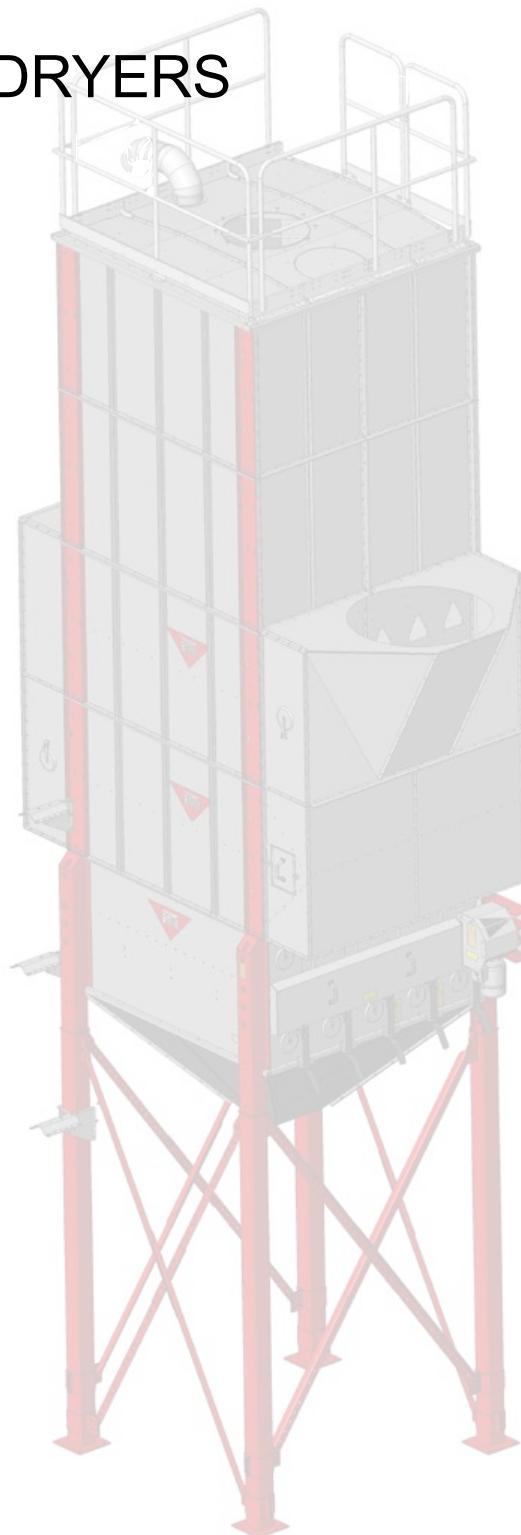


Assembly Instructions

ANTTI M06 3W DRYERS BASE

408080 (en) 05-2026

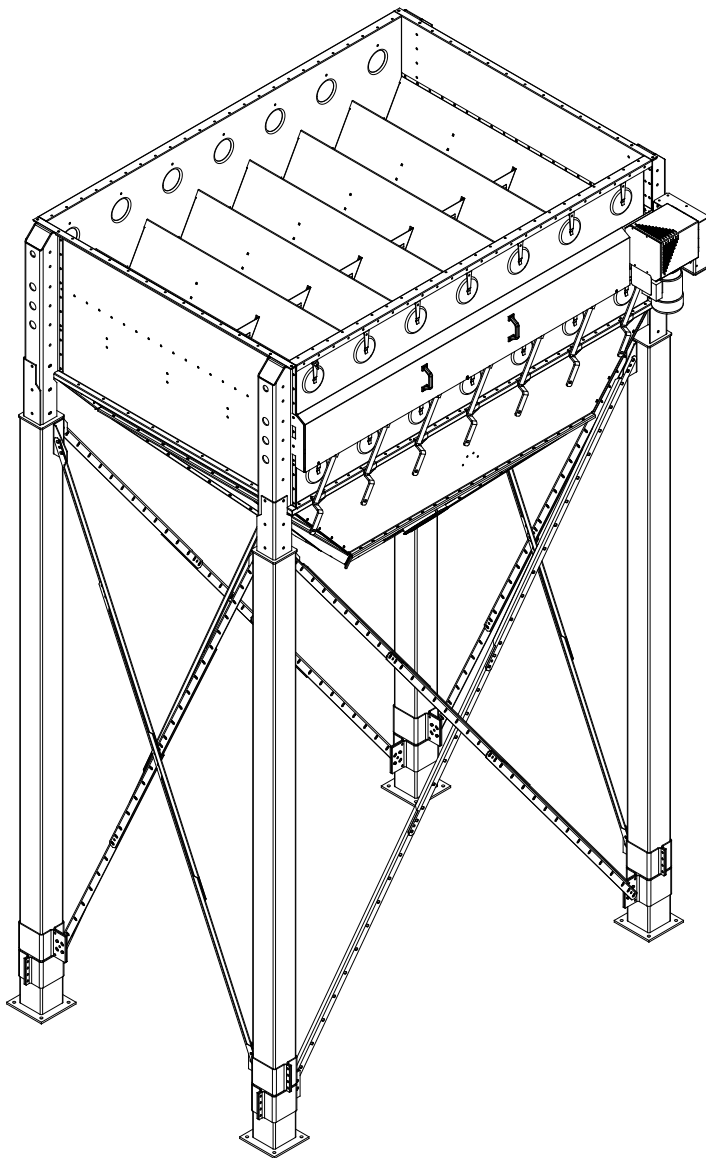


You'll see the difference

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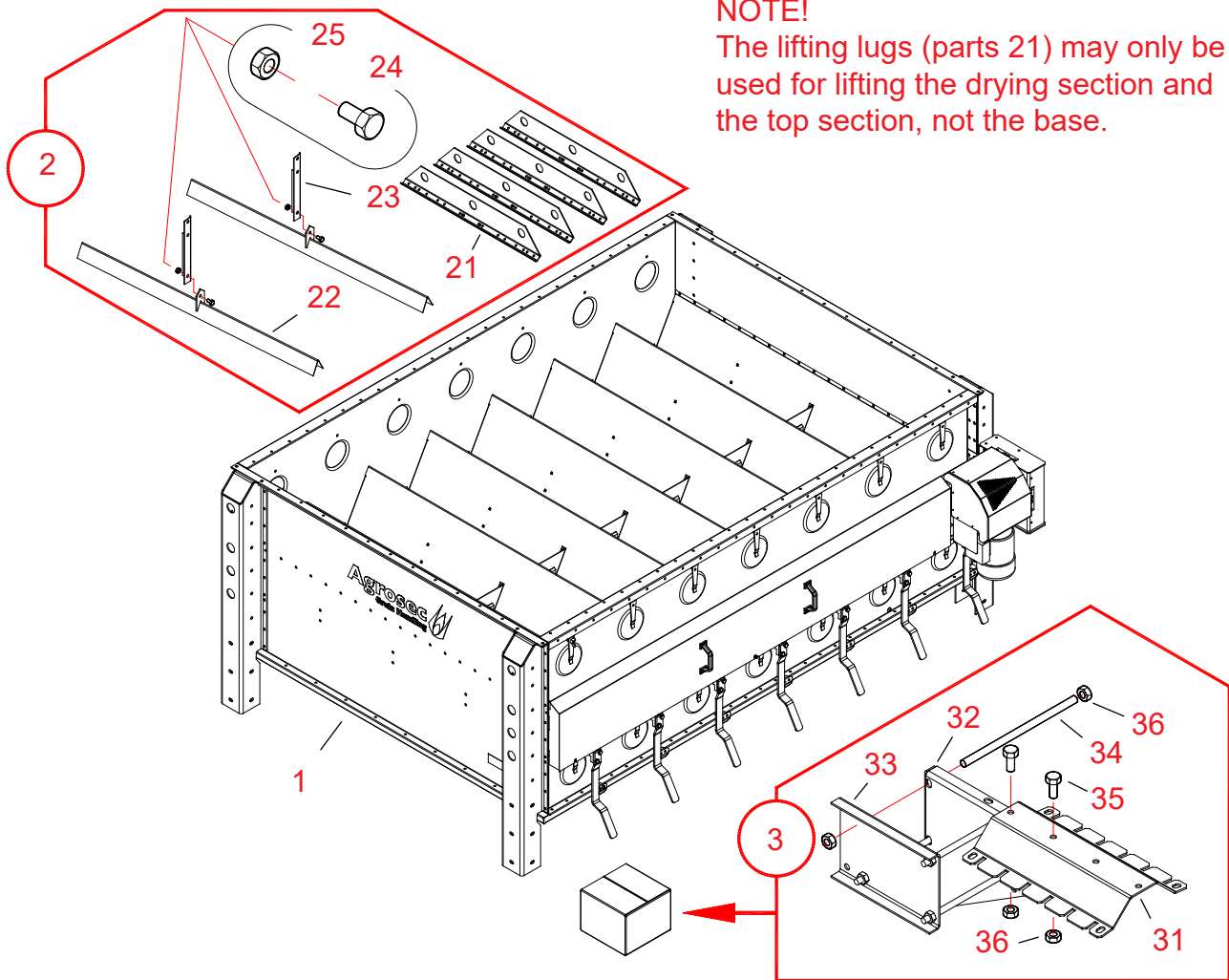


Base 3W assembled





Base 3W with accessories (A70427), spare parts





20061227

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	A71517	BASE WM06 3W 1.1 kW	1	A71517	870,93	3000
2	A71519	BASE WM06 LIFTING AND TOP SECTION, PACK	1	A71519	23,61	3000
3	A71514	BASE WM06 LOCKING-CHAIN PACK	1	A71514-A	9,87	3000

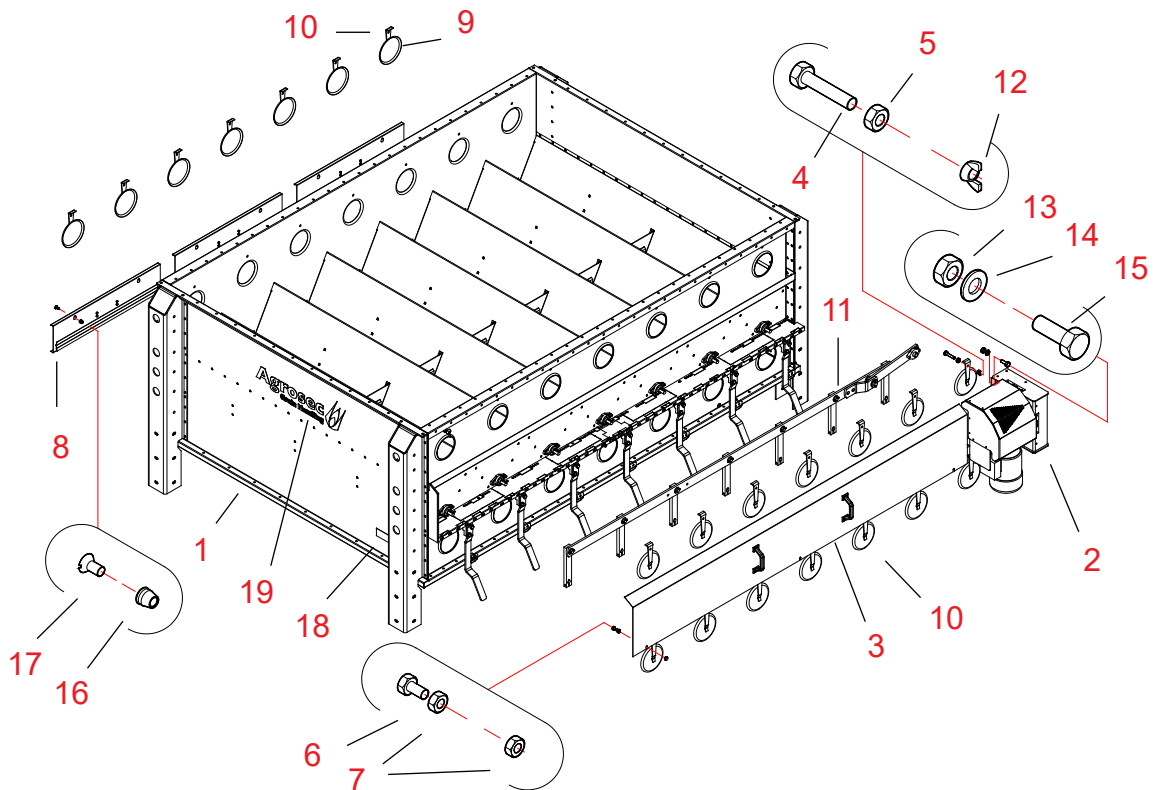
A71519

21	501010	LIFTING LUG, SECTION 4x165x900	2	S32277-D	0	3000
22	A70622	TOP SECTION WM06 BEARER LEG	1	A70622	2.86	3000
23	A70623	TOP SECTION WM06 LOWER PART OF BEARER	1	A70623	3.02	3000
24	102200	BOLT HEX ZN 8.8 – 10x25 AM DIN933	1		0	2010
25	110560	NUT ZN 8 - M10 DIN934	22		0	2010

A71514

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

Base 3W assembled (A71517), spare parts

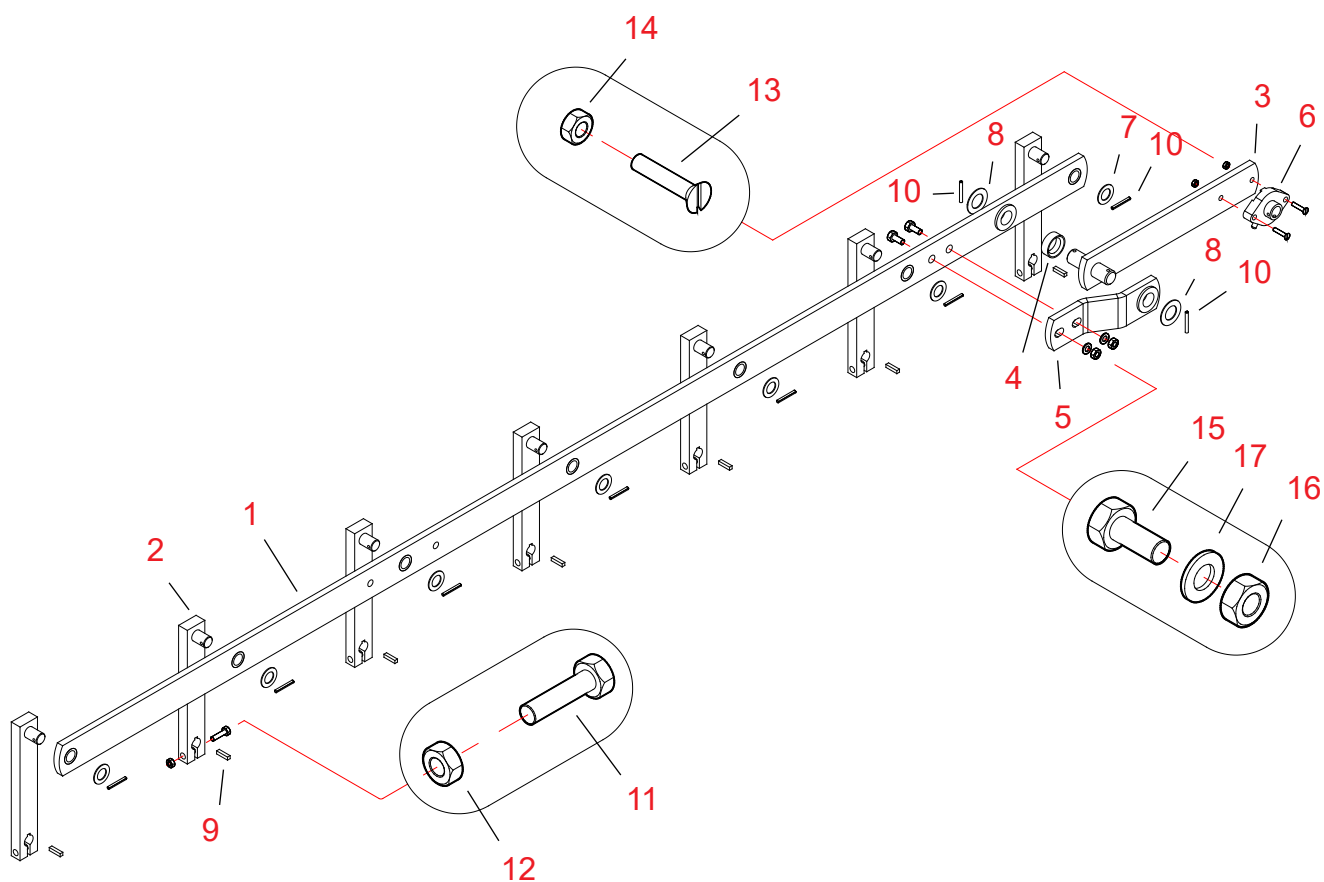


20061227

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	A70395	BASE WM06 3W FRAME	1	A70395	749.44	3000
2	A70416	BASE WM06 MOTOR RACK ASSEMBLY	1	A70416	123.41	3000
3	A70712	BASE WM06 3W FEEDER COVER	1	A70712	9.9	3000
4	102250	BOLT HEX ZN 8.8 – 10x40 AM DIN933	21		0	2010
5	110560	NUT ZN 8 - M10 DIN934	21		0	2010
6	101810	BOLT HEX ZN 8.8 - 8X16 AM DIN933	3		0	2010
7	110540	NUT ZN 8 – M8 DIN934	6		0	2010
8	33043	BASE XL CONTROL HATCH 182x840	3	33043-A	2.46	3000
9	400140	SHUTTER D173	21	S4293	0	3500
10	400150	HATCH HOLDER	21	4461-B	0	3500
11	A70428	BASE WM06 3W FEEDER DEVICE ASSEMBLY	1	A70428	21	3000
12	111030	NUT WING ZN - M10 DIN315	21		0	2010
13	110570	NUT ZN 8 - M12 DIN934	3		0	2010
14	111560	WASHER ZN - M12 DIN125	3		0	2010
15	102520	BOLT HEX ZN 8.8 - 12X35 AM DIN933	3		0	2010
16	110553	STUD NUT - M8 1.5-4.0 MM CTRSUNK	6		0	2010
17	103628	BOLT CTRSUNK SLOT ZN – 8x16 AM	6		0	2010
18	117909	PLATE STICKER 101x50 THT-55-434-1	1	41573-B	0	2900
19	117831	PLATE STICKER 150x500 AGROSEC GRAIN HANDLING	2		0	2900



Feeding equipment 3W (A70428), spare parts

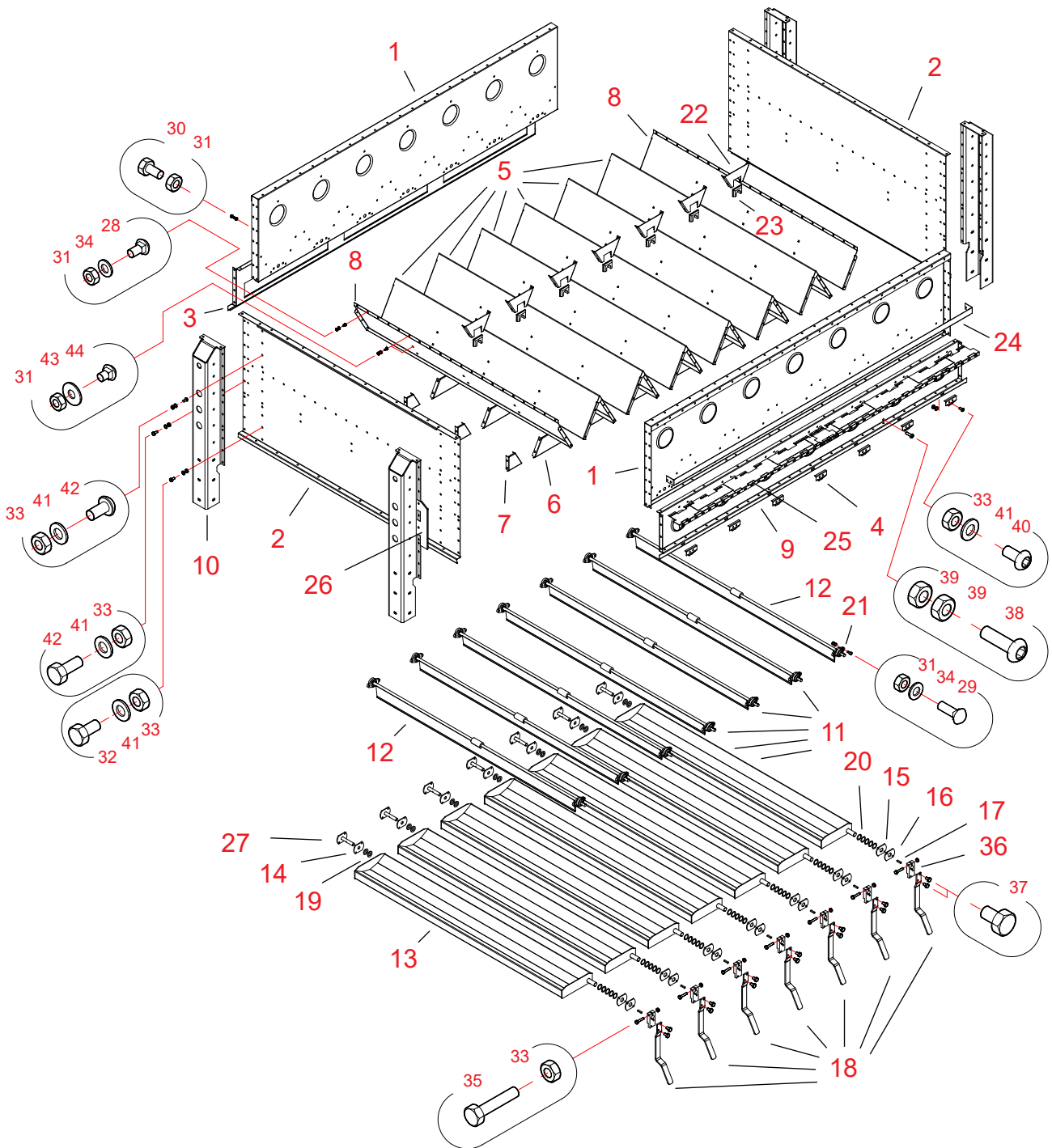


20060601

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	501440	BASE PENDEL ARM ELK,20X40-265 D20/20	7	31242-A	0	3000
2	A70429	BASE WM06 CONNECTING ROD 3W	1	A70429	14.23	3000
3	402420	BASE XL,EL TRANSMISSION ROD+SHAFT	1	A70331	0	2900
4	402421	BASE XL,EL SUPPORT ROD	1	A70421	0	3000
5	400185	BASE SPACER SLEEVE D40/28 L=14	1	A70332	0	2900
6	116510	BEARING FLANGE GLCTEY20 CAST P	1		0	2100
7	400344	WASHER AISI PL1.5 D45/25,5	2	21175,4	0	4500
8	400347	WASHER AISI PL1.5 D35/20.5	7		0	4500
9	A70438	KEY 6x6 - 25	7		0.01	3000
10	112540	SPRING PIN D5x40	9		0	2010
11	102282	BOLT HEX ZN 8.8 – 10x50 CM DIN931	7		0	2010
12	110560	NUT ZN 8 - M10 DIN934	7		0	2010
13	103640	BOLT CTRSUNK SLOT ZN – 8x40 AM	2		0	2010
14	110540	NUT ZN 8 – M8 DIN934	2		0	2010
15	102540	BOLT HEX ZN 8.8 – 12x40 AM DIN933	2		0	2010
16	110570	NUT ZN 8 - M12 DIN934	2		0	2010
17	111560	WASHER ZN - M12 DIN125	2		0	2010



