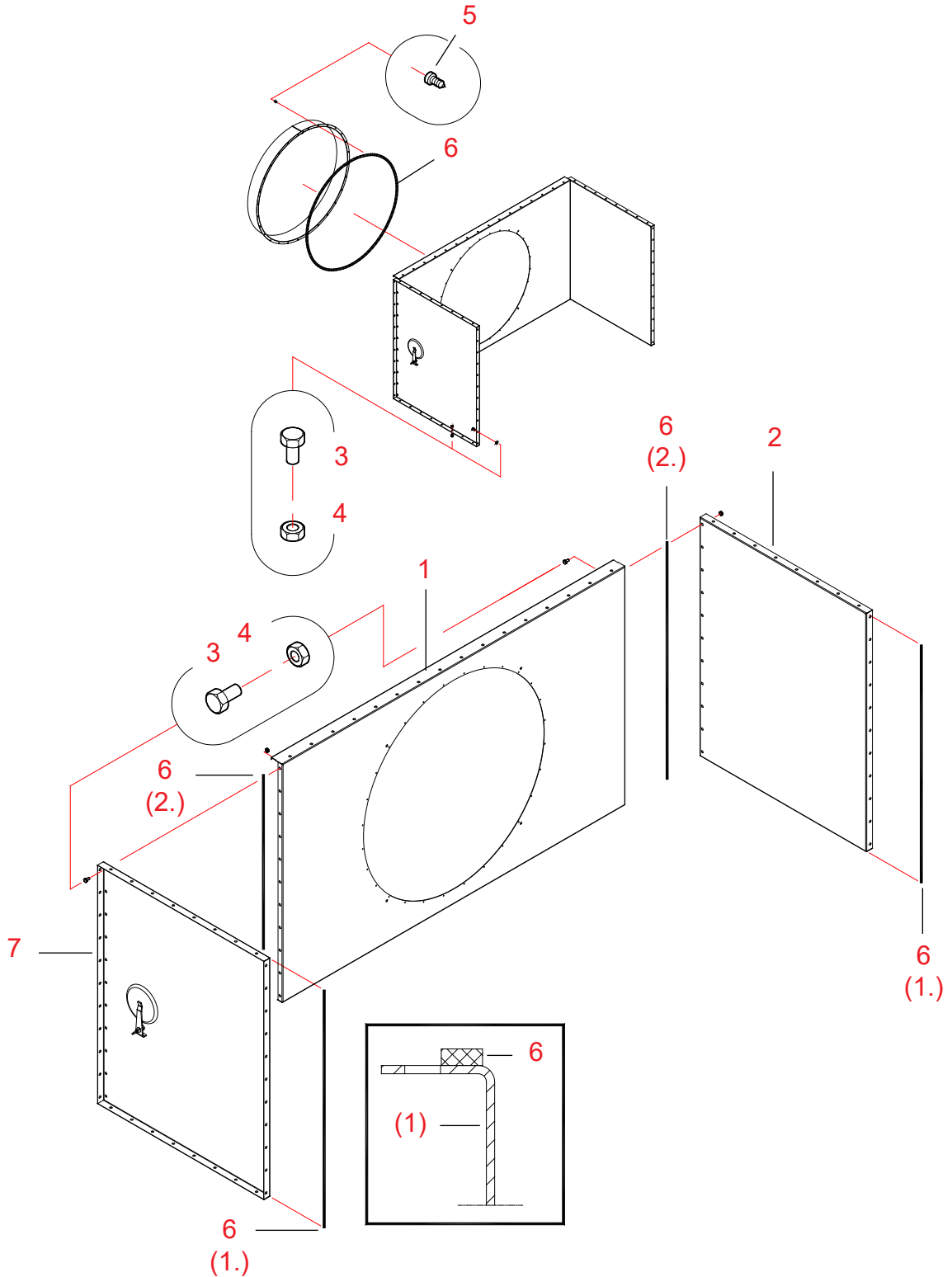
### 2. Fixing the side-plates of the air channel end to the air channel end A70826

- 8 **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.
  
- 7 **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 placing them against the flanges of the air channel end A70826.**  
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.**
  
- 7 **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.
  
- 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.
  
- 2 **Install the straight air channel end support in the vertical support (part 1).**  
Look up correct position for the support in the drawing and in the detail dwg. 1, alt. B.
  
- 6, 7 **Fix the support using bolts and nuts (M8 x 16, 2 pcs./support).**  
Installing the straight support, threaded rod and nuts (detail dwg. 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 A70826.**  
Tighten all bolts and nuts.



## Air channel end 1,0 2W (A71208) - centre-part S, Ø 1000 mm

### Spare parts





20061019

| Ref. | Part no. | Denomination 1         | Denomination 2      | Pcs. | Drawing No. | Weight | Group |
|------|----------|------------------------|---------------------|------|-------------|--------|-------|
| 1    | A71207   | AIR CHANN END WM06     | END D1000 SCREW ATT | 1    | A71207-B    | 19.34  | 3000  |
| 2    | A70640   | AIR CHANN END WM06 1.0 | SIDE-PLATE          | 1    | A70640      | 14.18  | 3000  |
| 3    | 101810   | HEX BOLT ZN 8.8        | 8X16 AM DIN933      | 76   |             | 0      | 2010  |
| 4    | 110540   | NUT ZN 8 M 8           | DIN934              | 76   |             | 0      | 2010  |
| 5    | 107720   | SELF-TAP HEX SCREW     | 4,8X13 ZN           | 28   |             | 0      | 2010  |
| 6    | 115570   | SEALING STRIP          | 4X10 MAPA           | 13   |             | 0      | 2600  |
| 7    | A71400   | AIR CHANN END WM06 1.0 | SIDE-PL CLEAN HATCH | 1    | A71400      | 14.56  | 3000  |

## Assembling air channel end A71208

Parts The numbering of work stages refers to reference numbers in the spare parts drawing A71208 for the air channel end.

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

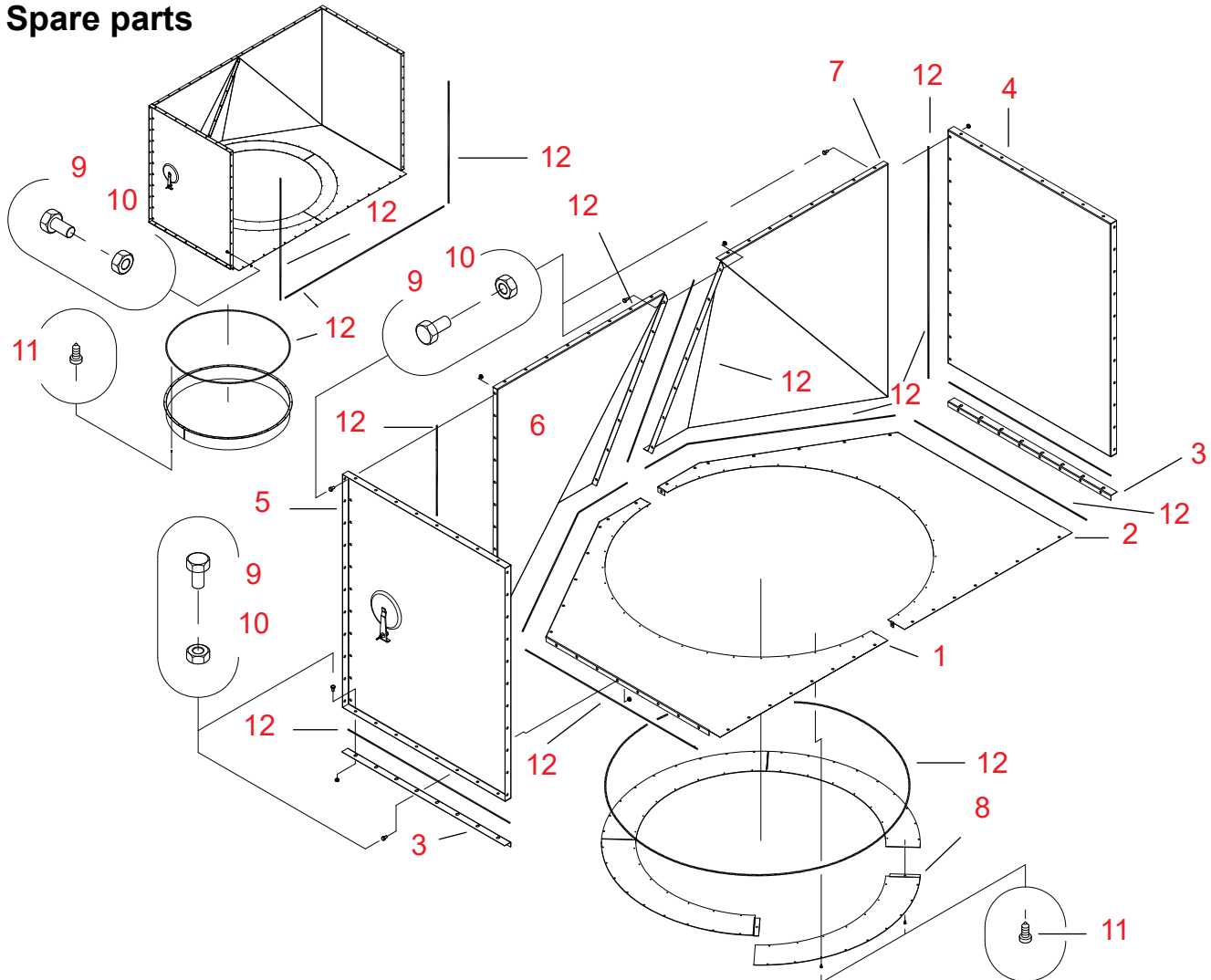
***This ensures the ready-assembled air channel end is straight.***

- 6 (1.)** Fix sealing strips to the attachment flanges of the side-plates (parts 2 and 7) to be attached to the drying section.  
Fix the sealing strips inside the bolthole rows.
- 2, 7** Move the side-plates tight against the ends of the section.  
***Be careful not to damage the sealing strips while installing the side-plates.***
- 3, 4** 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.
- 6 (2.)** Fix sealing strips to the end-flanges of the end-plate (part 1).  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing).
- 1** Move the end-plate between the side-plates.  
***Be careful not to damage the sealing strips while installing the side-plates.***
- 3, 4** 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.
- \*** See point "Installing the air pipe connector in the air channel end".
- 5** 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 2W (A71220) - 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            | 1    | A70640     | 14,18  | 3000  |
| 5    | A71400   | AIR CHANNEL END SIDE-PLATE CLEAN HTCH WM06 1,0 | 1    | A71400     | 14,56  | 3000  |
| 6    | A75079   | AIR CH END DIAGON RIGHT 1.0 V D1250 WM06       | 1    | A75079     | 15,49  | 3000  |
| 7    | A75080   | AIR CH END DIAGON LEFT 1.0 V D1250 WM06        | 1    | A75080     | 15,49  | 3000  |
| 8    | A71254   | AIR CH END 1/4 CIRCLE D1250/1000 WM06          | 4    | A71254     | 2,00   | 3000  |
| 9    | 101810   | BOLT 6K ZN 8.8 8X16 AM DIN933 CE               | 142  |            |        | 2010  |
| 10   | 110540   | NUT M8 ZN 8 DIN934 CE                          | 142  |            |        | 2010  |
| 11   | 107720   | SCREW SELF-TAP HEX 6K 4,8X13 ZN                | 64   |            |        | 2010  |
| 12   | 115570   | SEALING STRIP 4X8 EKO-40                       | 26   |            |        | 2600  |

## Assembling air channel end A71220

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

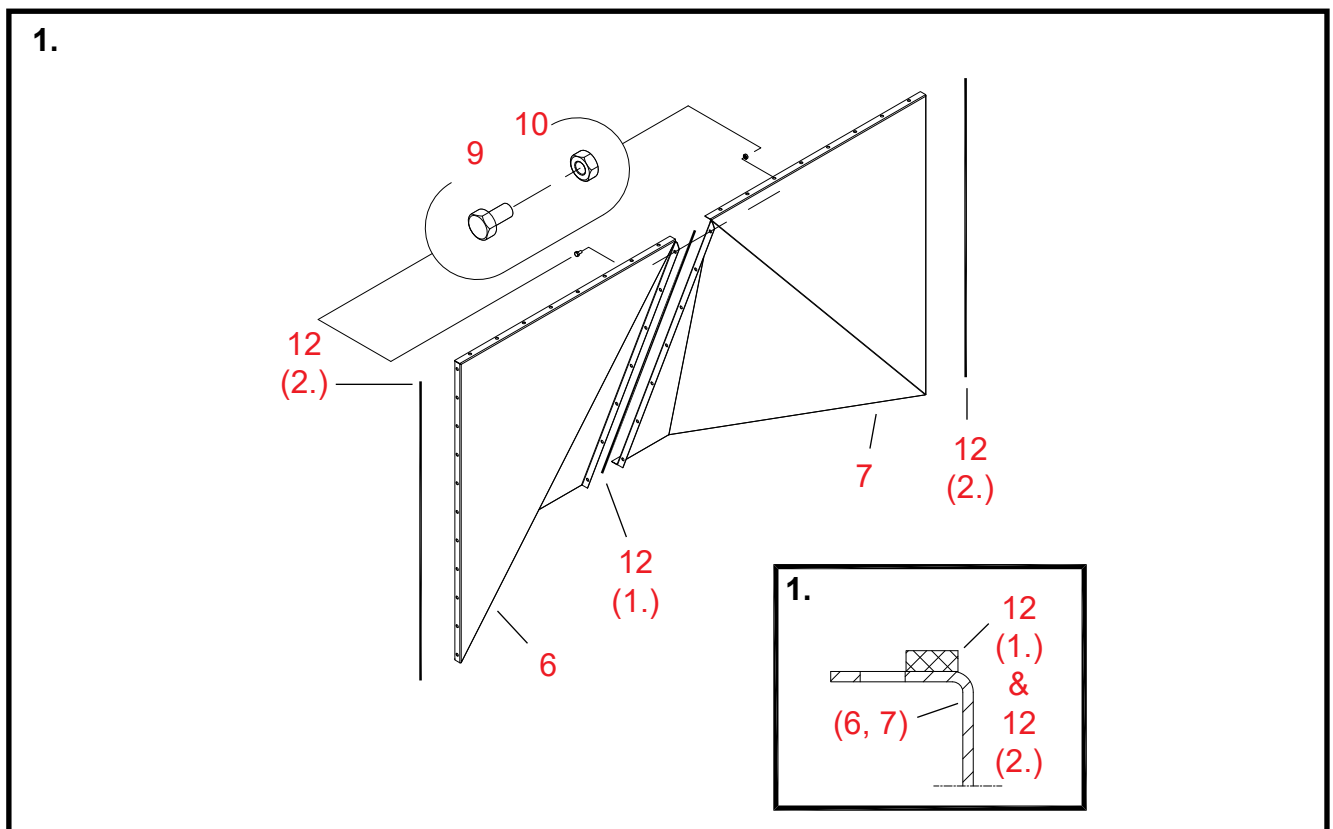
Parts The numbering of work stages refers to reference numbers in the spare parts drawing A71220 for the air channel end.

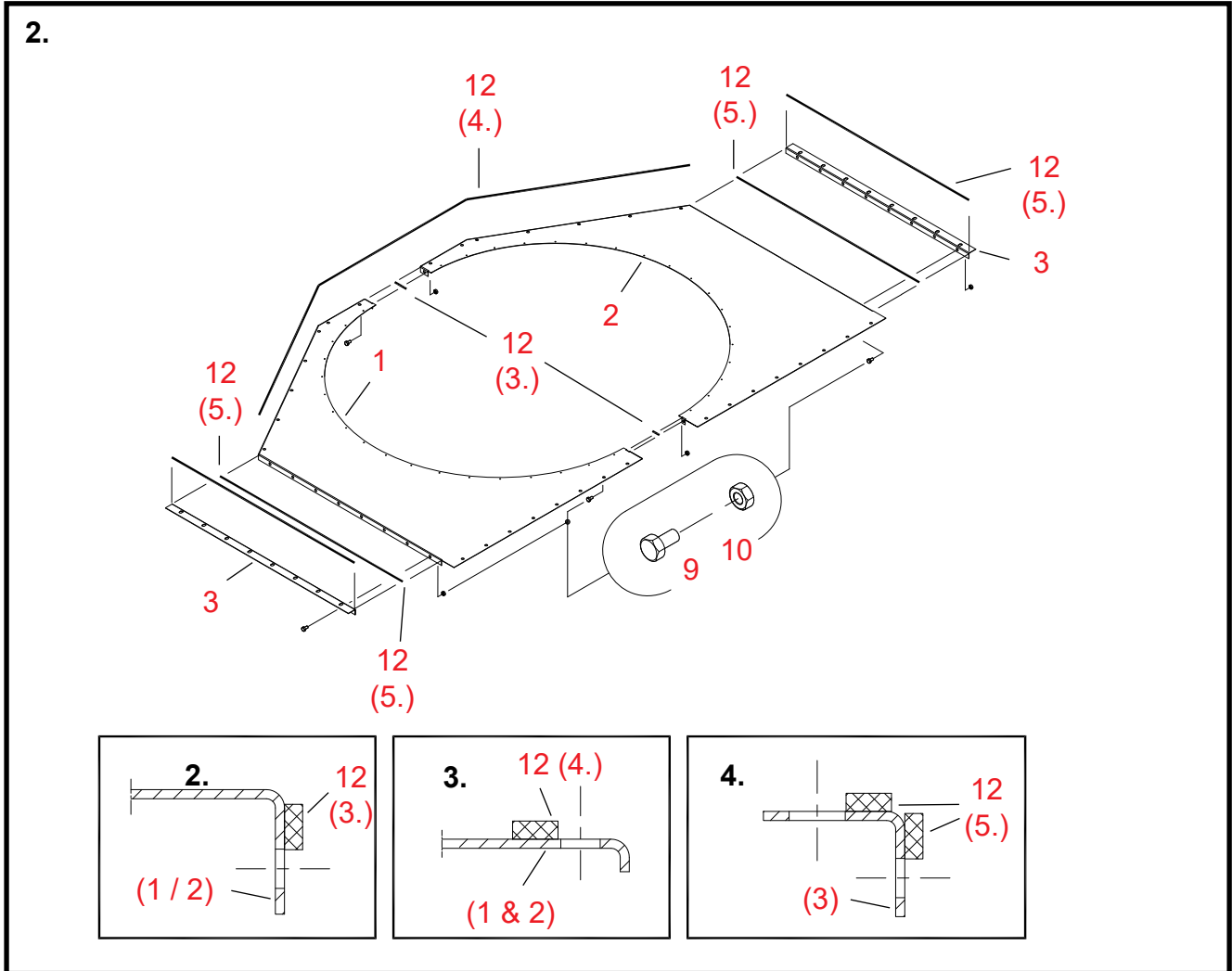
12 (1.) **Fix a sealing strip on both end-flanges of the right diagonal end (part 6).**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).

6, 7 **Join together the left and right diagonal ends.**  
*Be careful not to damage the sealing strips while joining the parts.*

9, 10 **Fix the joint of the diagonal end using bolts and nuts (M8 x 16, 7 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.

12 (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).

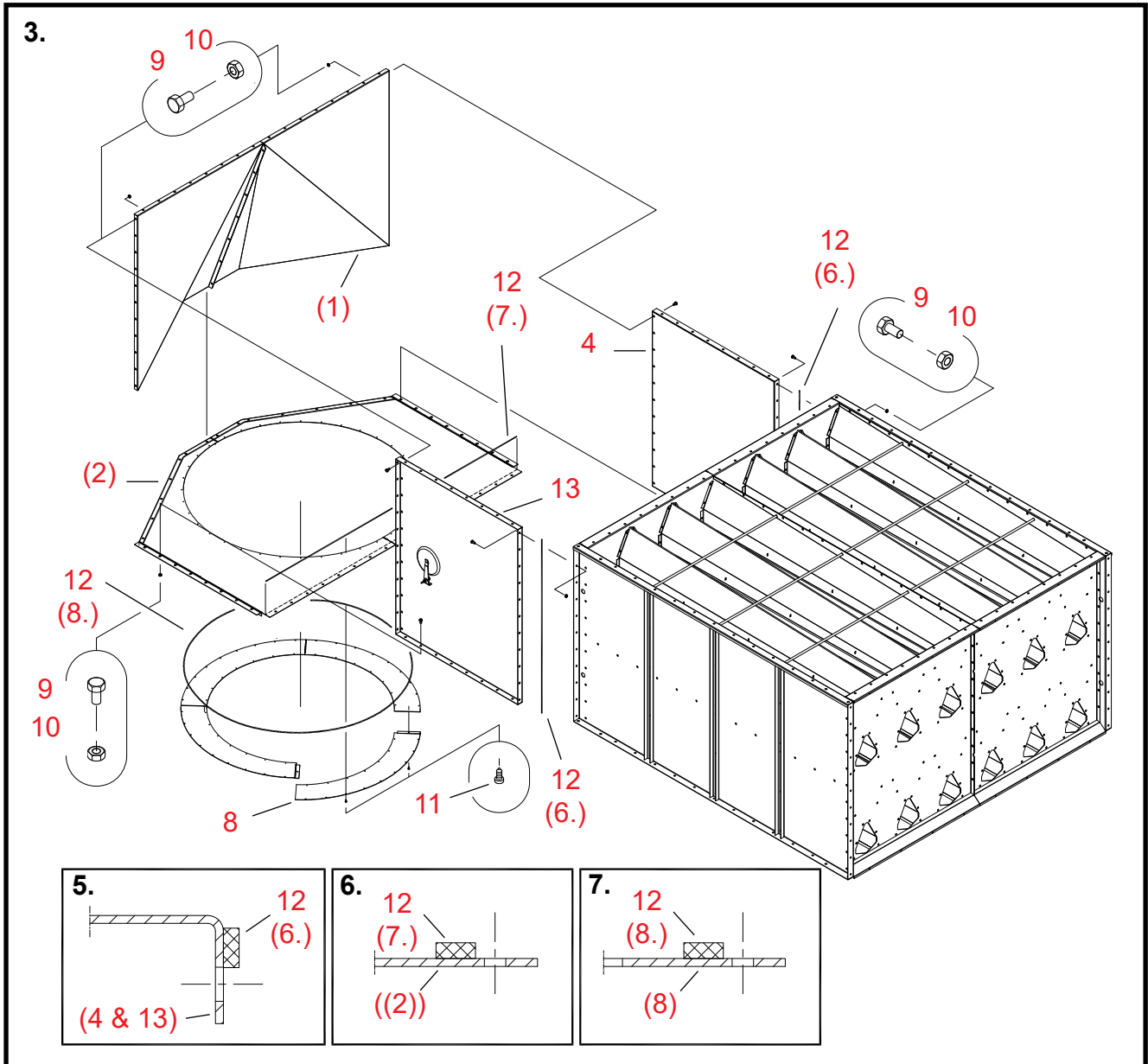






## 2. Assembling the shutter-plate set-up for the air channel end

- 12 (3.) **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 with holes.**
- 9, 10 **Fix the joints (2 pcs.) of the shutter-plates using bolt and nut (M 8 x 16, 1 + 1 pcs.).**
- 12 (4.) **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).
- 12 (5.) **Fix sealing strips to the flanges of the corner-strips (parts 3).**  
Fix the sealing strips inside the bolthole rows (see detail drawing 4).
- 3 **Attach corner-strips to the end-flanges of the shutter-plate.**
- 9, 10 **Fix the corner-strips (2 pcs.) using bolts and nuts (M8 x 16, 8 + 8 pcs.).**





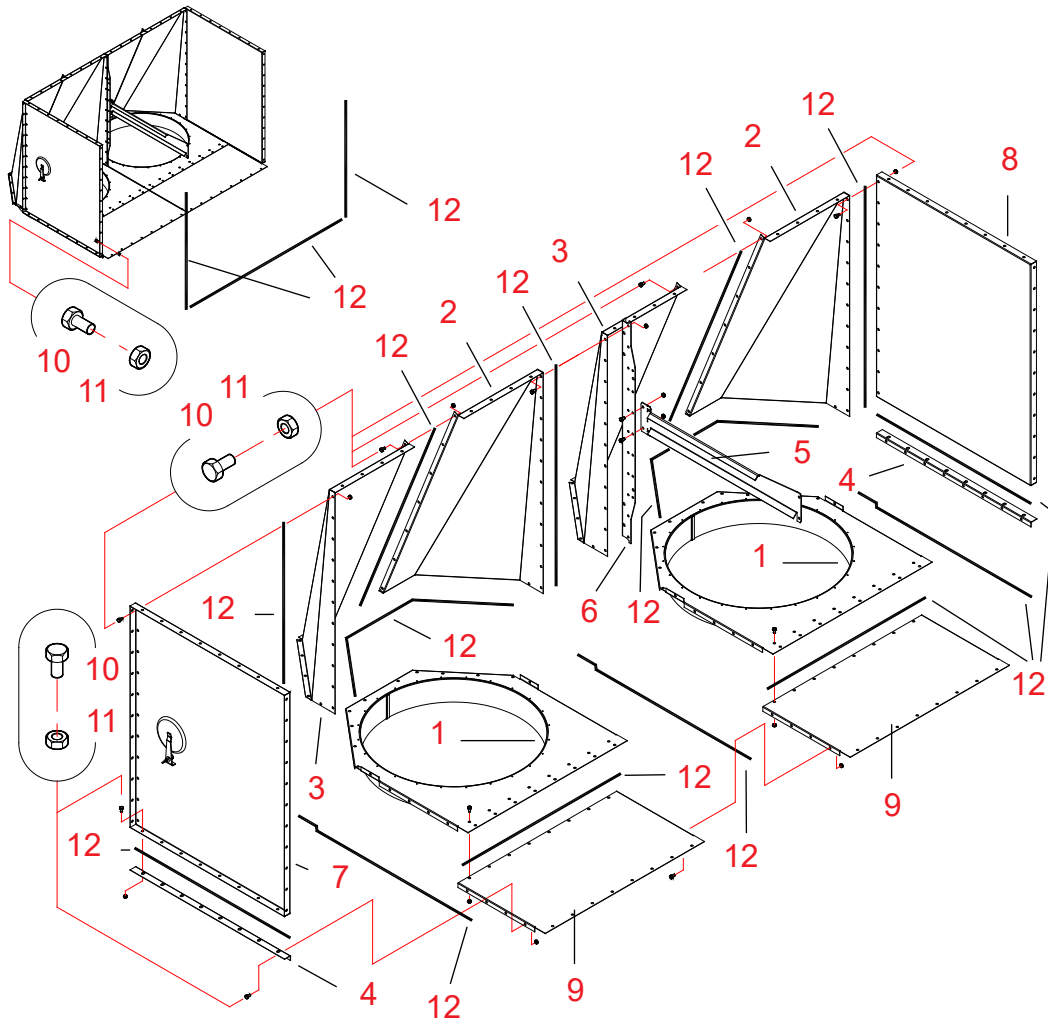
### 3. Assembling the air channel end

- 12 (6.) **Fix sealing strips to the flanges of the side-plates (parts 4 and 13).**  
Fix the sealing strips inside the bolthole rows (see detail drawing 5).
- 4, 13 **Move the side-plates tight against the end of the section.**  
*Be careful not to damage the sealing strips while installing the side-plates.*
- 9, 10 **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.
- 12 (7.) **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 6).
- (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.*
- 9, 10 **Fix the part to the section and to the side-plates using bolts and nuts (M8 x 16, 16 + 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.*
- 9, 10 **Fix the set-up, assembled at stage 1, using bolts and nuts (M8 x 16, 14 + 11 + 11 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- \* **With pipes, which are 1000 mm or less in diameter, use in the shutter-plate a reducer assembled of four sectors (parts 8).**
- 8 **Join up the sectors in such a manner that they form a round reduction circle.**
- 11 **Fix the sectors using self-tapping screws (4.8 x 13, 4 pcs.).**
- 12 (8.) **Fix the sealing strip so that it forms a circle on the upper surface of the reduction circle.**  
Fix the sealing strips inside the screw hole row (see detail drawing 8).
- 11 **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.
- 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 1.0 2W (A73407) - 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            | 1    | A70678      | 3.10   | 3000  |
| 6    | A70810   | TOP SECTION VERTICAL SUPPORT PL 3 WM06            | 1    | A70810      | 2.34   | 3000  |
| 7    | A71400   | AIR CHANNEL END SIDE-PLATE CLEAN HTCH WM06<br>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   | 101810   | BOLT 6K ZN – 8x16 AM DIN933                       | 195  |             | 0.00   | 2010  |
| 11   | 110540   | NUT M8 ZN 8 DIN934                                | 195  |             | 0.00   | 2010  |
| 12   | 115570   | SEALING STRIP 4x8 EKO-40                          | 34   |             | 0.00   | 2600  |





## Assembling air channel end A73407

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 A73407 for the air channel end.
- 12 (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).**
- 10, 11        **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.
- 12 (2.)        **Fix sealing strips to the outer 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).
- 12 (3.)        **Fix a sealing strip to the inner side-flange of the other diagonal end set-up.**  
**Observe that the seam between the set-ups to be joined shall only be provided with one sealing strip.**  
Fix the sealing strip to the flange outside the screw hole rows (see detail drawing 2).
- 6              **Cut off a bevel piece of 20 mm x 160 mm from the bent edge of the vertical support, and shorten it by 2 mm at its top end.**  
See close-up 3.  
**Place the vertical support inside the diagonal end set-up (rearmost in the drawing), against its centre-flange.**
- 10, 11        **Fix the diagonal end set-ups and the vertical support using bolts and nuts (M8 x 16, 11 pcs).**  
**Be careful not to damage the sealing strips while joining the parts.**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 5              **Install the straight air channel end support in the vertical support (part 6).**  
Look up correct position for the support in the drawing.
- 10, 11        **Fix the support using bolts and nuts (M8 x 16, 2 pcs.).**

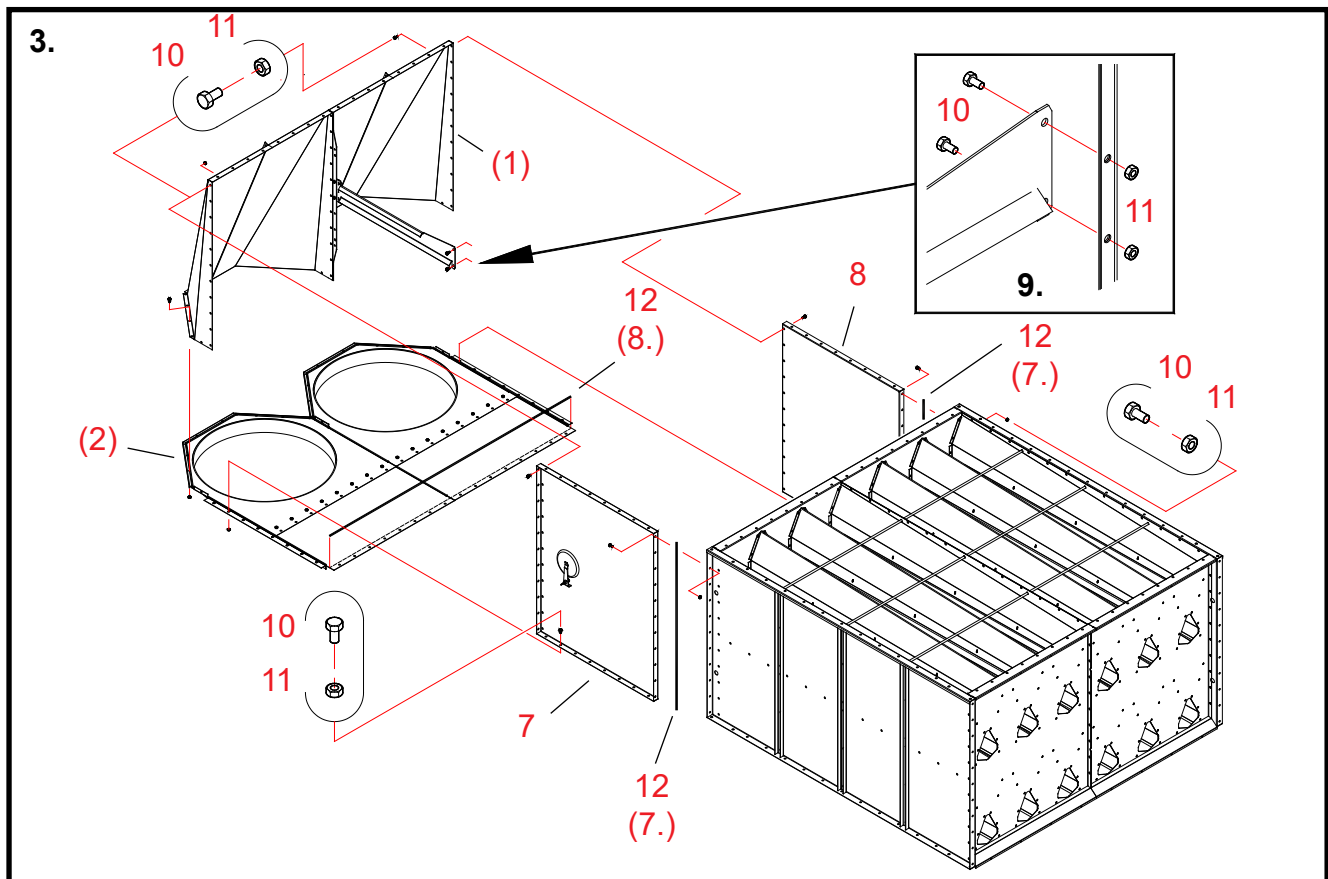
### 2. Assembling the shutter-plate set-up for the air channel end

- 12 (3.)        **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 4).
- 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 4).
- 10, 11        **Fix the plates together using bolts and nuts (M8x16, 8 pcs.).**

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

Continued from previous page >>>

- 12 (4.) **Fix sealing strips to the upper surface (parts 1 + 9) of the shutter-plates (parts 1) at the diagonal end.**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 5).  
Extend the sealing strips to inside the vertical flanges of the shutter-plate (see detail drawing 6).
- 12 (5.) **Fix a sealing strip to the centre-joint of the shutter-plates (only to one of the plates).**  
Fix the sealing strip inside the bolthole rows in the flange (see detail drawing 7).
- 1 + 9 **Place the end-flanges of the shutter-plate set-ups (parts 1 + 9, 2 pcs.) face to face.**
- 10, 11 **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.
- 12 (6.) **Fix sealing strips to the flanges of the corner-strips (parts 4).**  
Fix the sealing strips inside the bolthole rows (see detail drawing 8).
- 4 **Aim the corner-strips at the end-flanges of the shutter-plate.**
- 10, 11 **Fix the corner-strips (2 pcs.) using bolts and nuts (M8 x 16, 8 + 8 pcs.).**





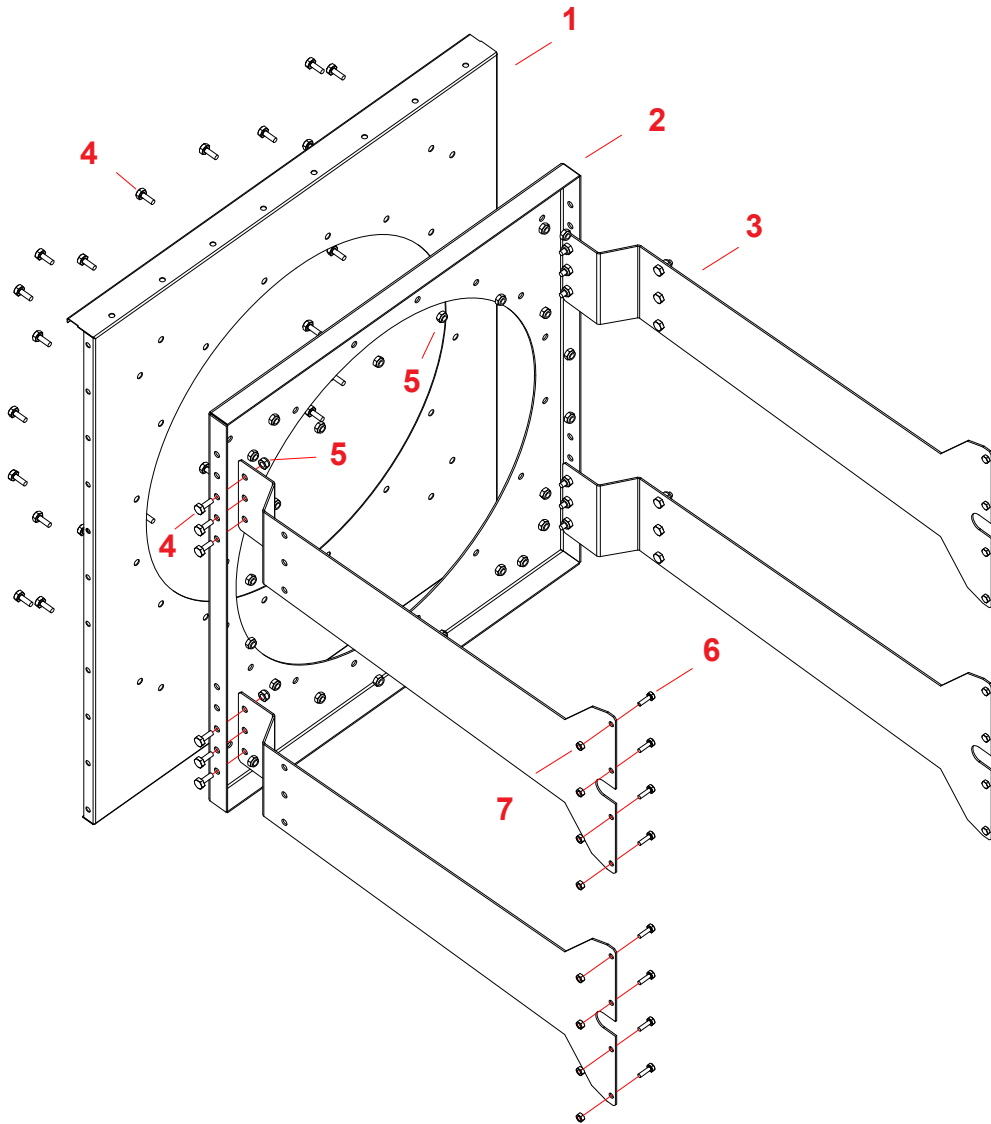
### 3. Assembling the air channel end

- 12 (7.) **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.*
- 10, 11 **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.
- 12 (8.) **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.*
- 10, 11 **Fix the part to the section and to the side-plates using bolts and nuts (M8 x 16, 16 + 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.*
- 10, 11 **Fix the set-up, assembled at stage 1, by its lower edge using bolts and nuts (M8 x 16, 23 pcs.).**  
10, 11 **Fix the set-up, assembled at stage 1, by its ends using bolts and nuts (M8 x 16, 11 + 11 pcs.).**
- 10, 11 **Fix the straight support for the air channel end using bolts and nuts (M 8 x 16, 2 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 (A76264) - fan mounting parts

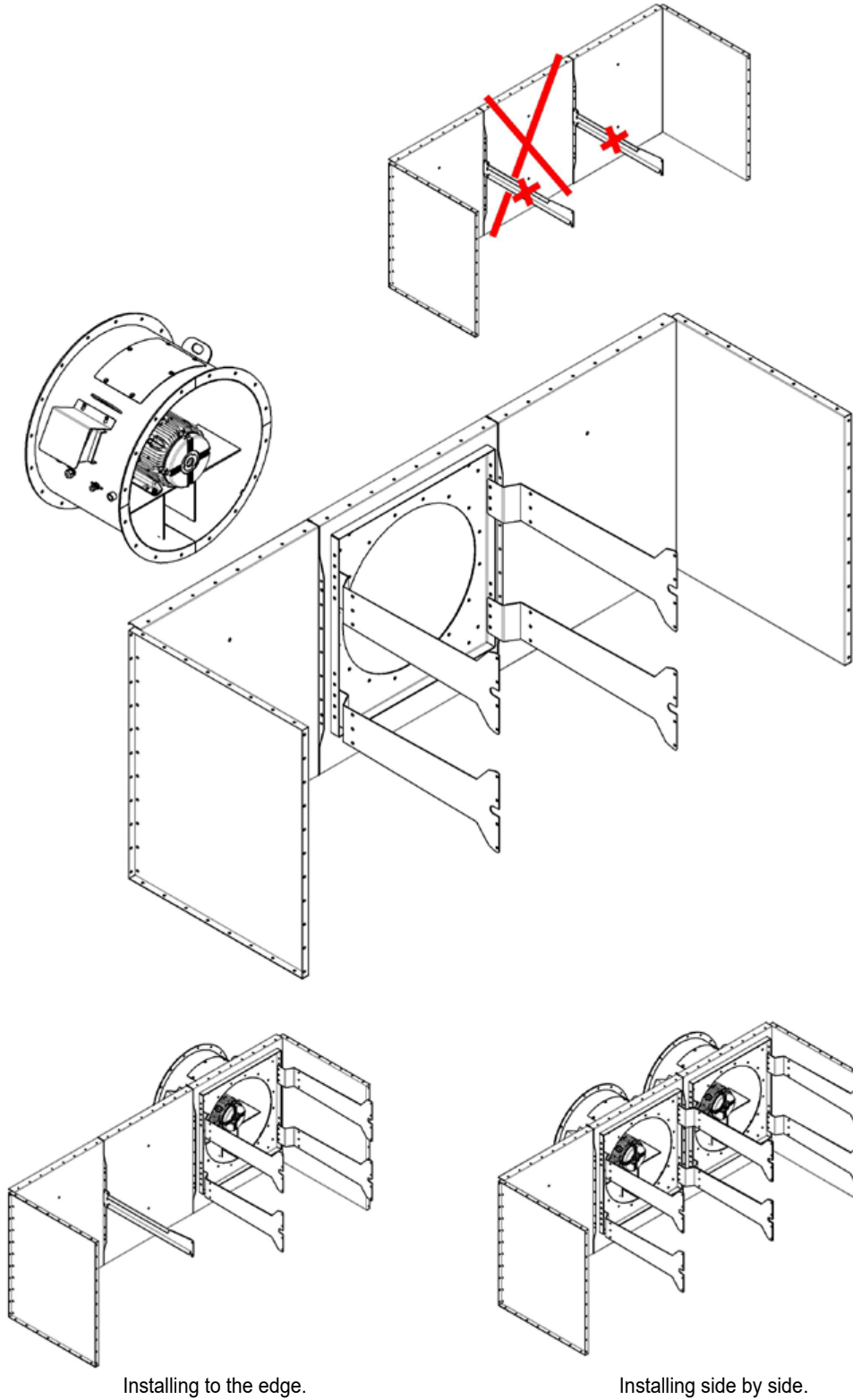
### Spare parts



| 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)



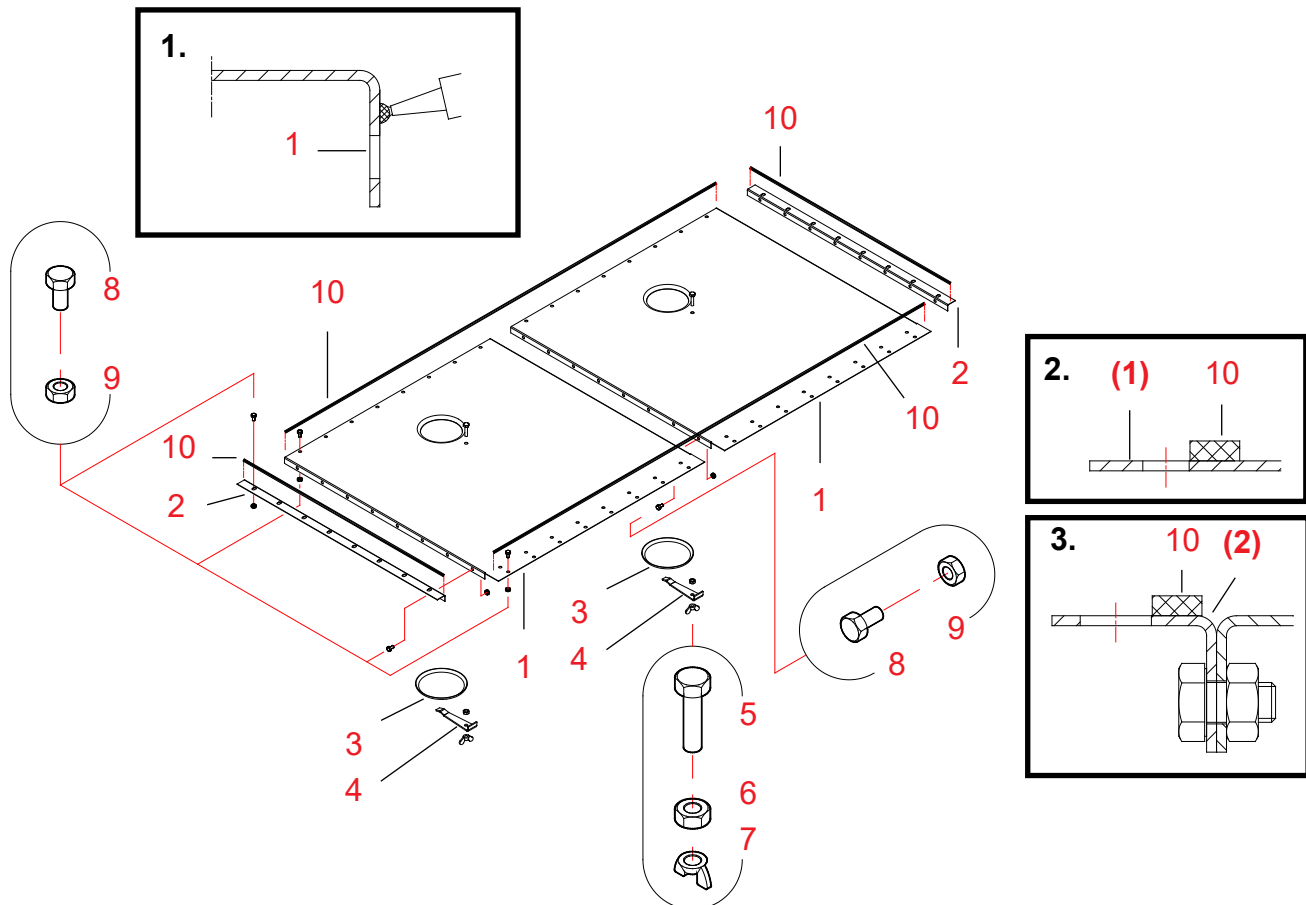
Installing to the edge.

Installing side by side.



## Air channel end 1,0 2W (A70913) - 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 | 2    | 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           |                        | 2    | S4293       | 0      | 3500  |
| 4    | 400150   | HATCH HOLDER           |                        | 2    | 4461-B      | 0      | 3500  |
| 5    | 102250   | HEX BOLT ZN 8.8        | 10X40 AM DIN933        | 2    |             | 0      | 2010  |
| 6    | 110560   | NUT ZN 8 M10           | DIN934                 | 2    |             | 0      | 2010  |
| 7    | 111030   | NUT WING ZN M10        | DIN315                 | 2    |             | 0      | 2010  |
| 8    | 101810   | HEX BOLT ZN 8.8        | 8X16 AM DIN933         | 56   |             | 0      | 2010  |
| 9    | 110540   | NUT ZN 8 M 8           | DIN934                 | 56   |             | 0      | 2010  |
| 10   | 115570   | SEALING STRIP          | 4X10 MAPA              | 4    |             | 0      | 2600  |
| 11   | 800271   | MASTIC SEALING/GLUE    | GREY 310 ML            | 1    |             |        | 2600  |

## Installing the lower shutter A70913 for the air channel end

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

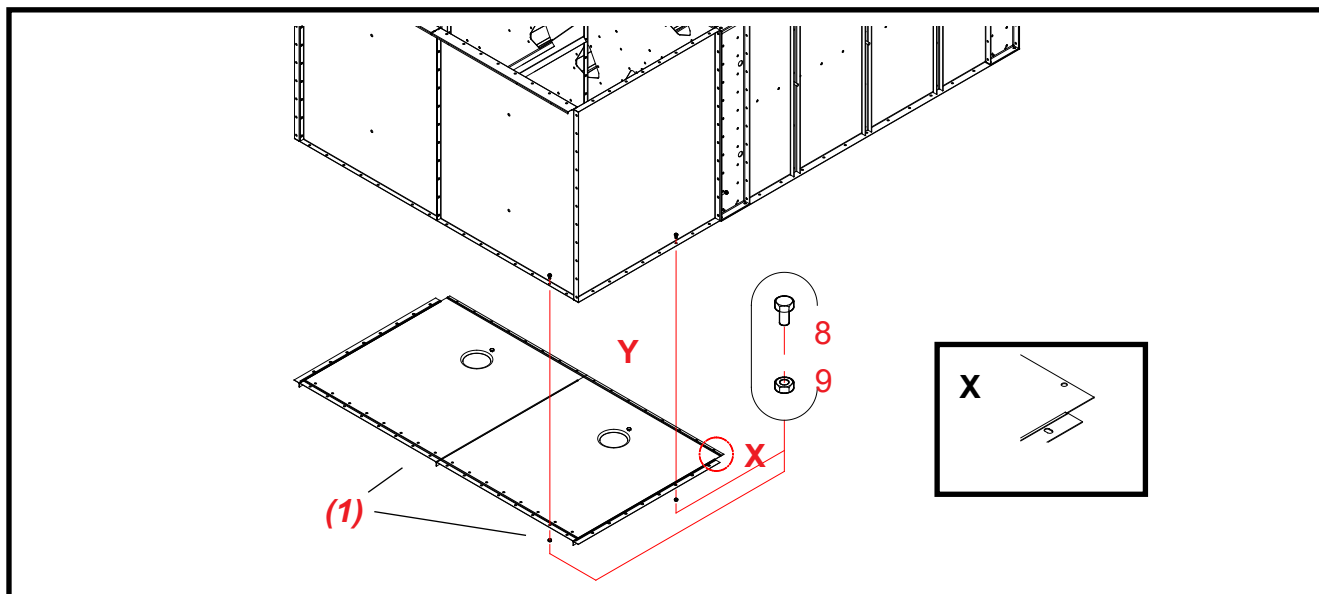
Parts The numbering of work stages refers to reference numbers in the spare parts drawing A70913 for the lower shutter.

- \* **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.
- 8, 9 **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.**
- 8, 9 **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

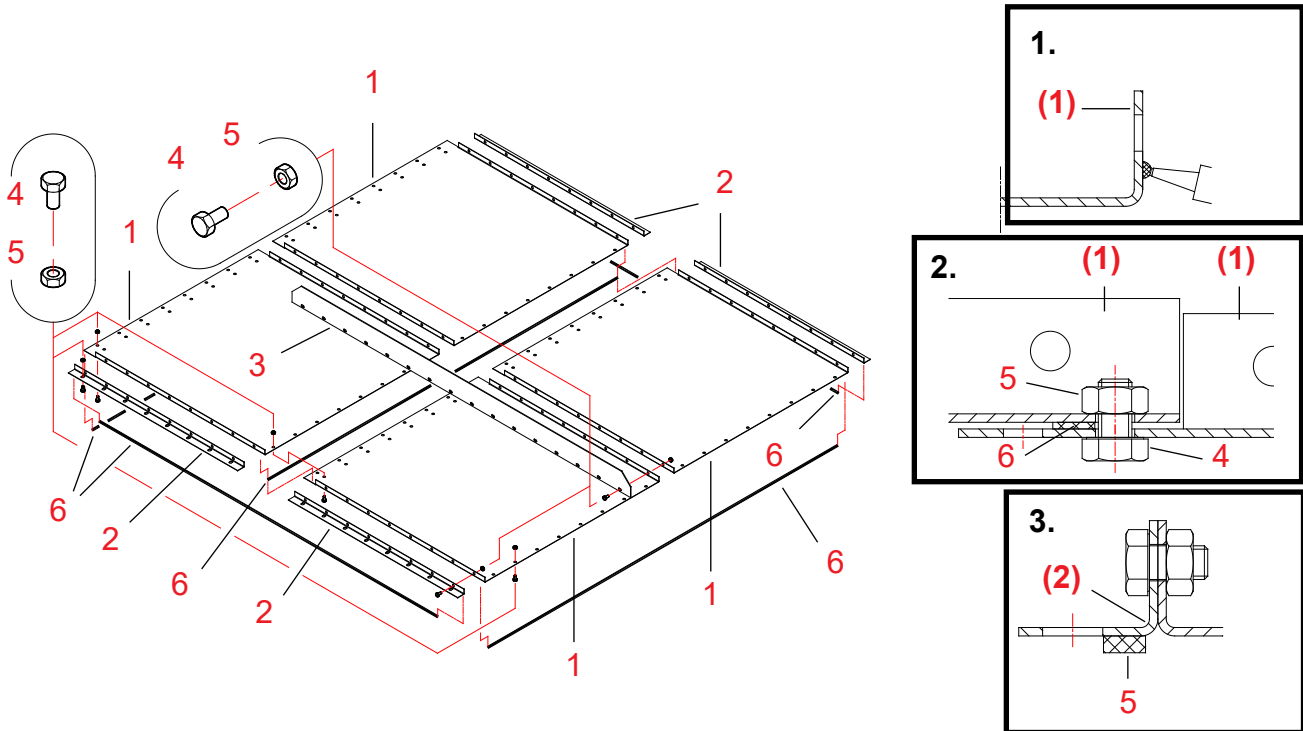
Parts Refer to installation drawing for the lower shutter A70913 of the air channel end.

- (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 X.
- 5, 6 **Fix the shutter-plate using bolts and nuts (M 8 x 16, 48 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 2W (A71015) - upper shutter B

### Spare parts



20080715tt

| 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      | 4    | A70570-A    | 0.94   | 3000  |
| 3    | A70975   | AIR CH END WM06 1.0X2  | LONG SUPPORT 1860 | 1    | A70975      | 4.27   | 3000  |
| 4    | 101810   | HEX BOLT ZN 8.8        | 8X16 AM DIN933    | 128  |             | 0      | 2010  |
| 5    | 110540   | NUT ZN 8 M 8           | DIN934            | 128  |             | 0      | 2010  |
| 6    | 115570   | SEALING STRIP          | 4X10 MAPA         | 6    |             | 0      | 2600  |
| 7    | 800271   | MASTIC SEALING/GLUE    | GREY 310 ML       | 1    |             |        | 2600  |

## Installing the upper shutter A71015 for the air channel end

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

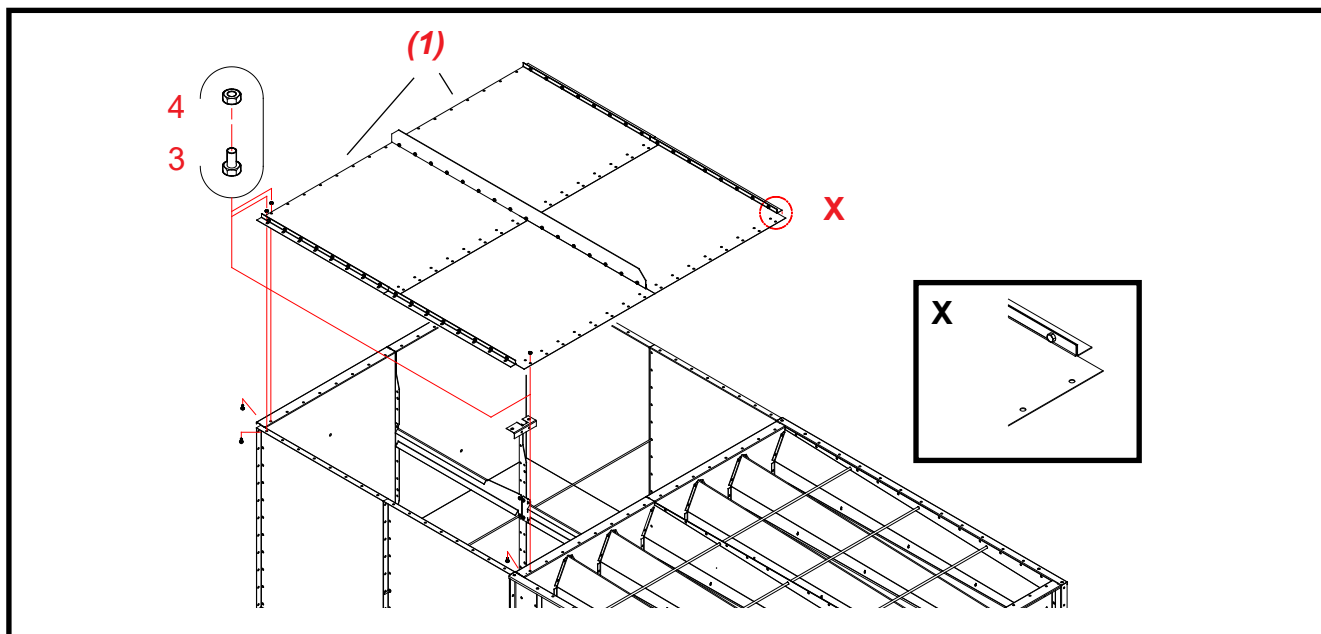
Parts The numbering of work stages refers to reference numbers in the spare parts drawing A71015 for the upper shutter of the air channel end.

- \* **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.

- 1 + 1      **Place two 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 two plates together using bolts and nuts (M 8 x 16, 8 pcs.).**
  
- 1 + 1, 6    **Assemble one more similar shutter-plate pair. Fix a sealing strip to its lower surface.**  
Fix a sealing strip to the straight edge of the plate pair with single screw hole row.  
Fix the sealing strip inside the screw hole row (see detail drawing 2).
  
- \*          **Place the shutter-plate pair with sealing on top of the other plate pair.**  
*Be careful not to damage the sealing strip while joining the plates.*  
Align the hole row in the upper plate pair with the inner hole row in the lower plate pair (see detail drawing 2).
  