Base frame 3W (A70395), spare parts

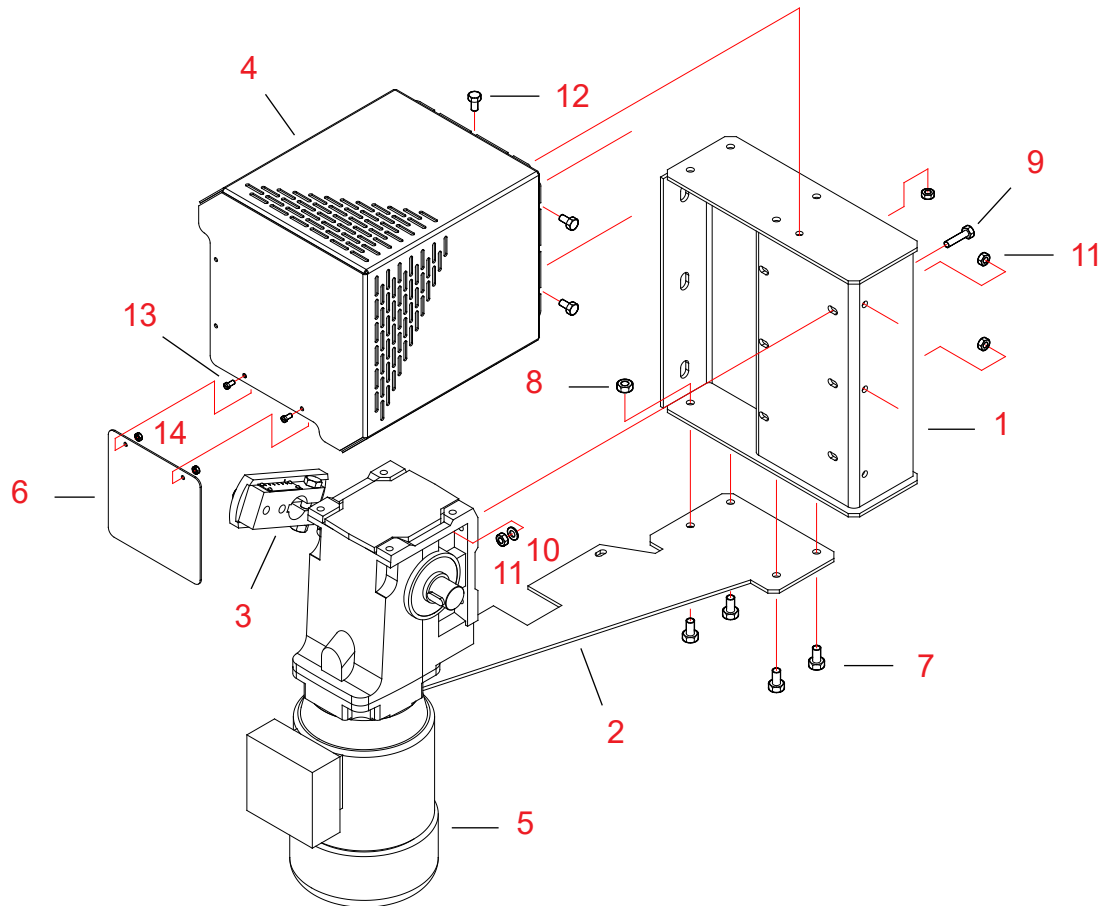




20061106

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	A70357	BASE WM06 3W END-PL TOP WITH OPEN	2	A70357-B	36,69	3000
2	A70649	BASE WM06 FEEDER SIDE-PLATE	2	A70649	36,69	3000
3	A70364	BASE WM06 3W END-PLATE BOTT OPEN	1	A70364-A	14,52	3000
4	A70384	BASE WM06 3W END-PL BOTT OPEN	1	A70384-D	17,6	3000
5	A70380	BASE WM06 3W DUCT 1/1	6	A70380-A	21,64	3000
6	A70393	BASE WM06 3W SUPP PL DUCT 1/1	18	A70393-A	0,69	3000
7	A70389	BASE WM06 SUPPORT PLATE ½ DUCT	6	A70389-A	0,31	3000
8	A70388	BASE WM06 SUCT FEEDER DUCT 1/2	2	A70388-B	10,55	3000
9	A70435	BASE WM06 TROUGH ROD STOPPER	7	A70435-C	0,06	3000
10	A70356	BASE WM06 LEG	4	A70356	26,37	3000
11	501704	BASE FEEDER I D20-2050H=85M,XL,EL	5	32226-D	0	3000
12	501705	BASE FEEDER II D20-2050H=105M,XL,EL	2	32227-D	0	3000
13	A70371	BASE WM06 FEED TROUGH	7	A70371	25,91	3000
14	400200	BASE ATTACH PLATE D20.5/M8	7	4606	0	3000
15	A70385	BASE WM06 ATTACH PLATE D30.5/M8	7	A70385	0,19	3000
16	A70386	BASE WM06 ATTACH PLATE D30.5/D10	7		0,18	3000
17	A70439	KEY DIN 6885B 7x8 - 35	7	A70439	0,02	3000
18	A71320	BASE WM06 TROUGH ROD BAR 8x40	7	A71320	1,24	3000
19	400345	WASHER PL4 D41/D22.5	14		0	4500
20	400348	WASHER ZN PL1.5 D41/31	35		0	4500
21	313100	BEARING FLANGE UCFL 204 CAST P	14		0	2100
22	A70399	BASE WM06 2W/4W BEARING SUPP PLATE	7	A70399	0,57	3000
23	313303	BEARING PLASTIC 55x80 MEGA 41646-A	7	41646	0	2100
24	A70689	BASE WM06 3W FEEDER COVER ATTACH	1	A70689	4,41	3000
25	A70524	BASE WM06 FEEDER COVER LOWER	2	A70524-A	2,41	3000
26	A70686	BASE WM06 FEEDER COVER END	1	A70686-A	0,26	3000
27	A70836	BASE WM06 TROUGH HOLDER	7	A70836	0,48	3000
28	107913	LOCK SCREW ZN - M8x20 DIN603 8.8	4		0	2010
29	107902	LOCK SCREW ZN - M8x25 DIN603	28		0	2010
30	101810	BOLT HEX ZN 8.8 - 8X16 AM DIN933	140		0	2010
31	110540	NUT ZN 8 – M8 DIN934	276		0	2010
32	102200	BOLT HEX ZN 8.8 – 10x20 AM DIN933	28		0	2010
33	110560	NUT ZN 8 - M10 DIN934	109		0	2010
34	111540	WASHER ZN - M8 DIN125	44		0	2010
35	101903	BOLT HEX ZN 8.8 – 10x60 AM DIN933	7		0	2010
36	A71321	BASE WM06 TROUGH ROD SHAFT ATTACH	7	A71321	0,75	3000
37	102499	BOLT HEX ZN 8.8 – 12x20 AM DIN933	14		0	2010
38	104263	SOCK SCREW BALL-H – 12x40 AM ISO 7380	1		0	2000
39	110570	NUT ZN 8 - M12 DIN934	2		0	2010
40	104259	SOCK SCREW BALL-H – 10x20 AM ISO 7380	30		0	2010
41	111550	WASHER ZN - M10 DIN125	104		0	2010
42	102210	BOLT HEX ZN 8.8 10x25 AM DIN933	44		0	2010
43	111532	WASHER ZN FENDER - M8 DIN9021	32		0	2010
44	107910	LOCK SCREW ZN - M8x16 DIN603 8.8	104		0	2010

Motor rack (A70416), spare parts

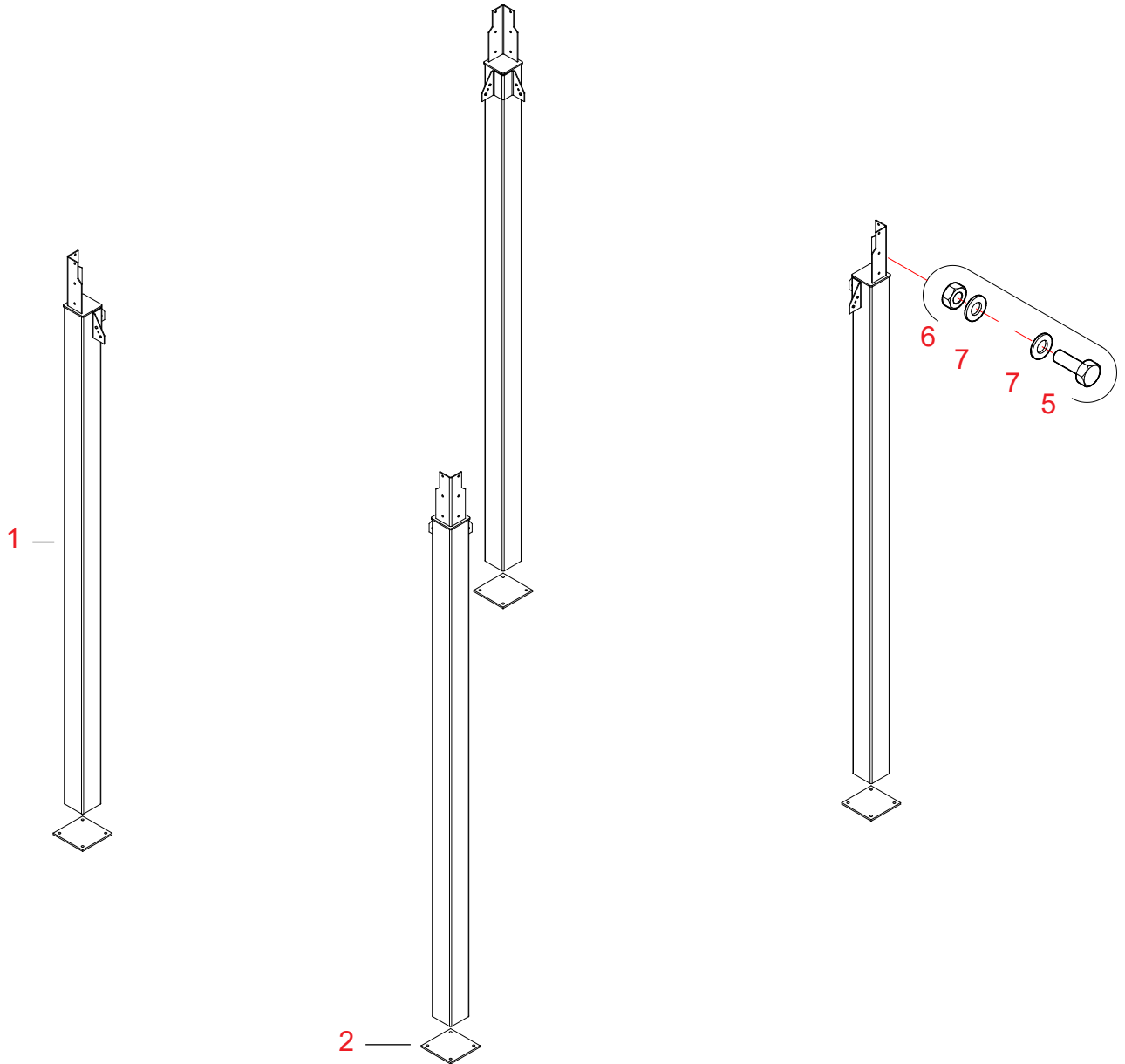


20060921

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



Extension leg set 3W (A70530), spare parts; L = 4100 mm



20061227

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
-	A70530	BASE WM06 LEGS 4100 PACK.	1	A70530		3000

THE SET INCLUDES:

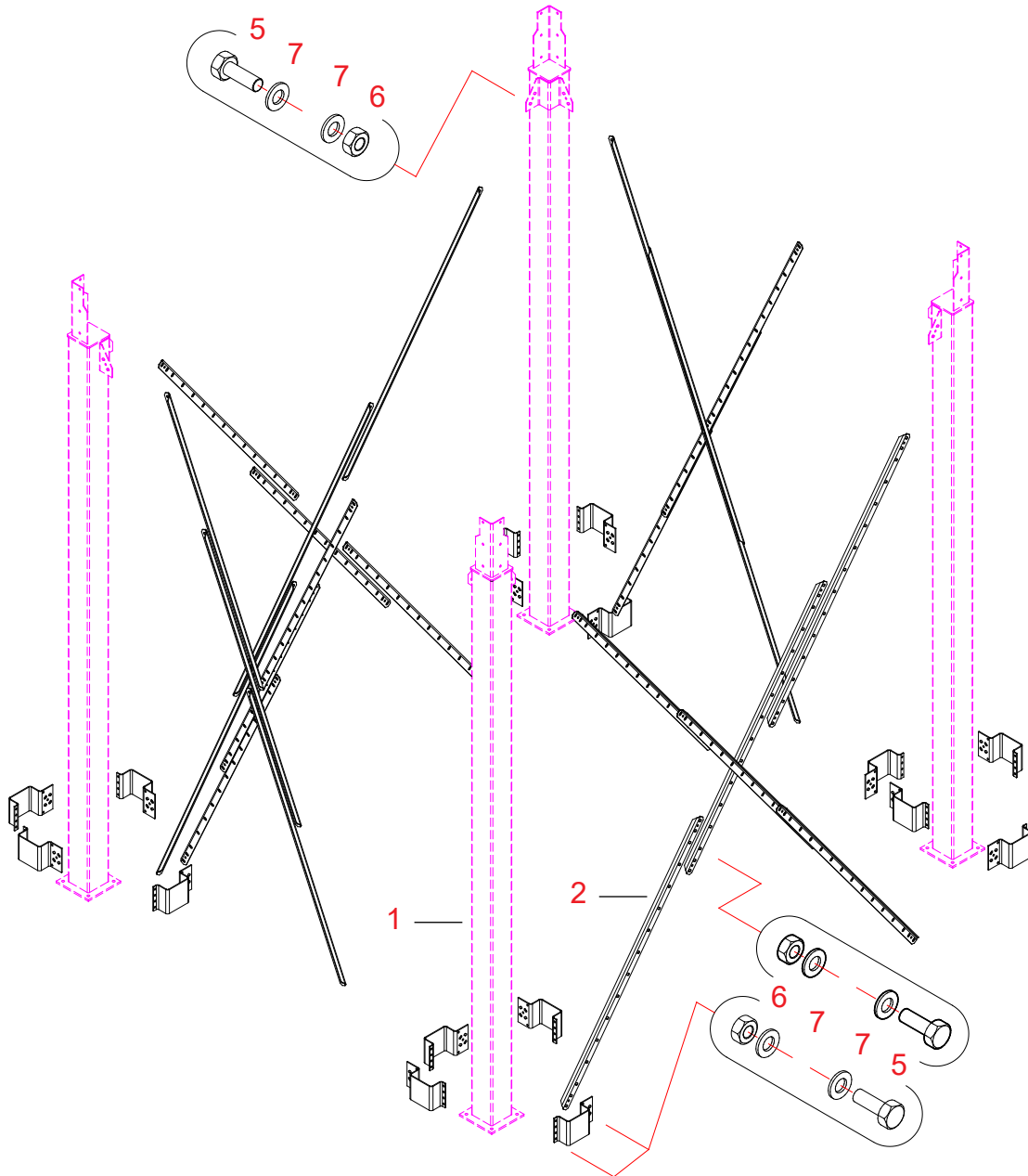
1	A70353	BASE M06W LEG 3W, 6WC	4	A70353	120.52	3000
2	A70561	LEGS WM06 END-PLATE 12X280X280	4	A70561	7.29	3000
5	102520	BOLT HEX ZN 8.8 - 10X25 AM DIN933	24		0.04	2010
6	110570	NUT ZN 8 - M12 DIN934	24		0.02	2010
7	111560	WASHER ZN - M12 DIN125	48		0	2010



Base

Antti WM06

Cross-braces for extension legs 3W (A71523), spare parts; legs L = 4100 mm

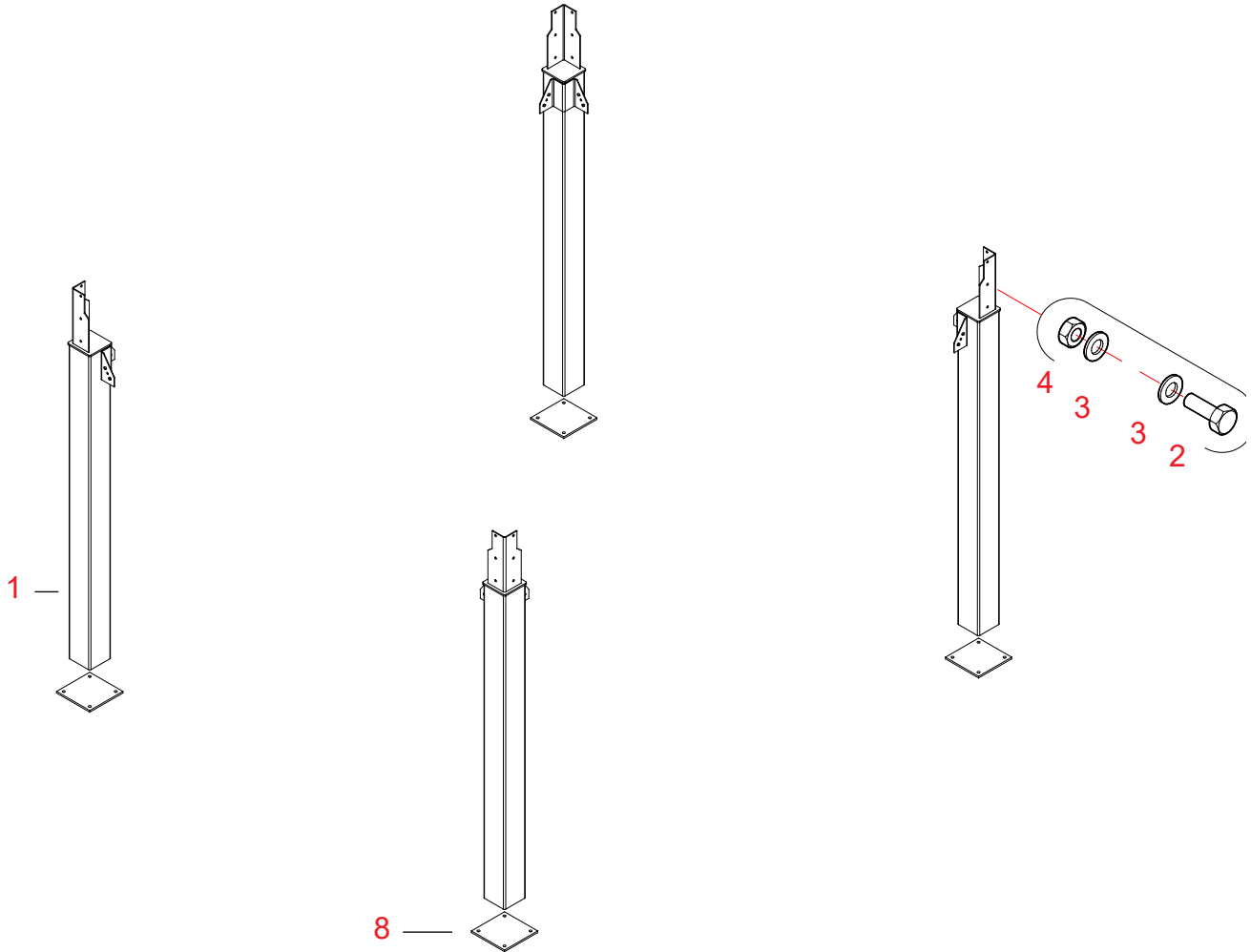


20061227

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	A70535	LEGS M06 ADJUST ATTACHMENT 3W/4	16	A70535-A	4.01	3000
3	A70528	LEGS M06W CROSS-BRACE L = 2000	24	A70528-C	5.92	3000
5	102520	BOLT HEX ZN 8.8 - 12X35 AM DIN933	150		0.04	2010
6	110570	NUT ZN 8 - M12 DIN934	150		0.02	2010
7	111560	WASHER ZN - M12 DIN125	300		0	2010