- 4, 5      **Fix the plate pairs by their straight edges using bolts and nuts (M 8 x 16, 8 + 8 pcs.).**
  
- 3, 4, 5    **Fix the long support and the centre seam of the plate pairs using bolts and nuts (M 8 x 16, 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

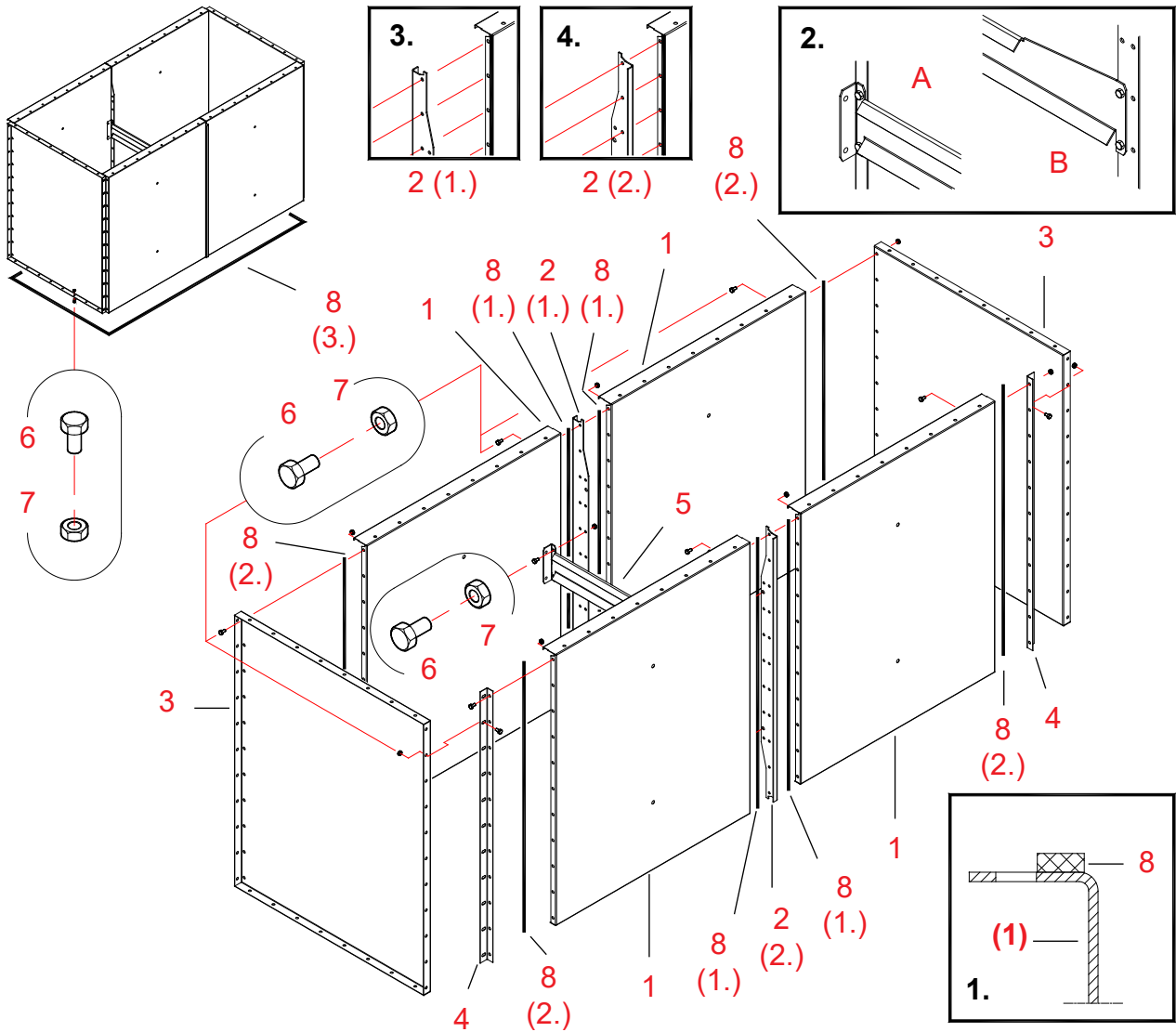
- (1)        **Move the assembly against the flanges at the upper end of the air channel end.**  
*Be careful not to damage the sealing strips while installing the plate.*  
Check correct position for the assembly in detail drawing X.
  
- 3, 4      **Fix the shutter-plate using bolts and nuts (M 8 x 16, 64 pcs.).**





## Air channel end 1,0 2W (A71332) - 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            | 4    | A70563-B    | 14.65  | 3000  |
| 2    | A70810   | TOP SECTION WM06       | VERTICAL SUPPORT PL3 | 2    | 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     | 1    | A70678-B    | 1.79   | 3000  |
| 6    | 101810   | HEX BOLT ZN 8.8        | 8X16 AM DIN933       | 126  |             | 0      | 2010  |
| 7    | 110540   | NUT ZN 8 M 8           | DIN934               | 126  |             | 0      | 2010  |
| 8    | 115570   | SEALING STRIP          | 4X10 MAPA            | 18   |             | 0      | 2600  |



## Assembling air channel end A71332

### 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 A71332 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 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 pairs of end-plates with vertical supports. Place the vertical support between the end-plates.**  
*Note, that the position of the vertical support 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 A71376.*  
*Be careful not to damage the sealing strips while installing the vertical support.*
- 6, 7 **Fix the end-plates and the vertical support using bolts and nuts (M8 x 16, 11 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 5 **Bend the straight support for the air channel end along the bending line and install it in the vertical support (part 2).**  
Look up, in the detail drawing 2A, how to bend the support and, in the main drawing, its correct position.  
Place one end of the support in the vertical support of the other end-plate pair as shown in the detail dwg. 2B.
- 6, 7 **Fix both ends of the support 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.

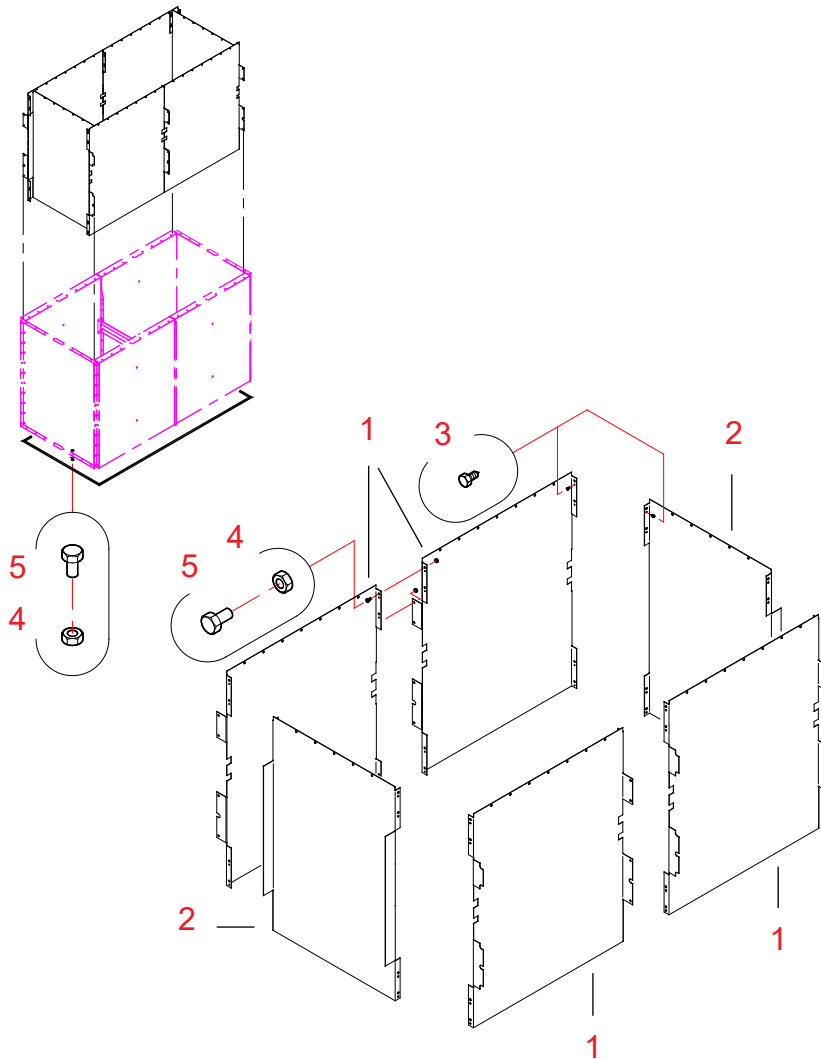
### 3. Installing the air channel end

- 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, 16 + 16 + 8 + 8 pcs.).**
- \* **Check the joints and rectangular shape of the set-up. Tighten all bolts.**

## Air channel end 1,0 2W (A71376) - radiation shields

### Spare parts

### An accessory to be installed inside the air channel ends



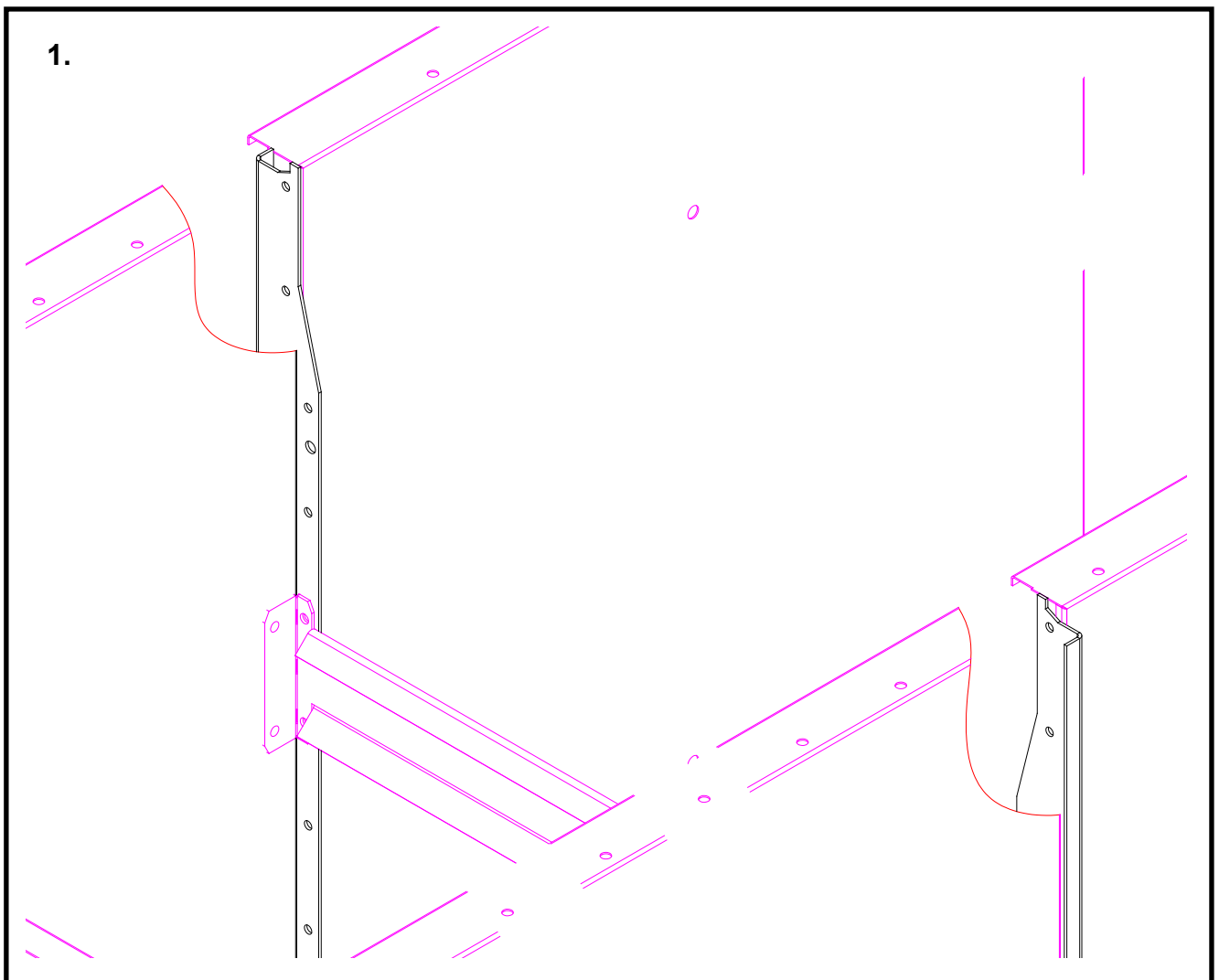
20080716

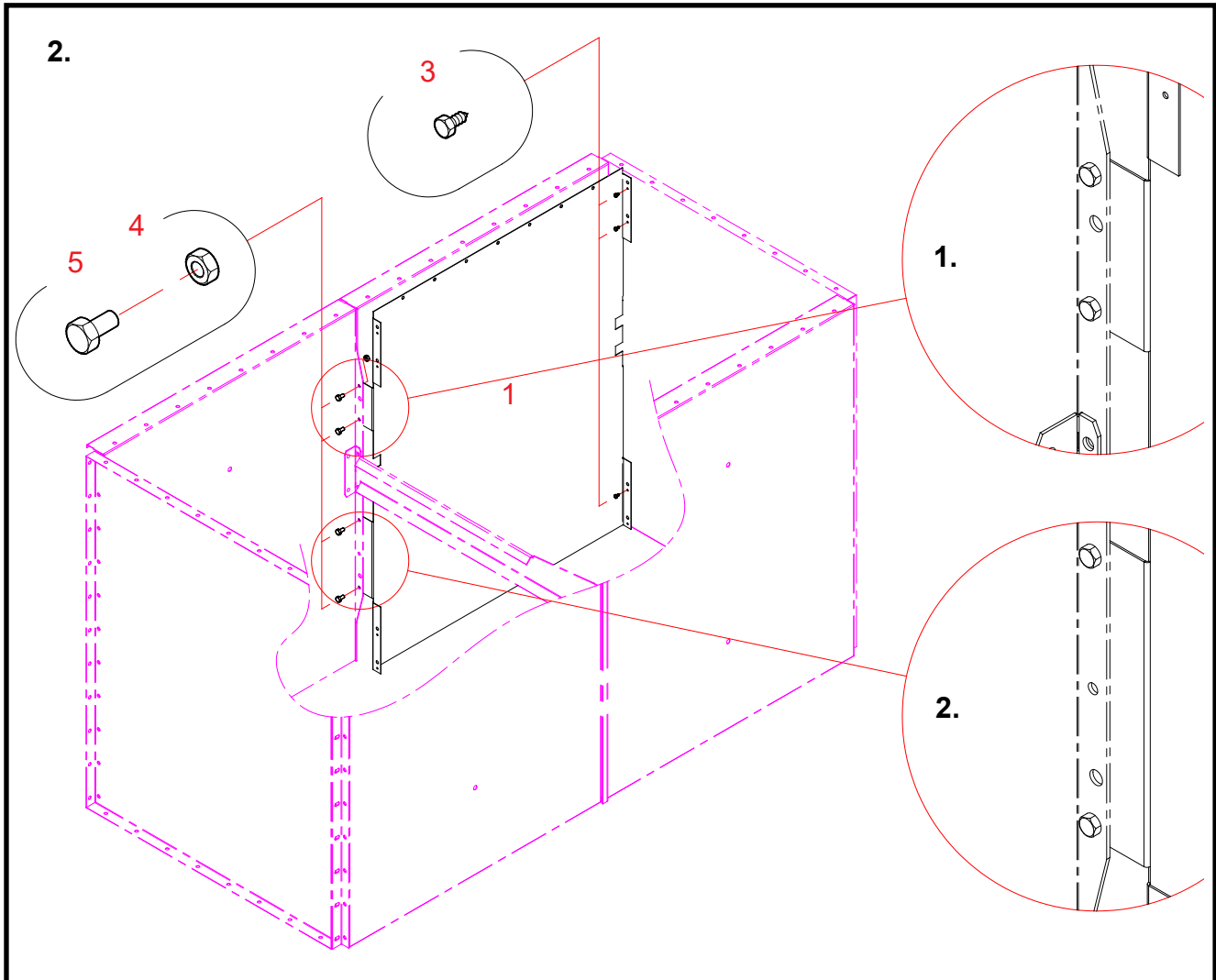
| Ref. | Part no. | Denomination 1     | Denomination 2  | Pcs. | Drawing No. | Weight | Group |
|------|----------|--------------------|-----------------|------|-------------|--------|-------|
| 1    | A71375   | AIR PIPE WM06 1,0  | RAD SHIELD END  | 4    |             | 14.07  | 3000  |
| 2    | A71374   | AIR PIPE WM06 1,0  | RAD SHIELD SIDE | 2    |             | 11.98  | 3000  |
| 3    | 107720   | SELF-TAP HEX SCREW | 4,8X13 ZN       | 74   |             | 0      | 2010  |
| 4    | 110540   | NUT ZN 8 M 8       | DIN934          | 16   |             | 0      | 2010  |
| 5    | 101820   | HEX BOLT ZN 8.8    | 8X20 AM DIN933  | 16   |             | 0      | 2010  |

## Assembling air channel end A71376

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!





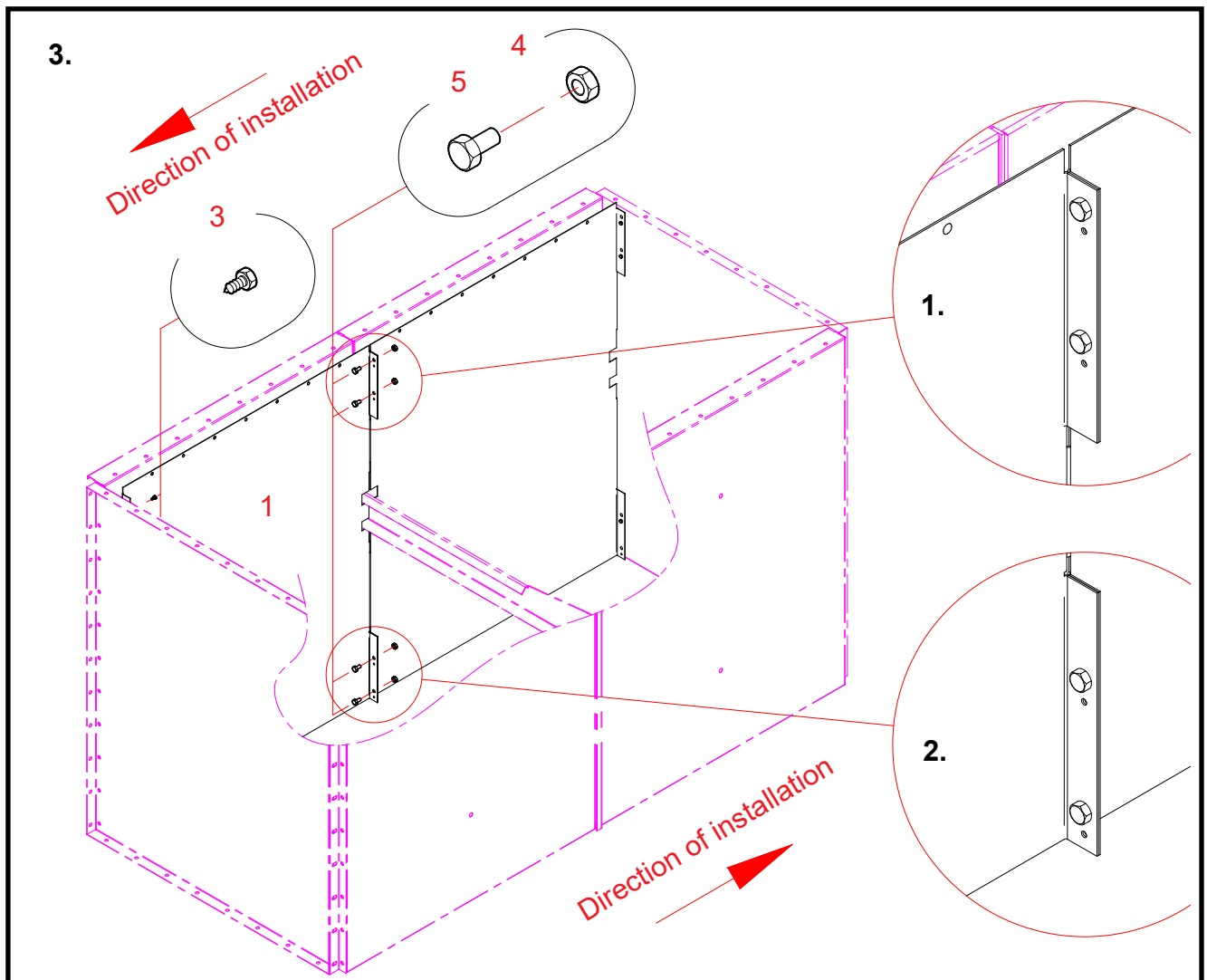
## 2. Installing the first radiation shield in the end-plate of the air channel end.

Parts The numbering of work stages refers to reference numbers in the spare parts drawing A71376 for the air channel end.

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

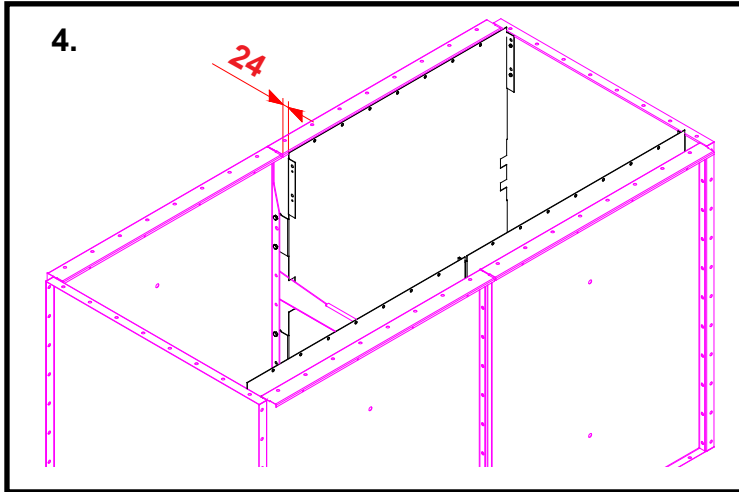
**4, 5** Fix the radiation shield to the vertical support for the air channel end using bolts and nuts (M 8 x 20, 4 pcs.).  
See detail drawings 1 and 2.

**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.



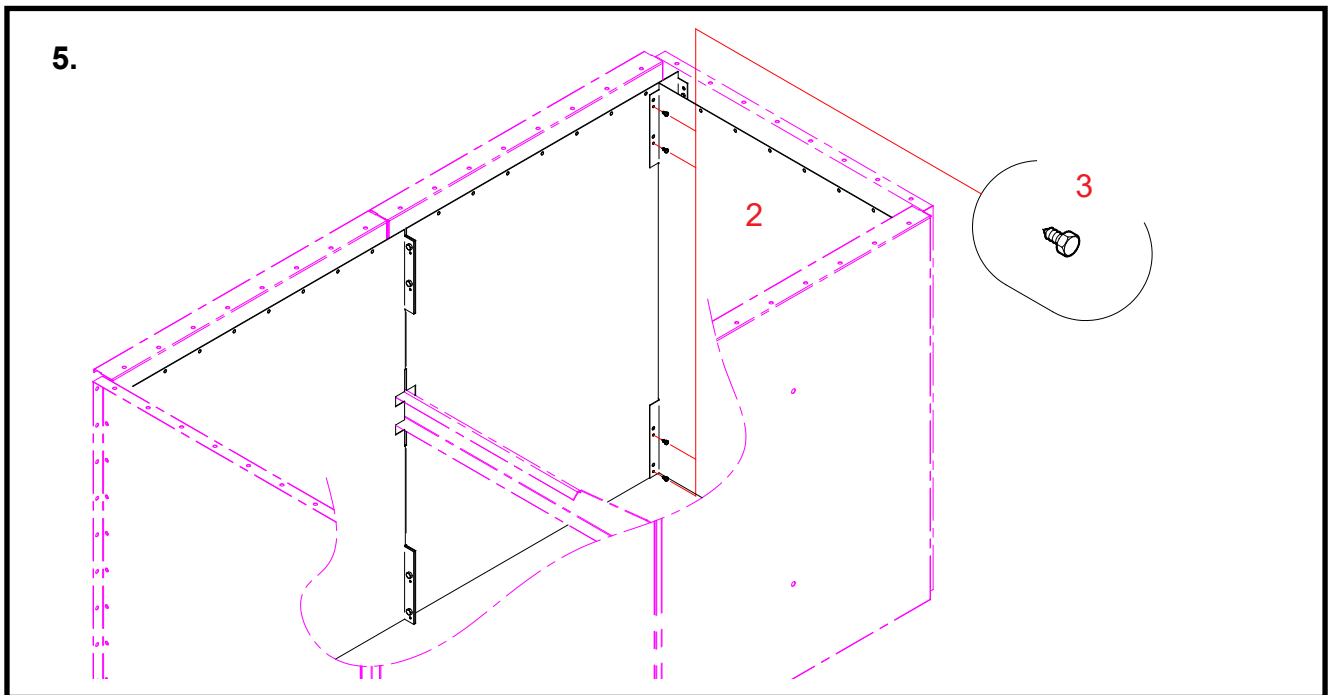
### 3. Installing the second radiation shield in the end-plate of the air channel end.

- 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.
- 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 shields to the other end-plates of the air channel end in the same way.  
*Observe the installation direction of the radiation shields!*



**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.**

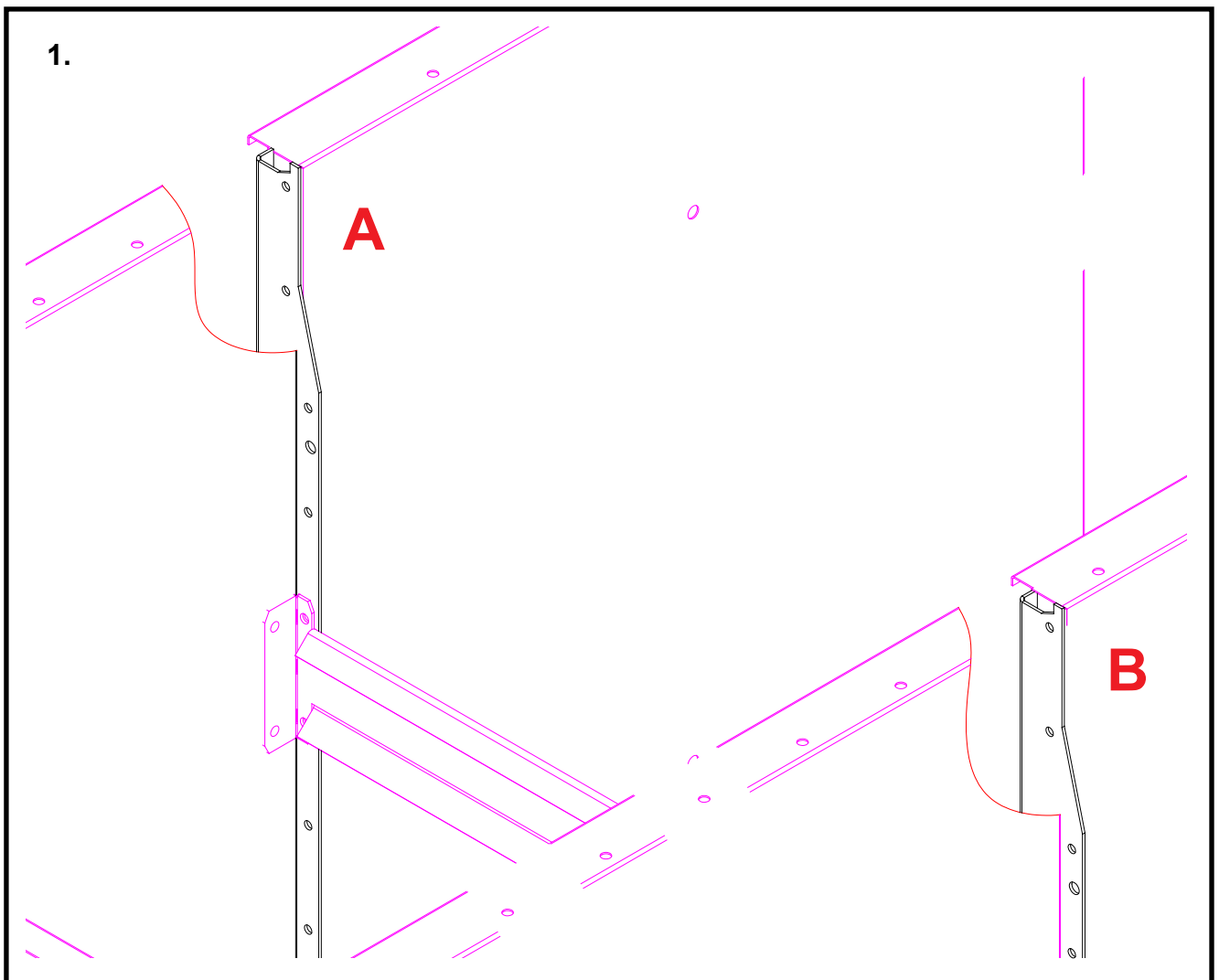
## Assembling air channel end A71376

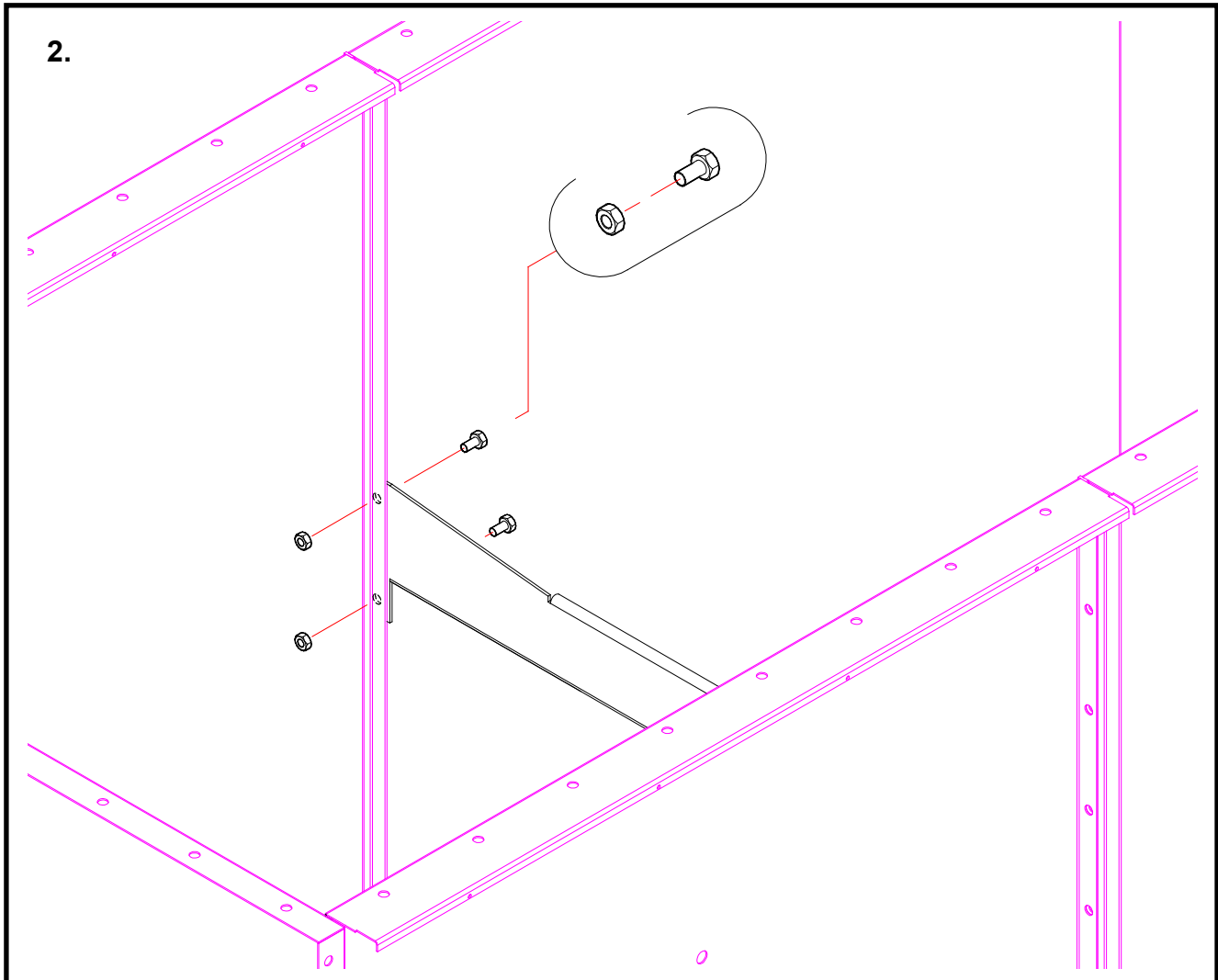
Stages 1 - 5: Special installation - of the two parallel air channel ends (2 x 1,0 m) the one installed on the same side as the drying section.

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

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

Check the direction of installation of the vertical support and turn it, as necessary.

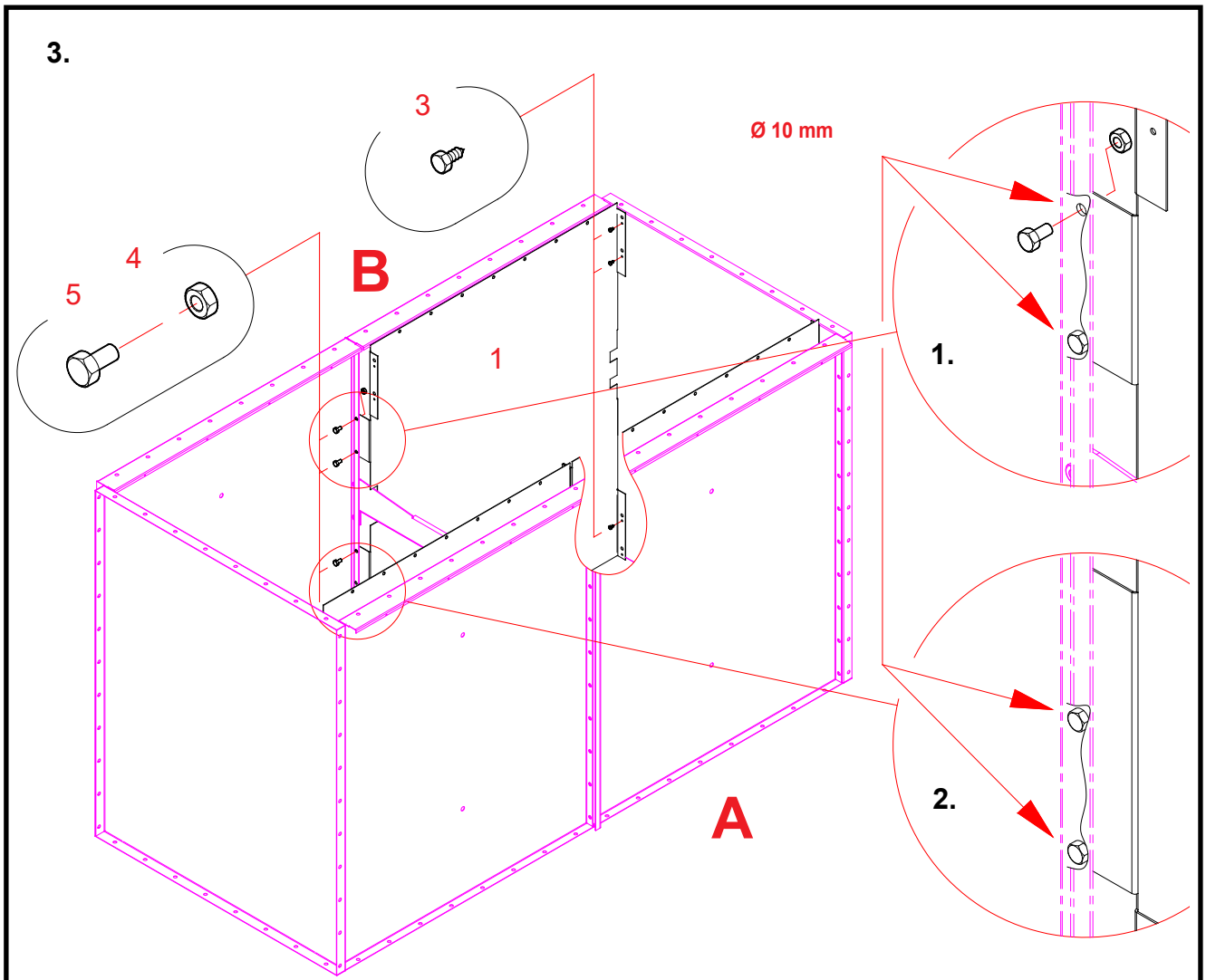




## 2. Reattachment of the straight support for the air channel end, if you have had to turn the vertical support

### Parts

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



### 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 A71376 for the air channel end.

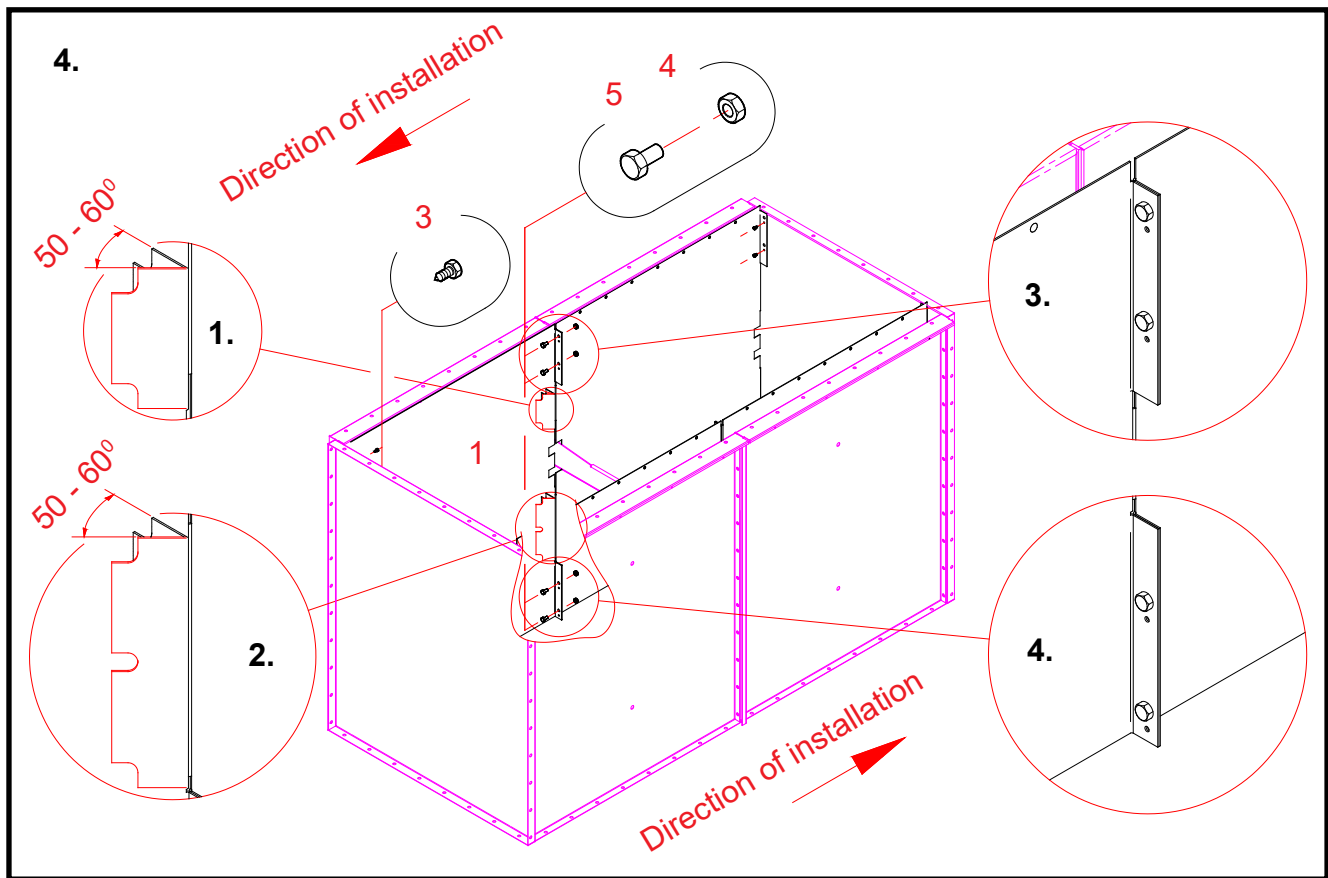
\* Install the radiation shields on the side A in accordance with the points 2-3 for the standard installation.

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.

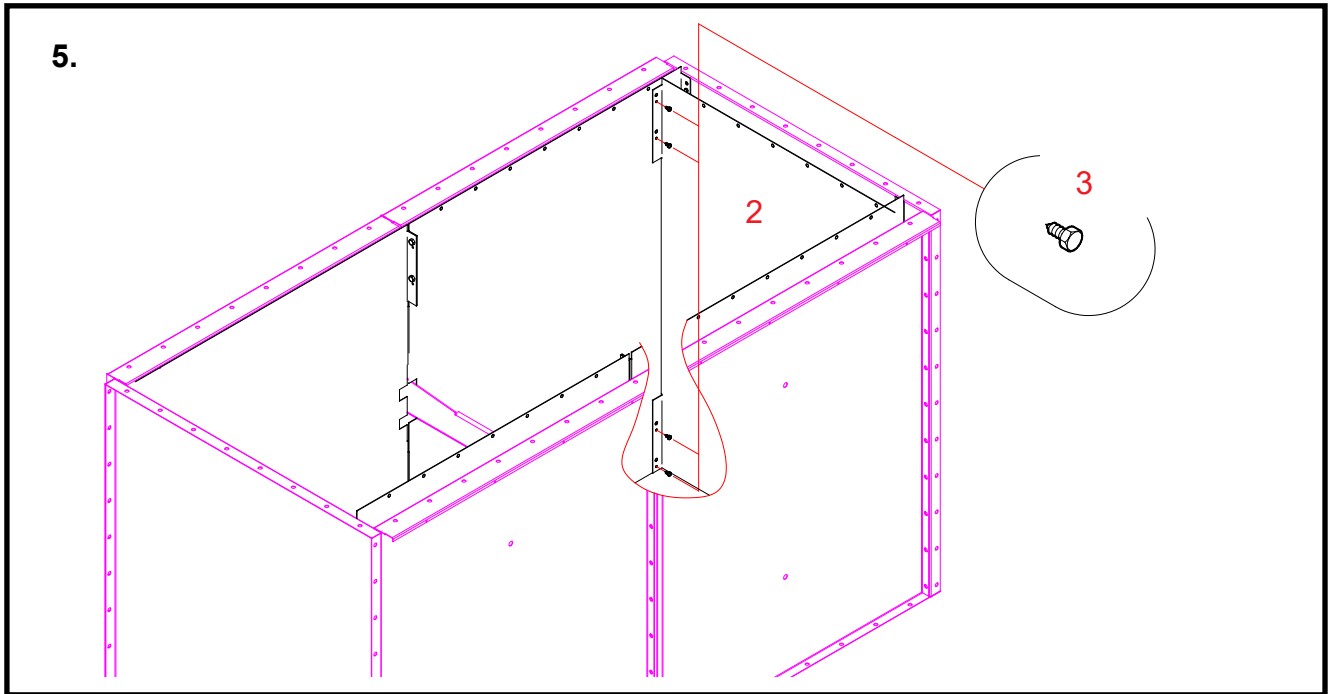
4, 5 Fix the radiation shield to the vertical support for the air channel end using bolts and nuts (M 8 x 20, 4 pcs.).  
See detail drawings 1 and 2.

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 radiation shield in the end-plate of the air channel end.

- \* **Bend more the two tongues of the radiation shield.**  
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.
- 3 **Fix the radiation shield to the side-plate of the air channel end using self-tapping screws (4,8 x 13, 3 pcs.).**



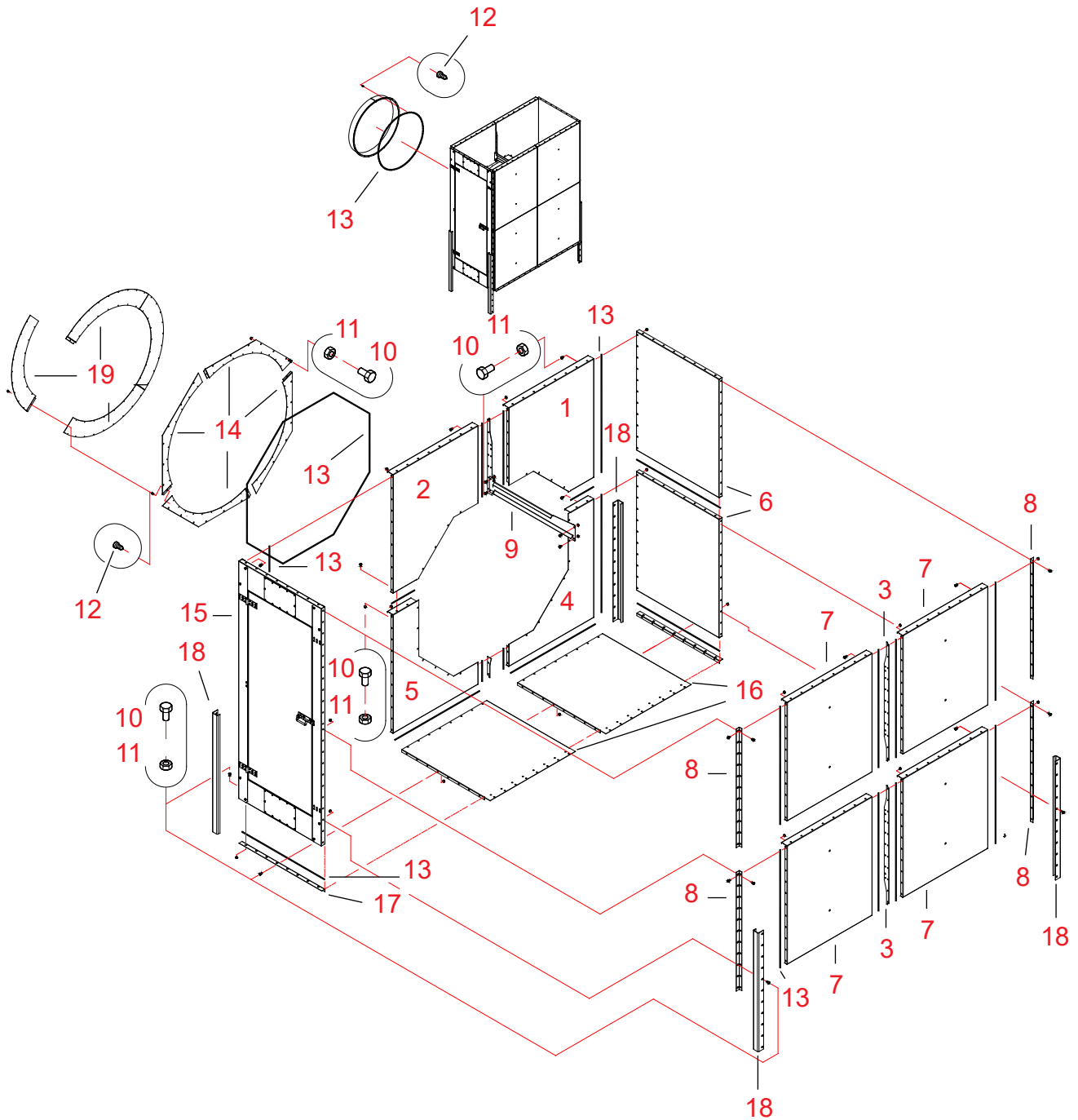
### 5. Installing the radiation shields on the side-plates of the air channel end

- 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 2W (A71393) - channel S, octagonal / Ø 1250 mm

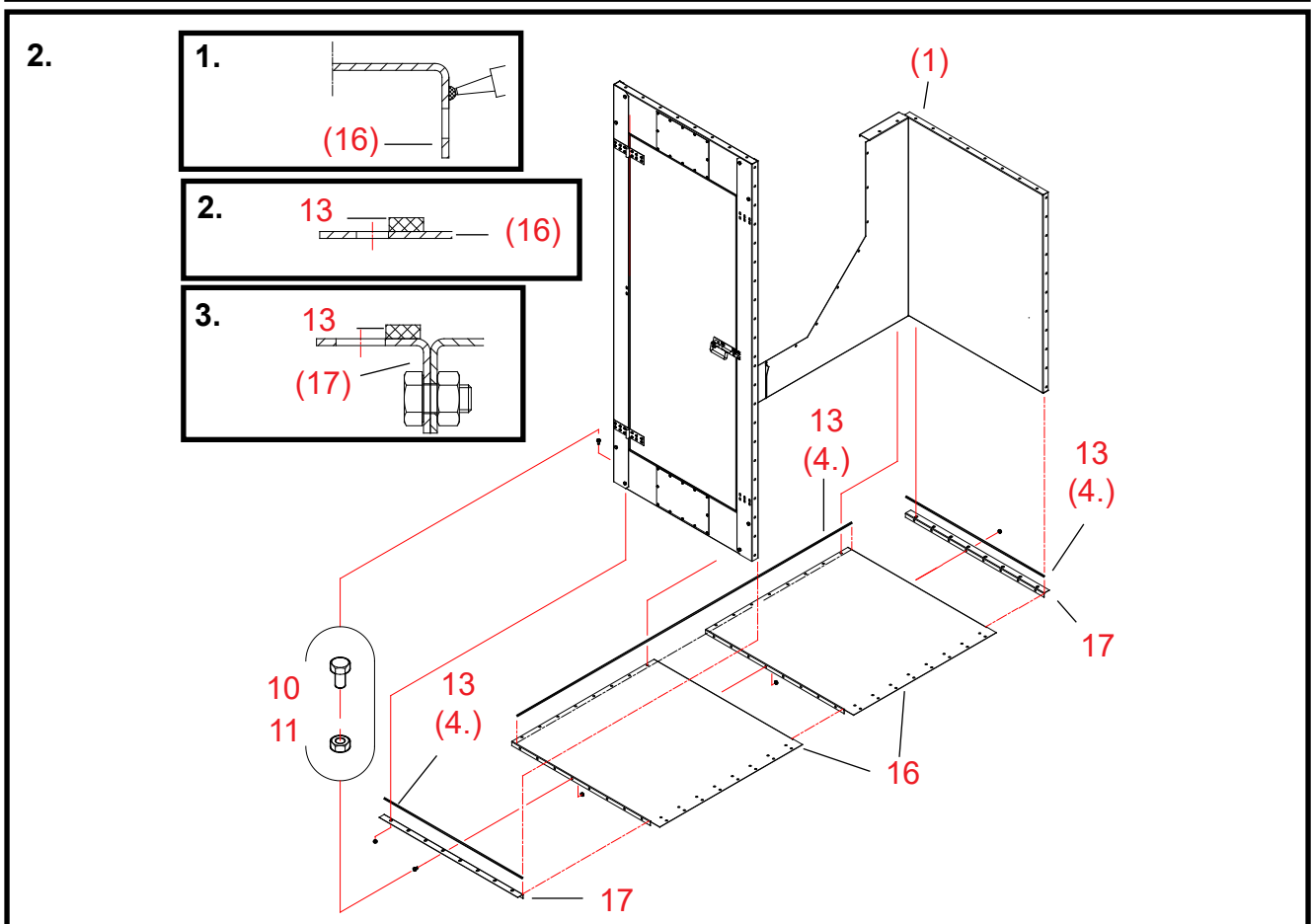
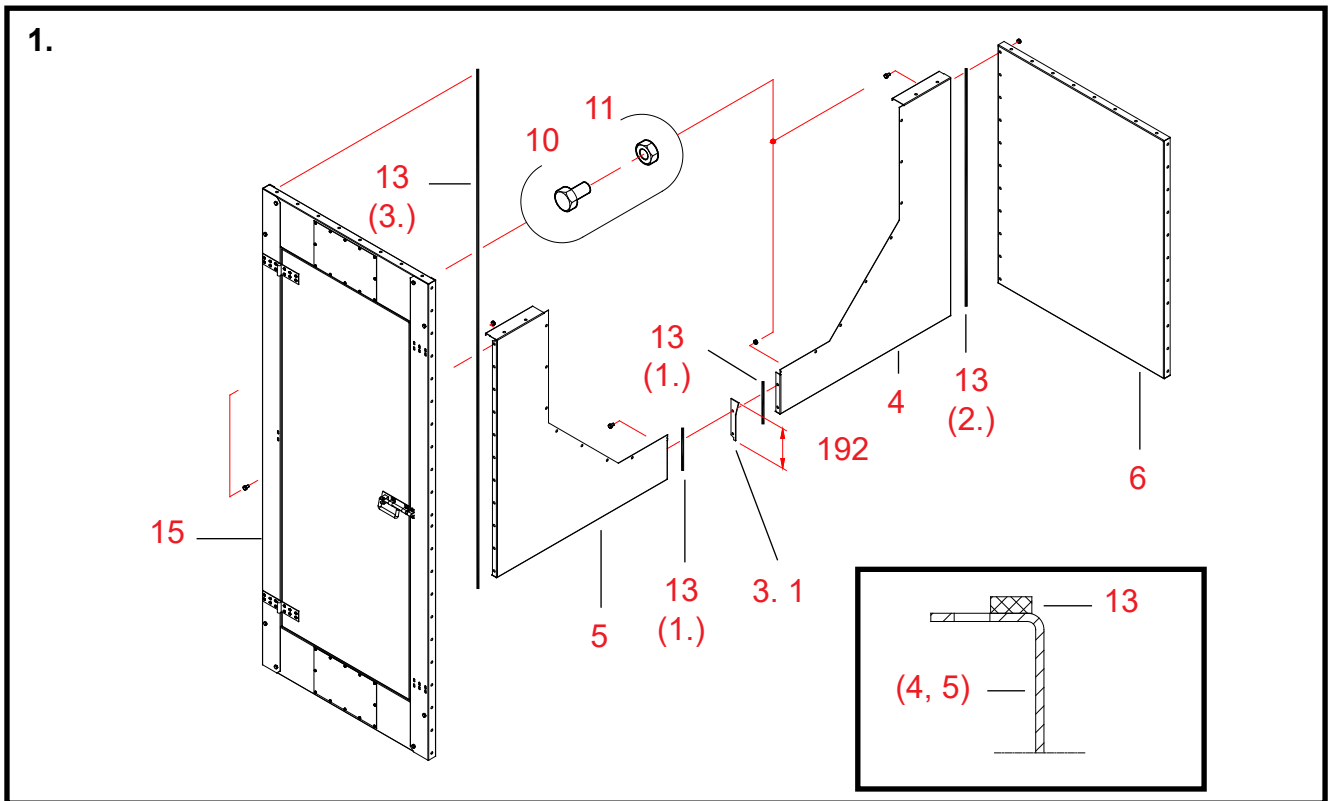
### Spare parts





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  | 3    | 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             | 4    | 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      | 1    | A70678-B    | 1.79   | 3000  |
| 10   | 101810   | HEX BOLT ZN 8.8        | 8X16 AM DIN933        | 371  |             | 0      | 2010  |
| 11   | 110540   | NUT ZN 8 M 8           | DIN934                | 371  |             | 0      | 2010  |
| 12   | 107720   | SELF-TAP HEX SCREW     | 4,8X13 ZN             | 72   |             | 0      | 2010  |
| 13   | 115570   | SEALING STRIP          | 4X10 MAPA             | 46   |             | 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         | 2    | 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 A71393