Extension leg set 3W (A71565), spare parts; L = 2295 mm



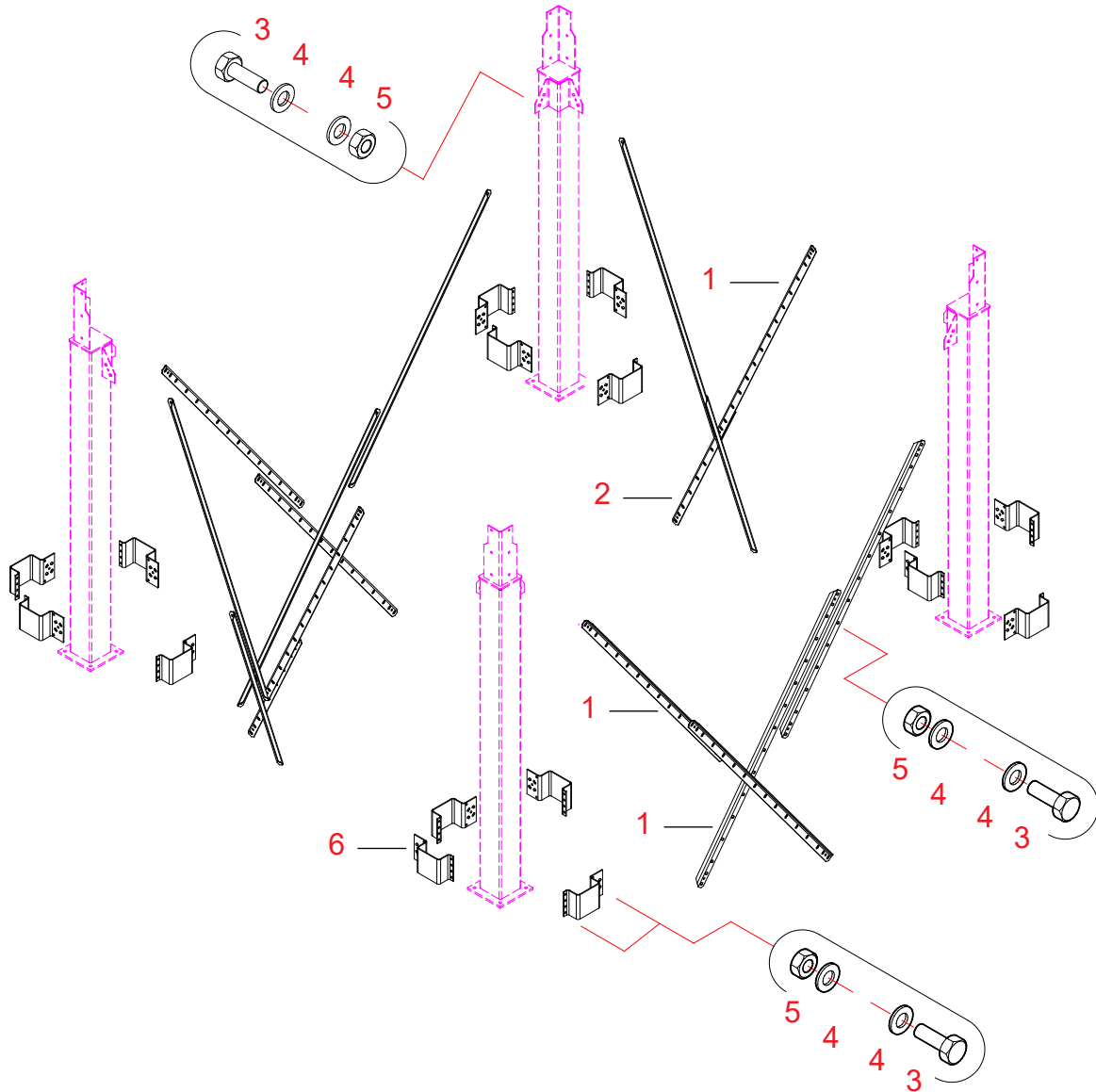
20080711

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
-	A71565	BASE WM06 LEGS 2295 PACK.	1	A71565	315.0	3000

THE SET INCLUDES:

1	A71586	BASE WM06 LEG 3W	4	A71586-A	71.46	3000
2	102520	BOLT HEX ZN 8.8 - 10X25 AM DIN933	25		0.04	2010
3	111560	WASHER ZN - M12 DIN125	50		0	2010
4	110570	NUT ZN 8 - M12 DIN934	25		0.02	2010
8	A70561	LEGS WM06 END-PLATE 12X280X280	4	A70561-0	7.29	3000

Cross-braces for extension legs 3W (A71566), spare parts; legs L = 2295 mm



20080711

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	A70528	LEGS M06W CROSS-BRACE L = 2000	12	A70528-C	5.92	3000
2	A70818	LEGS M06W CROSS-BRACE L = 1000	4	A70818-B	2.86	3000
3	102520	BOLT HEX ZN 8.8 - 12X35 AM DIN933	110		0.04	2010
4	111560	WASHER ZN - M12 DIN125	220		0	2010
5	110570	NUT ZN 8 - M12 DIN934	110		0.02	2010
6	A70535	LEGS M06 ADJUST ATTACHMENT 3W/4	16	A70535-A	4.01	3000



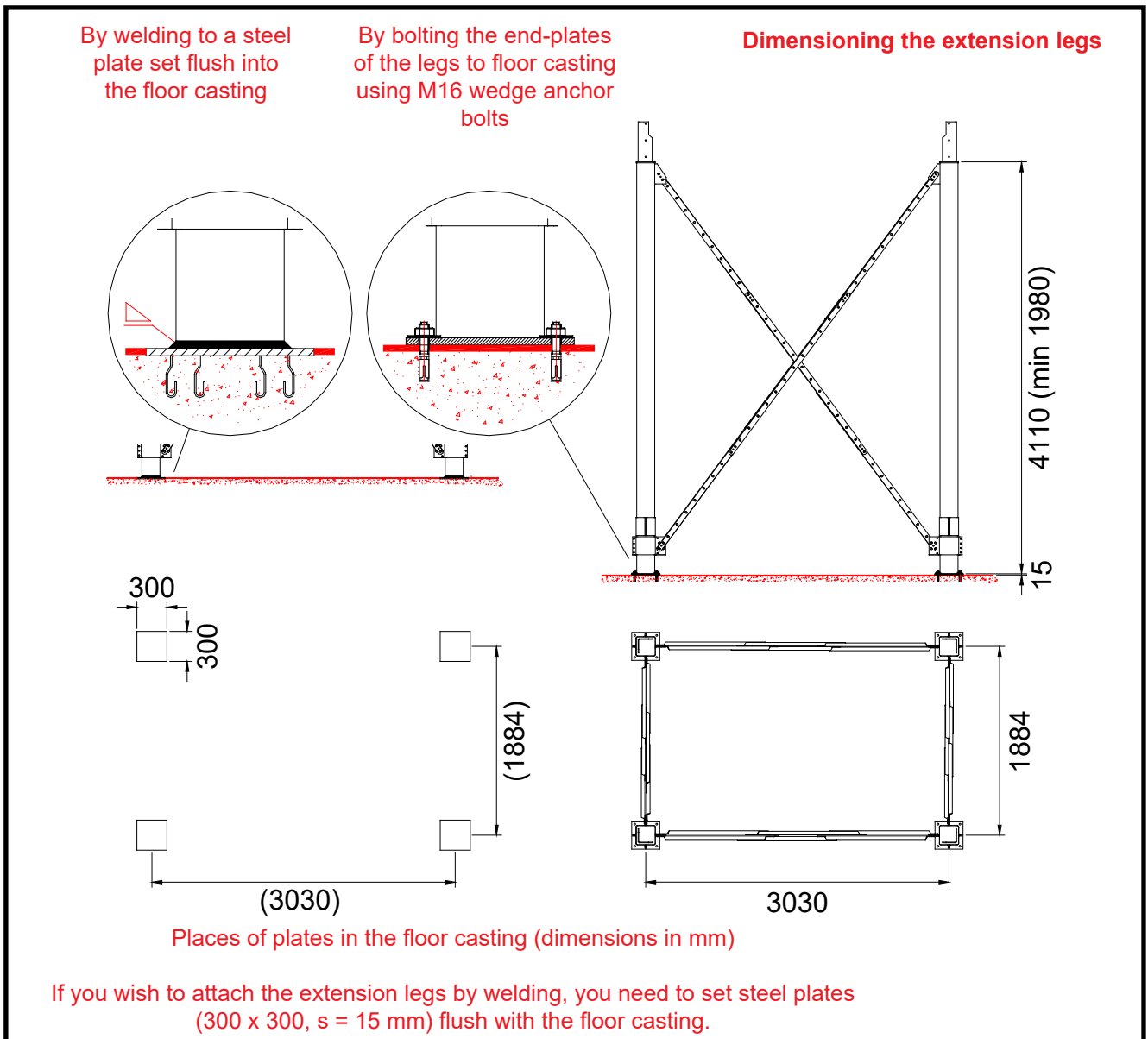
Base

Antti WM06

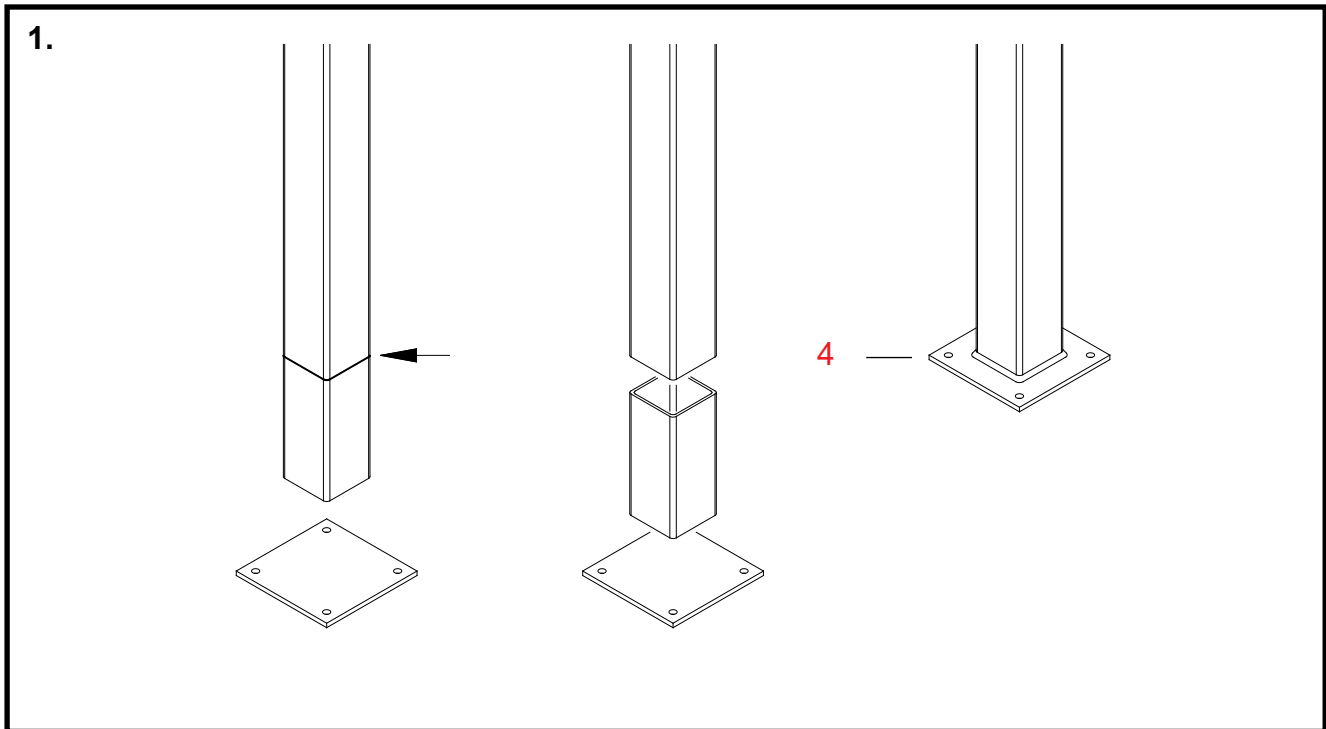
ASSEMBLING THE DRYER BASE

Optional ways to attach and dimension the lower ends of the extension legs on 3W

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



Attaching the extension legs to the base



1. Shortening the extension legs

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

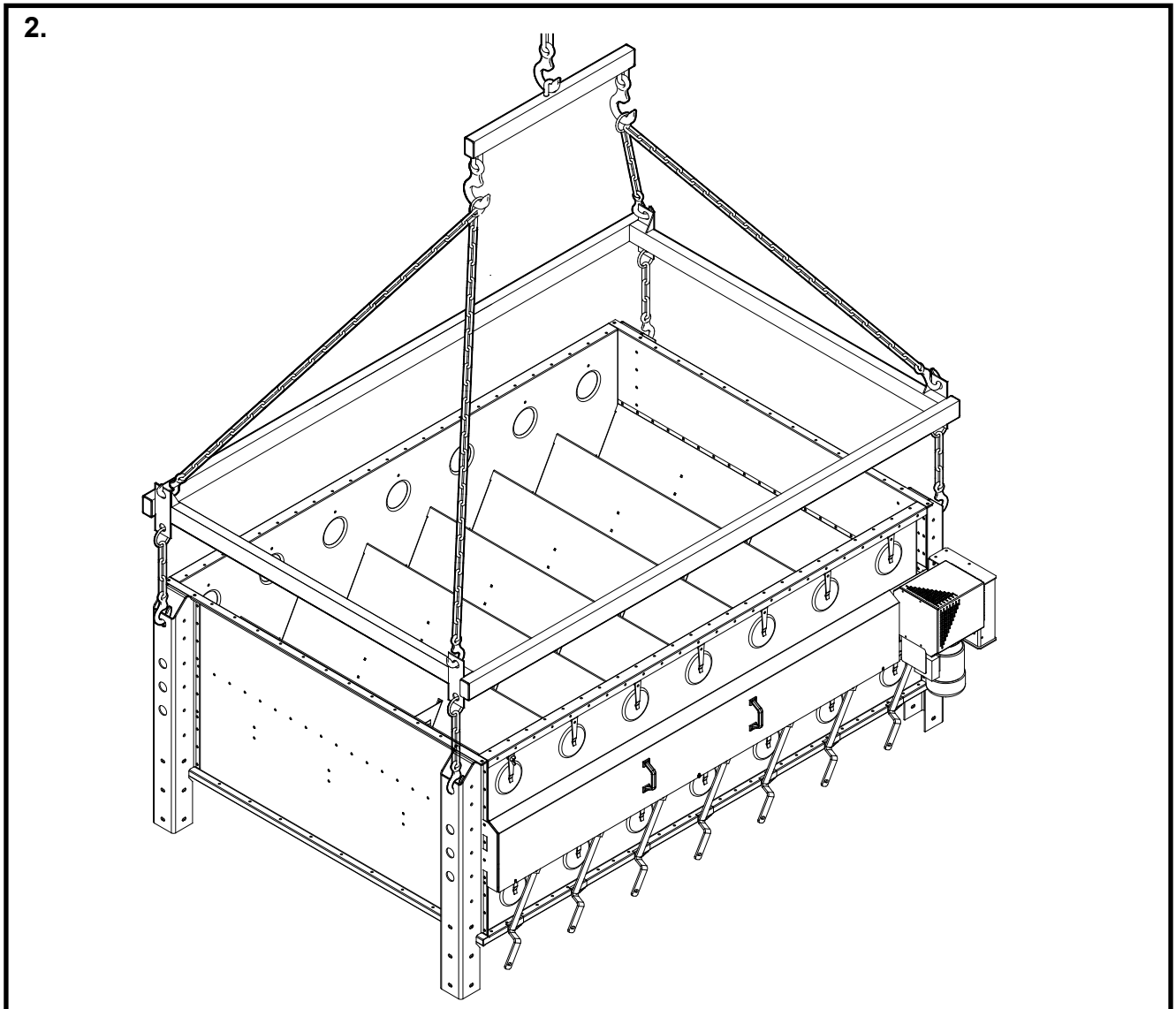
* **At first, determine the length required for the extension legs.**

If you attach the extension legs to the floor casting using wedge anchors, note the thickness of the extension leg end-plates (12 mm) when determining the length to be cut off.

The main rule is that the angle of the pipe leading from the base cone to the elevator should be a minimum of 45 degrees to horizontal.

* **Cut the lower ends of the extension legs to the appropriate length.**

2 **As required, attach the end-plates included in the delivery by welding to the lower ends of the legs.**



2. Lifting the base frame of 3W

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

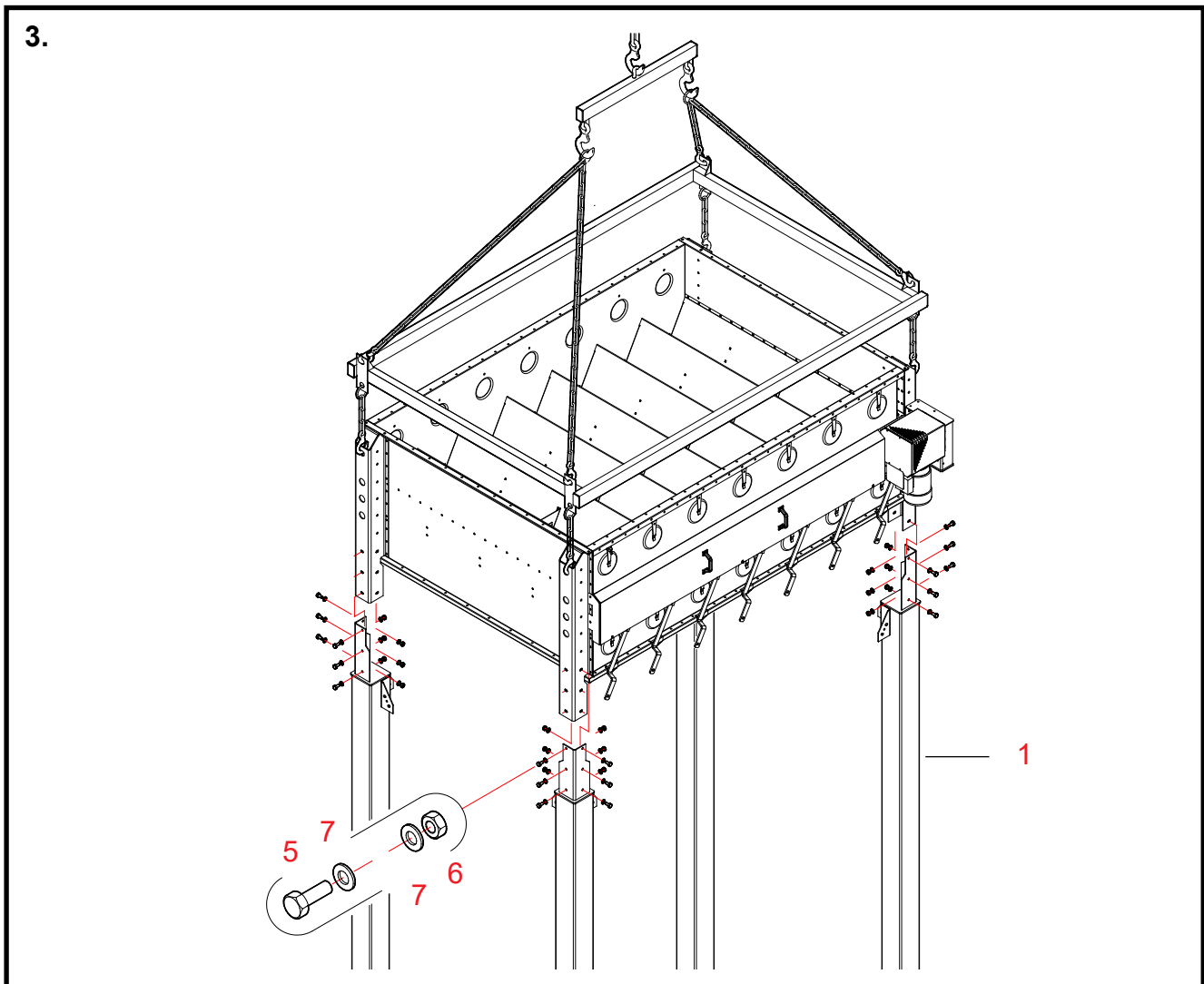
Simply tear off the plastic. Use knife, as necessary.

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

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

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

The weight of the base frame of 3W is about 950 kg.



3. Installing the extension legs on 3W

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

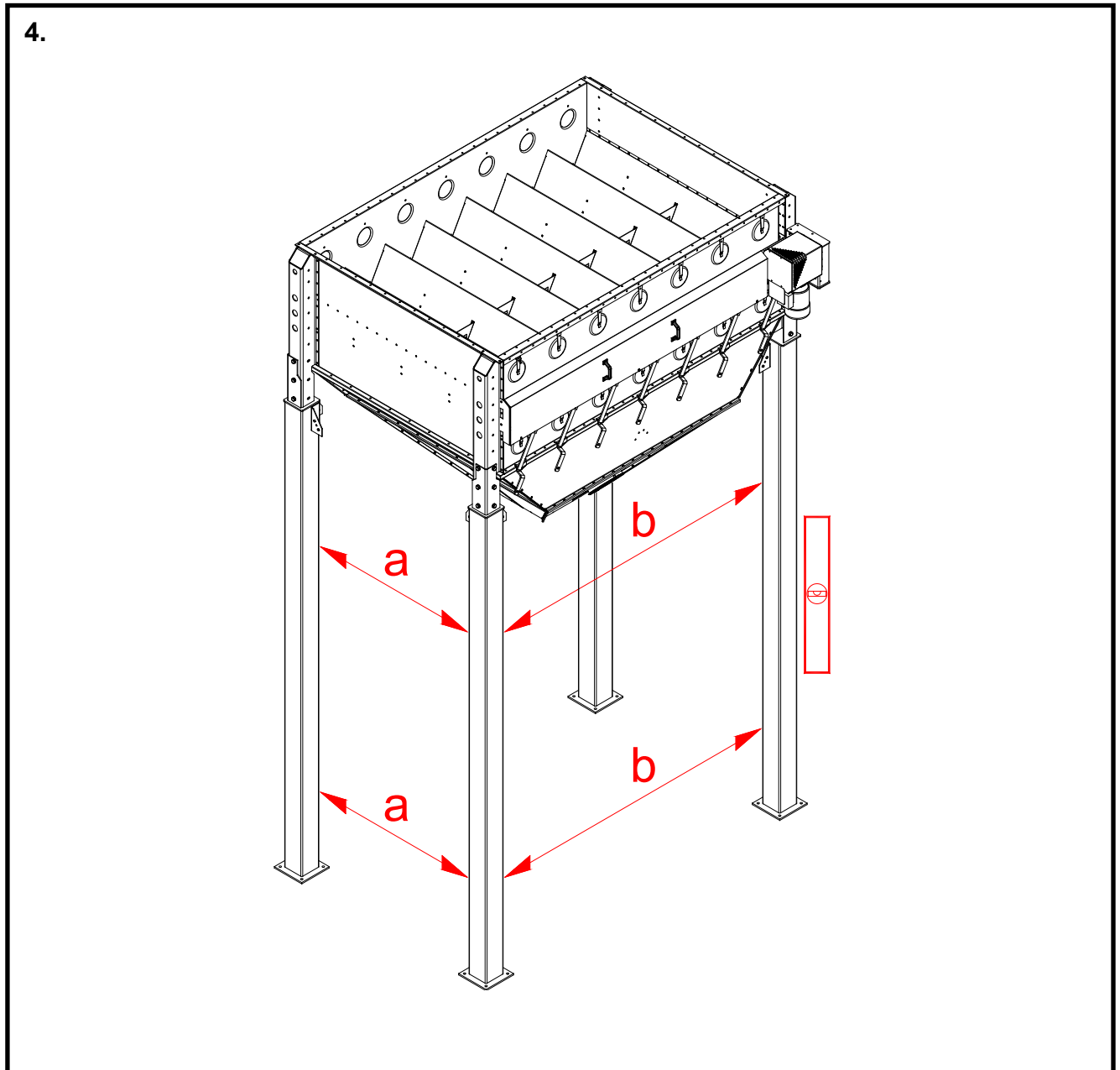
1 **Insert the extension legs in the base frame legs.**
The upper part of the leg comes outside the base leg.