### 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 A71393 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.*

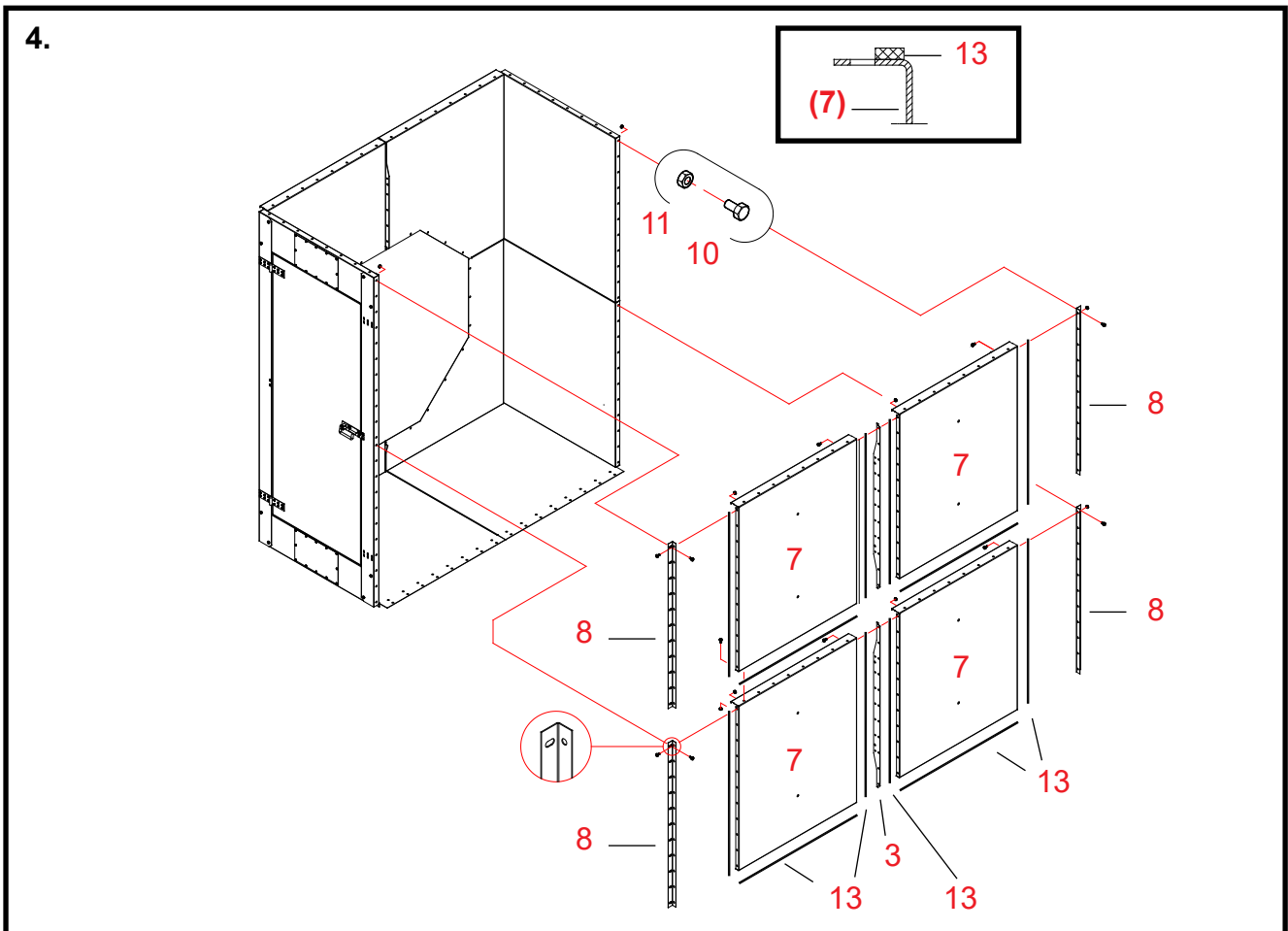
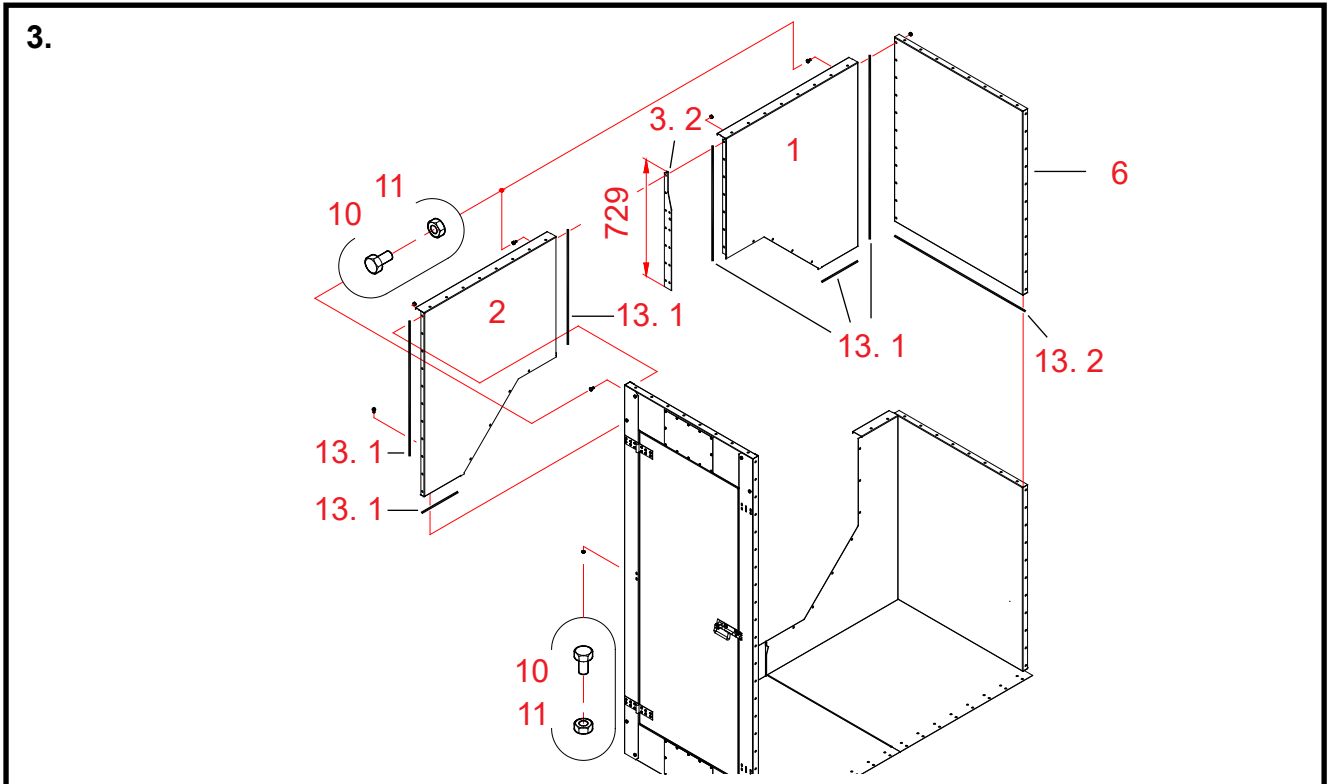
- 13 (1.) Fix sealing strips to the short end-flanges of the end-plates (parts 4 and 5).  
13 (2.) Fix sealing strips to the long end-flange of the end-plate 4.  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing).
- 4 + 5 Move the short flanges of the end-plates close 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.
- 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 and the corner-strips 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 1).  
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 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 strip inside the screw hole rows onto the upper surfaces of the shutter-plates (see detail drawing 2).  
Fix the sealing strips inside the screw hole rows onto the upper surfaces of the corner-strips (see detail drawing 3).

### 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 flanges at the lower end of the air channel end.  
*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 + 16 + 8 pcs.).



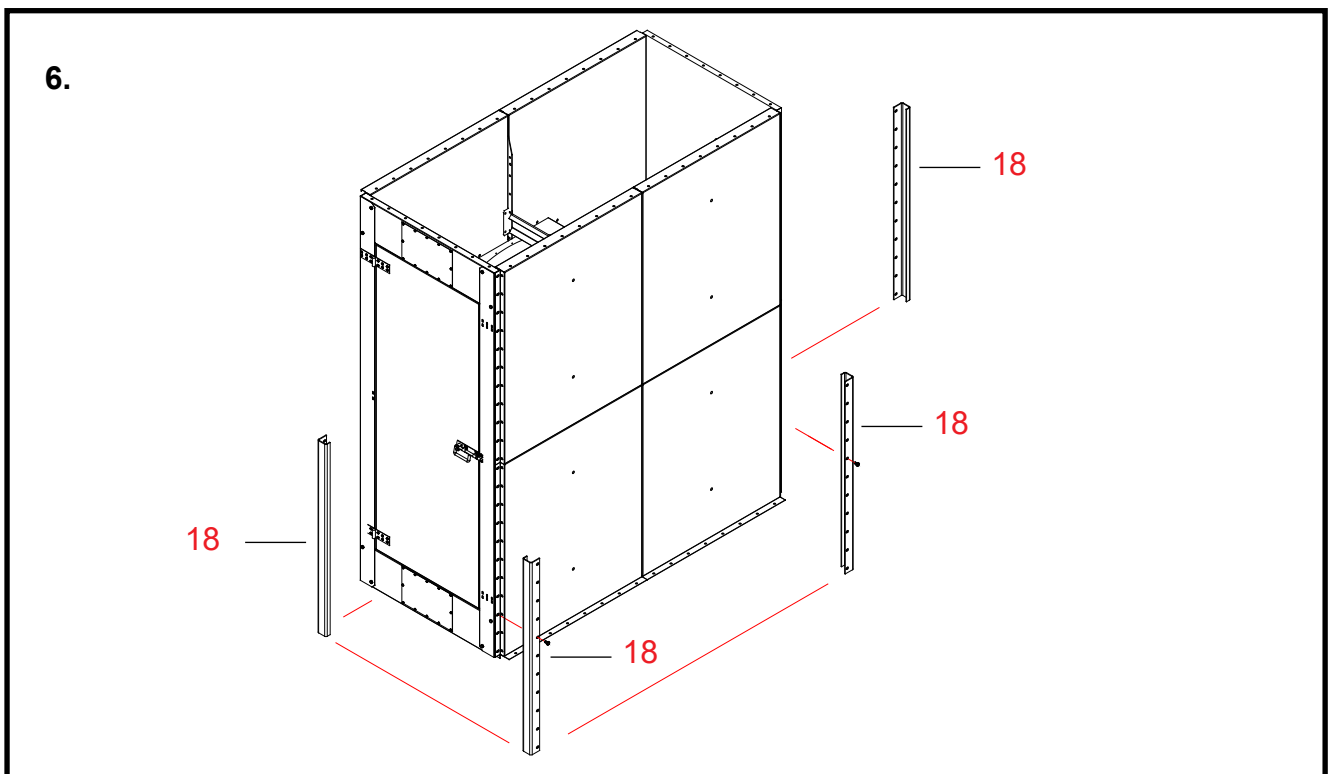
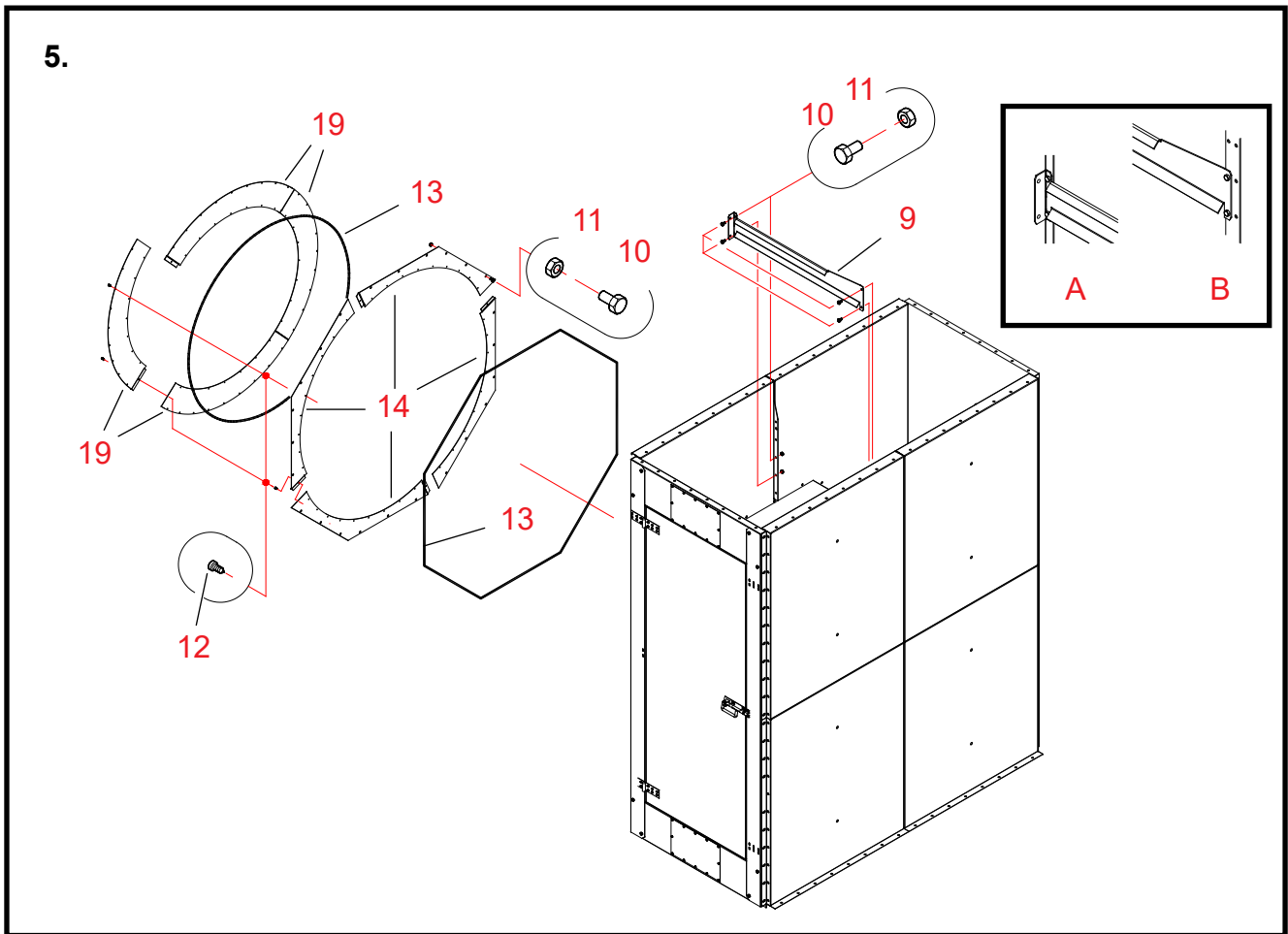


### 3. Joining together the upper end-plate and the side-plate of the air channel end

13. 1      **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. 2      **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.
- (3)        **Move the set-up, assembled at stage 3, on top of the set-up, assembled at stage 1.**
- 10, 11     **Join the set-ups together using bolts and nuts (M8 x 16, 23 pcs.).**

### 4. Installing the rear-plate for the air channel end

- 13        **Fix sealing strips to both end-flanges and lower flanges of the end-plates ( 4 pcs. of parts 7).**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing).
- 3        **Place the vertical supports 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 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 3.**
- 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.





## 5. 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            **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.).**
- 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            **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.**

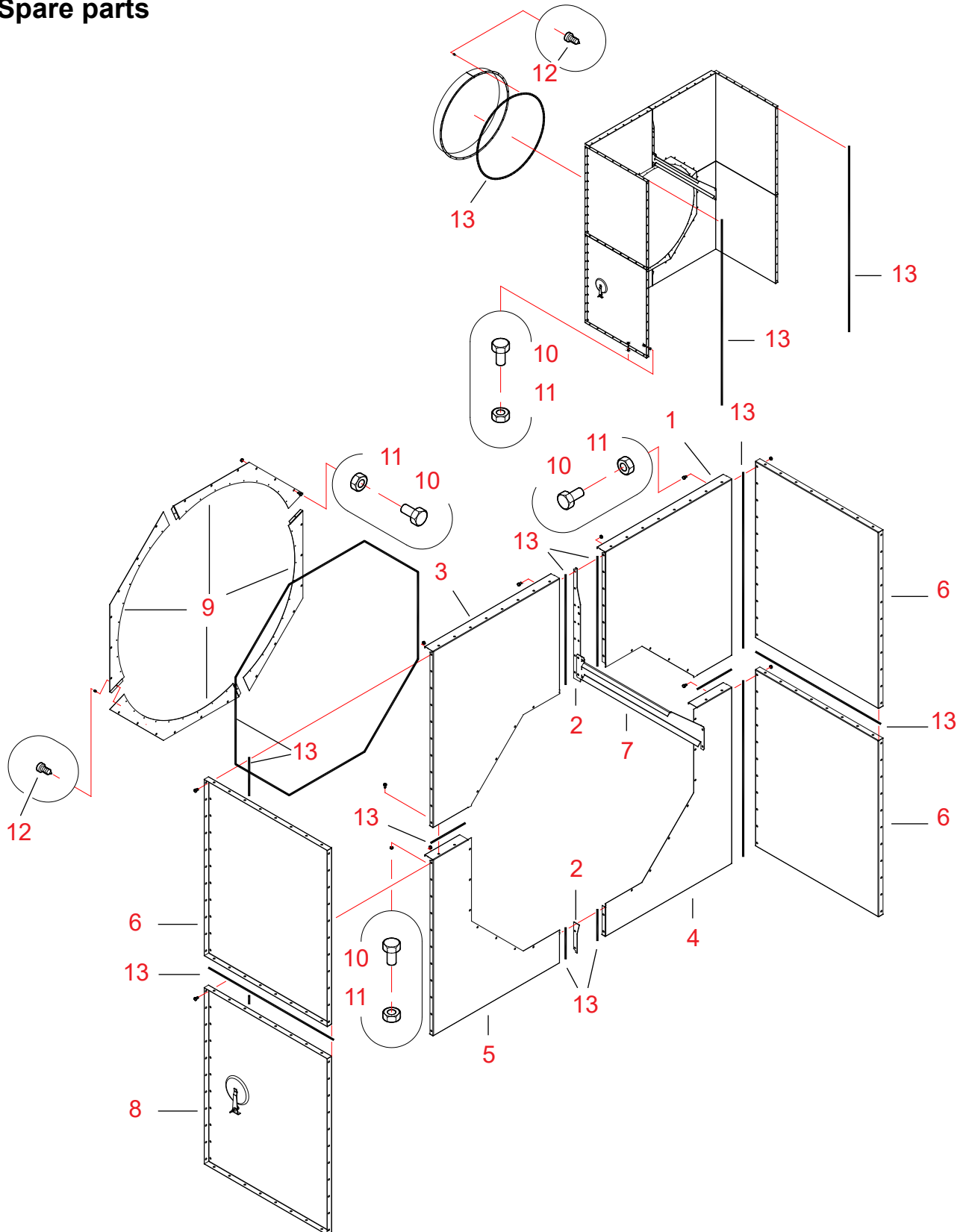
## 6. Installing the ground support legs for the air channel end

- 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 2W (A71402) - centre-part S, octagonal / Ø 1250 mm

### Spare parts





20061019

| 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 | 2    | 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     | 1    | 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       | 175  |             | 0      | 2010  |
| 11   | 110540   | NUT ZN 8 M 8           | DIN934               | 175  |             | 0      | 2010  |
| 12   | 107720   | SELF-TAP HEX SCREW     | 4,8X13 ZN            | 40   |             | 0      | 2010  |
| 13   | 115570   | SEALING STRIP          | 4X10 MAPA            | 21   |             | 0      | 260   |





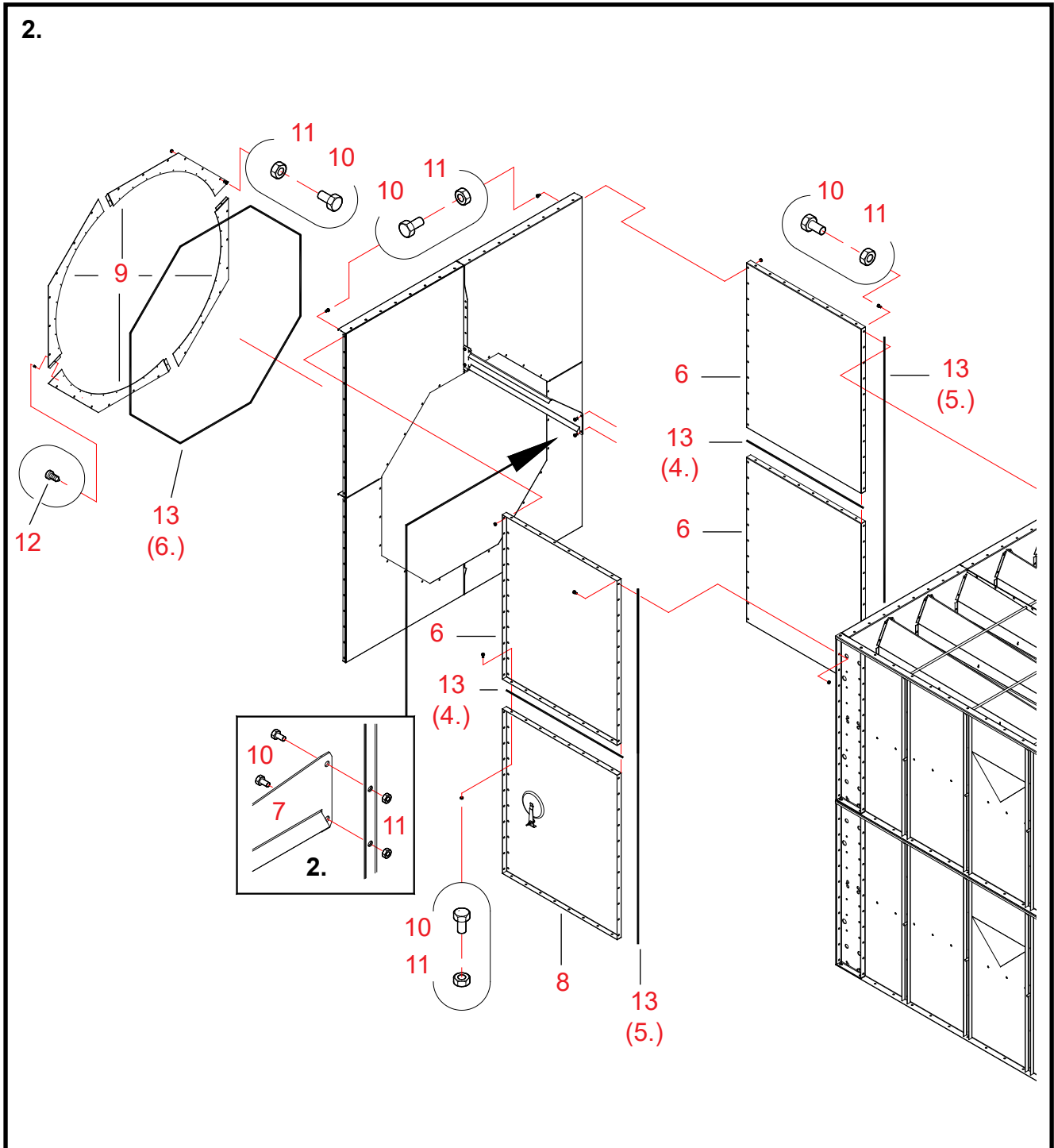
## Assembling air channel end A71402

### 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 A71402 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).**  
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.
- 13 (2.)            **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.
13. 3              **Fix sealing strips to lower flanges of the end-plates 1 and 3.**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing in drawing 1).
- 1 + 3  
4 + 5              **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, 2 + 2 pcs.).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 7                   **Attach the straight air channel end support to the vertical support of the end-plate.**  
Look up correct position for the support in the drawing.
- 10, 11            **Fix the 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.





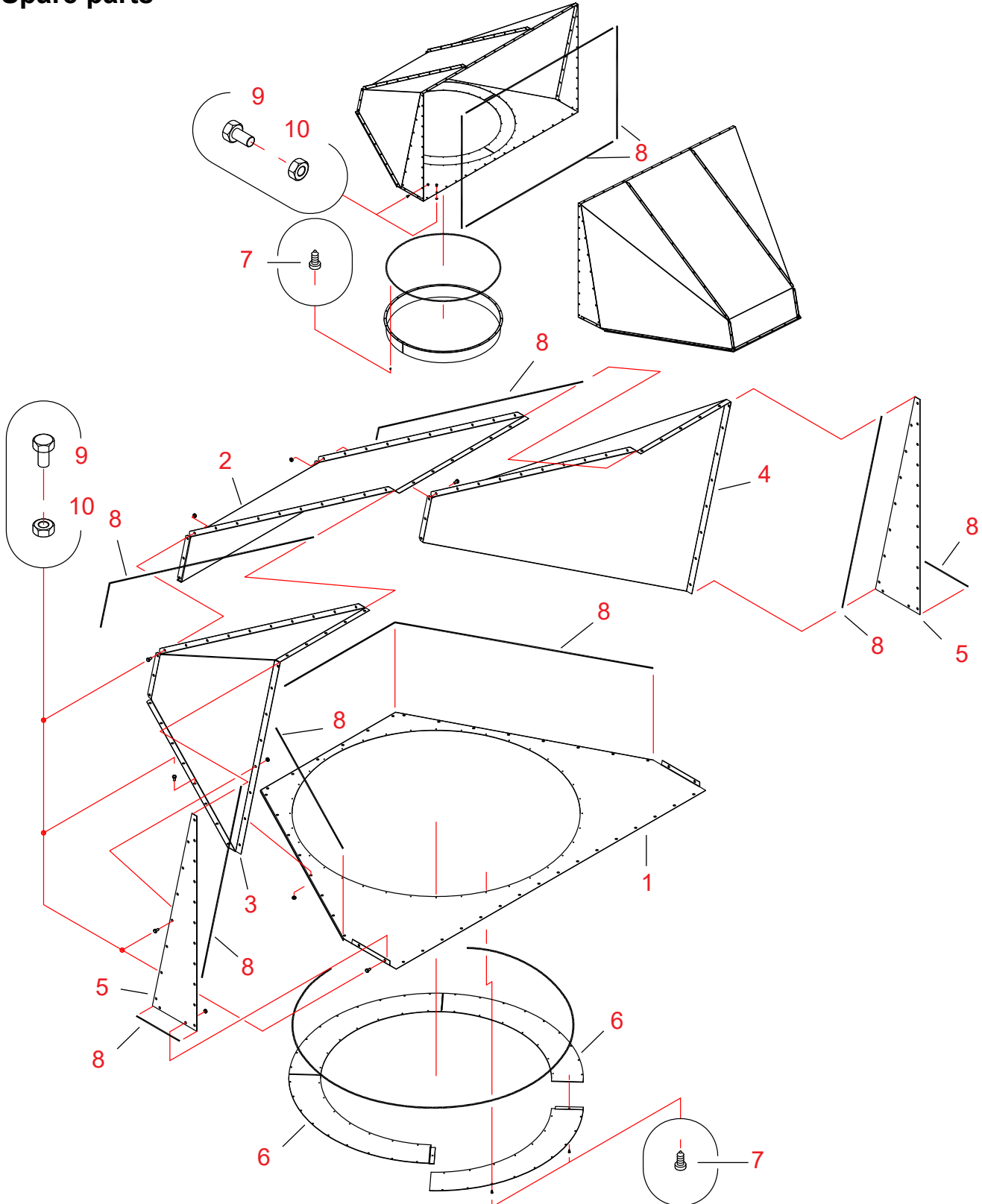
### 2. Installing the side-plates of the air channel end

- 13 (4.) **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 (5.) **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 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.
- 9, 12 **Assemble the octagonal adapter of the four parts.**  
**Fix the parts using self-tapping screws (4,8 x 13, 4 pcs.).**
- 13 (6.) **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

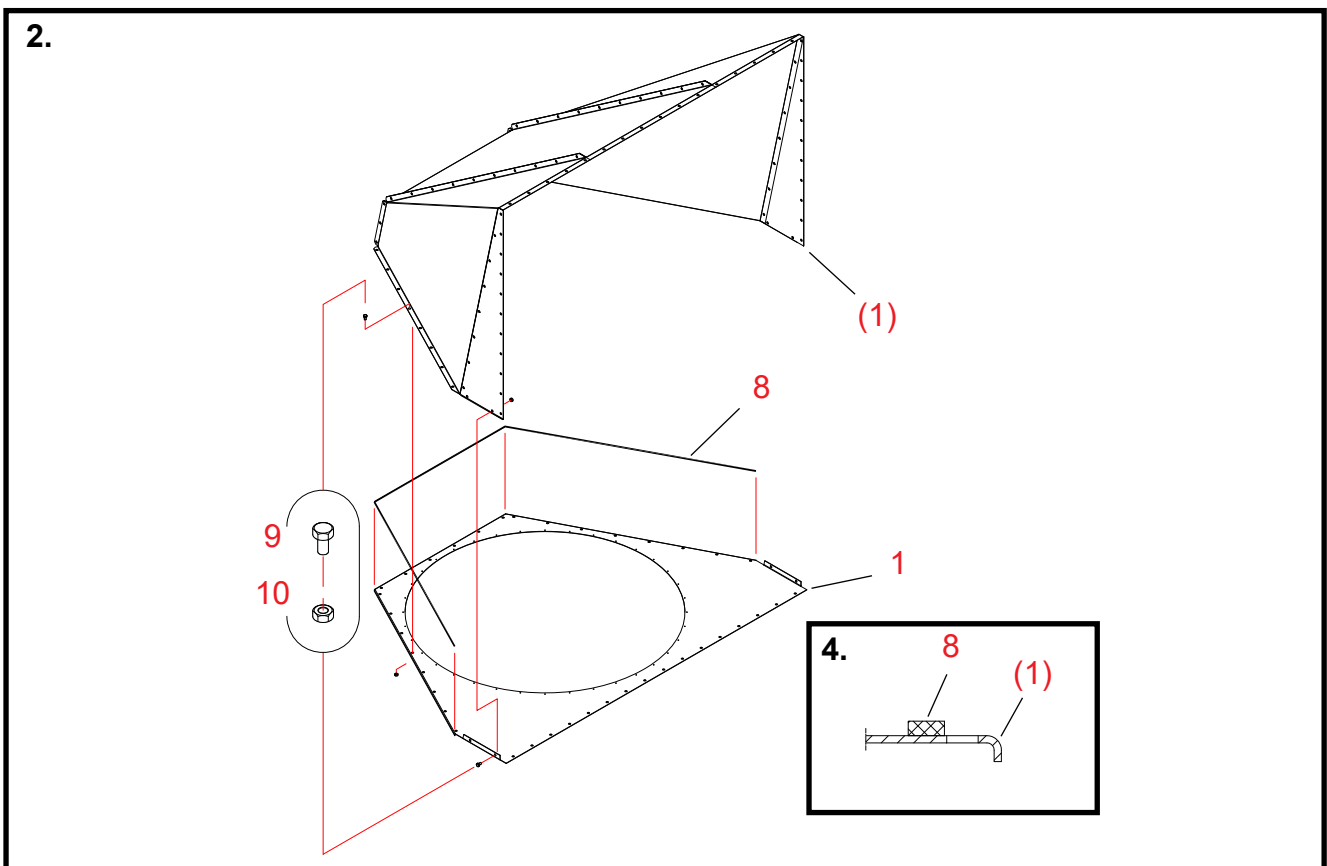
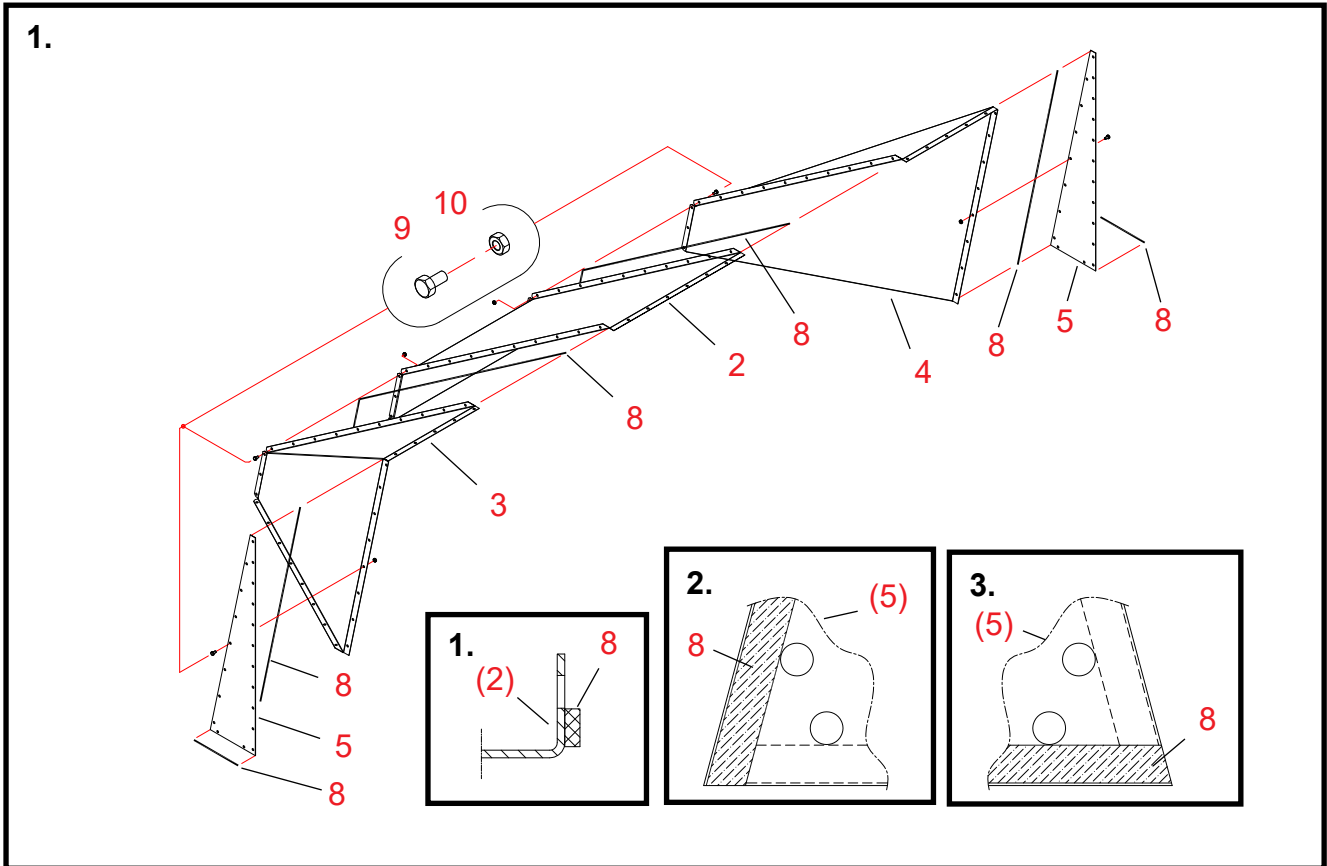
## Spare parts





---

| 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.