5, 6, 7 **Attach the extension legs to the base legs (bolts M12 x 35).**

Note!

Provide each leg with 6 bolts, washers and nuts!

* **Lower the dryer base onto the extension legs.**

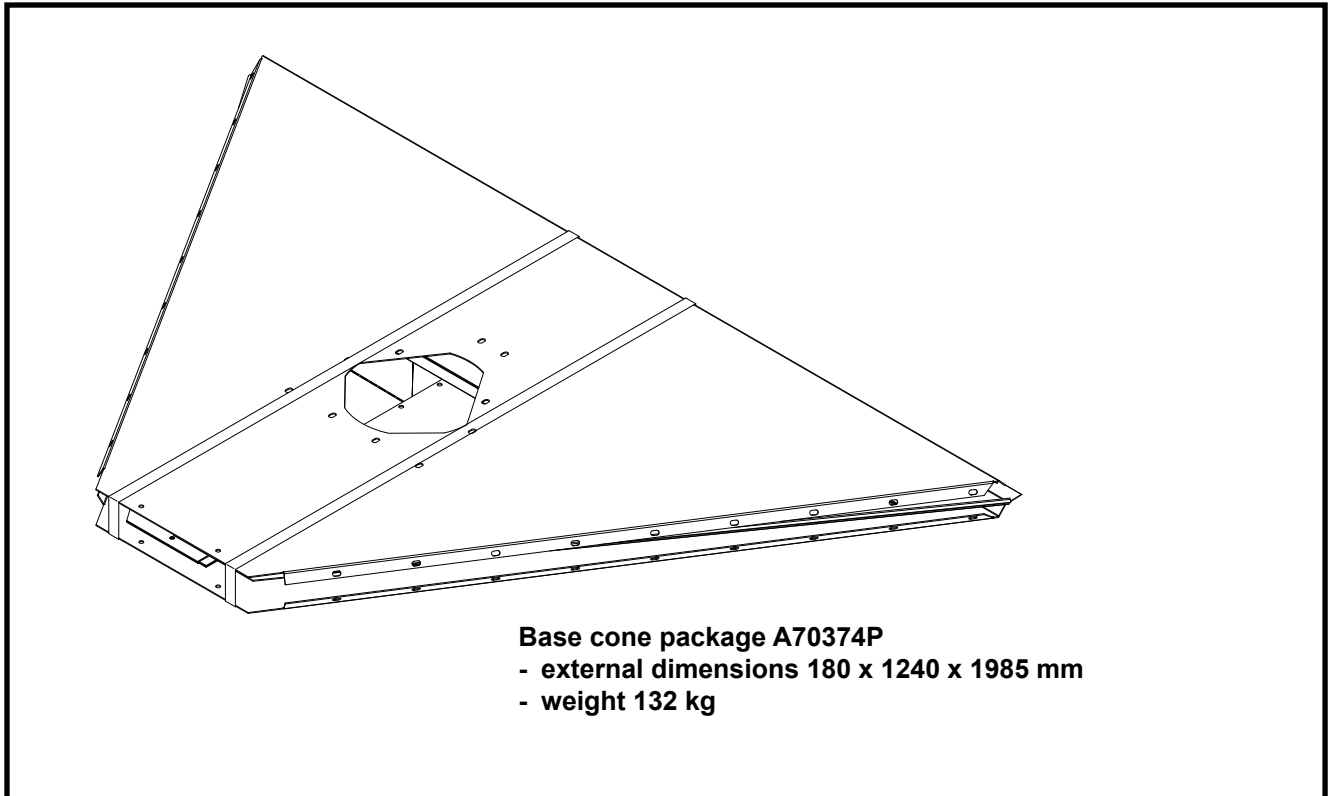


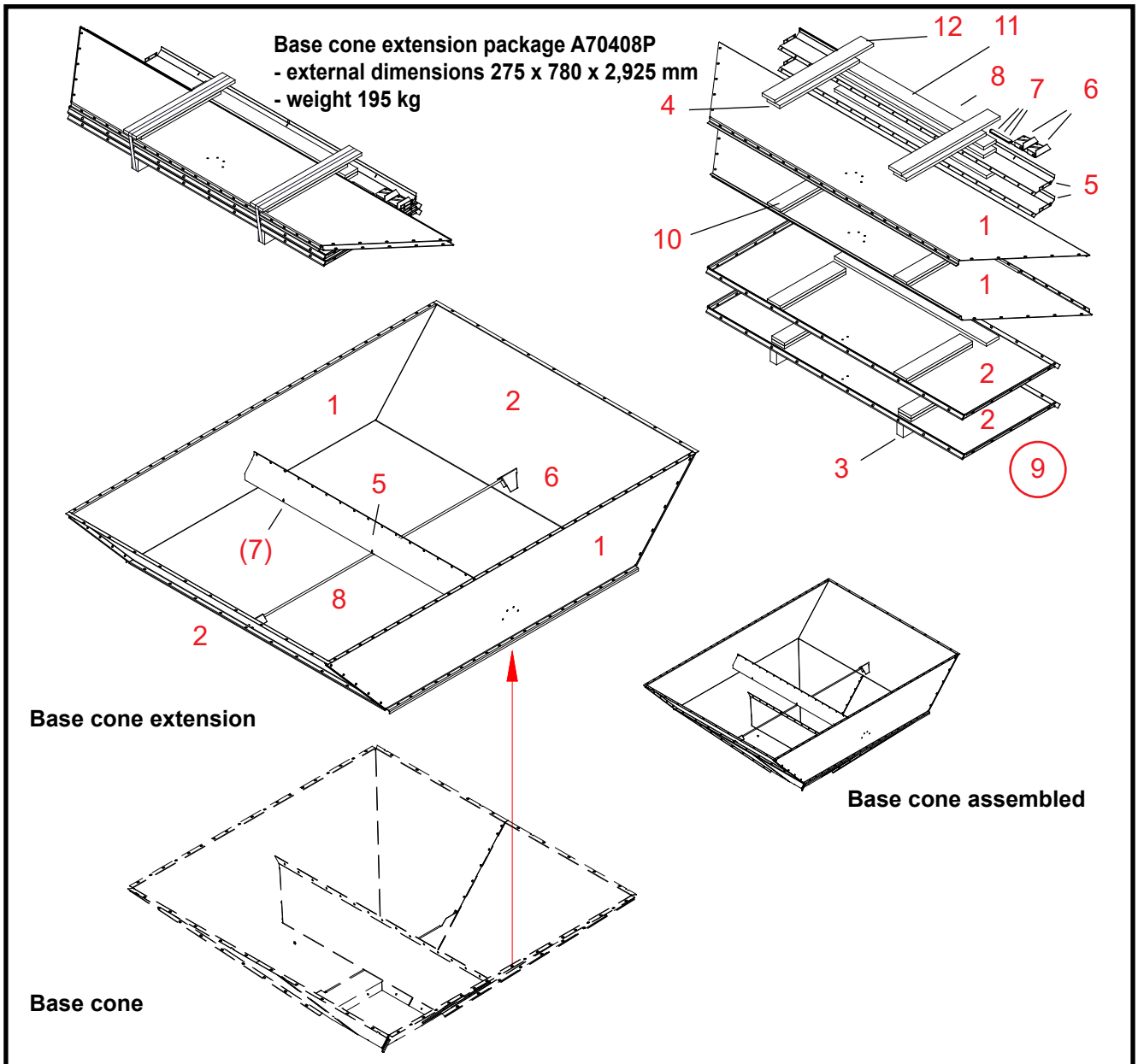
4. Checking alignment of the extension legs

- * **Check that the extension legs are in an upright position and parallel to each other.**
Carry out the measurement and perform the required corrections before attaching the legs to the floor.
- * **Attach the legs to the floor either by welding or using wedge anchors.**
Attachment by welding is possible only if metal plates have been set into the floor during casting.



Structure of the base cone 3W





20060601

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	A70406	BASE M06W CONE EXTENS SIDE 3W	2	A70406	35.5	3000
2	A70407	BASE M06W CONE EXTENS END 3W	2	A70407-A	26.04	3000
3	315428	BATTEN L=700 50X100	2		0	2800
4	315450	BOARD L= 630 22x100 (19x100)	6		0	2800
5	A70496	BASE M06W CONE DUCT 3W/4W	2	A70496-A	11.48	3000
6	A70540	BASE M06W NTERM SUPP BEARER 3W	2	A70540-A	0.4	3000
7	400850	SECT INTERM SUPP 3X22-153.5	3	A70498	0	3000
8	119013	THREADED ROD ZN - M12x2000 MM 8.8	1		0	2000
9	A70969	BASE CONE 3W BOLT PACK 9994200046	1	A70969-A	1.96	2010
10	315425	BOARD L= 520 22x100	8		0	2800
11	315418	BOARD L=1200 22x100	4		0	2800
12	315430	BOARD L= 780 22x100 (19x100)	2		0	2800

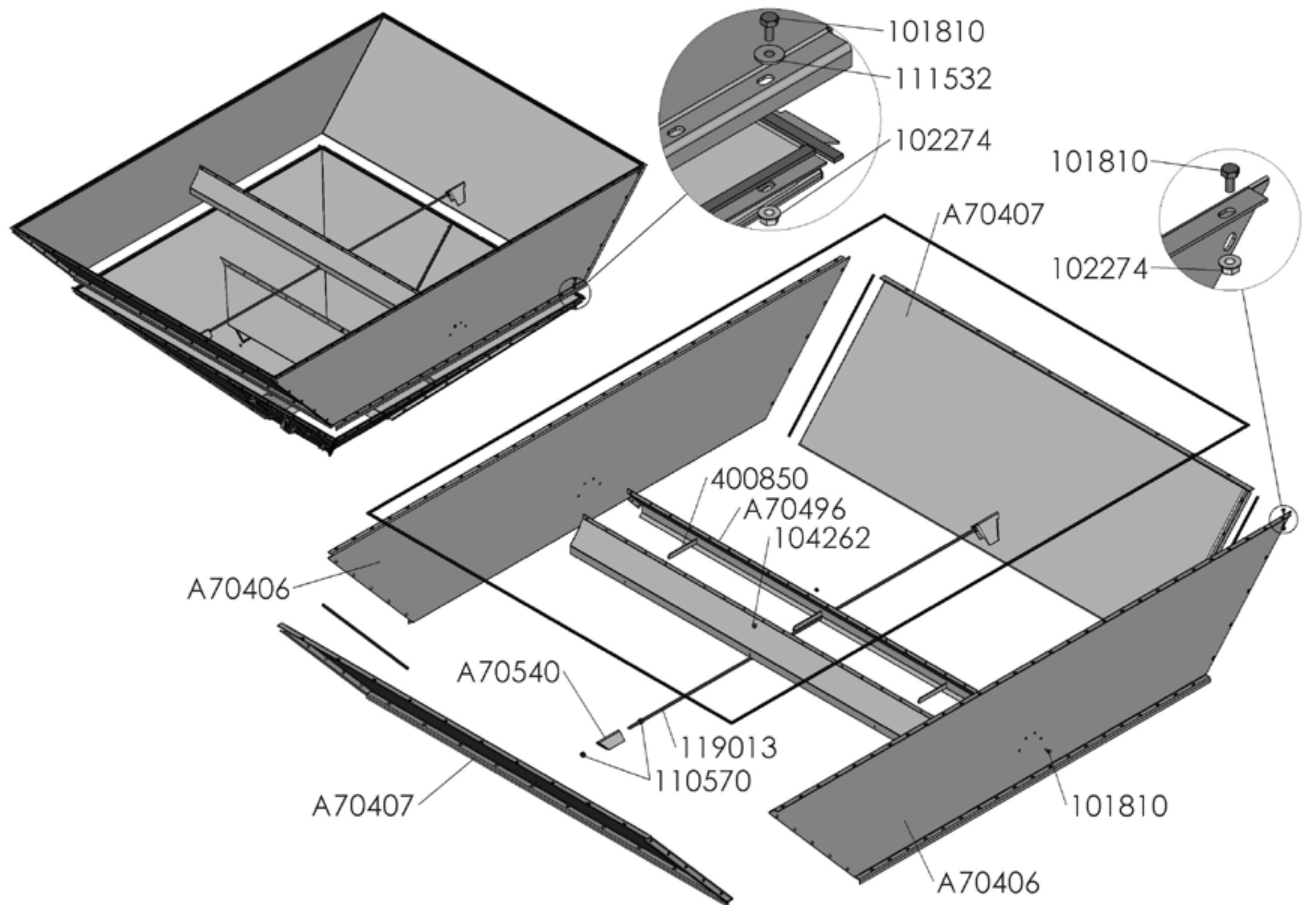


Base

Antti WM06



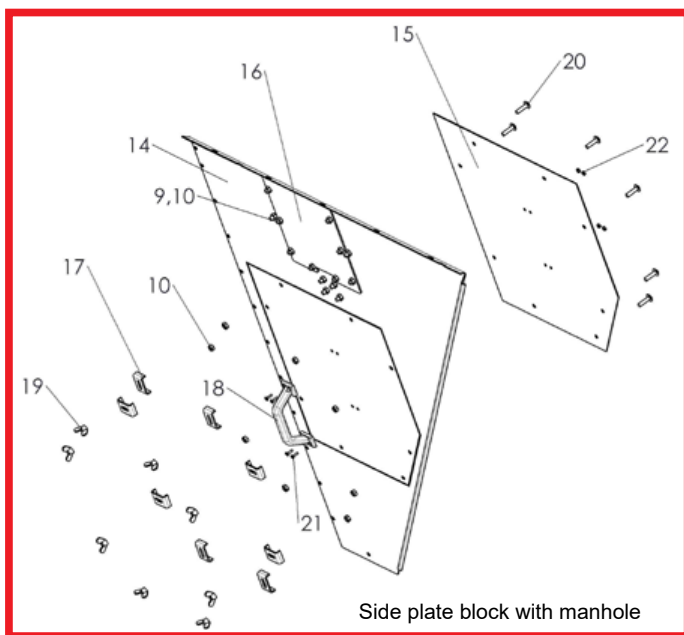
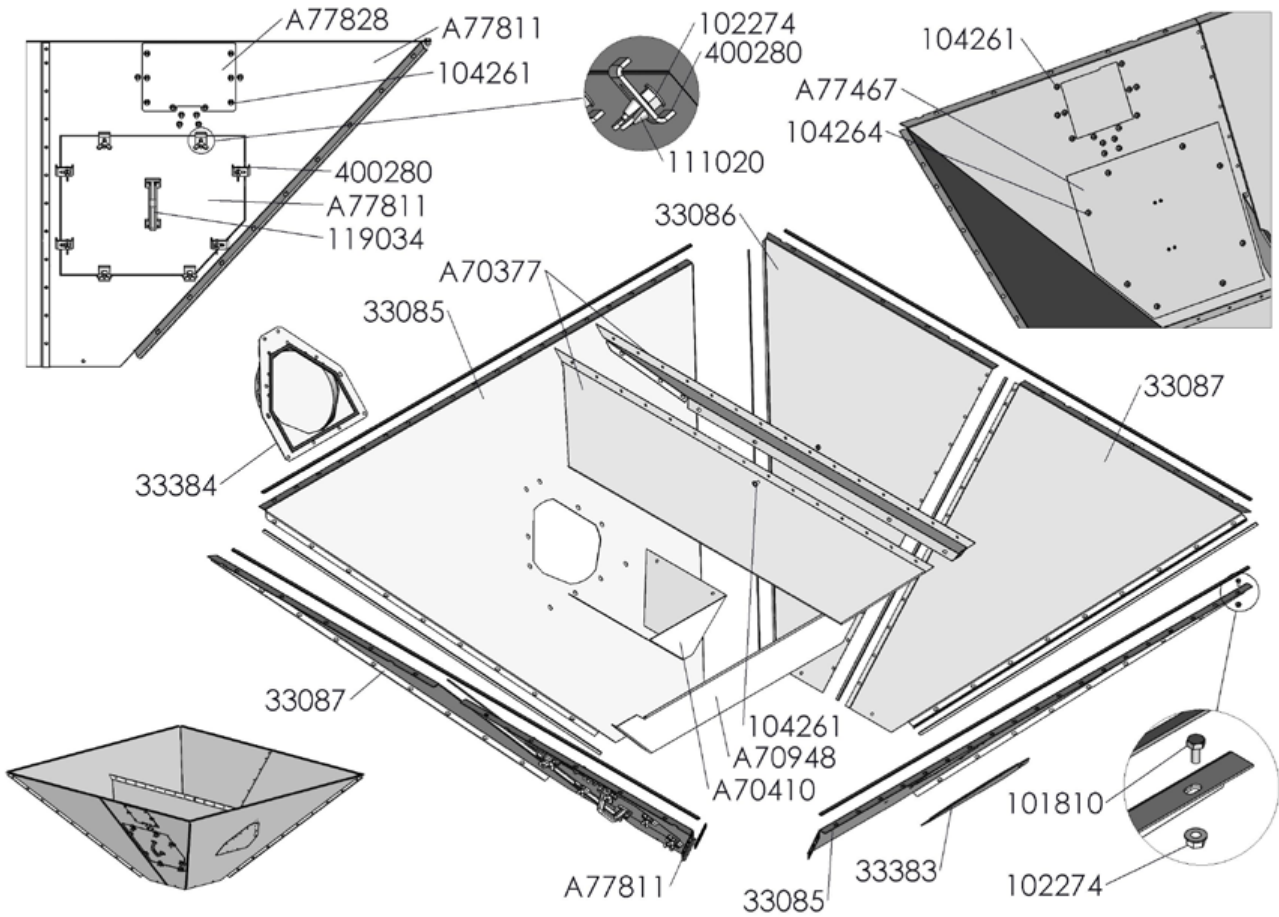
Cone extension 3W (A70408), spare parts



Ref.	Part no.	Denomination	Pcs.
1	A70406	BASE CONE EXTENSION SIDE WM06 3W	2
2	A70407	BASE CONE EXTENSION END WM06 3W	2
3	A70540	BASE CONE EDGE SUPPORT CLAMP WM06 3W	2
4	119013	STUDBOLT M12X2000 MM 8.8 ZN	1
5	A70496	BASE CONE DUCT WM06 3W/4W	2
6	400850	CELL DUCT SUPPORT WM06 3X22-153,5	3
7	101810	BOLT HEX ZN 8.8 8X16 AM DIN933	110
8	102274	HEX FLANGE NUT M8 ZN 8 DIN 6923	129
9	110570	NUT M12 ZN8 DIN934	4
10	104262	SCREW HEX, DOME NUT 8X12 AM ISO 7380-2	19
11	111532	BODY WASHER ZN M 8 DIN9021	60
12	115570	SEALING STRIP 4X8 EKO-40	11



Base cone 3W (A70374), spare parts



Side plate block with manhole

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

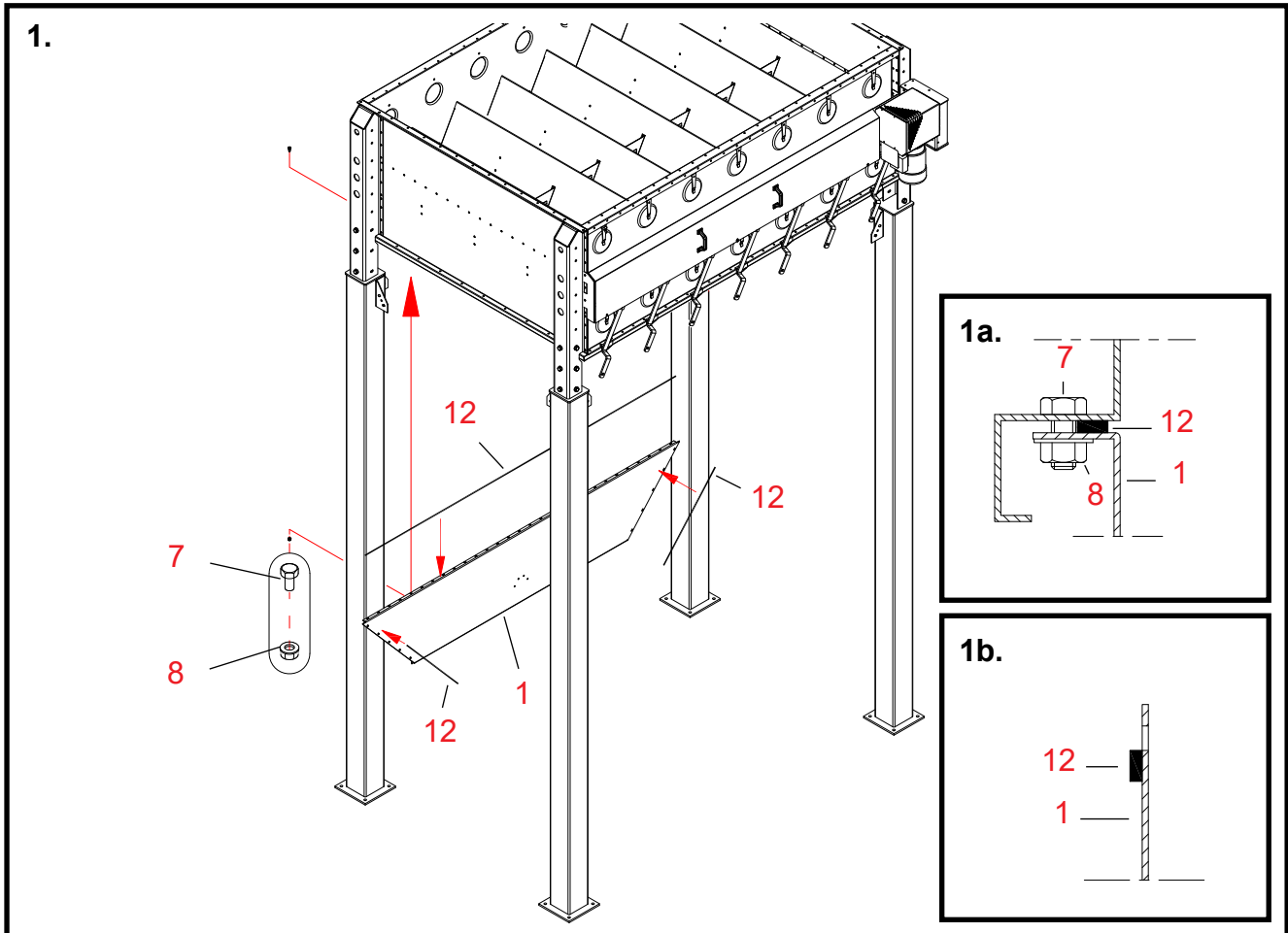


Base

Antti WM06

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

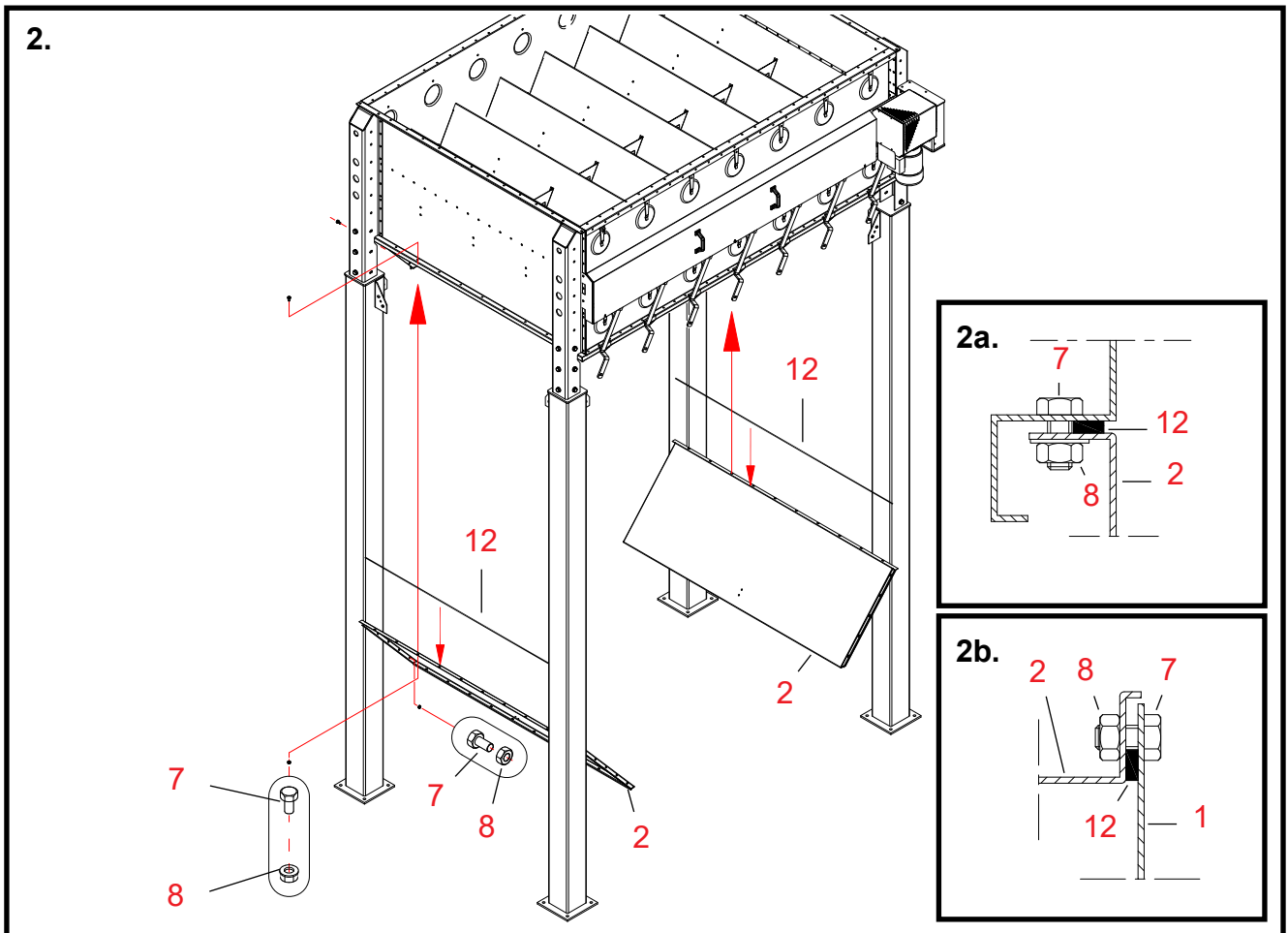
Installing the base cone extension on 3W



1. Installing the first side-plate of the base cone extension

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

- 12 Fix a sealing strip to the upper surface of the side-plate flange.**
Fix the sealing strip inside the bolthole row in the flange (see drawing. 1a).
- 12 Provide both ends of the side-plate with sealing strips.**
Fix the sealing strip inside the bolthole row of the plate (see Fig. 1b).
- 1 Lift the sideplate against the bottom surface of the base.**
- 7, 8 Attach the plate using bolts and flange nuts (M8 x 16, 29 pcs.).**
See dwg. 1a.
Do not tighten the bolts yet.



2. Installing the end-plates of the base cone extension

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

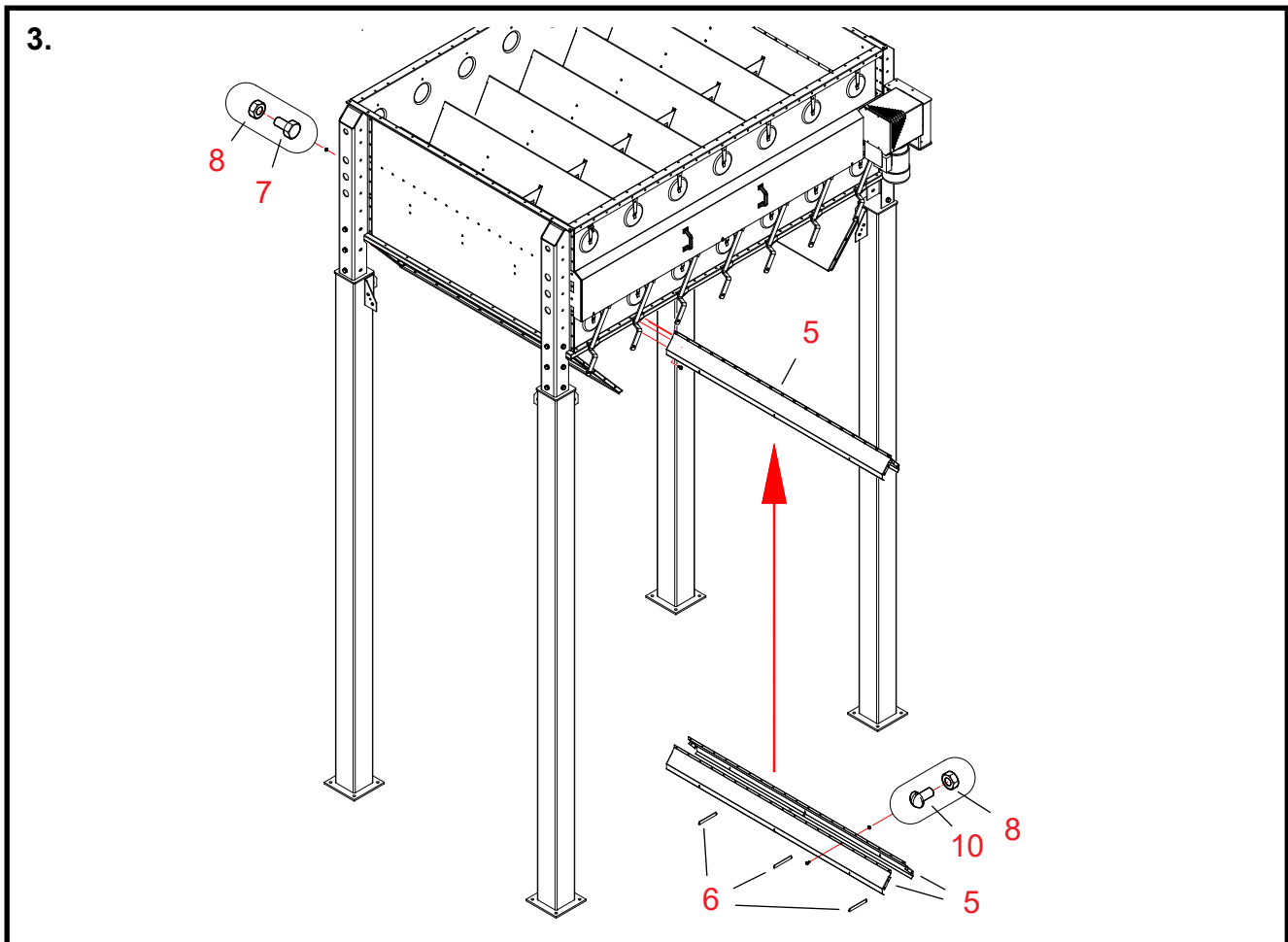
12 Fix a sealing strip to the upper surface of the flanges of both end-plates.
Fix the sealing strip inside the bolthole row in the flange (see drawing. 2a).

1 Lift the sideplates against the bottom surface of the base.

7, 8 Attach the plates using bolts and flange nuts (M8 x 16, 10 + 10 pcs).
See dwg. 2a.
Do not tighten the bolts yet.

2 Lift both end-plates tight against the side-plate.
Carefully align the corner joint between the plates.

7, 8 Fix both seams using bolts and nuts (M8x16, 5+ 5 pcs).
See dwg. 2b.
Do not tighten the bolts yet.



3. Installing the air duct in the base cone extension

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

5 **Place the suction air duct halves face to face.**

Make sure that the end flanges of the air duct do not "indent".

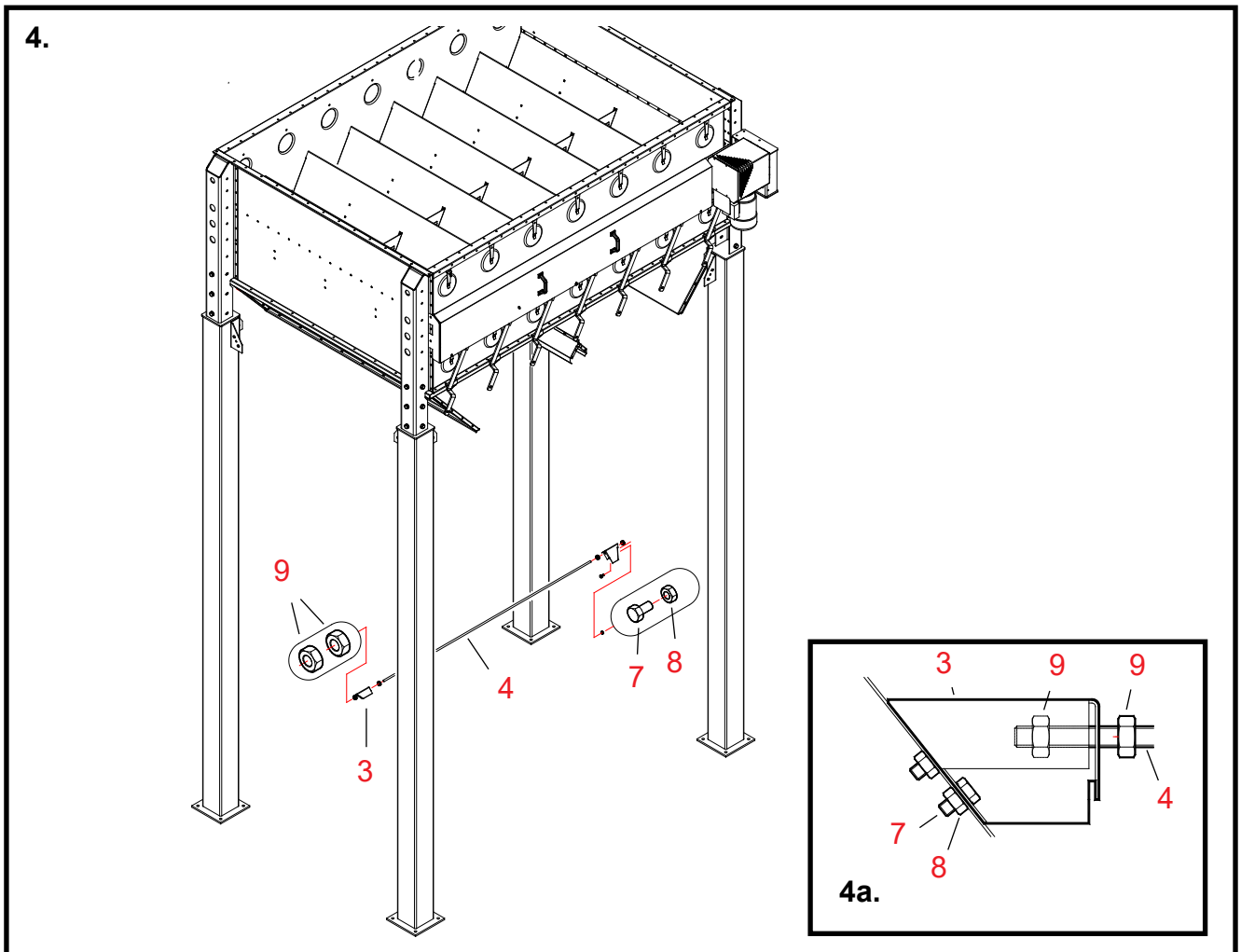
8, 10 **Join the halves together using ball-headed nuts and bolts (M8 x 10, 19 pcs.).**

6 **Place three intermediate supports inside the part 5 air duct.**

5 **Thread the air duct into position inside the cone.**

7, 8 **Fix the air channel at one end using bolts and nuts (M8 x 16, 4 pcs.).**

Support the free end of the air duct temporarily on the dryer until the other side-plate has been fixed in place.



4. Installing the intermediate support of the base cone extension

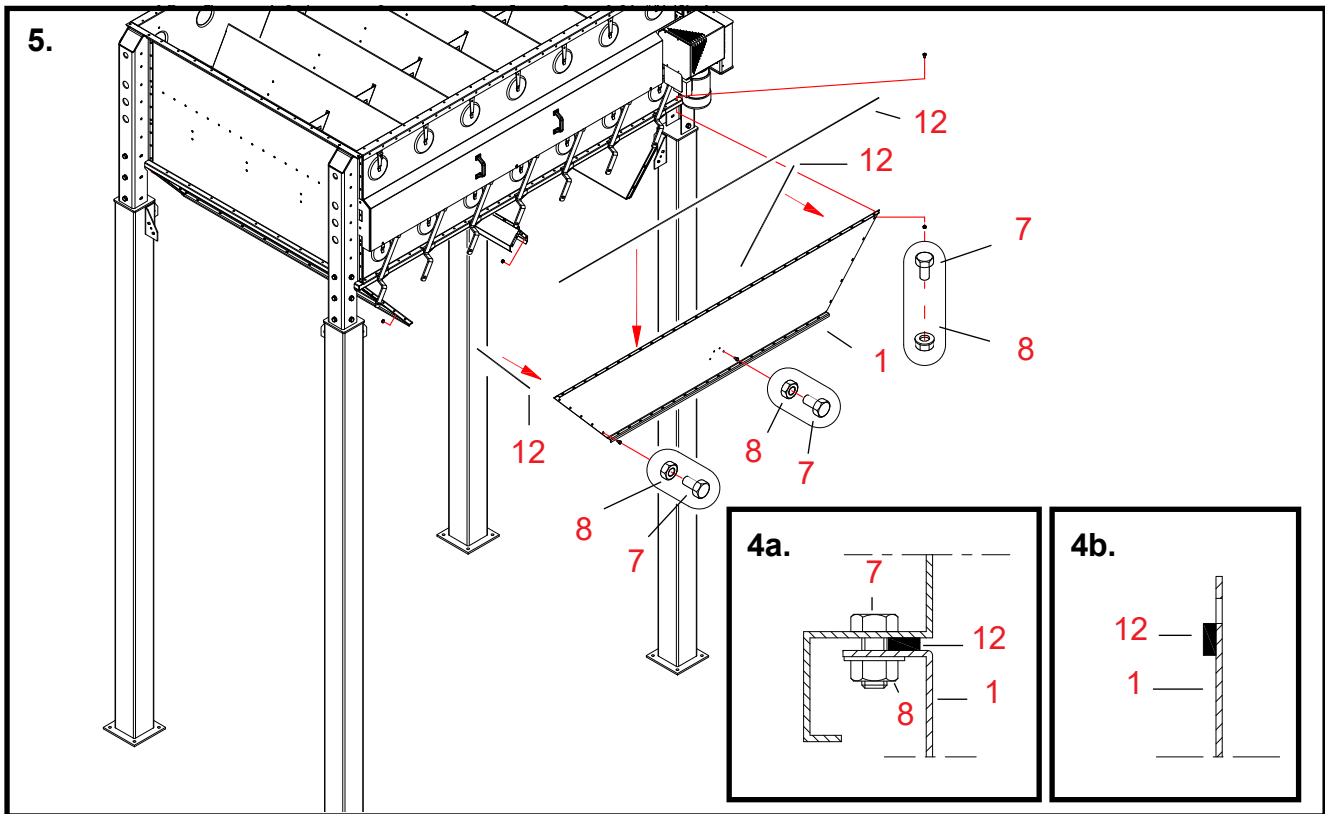
Parts The numbering of work stages refers to reference numbers in the spare parts drawing of base cone extension.

9 Turn a nut onto the threads at both ends of the threaded rod (part 4).

3 Thread a bearer for the intermediate support on both ends of the threaded rod (part 4).

9 Thread another nut onto both ends of the rod outside the bearers.

7, 8 Fix the intermediate support bearers using bolts and nuts (M8x16, 2+2 pcs.).
See dwg. 4a.



5. Installing the other side-plate of the base cone extension

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

12 Fix sealing strips to both ends of the side-plate on the upper surface of the flange.
Fix the sealing strip to the flange inside the bolthole row (see drawing 4a and 4b).

1 Lift the sideplate against the bottom surface of the base.

7, 8 Attach the plate using bolts and flange nuts (M8 x 16, 29 pcs.).
See dwg. 1b. Do not tighten the bolts yet.

7, 8 Attach the side-plate by its two ends using bolts and nuts (M8 x 16, 5 + 5 pcs.).
Do not tighten the bolts yet.

7, 8 Fix the air channel to the side-plate using bolts and nuts (M 8 x 16, 4 pcs).

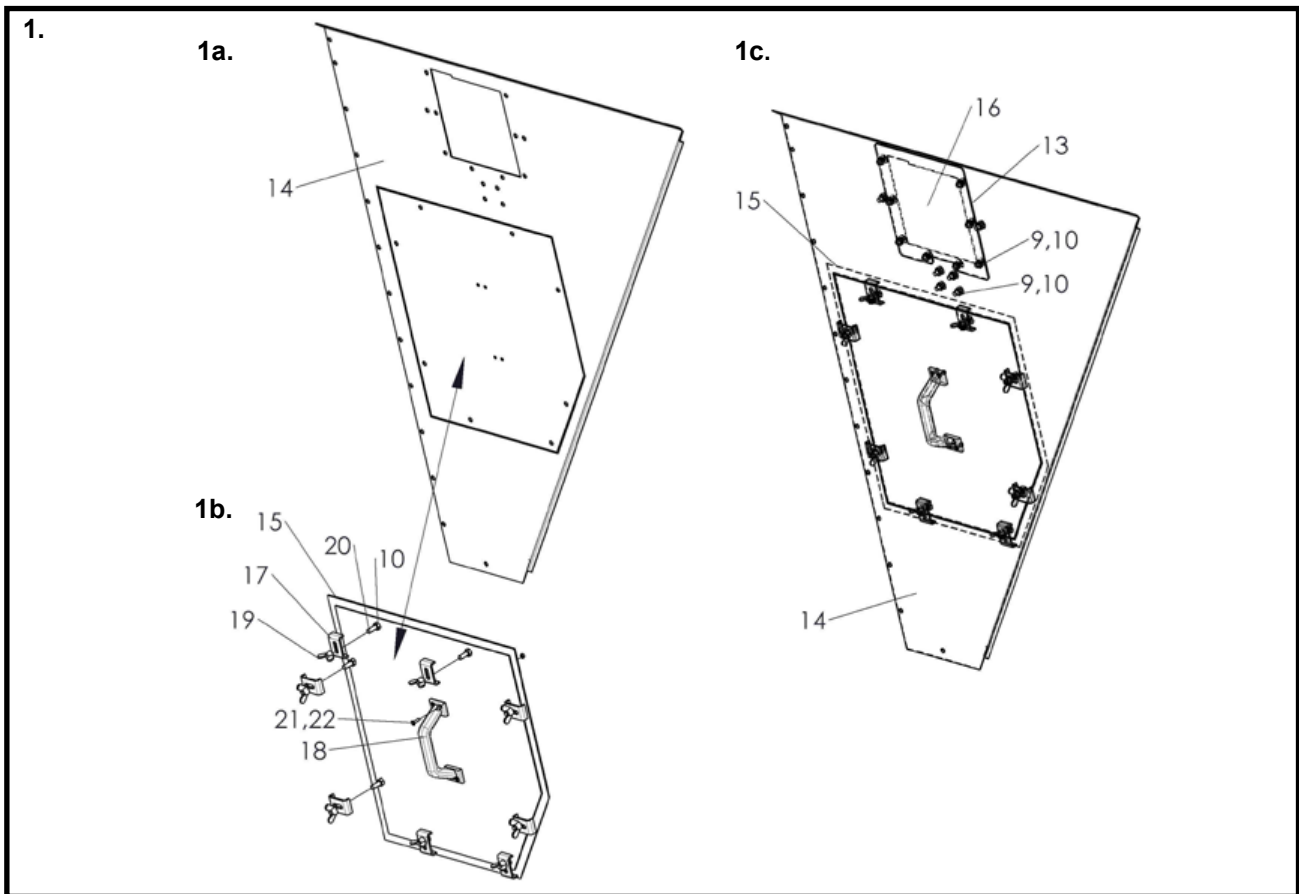
* Ensure that the base cone extension is aligned in the correct position against the bottom surface of the base.