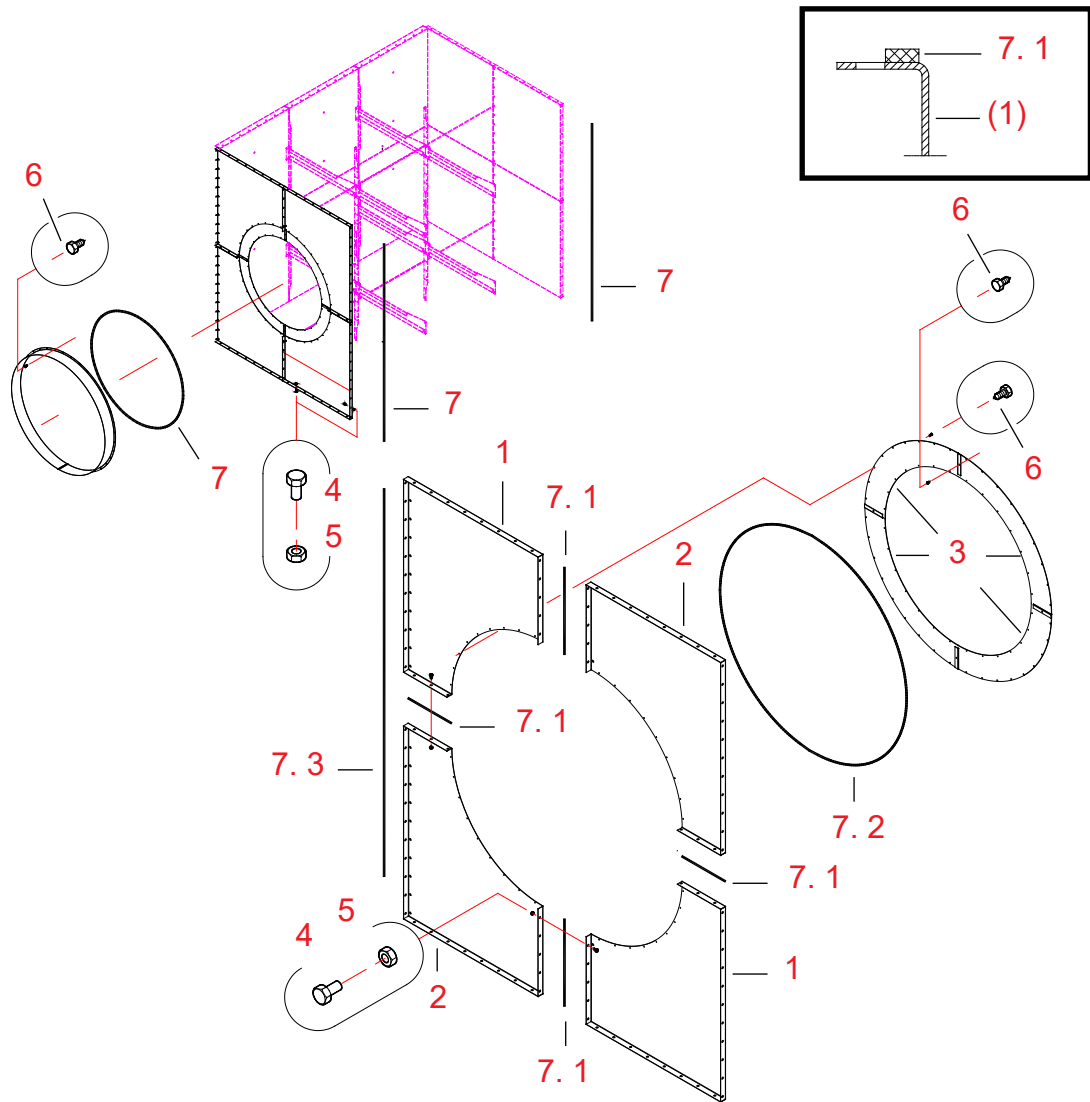
### 2. Assembling the air channel end

- 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. A71017 + A70826)

### 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.*

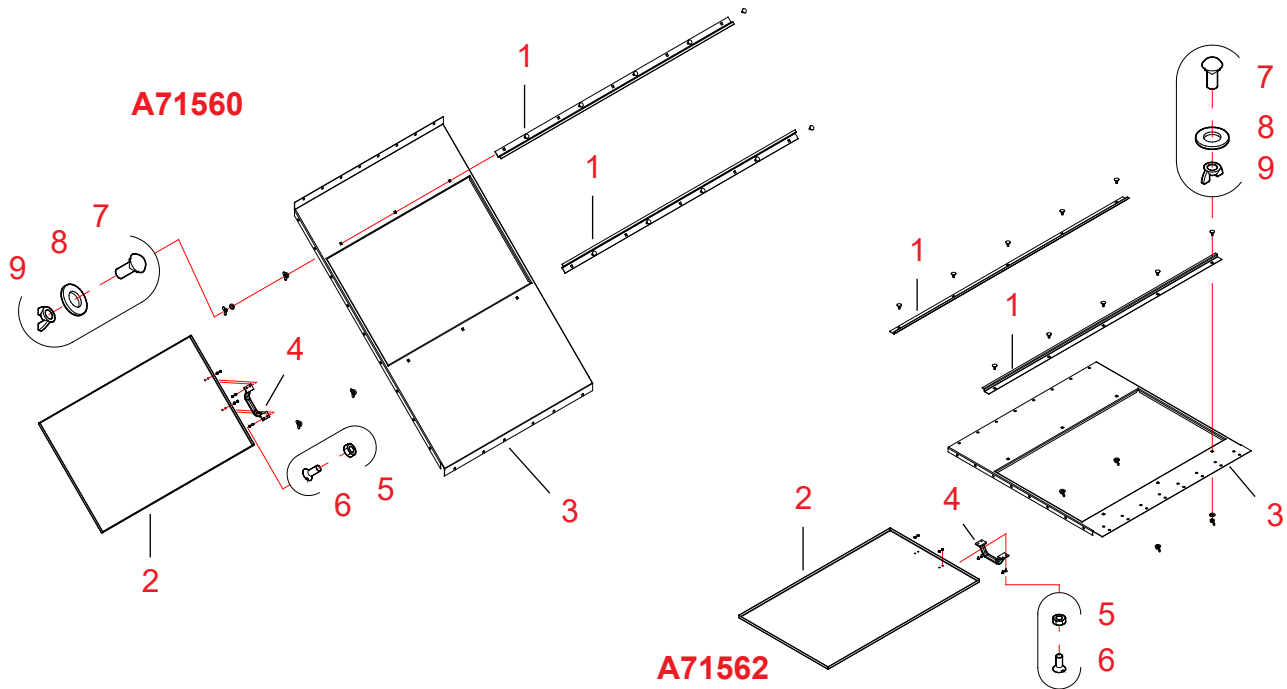
7. 1 **Fix sealing strips to the short flanges of the side-plates 1.**  
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing).
- 1 + 2 **Place the short flanges of the side-plates face to face.**  
*Be careful not to damage the sealing strips while installing the end-plates.*
- 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.

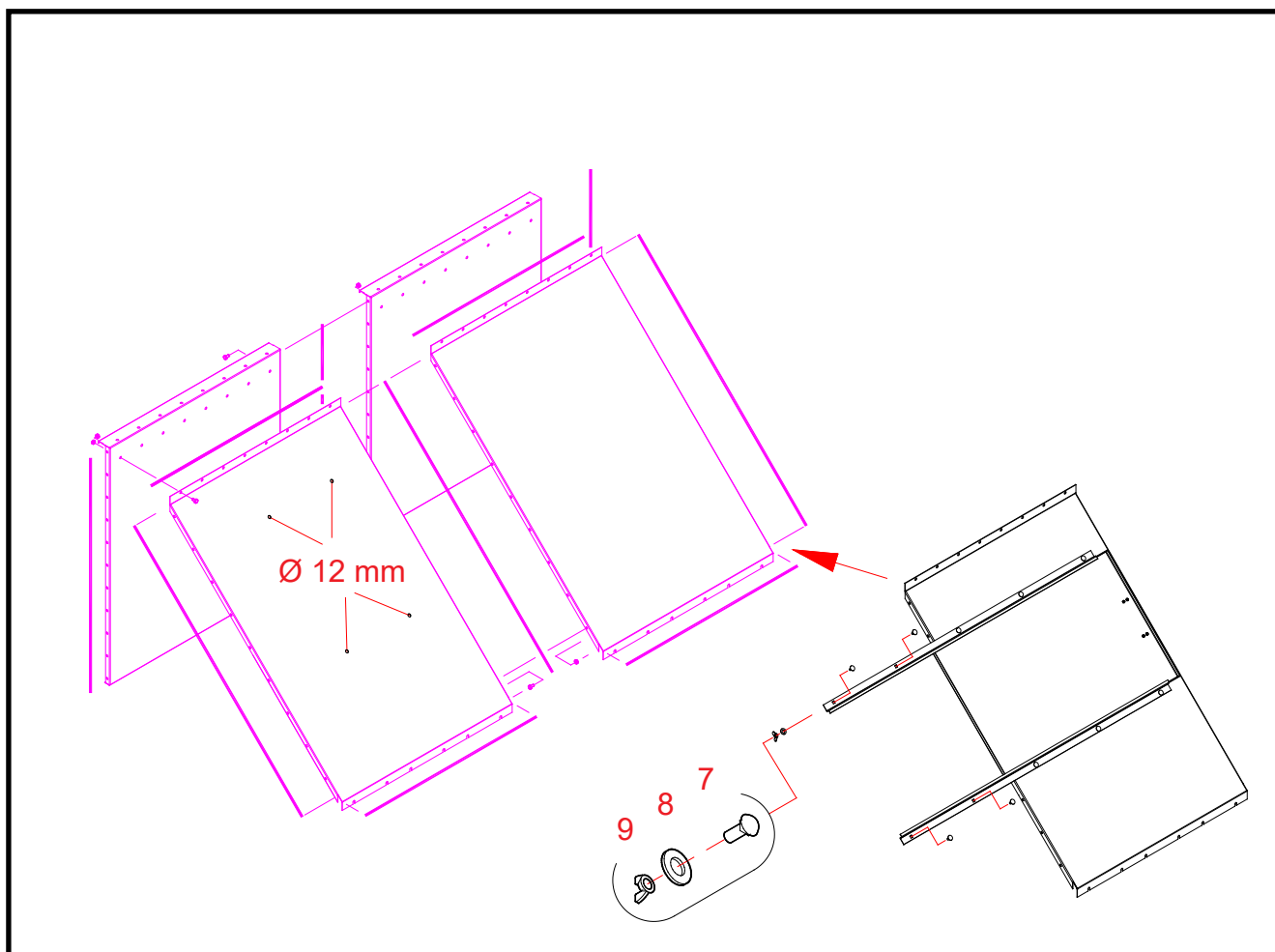
**Air channel end 1,0 (A71560) - replacement air opening in the return bottom**  
**Air channel end 1,0 (A71562) - replacement air opening in the shutter-plate**

## Spare parts



20070322

| Ref.          | Part no. | Denomination 1     | Denomination 2         | Pcs. | Drawing No. | Weight | Group |
|---------------|----------|--------------------|------------------------|------|-------------|--------|-------|
| <b>A71560</b> |          |                    |                        |      |             |        |       |
| 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   |       |
| <b>A71562</b> |          |                    |                        |      |             |        |       |
| 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

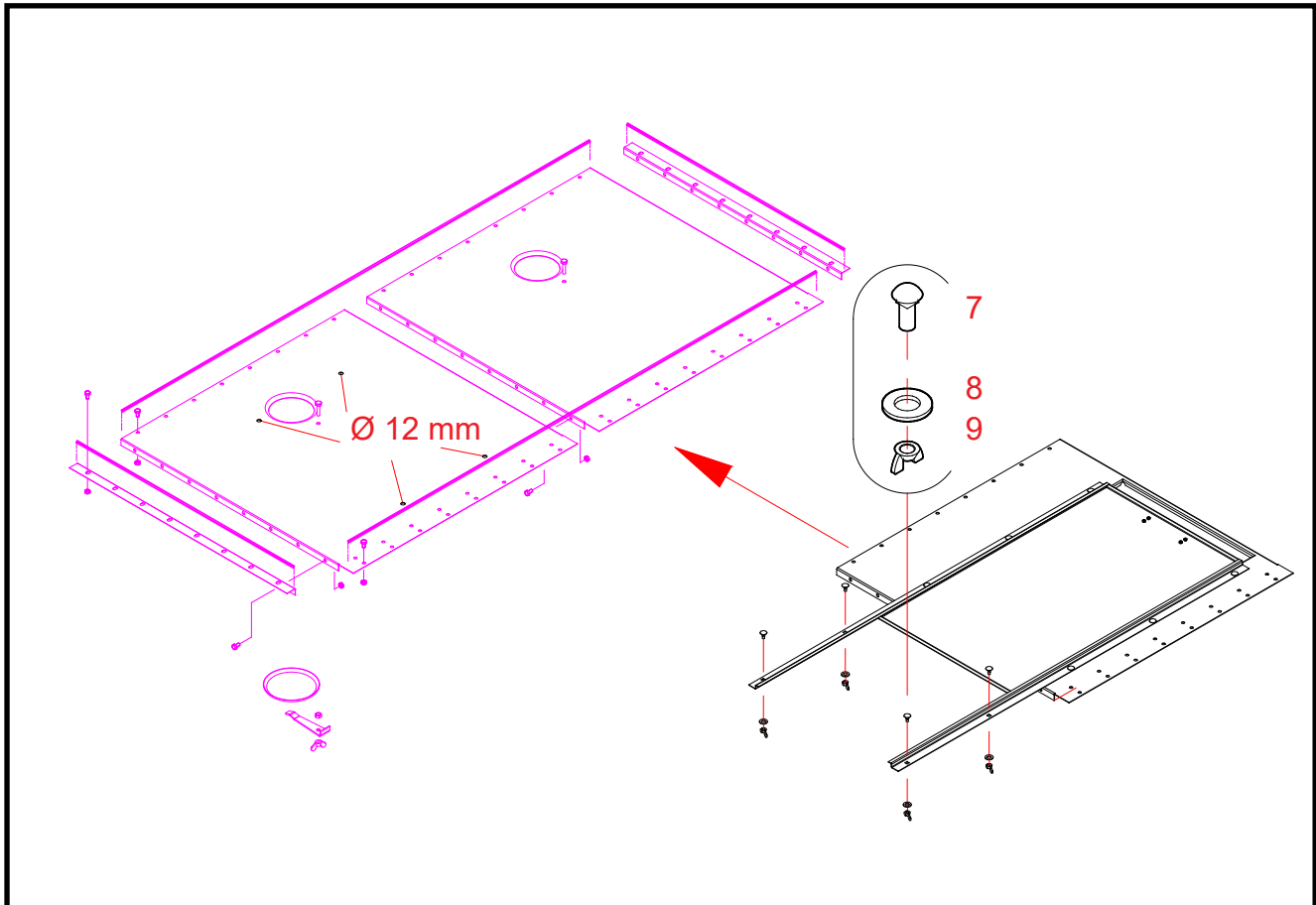
The replacement air opening (A71014) can be installed in place of the other return bottom plate

### 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 A71014.*

1.            The replacement air plate is installed in the same way as the right-hand return bottom in the drawing.
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 (A70913) can be installed in place of the other shutter-plate

### 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.

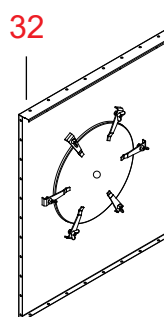
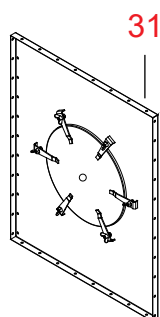
*Please refer to the assembly instructions for the lower shutter-plate A70913.*

1.            The replacement air plate is installed in the same way as the right-hand shutter-plate in the drawing.
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

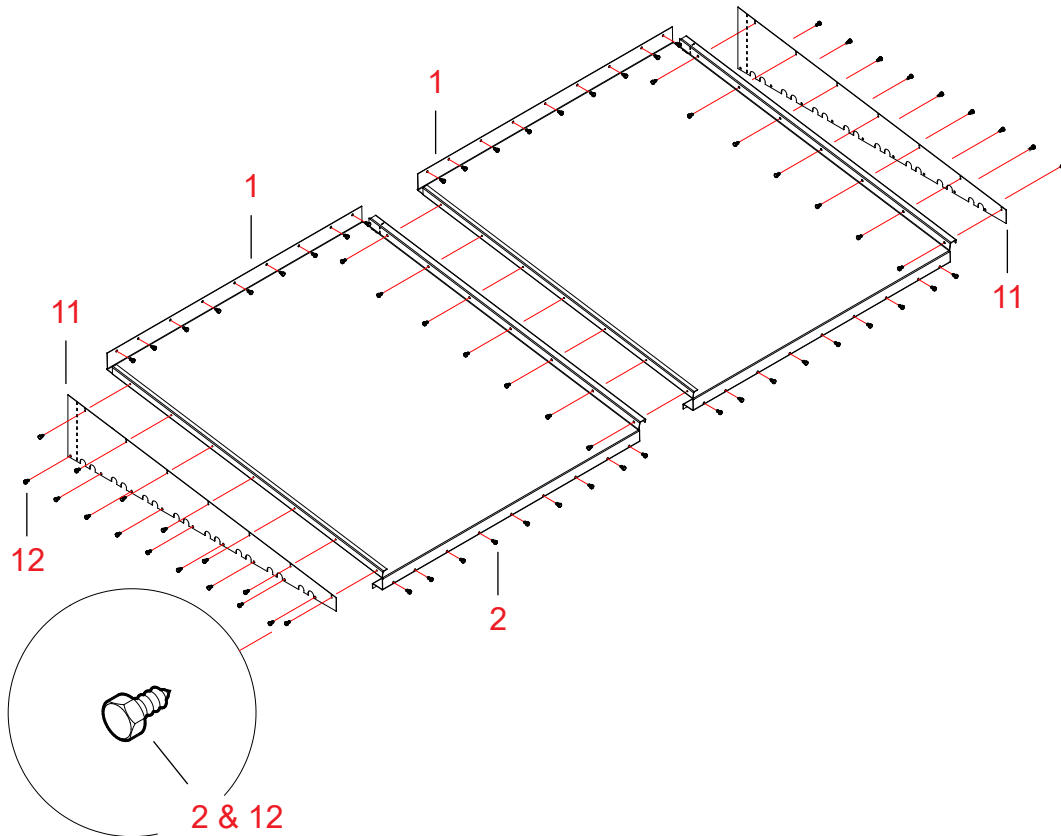


20080715

| 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 2W

### Spare parts



20080822

| Ref.  | Part no. | Denomination 1   | Denomination 2          | Pcs. | Drawing No. | Weight | Group |
|---|----------|--|-------------------------|------|-------------|--------|-------|
| 2 pcs. of roof plates A72231 with their screws are required for one 1,0 m air channel end on 2W dryer.      |          |  |                         |      |             |        |       |
| -   | A72231   | AIR CH END WM06 1.0<br>Includes parts 1 (1 pc.)<br>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  |
| 3 pcs. of end cover plates A72232 with their screws are required for one 1,0 m air channel end on 2W dryer. |          |  |                         |      |             |        |       |
| -   | A72232   | AIR CH END WM06 1.0<br>Includes parts 11 (2 pc.)<br>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  |

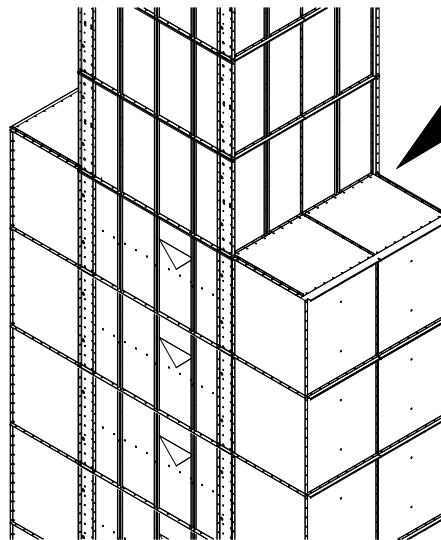


## Installing the rain roof (A72231, A72232) for the 1,0 m air channel end

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

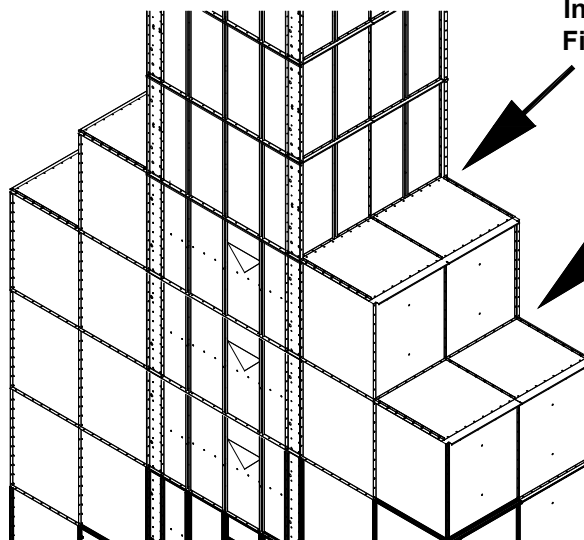
Tops of the air channel ends with the upper shutters before the installation of the rain roofs

2W, 1,0 m air channel end



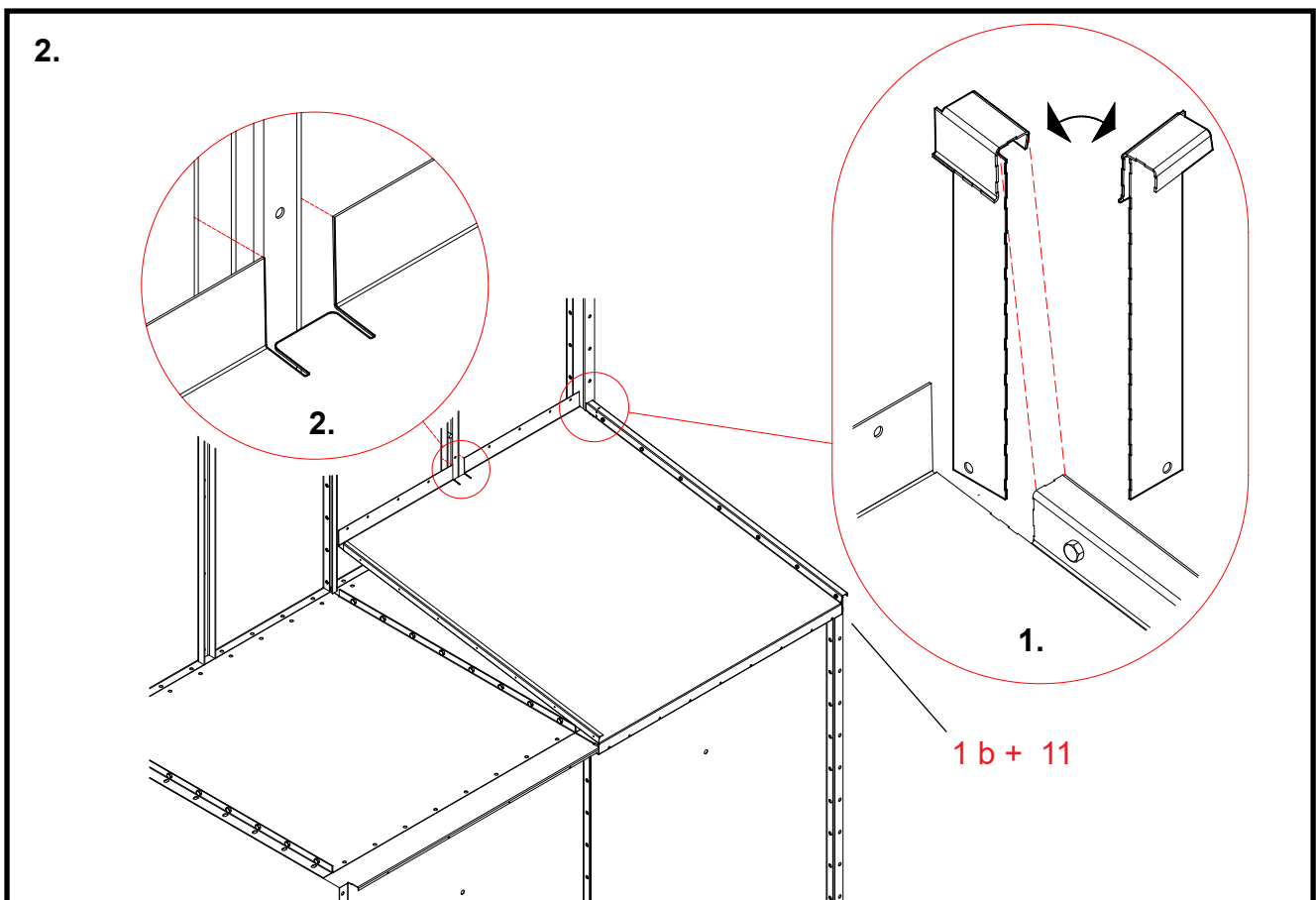
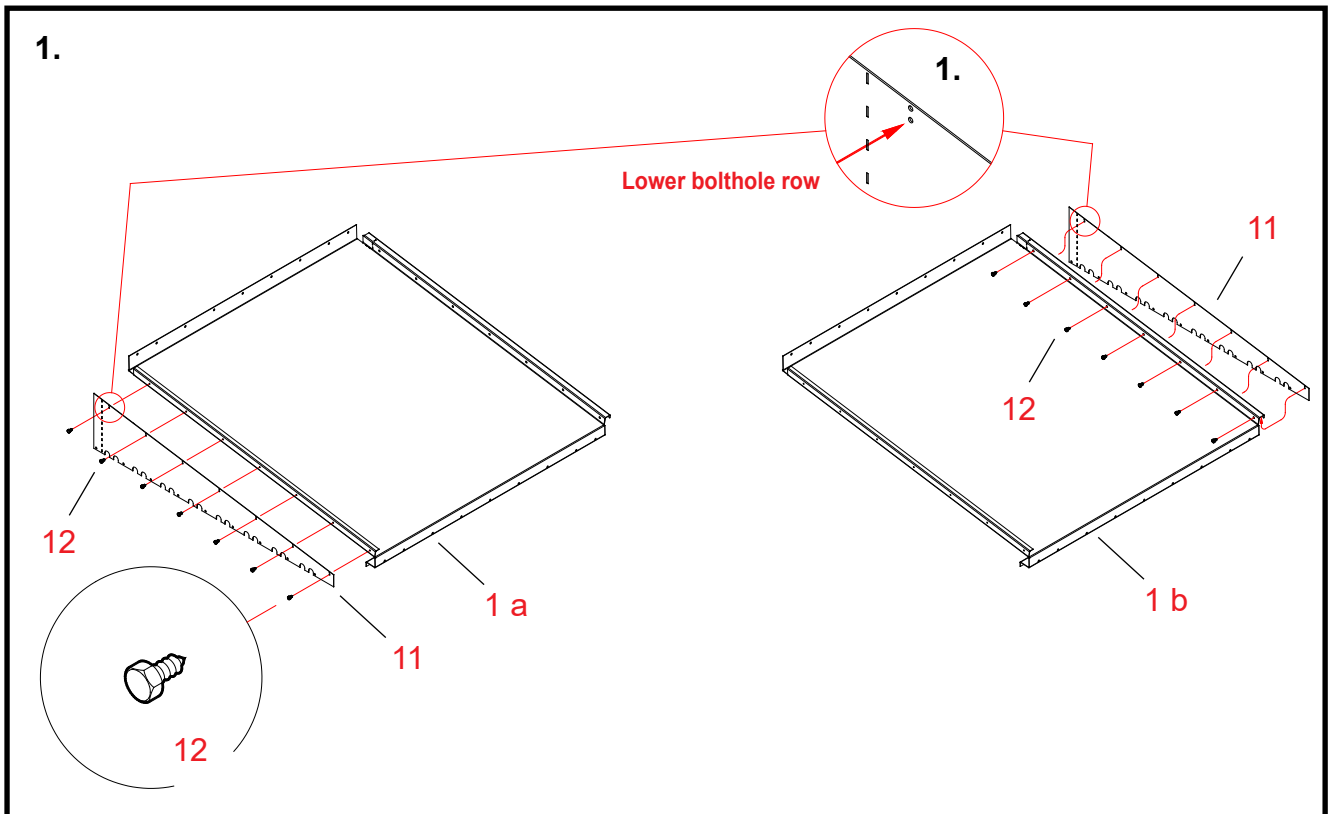
Installation practice 1  
Fixing the rain roof to  
the top section