* Tighten all bolts at the corners of the base cone extension.

* Tighten all bolts attaching the base cone extension to the base.

* Lightly twist the outermost nuts on the threaded rod against the brackets.
Tighten the innermost nuts on the threaded rod. Hold the outermost nuts while wrenching.

Assembling the base cone 3W



1. Side plate block with manhole; assembly instruction

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

14 **Remove the plate in section 14..**

14-15 Connect the detached plate to part 15 with dome head screws and nuts (M8x30; 8pcs).
Place the screw domes on the grain farm side (see picture 1b)

17-19 **Connect the parts as shown in Figure 1b.**

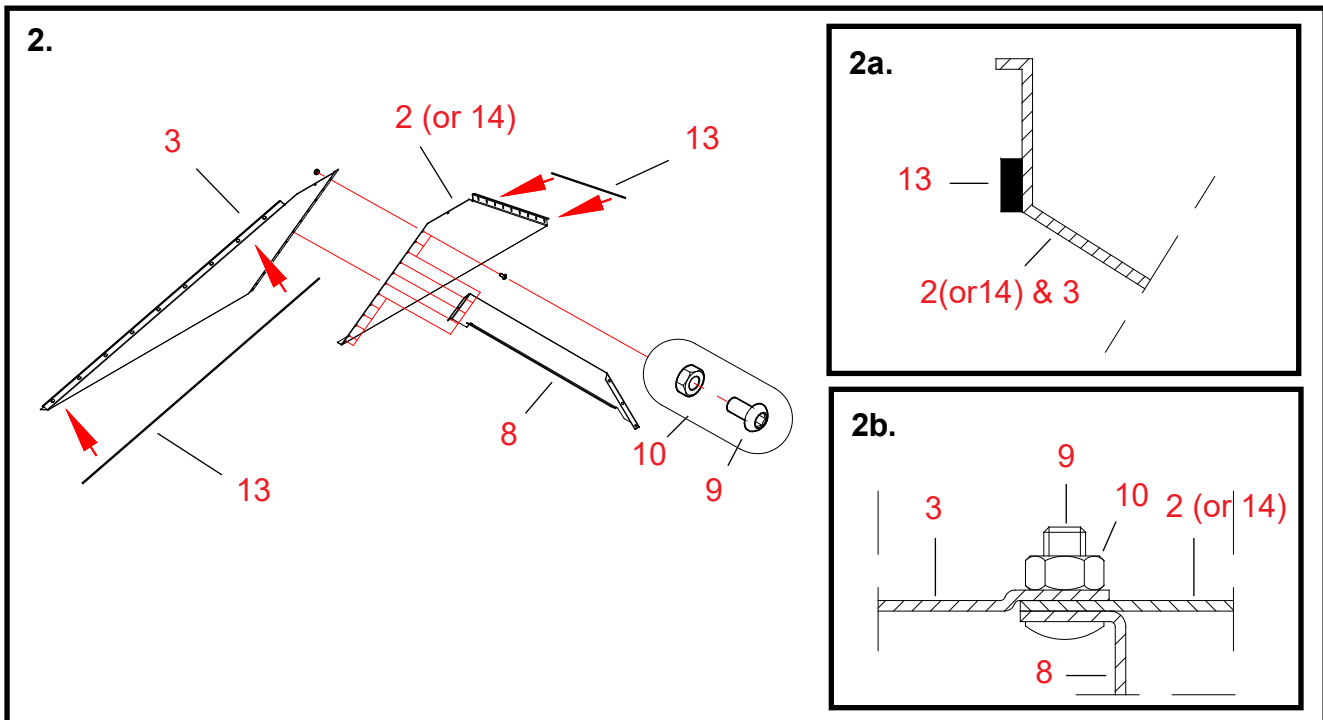
18 **Connect the handle with screws and nuts (M5x16; 4pcs). as shown in figure 1b.**

14 Attach the assembly according to figure 1b. to the cone block (fig. 1c.)
The larger plate (part 15) is on the inside of the cone.

13 Attach the sealing strip around the upper opening (see picture 1c).

16 Attach the cover plate to the outer surface of the cone plate with dome head screws and nuts.
Also put the screws into the underneath holes near the cover plate. (M8x16; 12pcs.)
Place the screw dome heads on the grain farm side (see picture 1c).

Structure of the base cone 3W



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

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

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

13 Fix sealing strip to the corner flange of the plate with straight edge (part 2).

Fix the sealing strip inside the bolthole row in the plate (see drawing 2a).

13 Fix a sealing strip to the corner flange of the shouldered side-plate (part 3).

Fix the sealing strip inside the bolthole row in the plate (see drawing 2a).

Note: no sealing strip is required at the centre seam of the base cone.

Be careful not to damage the sealing strips while joining the plates.

2 + 3 Place the shouldered side-plate tight against the side-plate with straight edge.

The shouldered edge of plate 3 shall remain outside plate 2.

8 Place the additional support for the cone inside the side-plates.

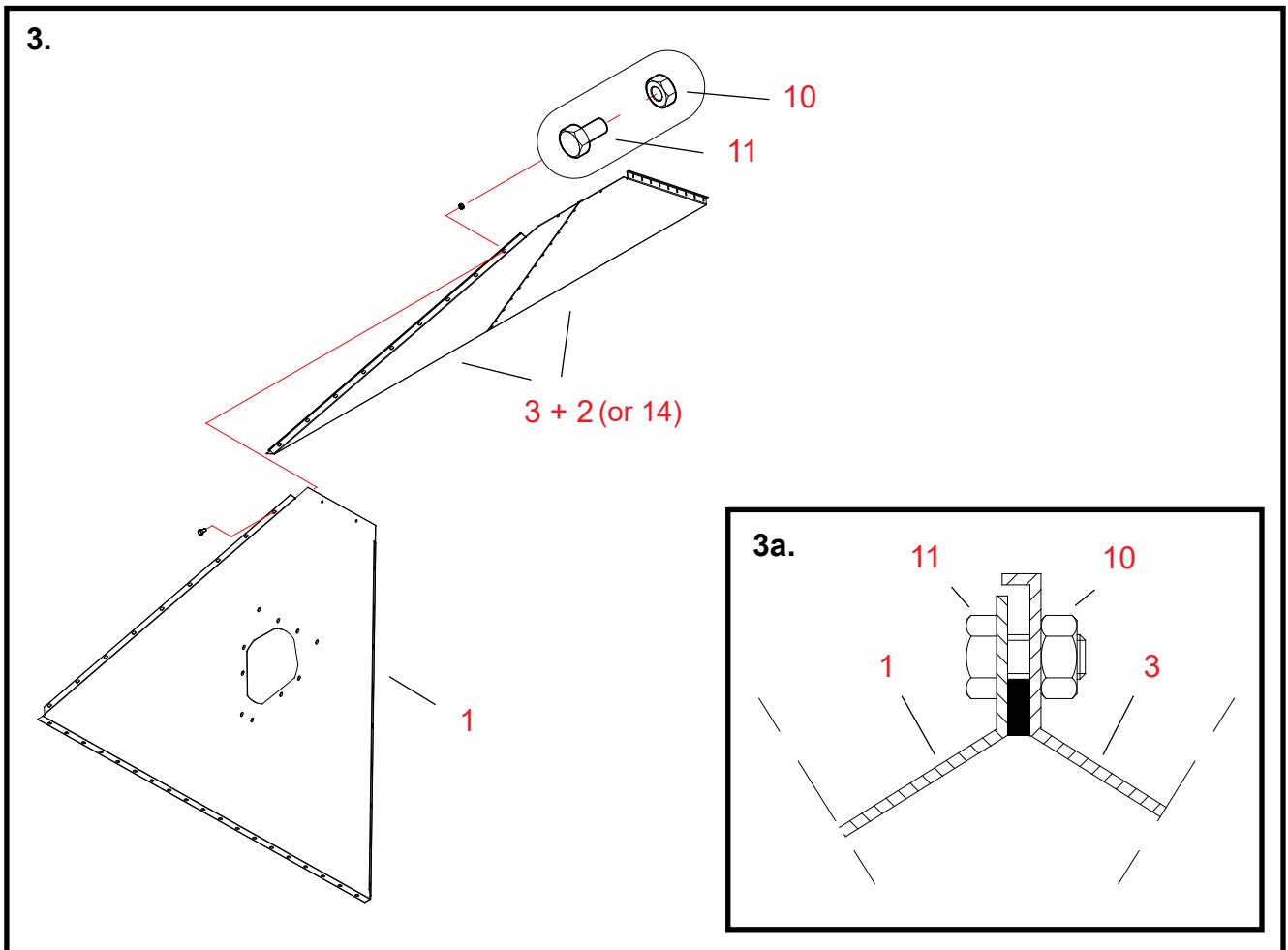
Look up the correct position and attachment point for the support in the drawing.

9, 10 Fix the seam using ball-headed nuts and bolts (M8 x 16, 12 pcs.).

Place the bolt heads on the grain space side (see Fig. 2b).

2 + 3 Assemble another similar side-plate without additional support (part 8) of parts 2 and 3.

Do not put bolts into the three holes in the additional support at this stage.



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

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

1 Lift the side-plate with opening for the base cone onto the assembly plane.

Place the flange of the plate with 19 holes against the plane.

2 + 3 Lift one of the recently assembled side-plates, the one without additional support, against the side-plate with opening.

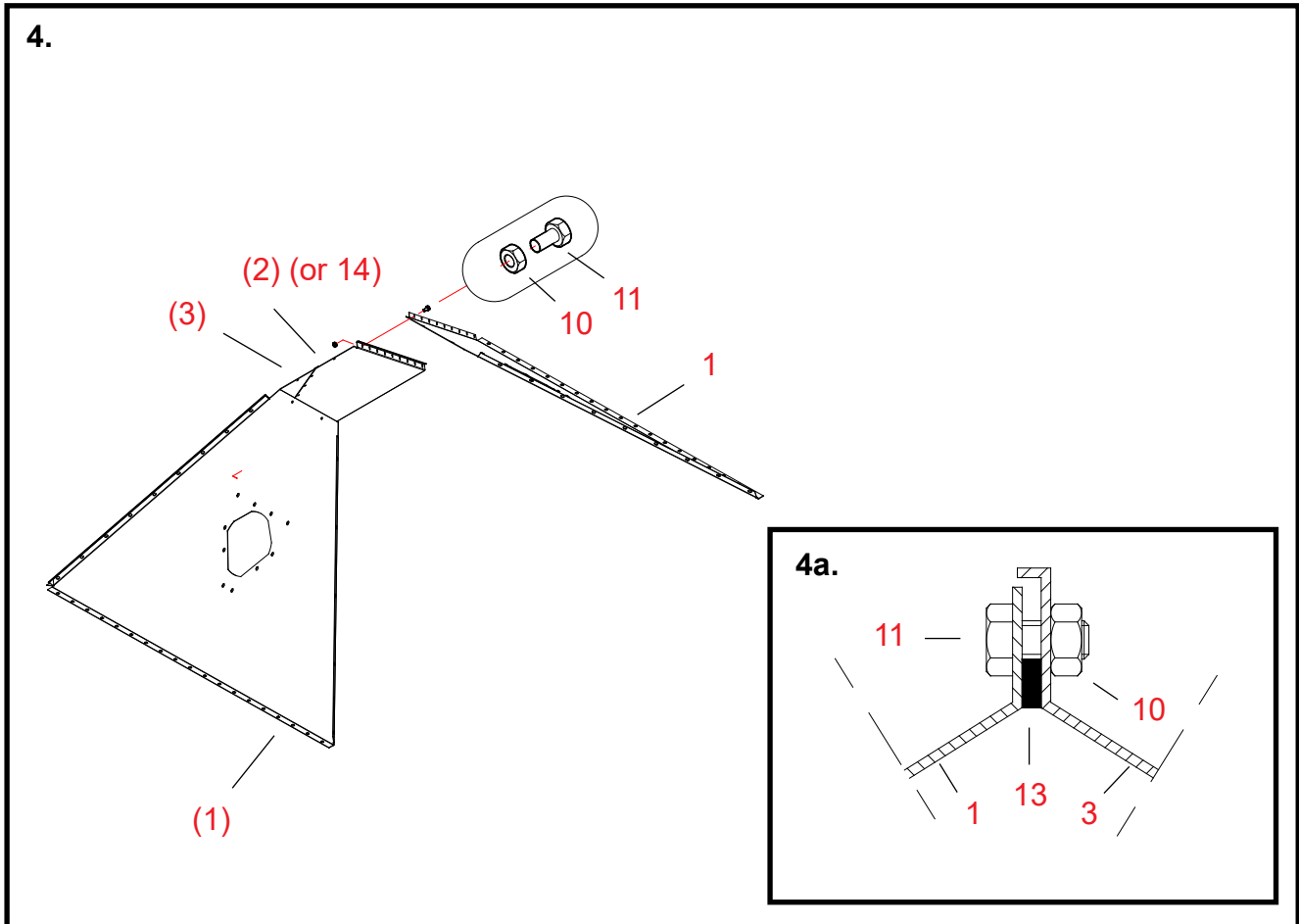
Carefully align the corner joint between the plates.

Check that the flanges of the plates are lying tight against the assembly plane.

10, 11 Fix the seam using bolts and nuts (M8 x 16, 9 pcs.).

See dwg. 3a.

Do not tighten the bolts yet.



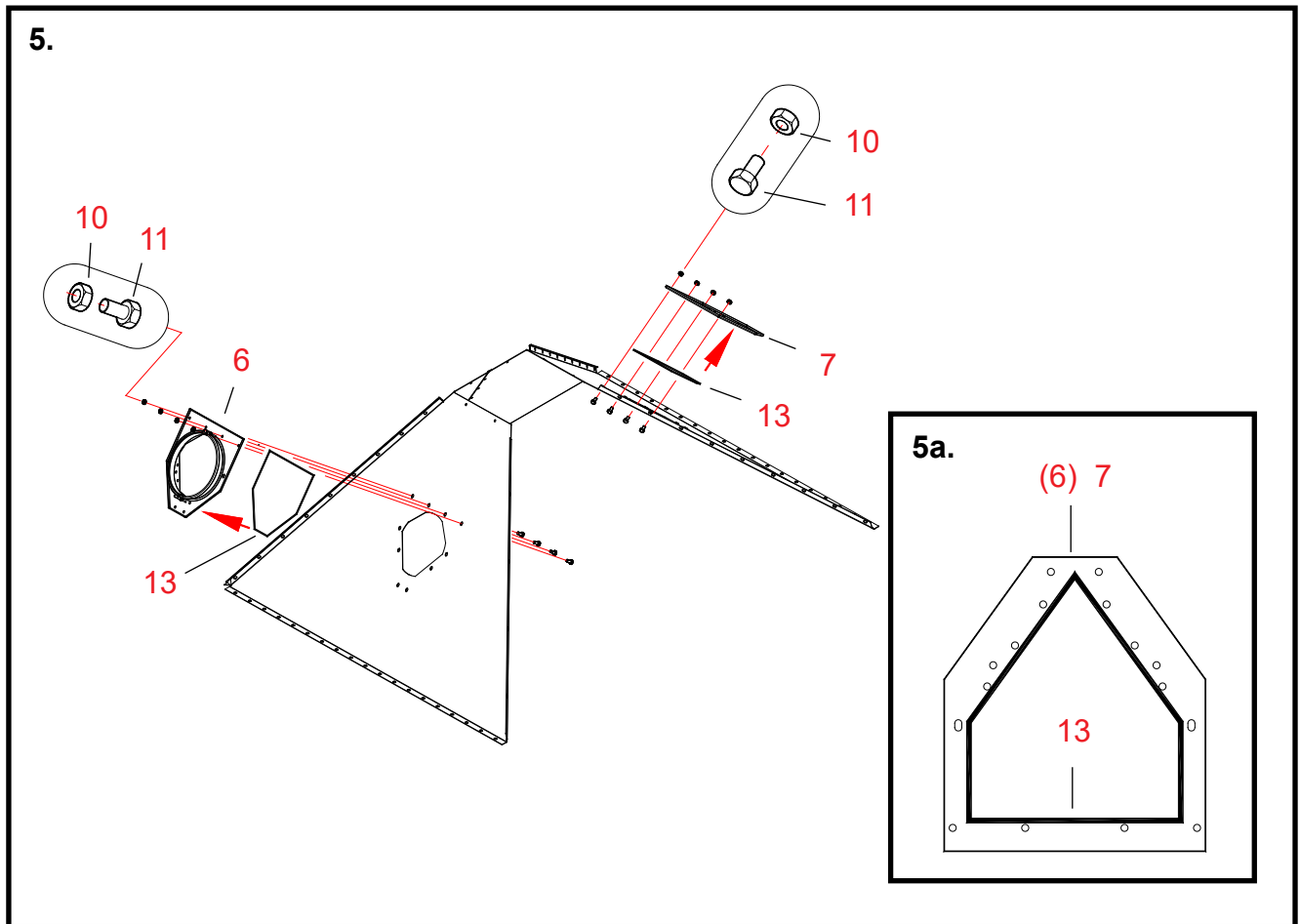
4. Fixing the fourth side-plate for the base cone

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

1 **Lift the other side-plate with opening for the base cone onto the assembly plane.**

1, 3 **Carefully align the corner joint between the plates.**
Check that the flanges of the plates are lying tight against the assembly plane.

10, 11 **Fix the seam using bolts and nuts (M8 x 16, 9 pcs.).**
Fig. 4a. Do not tighten the bolts yet.



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

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

13 Fix a sealing strip onto the inner surface of the connecting part with opening (part 6).

13 Fix a sealing strip onto the inner surface of the cover plate (part 7).

Fix the sealing strips inside the bolthole row in the plates (see drawing 5a).

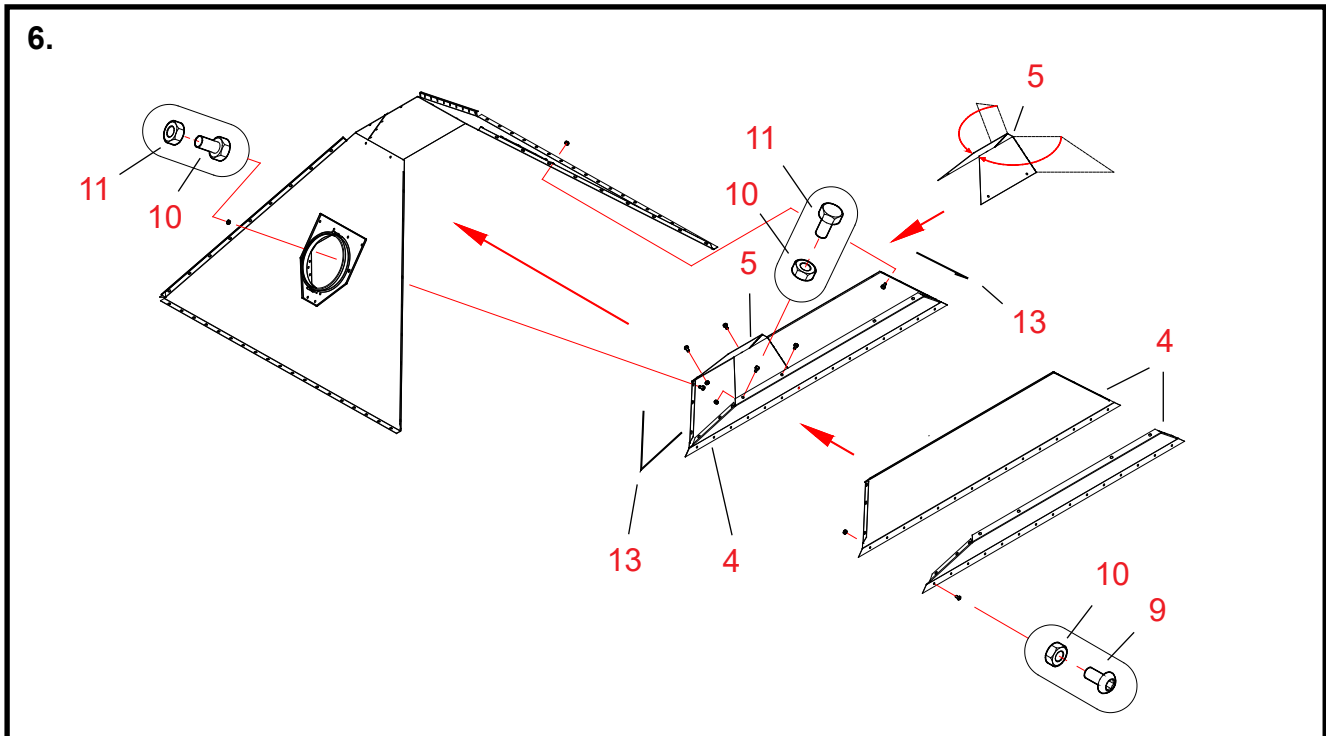
6 Install the connecting part with opening to the base cone on the bottom suction fan side.

Make yourself clear about on which side the bottom suction fan is to be installed.

7 Install the cover plate on the opposite side.

10, 11 Fix the connecting part and the cover plate to the base cone using nuts and bolts (M8 x 16).

Place hexagon nuts and bolts (4 + 4 pcs) at this stage only in holes in straight line at the lower edge of the connecting part and cover plate.



6. Installing the suction air duct in the base cone

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

4 Place the suction air duct halves face to face.

Make sure that the end flanges of the air duct do not "indent".

9, 10 Join the halves together using ball-headed nuts and bolts (M8 x 16, 15 pcs.).

5 Attach the stop plate to the lower edge of the suction air duct (i.e. to the upper edge while the cone lies upside down during assembly).

The stop plate is straight when delivered.

Bend the plate along the row of holes to the shape illustrated in the drawing.

Place the stop plate in the duct at the end where the bottom suction fan is to be installed.

The open end of the plate comes against the cone wall.

Place its edges inside the flanges of the suction air duct.

10, 11 Fix the stop plate using hexagon bolts and nuts (M8 x 16, 4 pcs.).

13 Fix sealing strips to the end flanges of the suction air duct.

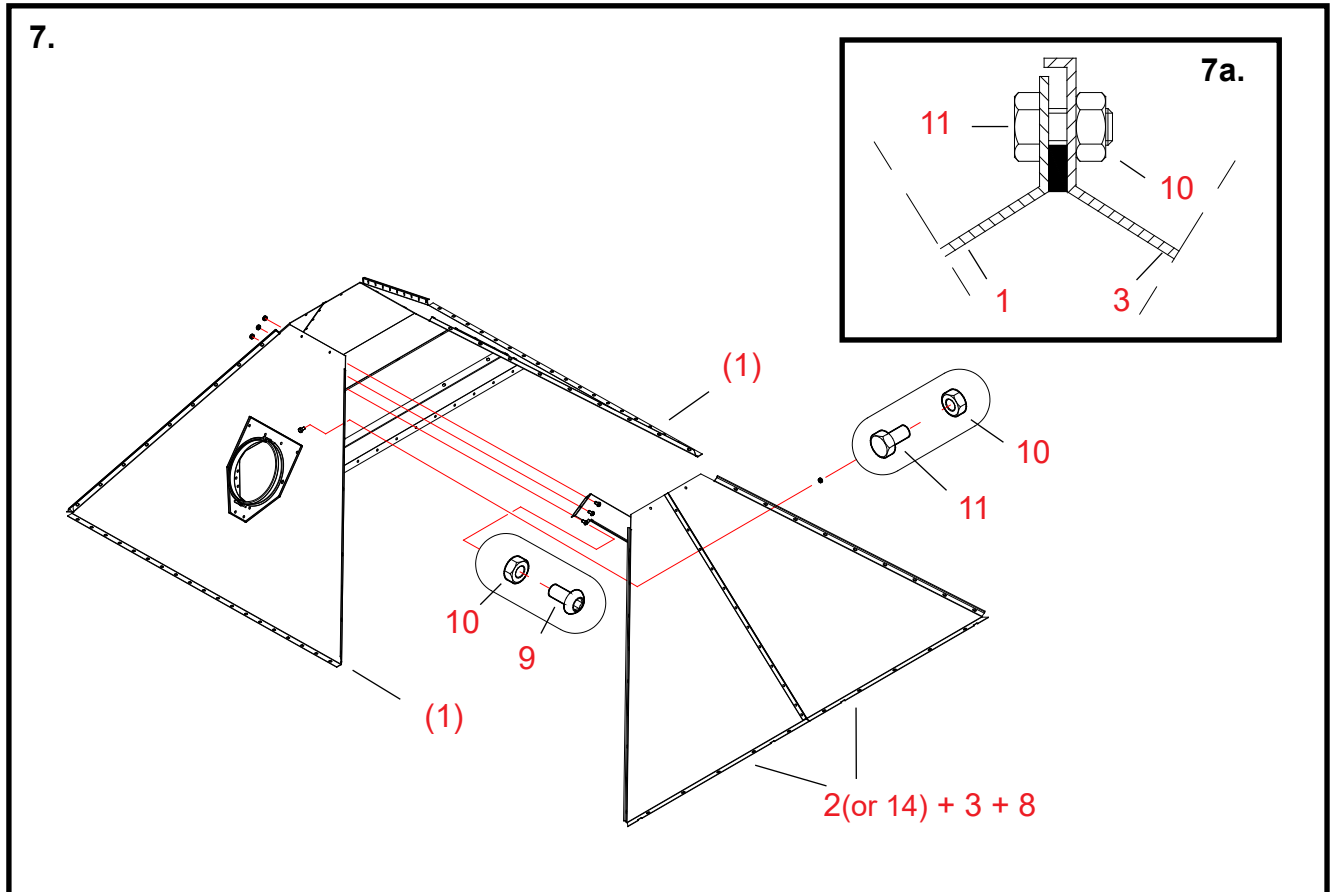
4 Place the suction air channel with the stop plate attached inside the base cone.

10, 11 Fix the air channel by its end-flanges using bolts and nuts (M8 x 16, 6 + 6 pcs.).

These bolts are also used for fixing the connecting part and the cover plate in their final positions.

Ensure that the joint between the stop plate and the base cone wall is tight.

If necessary, seal with butyl compound (the compound and the press are included in the delivery).



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

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

2 + 3 + 8 Close the ready-assembled base cone using the joined-together fifth and sixth side-plates.

1, 2, 3 Carefully align the corner joints between the plates.
Check that the flanges of the plates are lying tight against the assembly plane.
Align the bolt holes in the additional support with the three unused holes in the opposite side-plate.

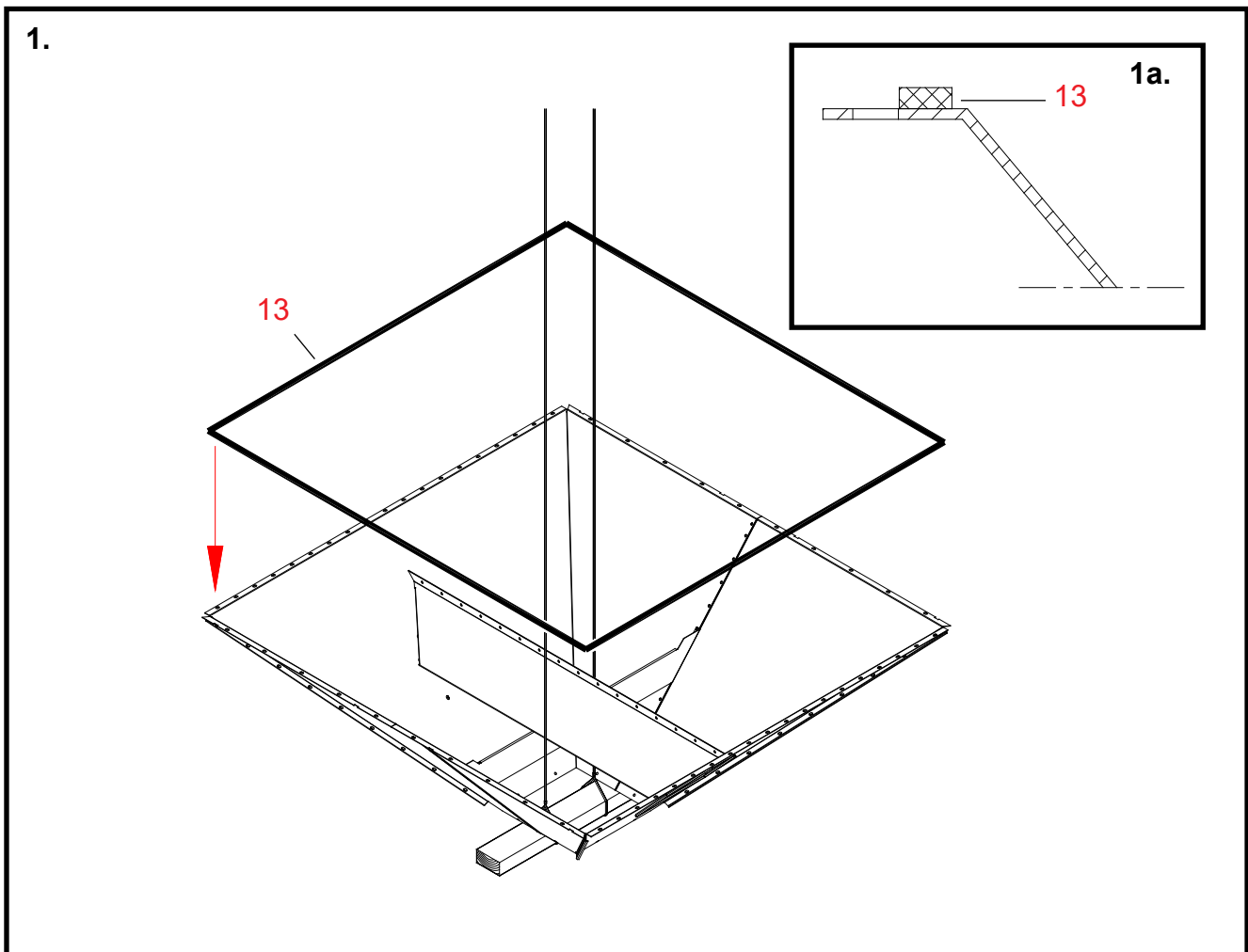
10, 11 Fix the corner joints using bolts and nuts (M8 x 16, 9 + 9 pcs.).

9, 10 Fix the intermediate support using ball-headed bolts and nuts (M8 x 16, 3 pcs.).

Finally, ensure that the whole cone is lying tight against the assembly plane.

* Tighten all bolts in the corner joints.

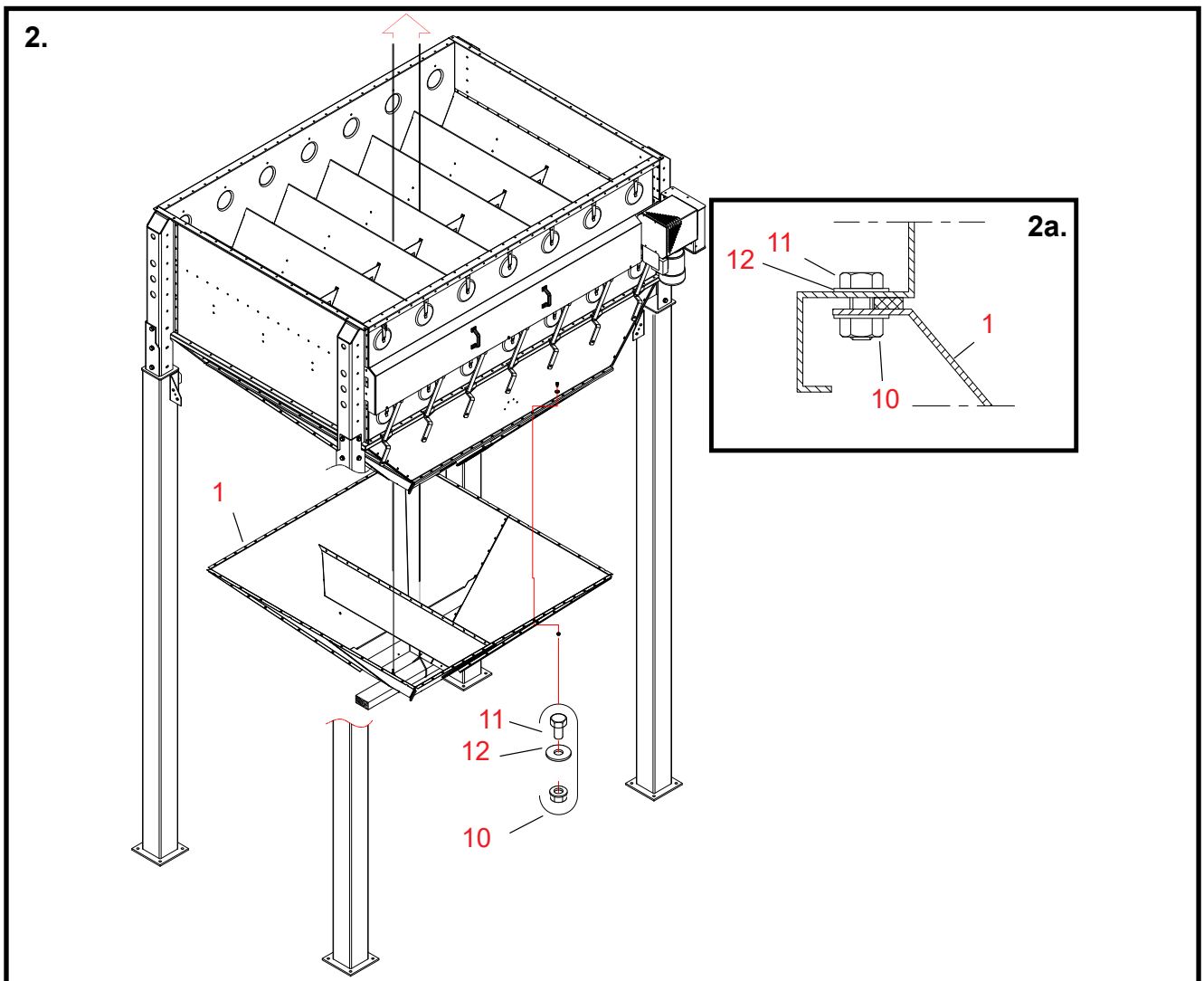
Structure of the base cone 3W

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

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

- * **Turn the base cone to a position where the attachment flange comes on the upside.**
- * **Place a batten, e.g. 50 x 100 mm of about 1 metre in length, under the cone.**
- * **Attach the wire ropes for lifting the cone to the batten on both sides of the suction air duct.**

13 **Fix sealing strips to the flanges on the upper surface of the cone.**
Fix the sealing strip inside the bolthole row in the flange (see drawing 1a).



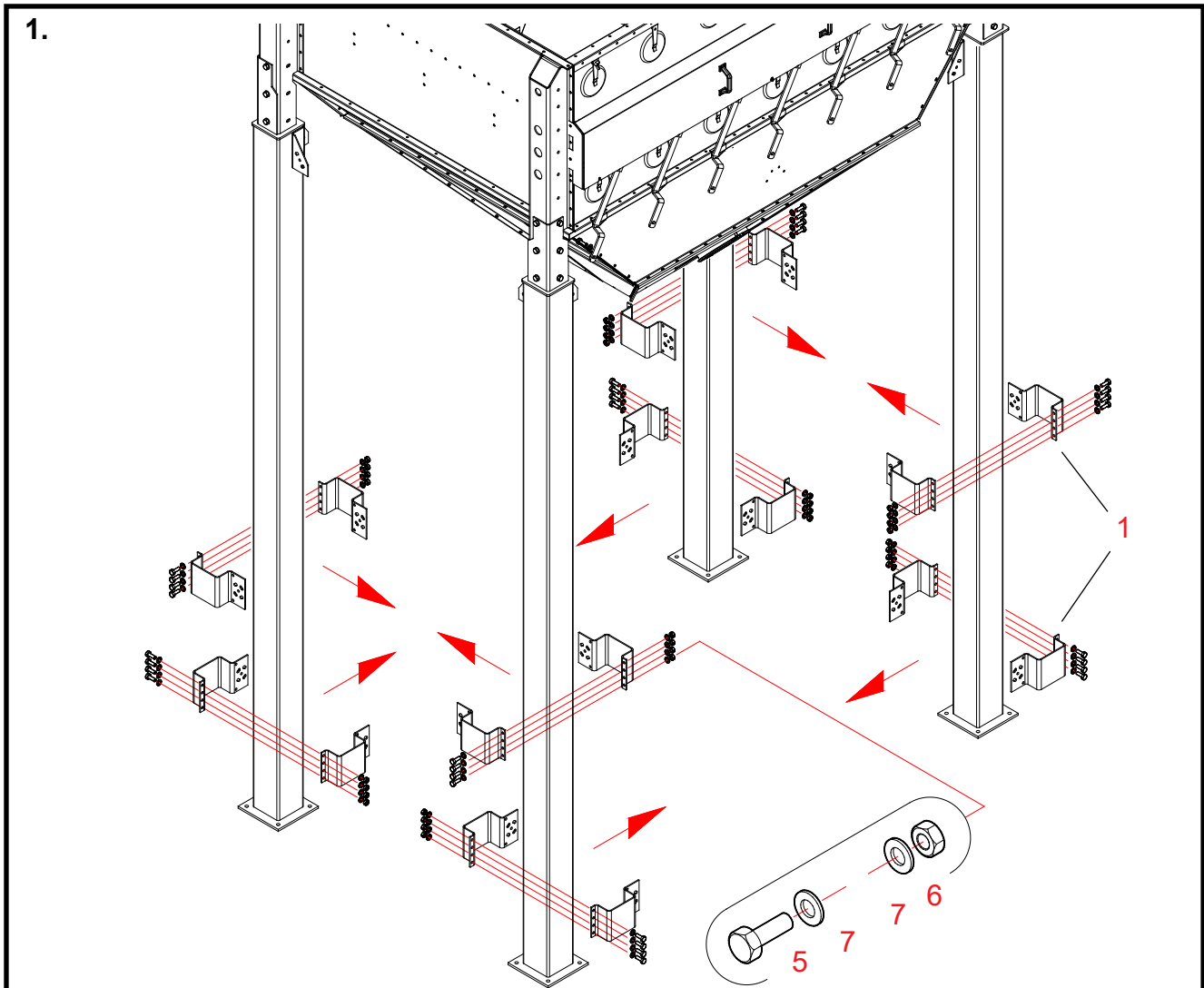
2. Lifting and fixing the base cone

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

Be careful not to damage the sealing strips when lifting the cone.

- * **Move the base cone under the base.**
- * **Lift the cone using the wire rope threaded in between the air ducts in the base.**
- 1 Lift the base cone against the lower surface of the cone extension.**
- 10, 11 Attach it using bolts and flange nuts (M8 x 16, 58 pcs.).**
See dwg. 2a. Note: two washers per bolt.

Installing the cross-braces for extension legs on 3W

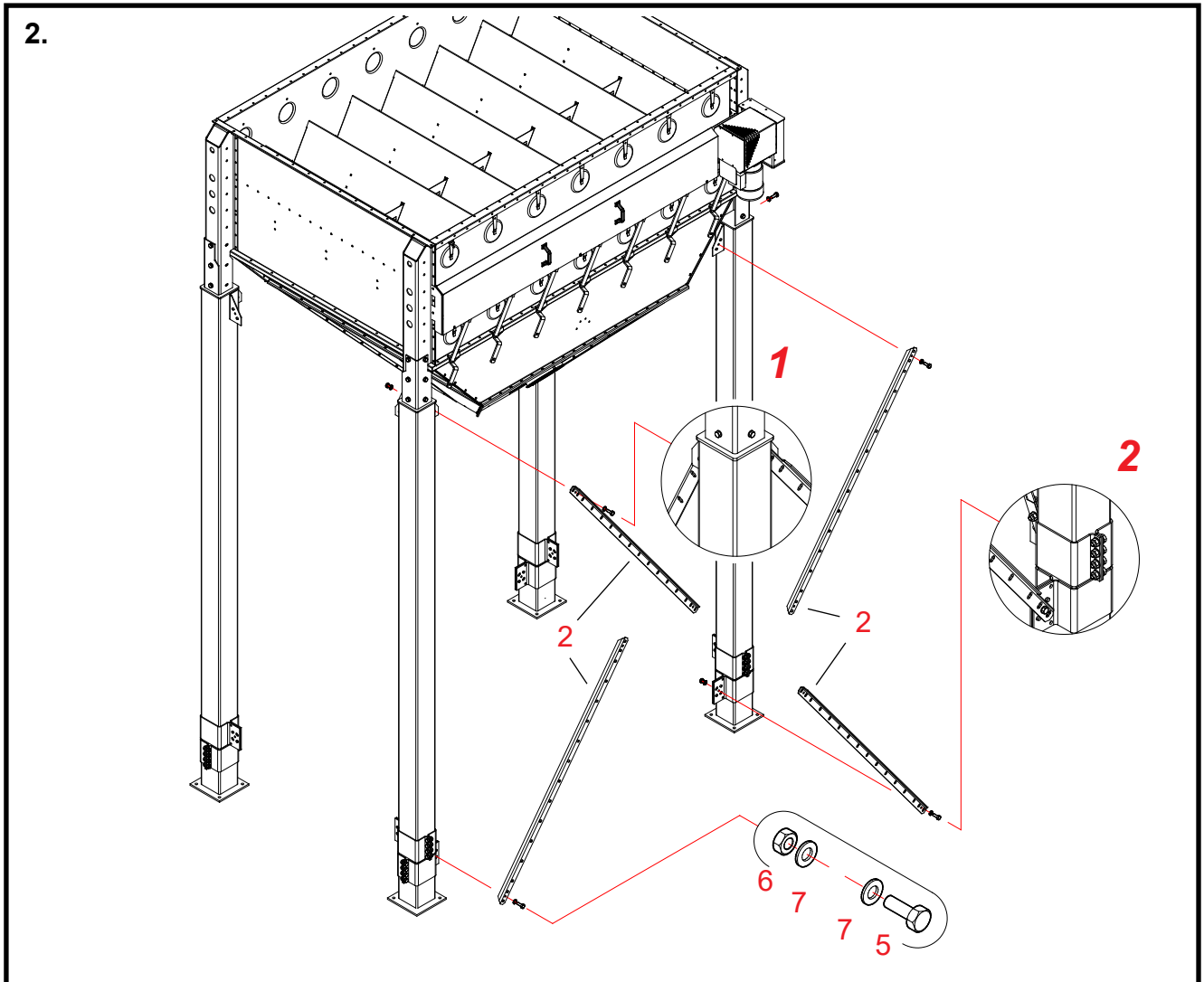


1. Installing the adjustable cross-brace brackets on the extension legs on 3W

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for cross-braces for the extension legs on 3W.

1 Put the halves of the adjustable brackets on the extension legs.
 Install two pieces of brackets, consisting of two halves each, on each leg.
 Check the correct direction for the bracket flange with 7 holes in the drawing.