2W, 2 x 1,0 m air channel end  
"Stepped" top of the air channel  
end



Installation practice 1  
Fixing the rain roof to  
the top section

Installation  
practice 2  
Fixing the rain  
roof to the air  
channel end





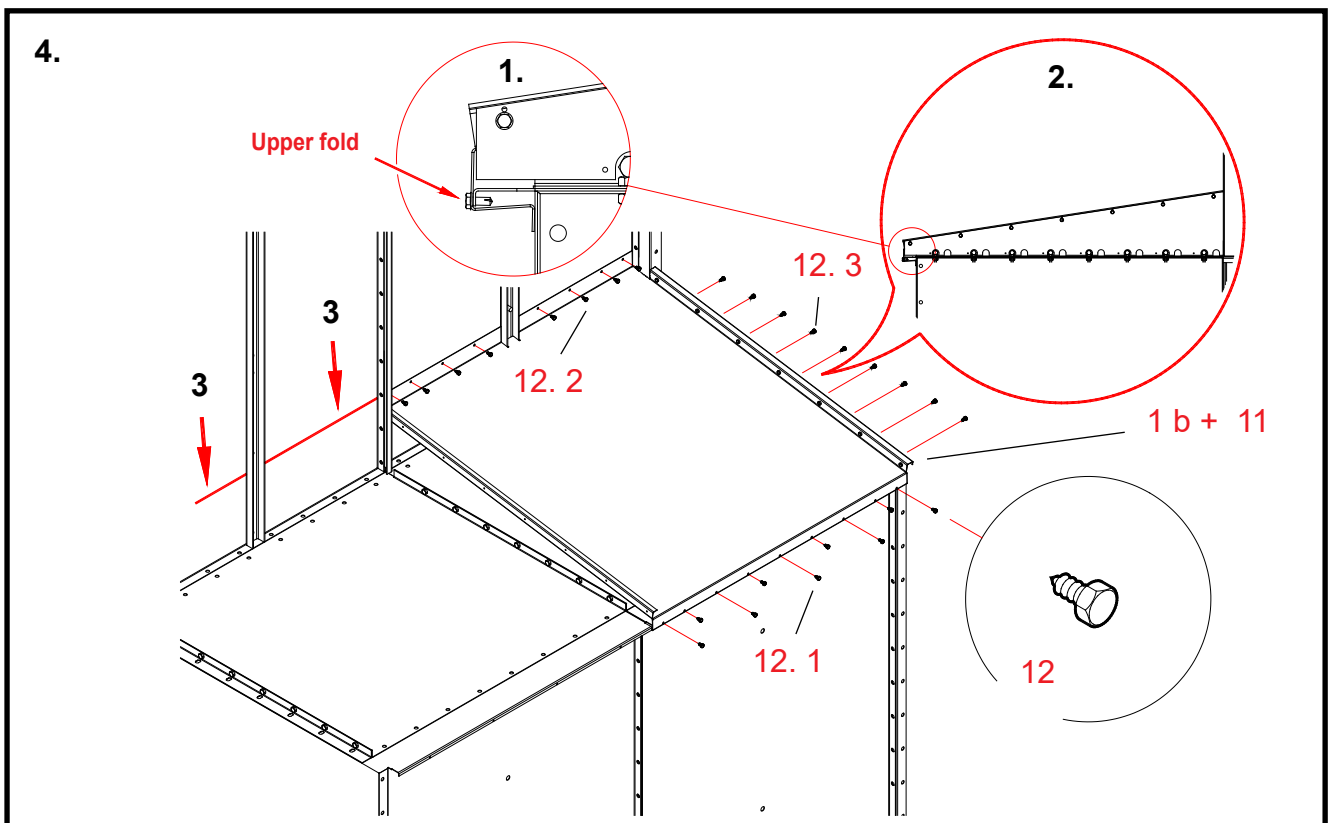
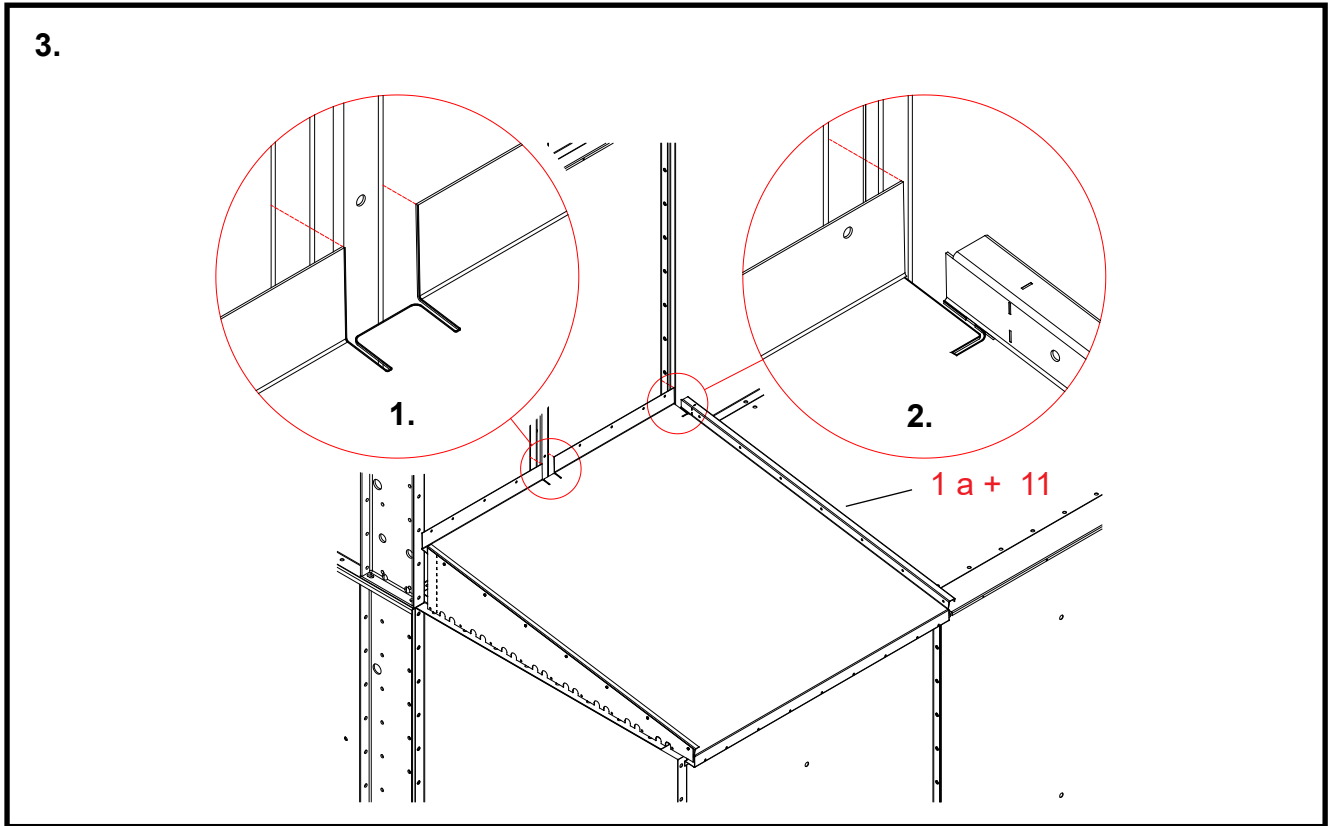
**Stages 1 - 6: Installation practice 1: Fixing the rain roof to the wall of the top section (air channel ends 1 x 1,0 m and 2 x 1,0 m).**

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

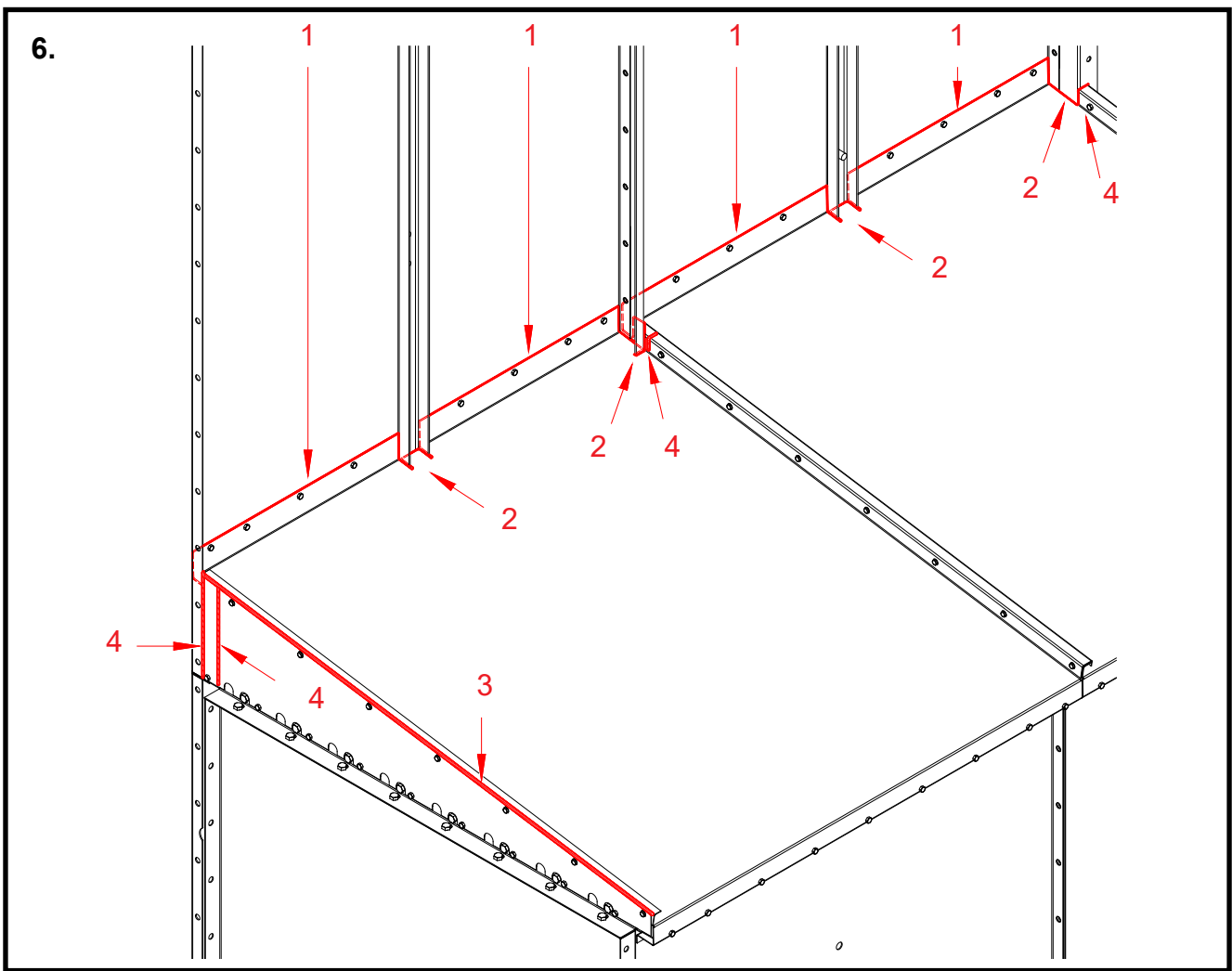
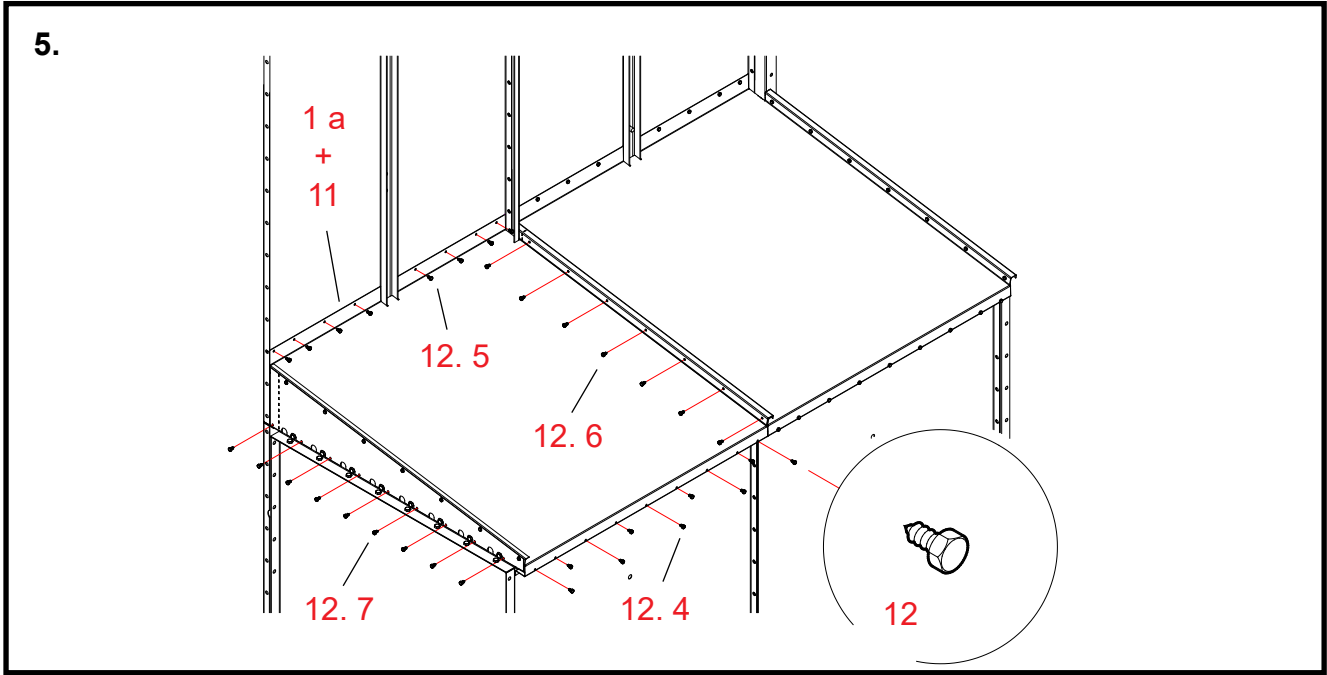
Parts The numbering of work stages refers to reference numbers in the spare parts drawing (A72231. A72232) for the rain roof.

- \* **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.**

### 4. 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.).**



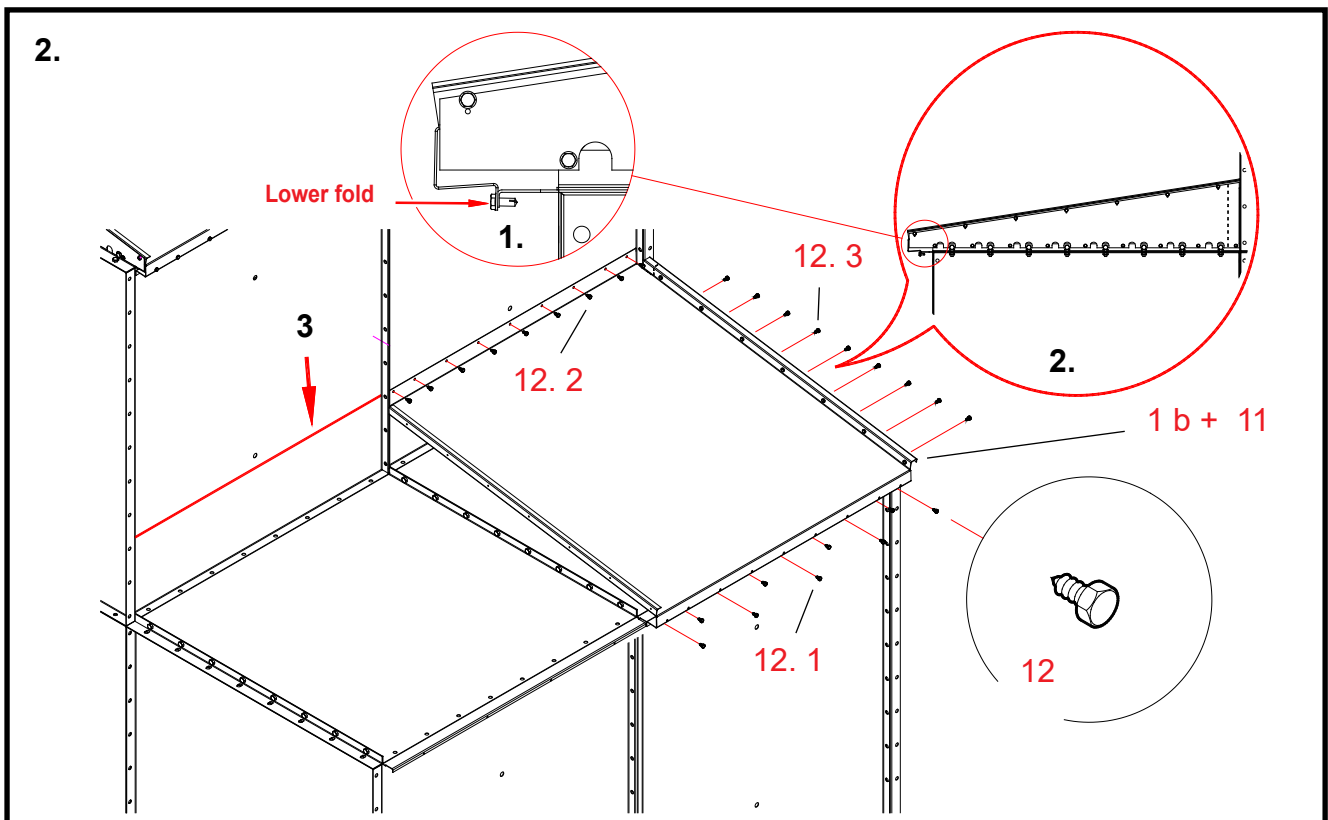
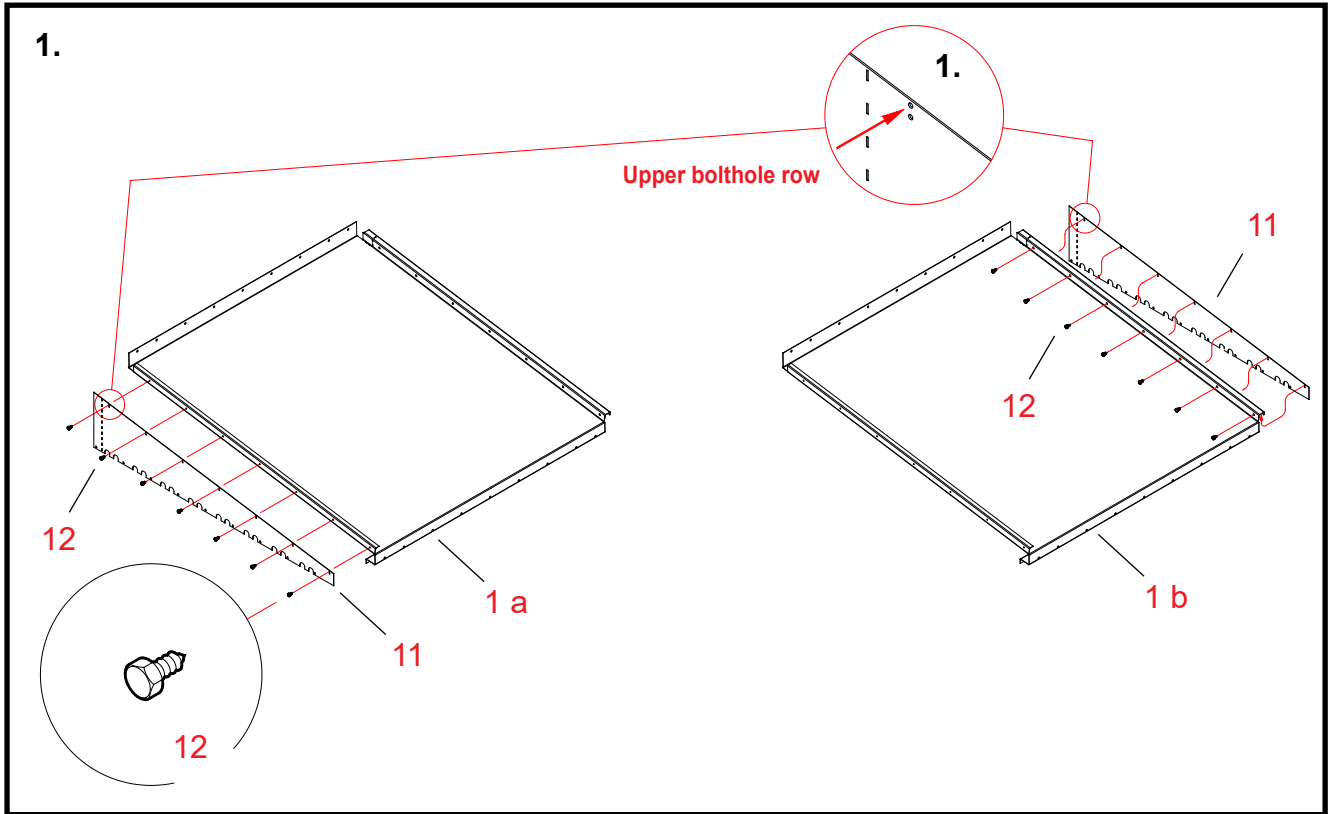


### 5. Installing the left-hand (1 a at stage 1) slanting roof plate of the rain roof

- 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. 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 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 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.).**
- 12. 7            Fix the end cover to the top section using self-tapping screws (4,8 x 13, 9 pcs.).**

### 6. Sealing the rain roof seams

- \***                **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).**

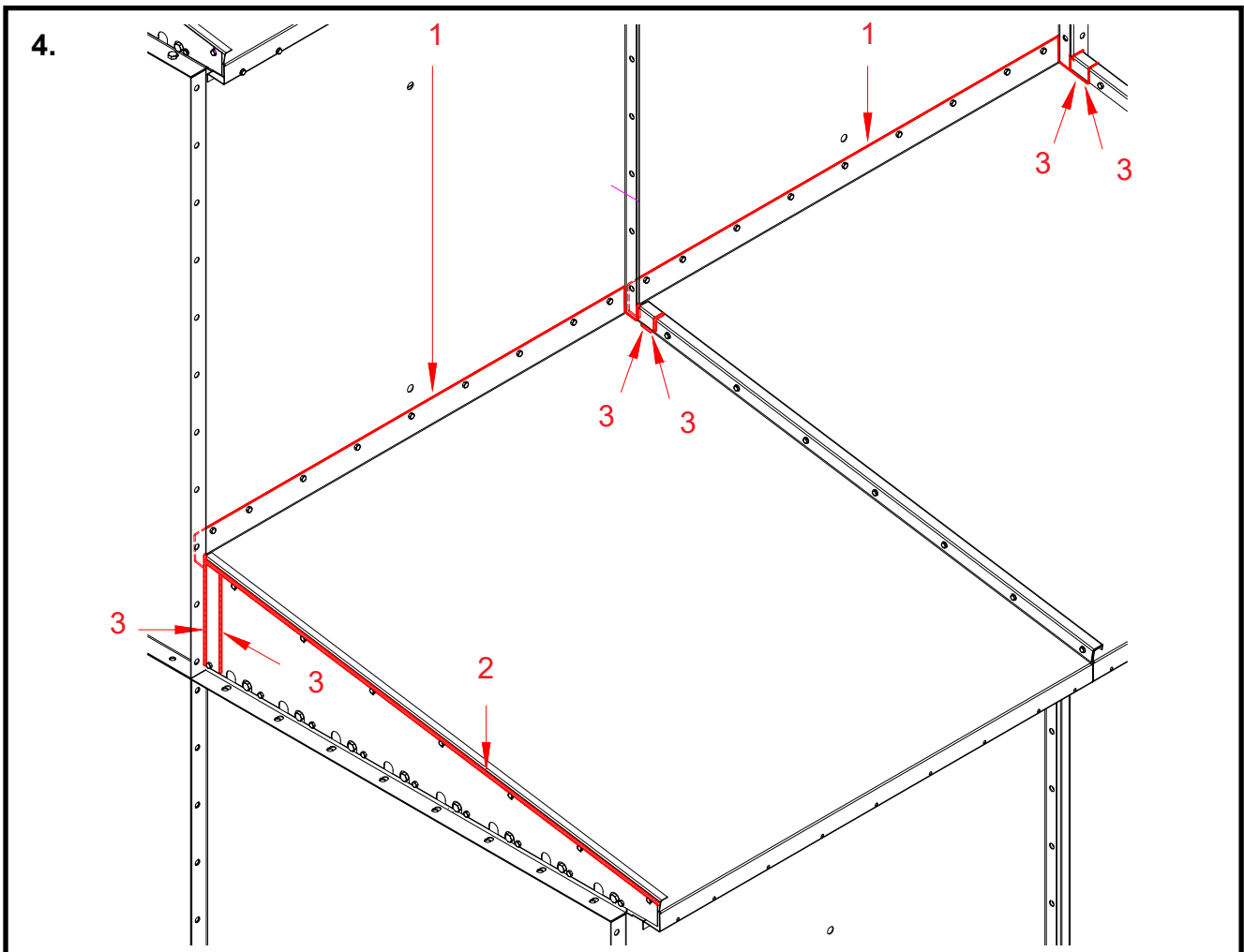
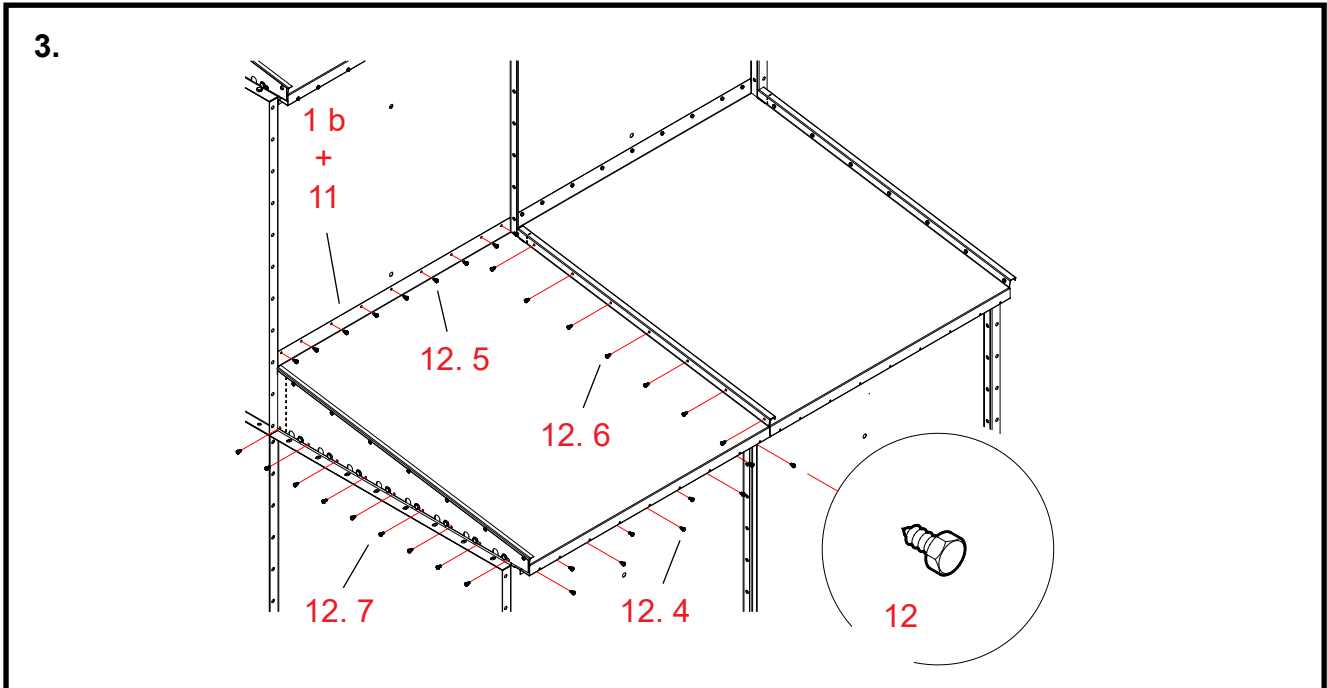
### 1. Joining together the slanting roof plates of the rain roof and the end covers

- 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 (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 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 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. 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 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. 5            Fix the slanting roof plate to the air channel end using self-tapping screws (4,8 x 13, 9 pcs.).**
- 12. 6            Fix the slanting roof plate to the other slanting roof plate using self-tapping screws (4,8 x 13, 7 pcs.).**
- 12. 7            Fix the end cover to the air channel end using self-tapping screws (4,8 x 13, 9 pcs.).**

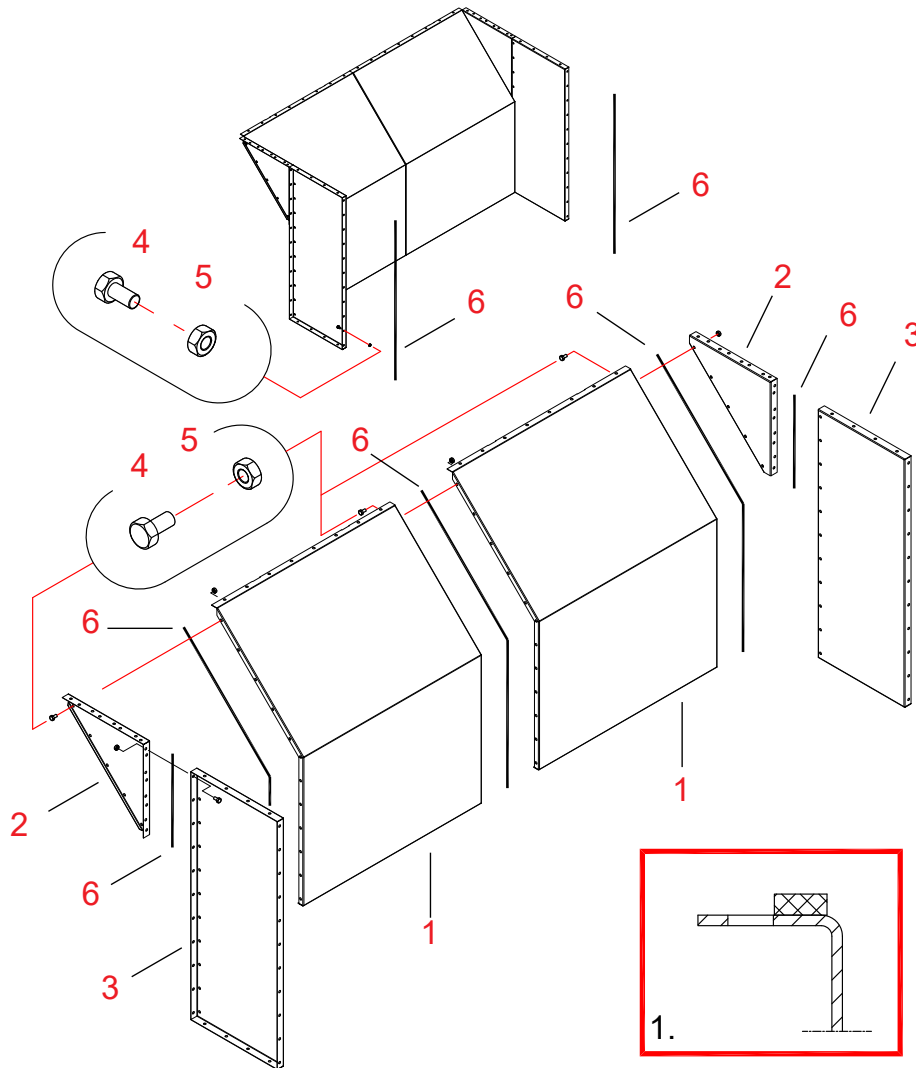
### 4. Sealing the rain roof seams

- \***                **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 0,5-1,0 2W (A75959) - 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      | 2    | 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               | 103  |             |        | 2010  |
| 5    | 110540  | NUT M8 ZN 8 DIN934 CE                           | 103  |             |        | 2010  |
| 6    | 115570  | SEALING STRIP 4X8 EKO-40                        | 14   |             |        | 2600  |



## Assembling air channel end A75959

Parts            The numbering of work stages refers to reference numbers in the spare parts drawing A75959 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.

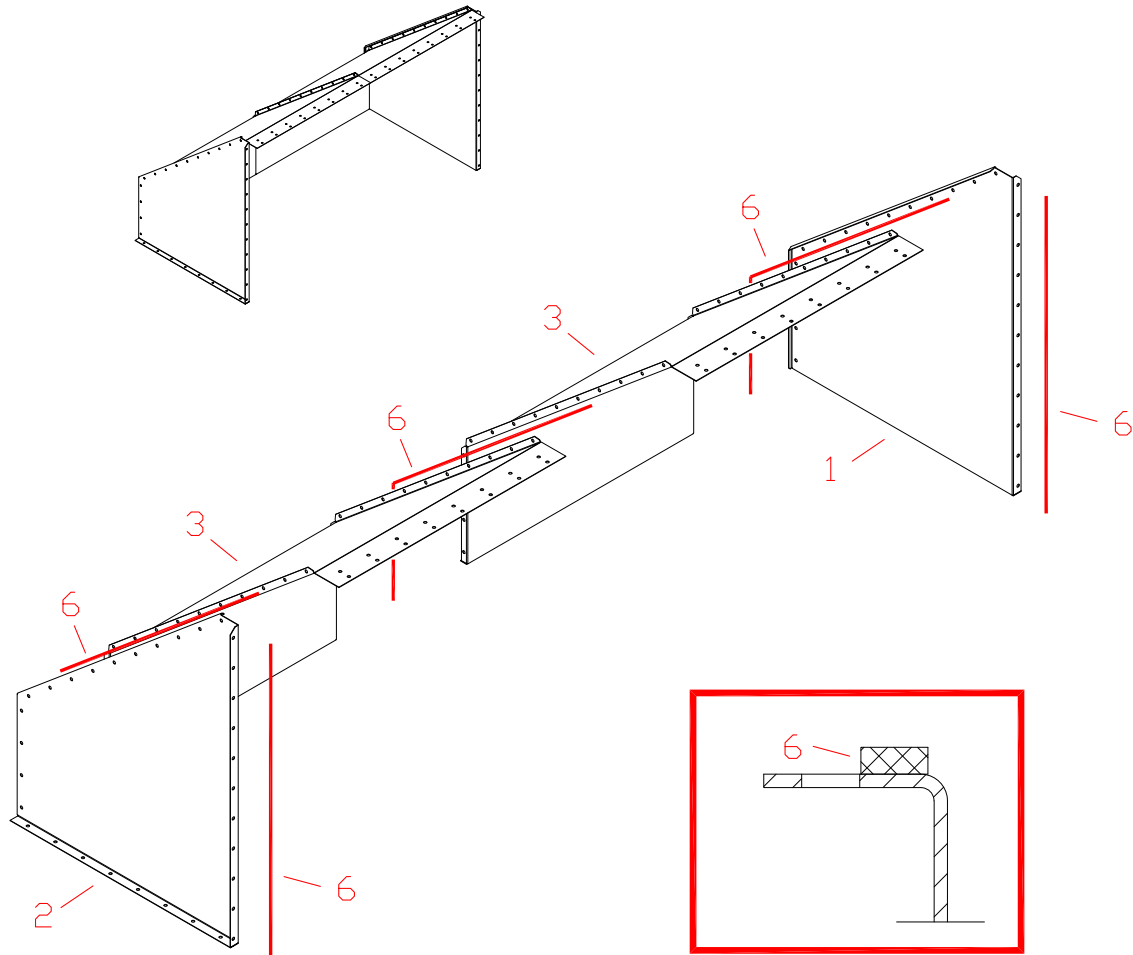
**4,5**            **Fix the side-plates using bolts and nuts (M 8 x 16, 11 pcs / side-plate).**  
Tighten the bolts only lightly so that you can straighten the air channel end later.

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



## Air channel end diagonal roof 2W (A75589)

### 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   | 2    | A75585     | 19.8   | 3000  |
| 4    | 101810  | HEX BOLT ZN 8.8 8X16 AM DIN933 CE         | 111  |            |        | 2010  |
| 5    | 110540  | NUT M8 ZN 8 DIN934                        | 111  |            |        | 2010  |
| 6    | 115570  | SEALING STRIP 4X8 EKO-40 100m rll         | 17   |            |        | 2600  |



## Assembling air channel end A75589

Parts            The numbering of work stages refers to reference numbers in the spare parts drawing A75989 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.

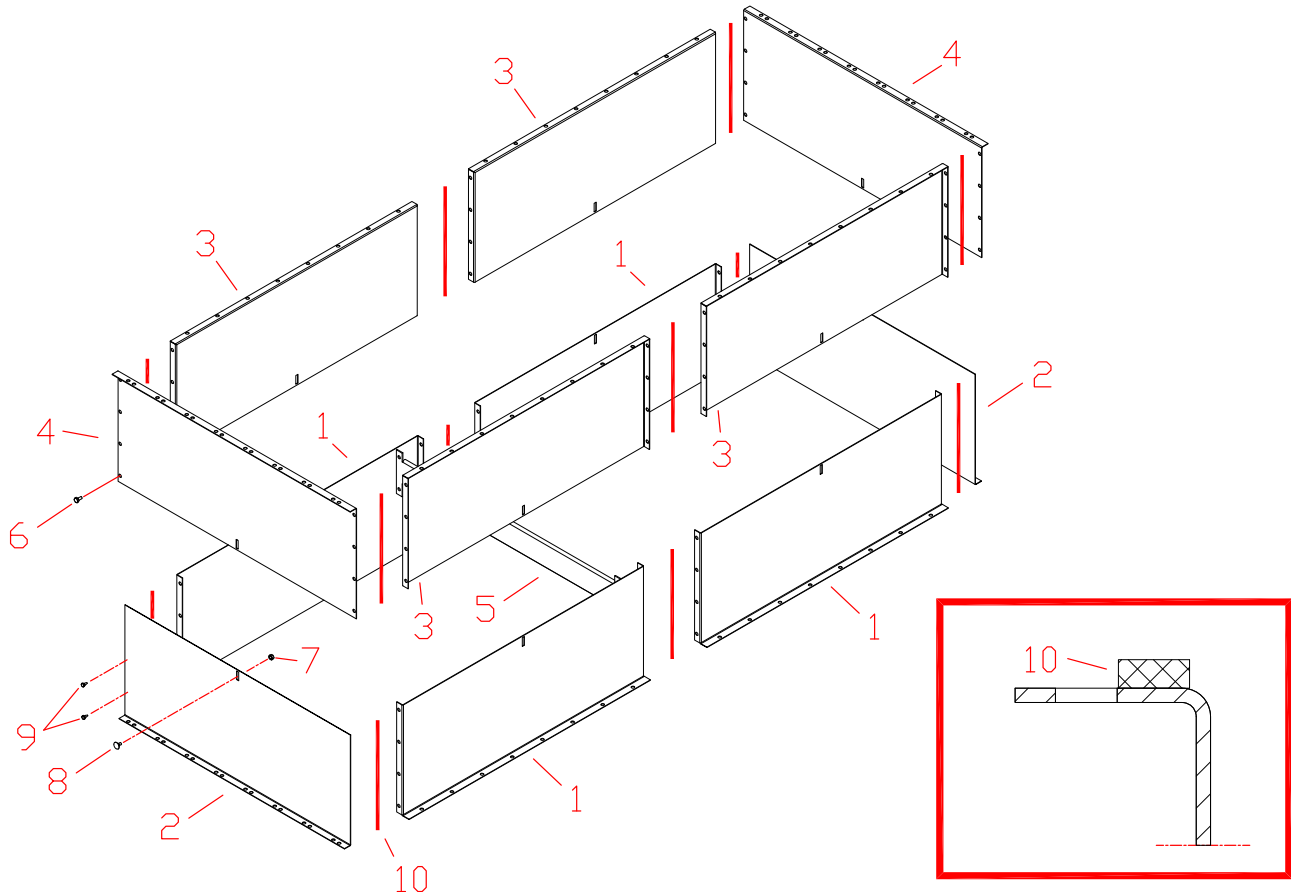
**4**                **Shift the side plates tight against the ends of the section and the end plate of the slanting roof on top of the edge of the section so that the edge comes between the edges of the section and the top tank.**  
Be careful not to damage the sealing strips while installing the side-plates.

**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 2W (A76734)

### Spare parts

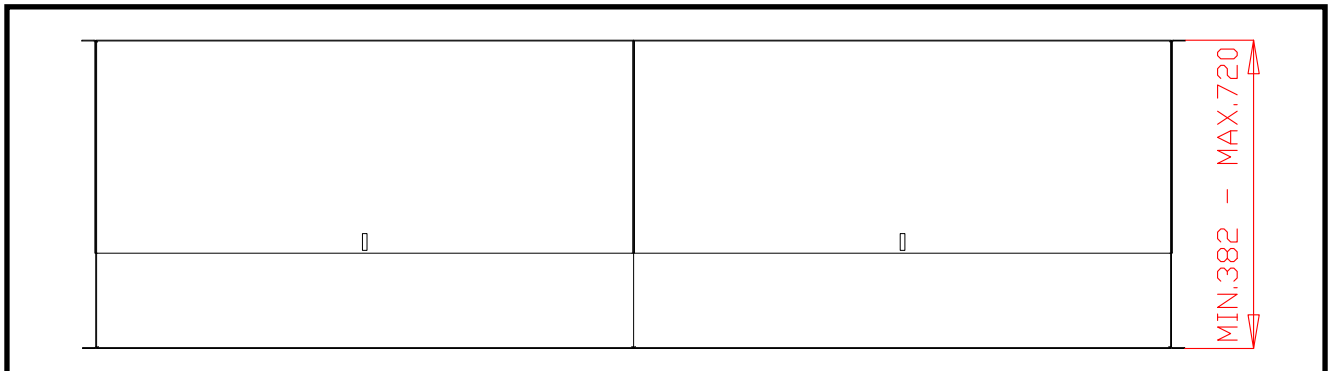


| Ref. | Part no | Denomination 1 and 2                           | Pcs. | Drawing No | Weight | Group |
|------|---------|--|------|------------|--------|-------|
| 1    | A76729  | AIR CHANNEL TELESCOPE LOWER PLATE M21          | 4    | A76729     | 4.7    | 3000  |
| 2    | A76730  | AIR CHANNEL TELESCOPE SIDE LOWER PLATE1.0 M21  | 2    | A76730     | 4.2    | 3000  |
| 3    | A76731  | AIR CHANNEL TELESCOPE UPPER PLATE M21          | 4    | 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          | 1    | A76733     | 2.9    | 3000  |
| 6    | 101810  | HEX BOLT ZN 8.8 8X16 AM DIN933                 | 218  |            |        | 2000  |
| 7    | 110540  | NUT M8 ZN 8 DIN934                             | 231  |            |        | 2000  |
| 8    | 107910  | SCREW LOCK ZN M 8X16 DIN603 8.8                | 13   |            |        | 2000  |
| 9    | 107720  | SCREW SELF-DRILLED HEX DIN 7504K Zn 4,8x13     | 20   |            |        | 2000  |
| 10   | 115570  | SEALING STRIP 4X8 EKO-40 100m rll              | 18   |            |        | 2600  |



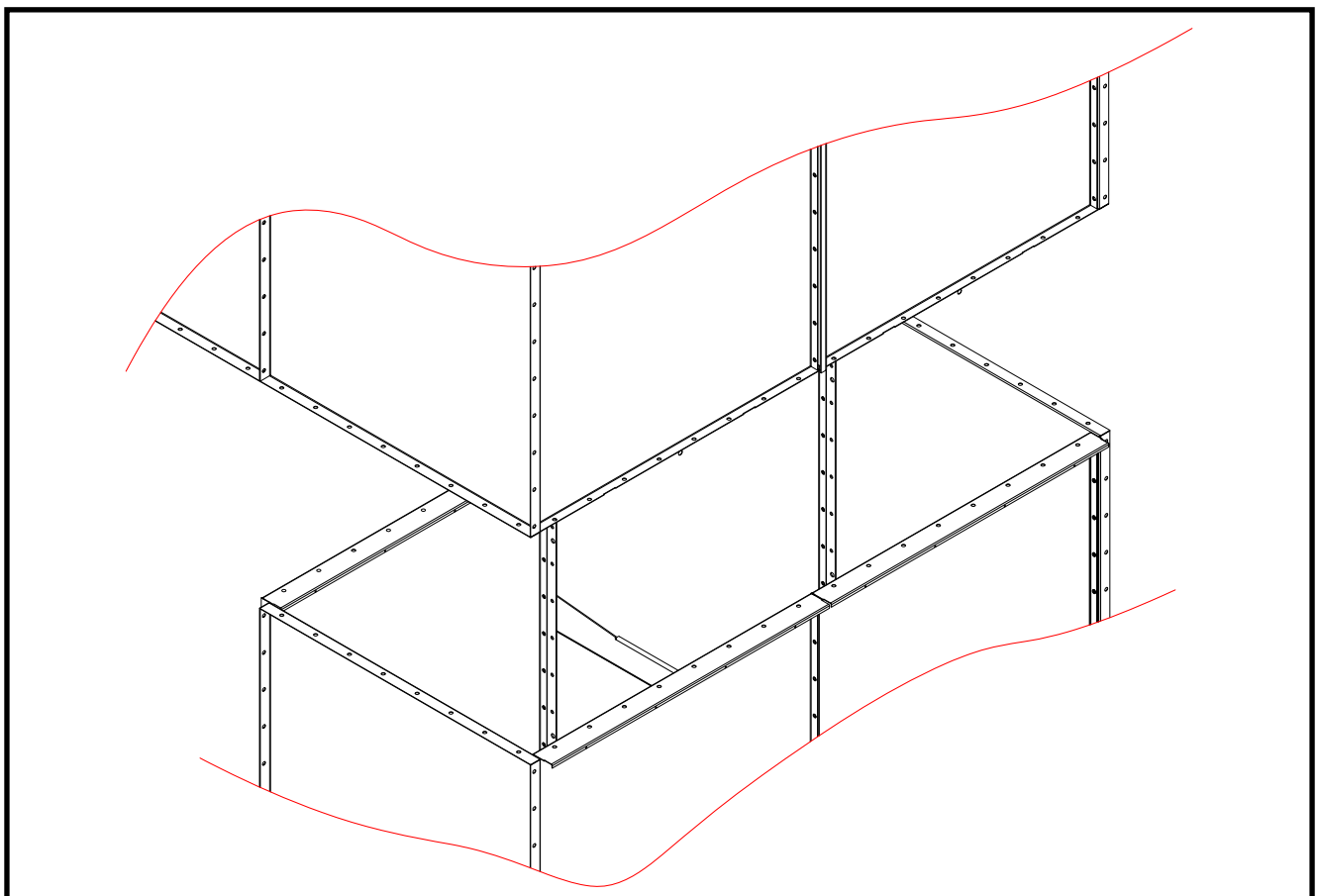
## Threshold values for the dimensions of the air channel end A76734

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.

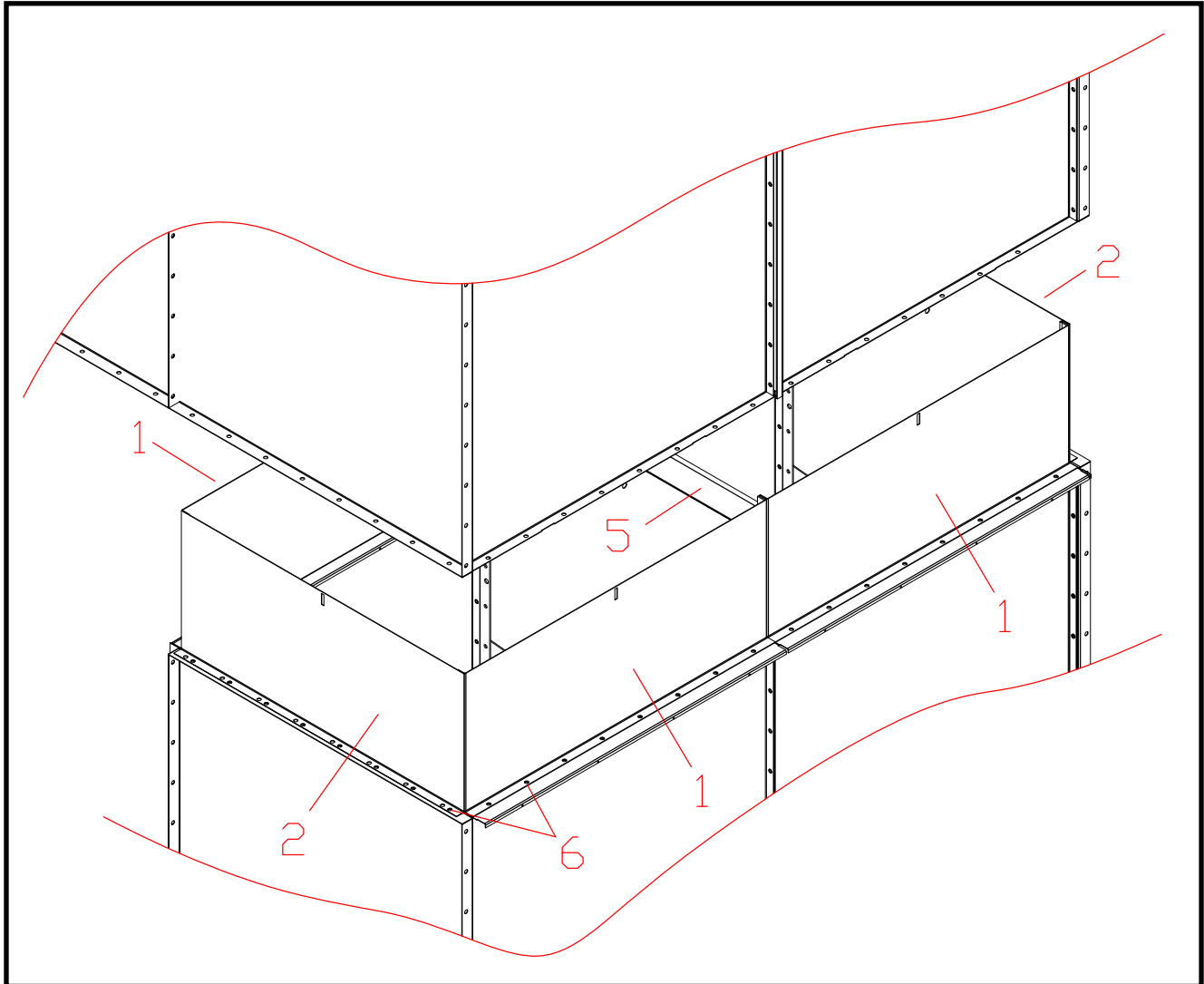


## Initial position before installation of the telescope

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

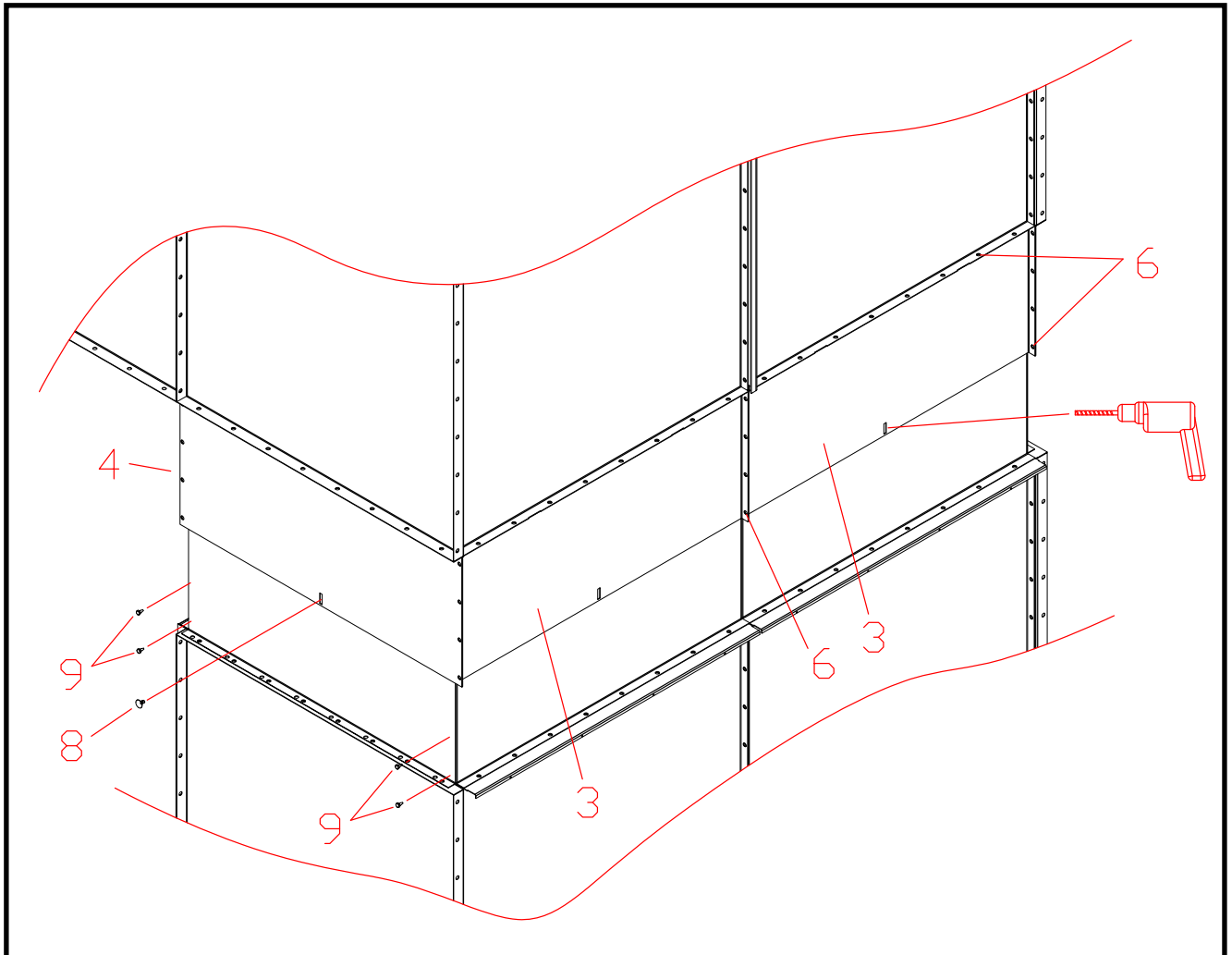


Parts            The numbering of work stages refers to reference numbers in the spare parts drawing A76734 for the air channel end.

**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 bolthole 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 A76734 for the air channel end.

- 10 (3.4)** Fix sealing strips to the flanges of the two end plates (parts 3) parts and the flanges of the upper surface. 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.