5, 6, 7 Attach the brackets to the extension legs (bolts M12 x 35).
 Look up the correct position for the bolts in the drawing.
 At this stage, attach the brackets only by their flanges with 4 holes.
 Leave the bolt attachments loose in order to be able to move the brackets without damaging the surface treatment of the legs.



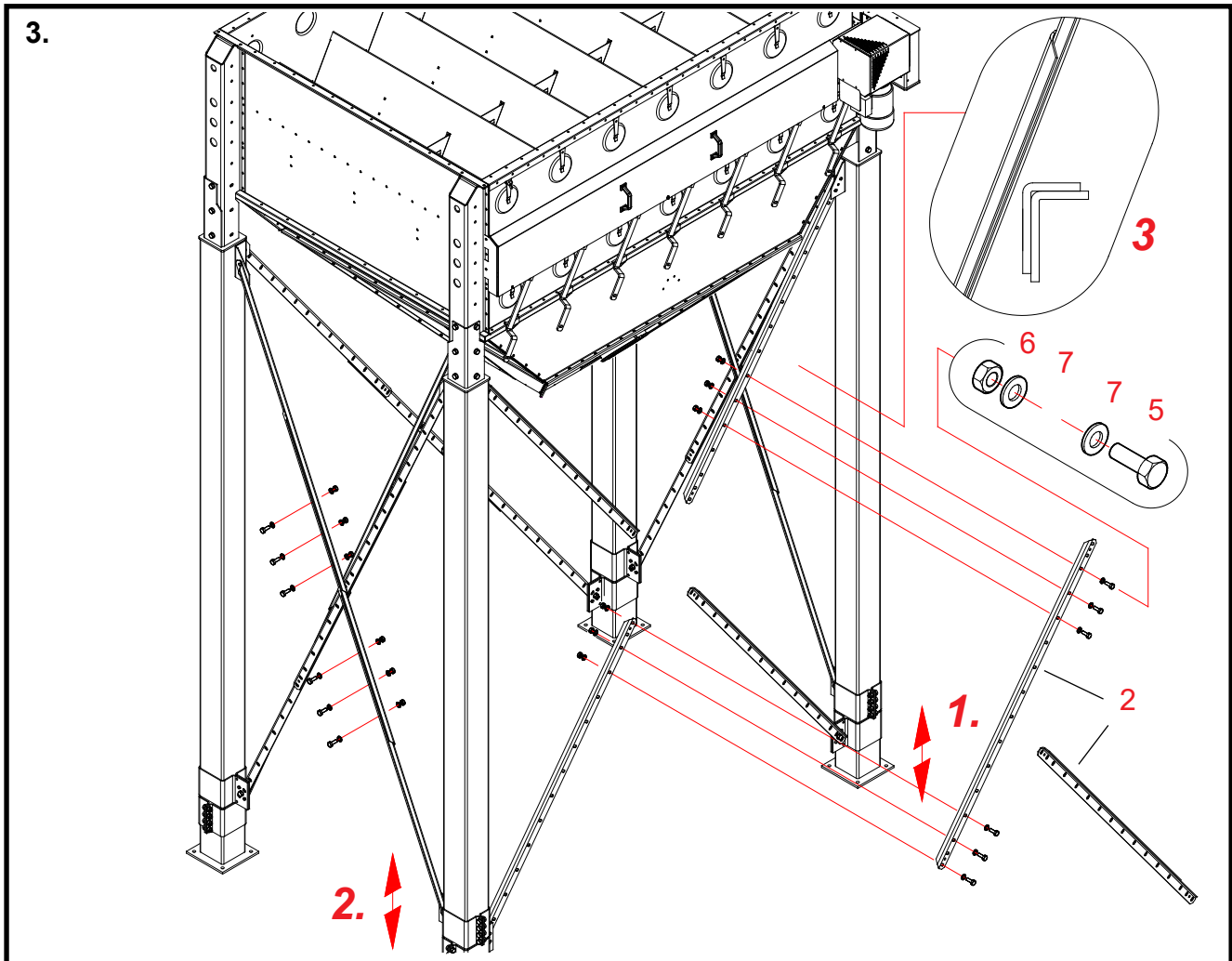
2. Fixing the cross-brace ends to extension legs on 3W

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for cross-braces for the extension legs on 3W.

2 Put in place the cross-brace parts in the upper and lower brackets on one side of the base.
Select the direction and position for the cross-braces at the side of the bracket, as illustrated in drawings **1** and **2**.

5, 6, 7 Fix the ends of the cross-braces to the brackets in the extension legs (bolts M12 x 35).
Look up the correct position for the bolts in the drawing.
Fix the cross-braces at both their ends at this stage only with one bolt.
Put the bolt, the washers and the nut in place in the round hole in the brace and the bracket.
Do not wrench the bolts to their final tightness yet.

***** Install the upper and lower parts of the cross-braces in the same way on the other three sides of the base.



3. Installing the bolts to the centre-parts and joints of the cross-braces on 3W

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for cross-braces for the extension legs on 3W.

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

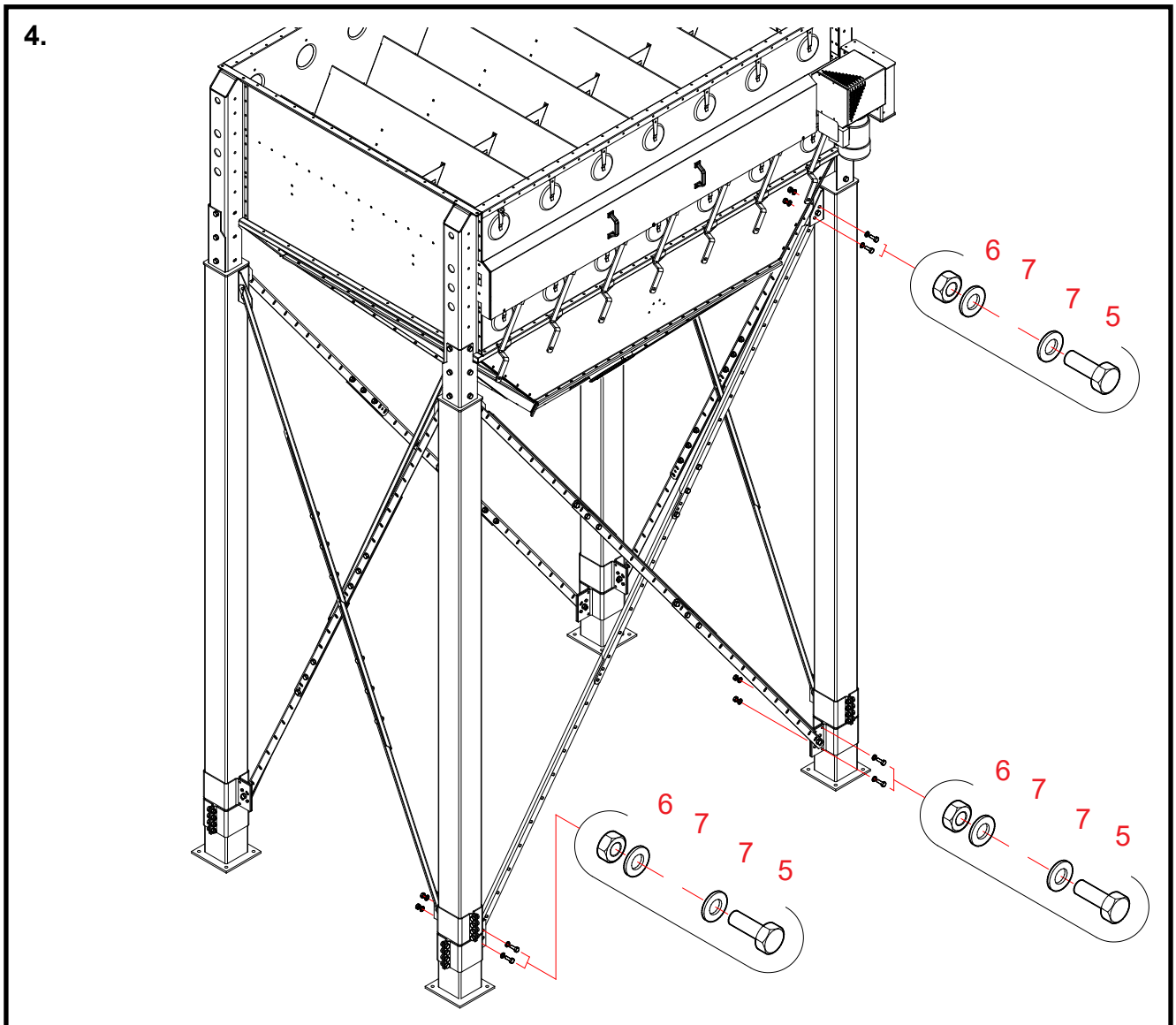
2 Complete the cross-brace on the long side of the base using the third part of the brace.
Place the parts one inside the other, as shown in detail drawing 3.

* **Move the lower cross-brace bracket along the extension leg.**
Select the position so that it is possible to install three bolts in every cross-brace joint.
Extend the cross-brace as much as possible (move the lower bracket to as low as it goes).

5, 6, 7 Put in place and tighten the bolts at the cross-brace joints (3 pcs. M12 x 35).

* **Join together the braces fixed to the lower brackets on the other long side of the base.**

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



4. Fixing the upper and lower ends of the cross-braces for the extension legs in their final positions on 3W

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for cross-braces for the extension legs on 3W.

5, 6, 7 Put in the place the missing bolts (M12 x 35) in all adjustable brackets.

Provide each adjustable bracket with two bolts, washers and nuts.

5, 6, 7 Put in place the missing bolts (M12 x 35) in the upper and lower ends of each cross-brace.

Provide each cross-brace part with two bolts, washers and nuts.

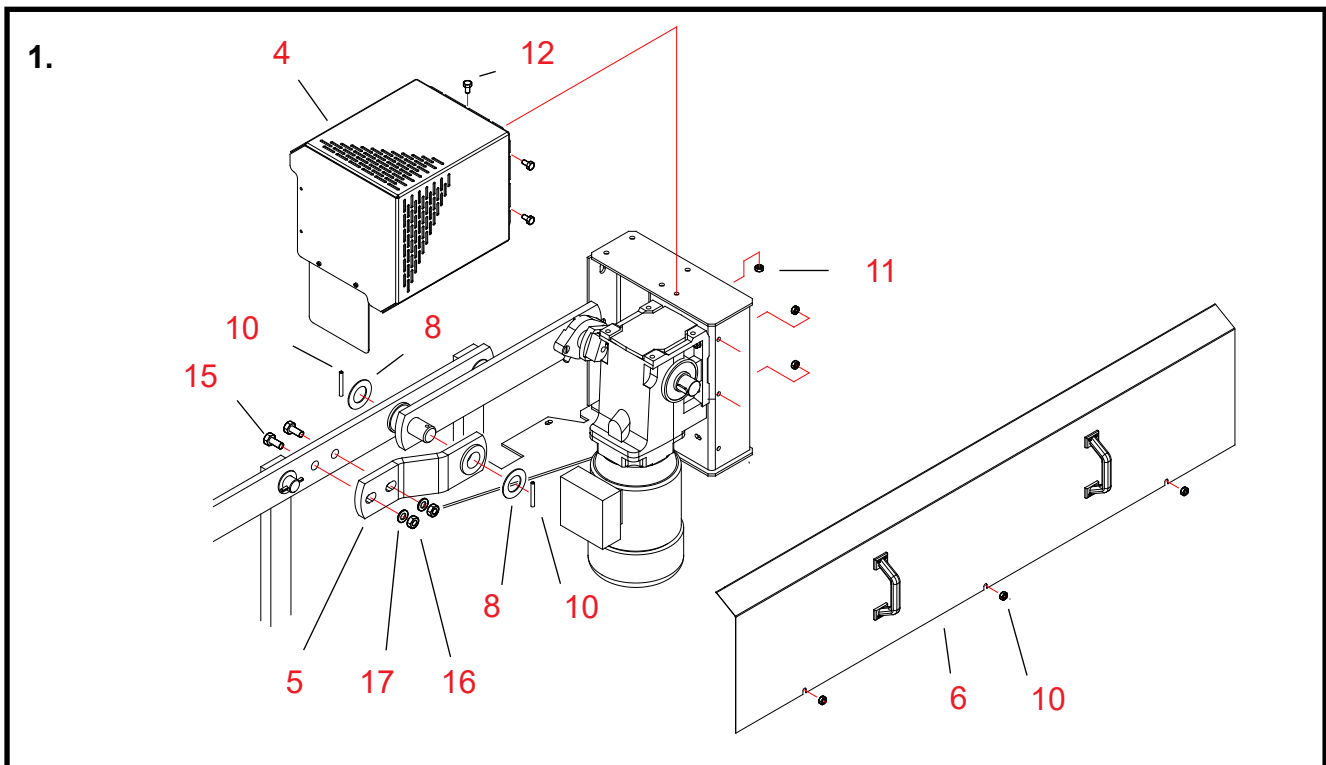
Every cross-brace must be attached to the bracket on the extension leg by three bolts, washers and nuts at its lower and upper ends.

* **Tighten all bolt attachments at the upper and lower ends of the cross-braces.**

Transferring the feeding equipment motor to another position

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

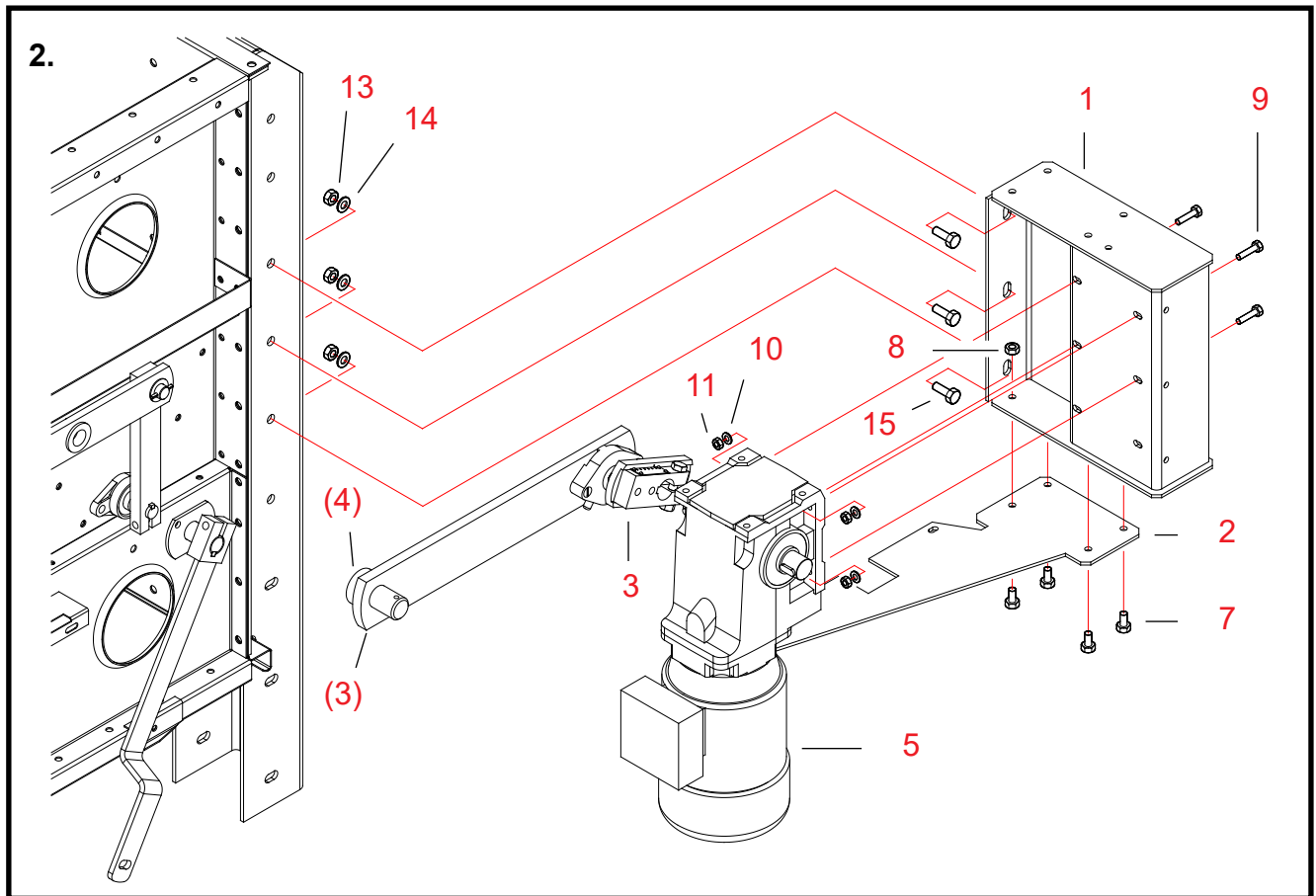
At the factory, the motors are always placed on the right-hand side of the dryer base.



1. Dismantling the eccentric piece cover and the transmission rod

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

- 10 Remove the three attachment nuts for the protective cover of the feeding equipment.
- 6 Remove the protective cover for the feeding equipment.
- 11, 12 Remove the three attachment nuts and bolts for the eccentric piece cover.
- 4 Dismantle the eccentric piece cover with its additional cover from the motor rack.
- 8, 10 Remove the spring cotters and washers from both ends of the transmission of the feeding equipment.
- 15, 16, 17 Remove the two bolts and washers from the connecting rod support.
- 5 Dismantle the connecting rod support from the connecting rod and the transmission rod.



2. Dismantling the motor and the motor rack

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

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

5 Dismantle the motor, the eccentric piece and the transmission rod from the rack.

As required, use a pry-bar for removal of the transmission rod shaft (part 3).

Leave the spacer (part 4) on the transmission rod shaft.

Lift the dismantled unit onto a suitable work plane.

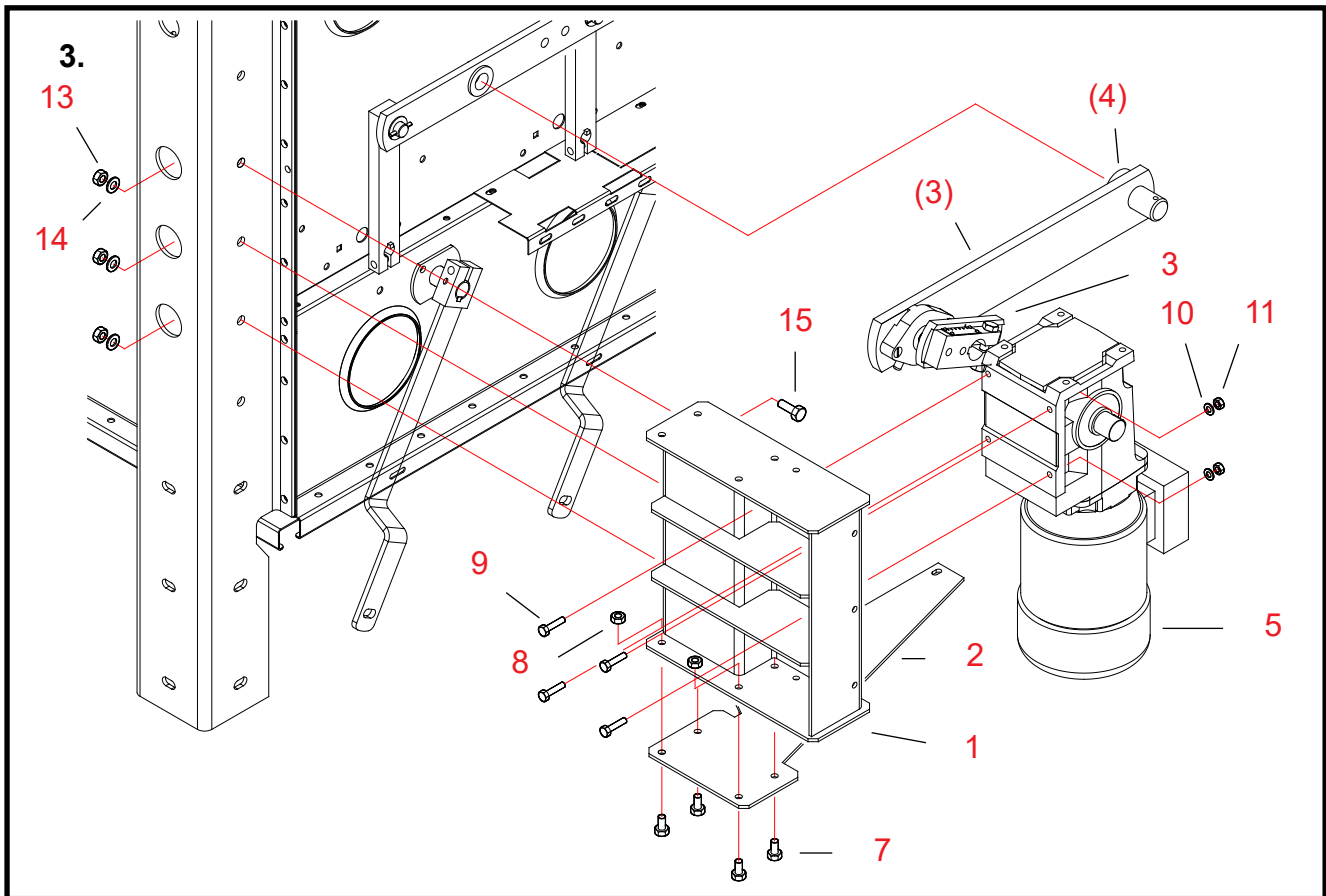
13, 14, 15 Remove the three attachment bolts, nuts and washers for the motor rack.

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

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

2 Disconnect the torque arm from the motor rack.

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



3. Re-installing the motor and the motor rack

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

2 Put the torque arm in place in the motor rack.

7, 8 Attach the torque arm using nuts and bolts (M10 x 20, 4 pcs.).

1 Attach the motor rack and the torque arm to the dryer base leg.

13, 14, 15 Attach the motor rack using bolts, washers and nuts (M12 x 35, 3 pcs.).

Check that the relevant end of the motor shaft is equipped with a key.

3 Place the eccentric piece onto the motor shaft.

Push the eccentric piece on the shaft to as far it as goes.

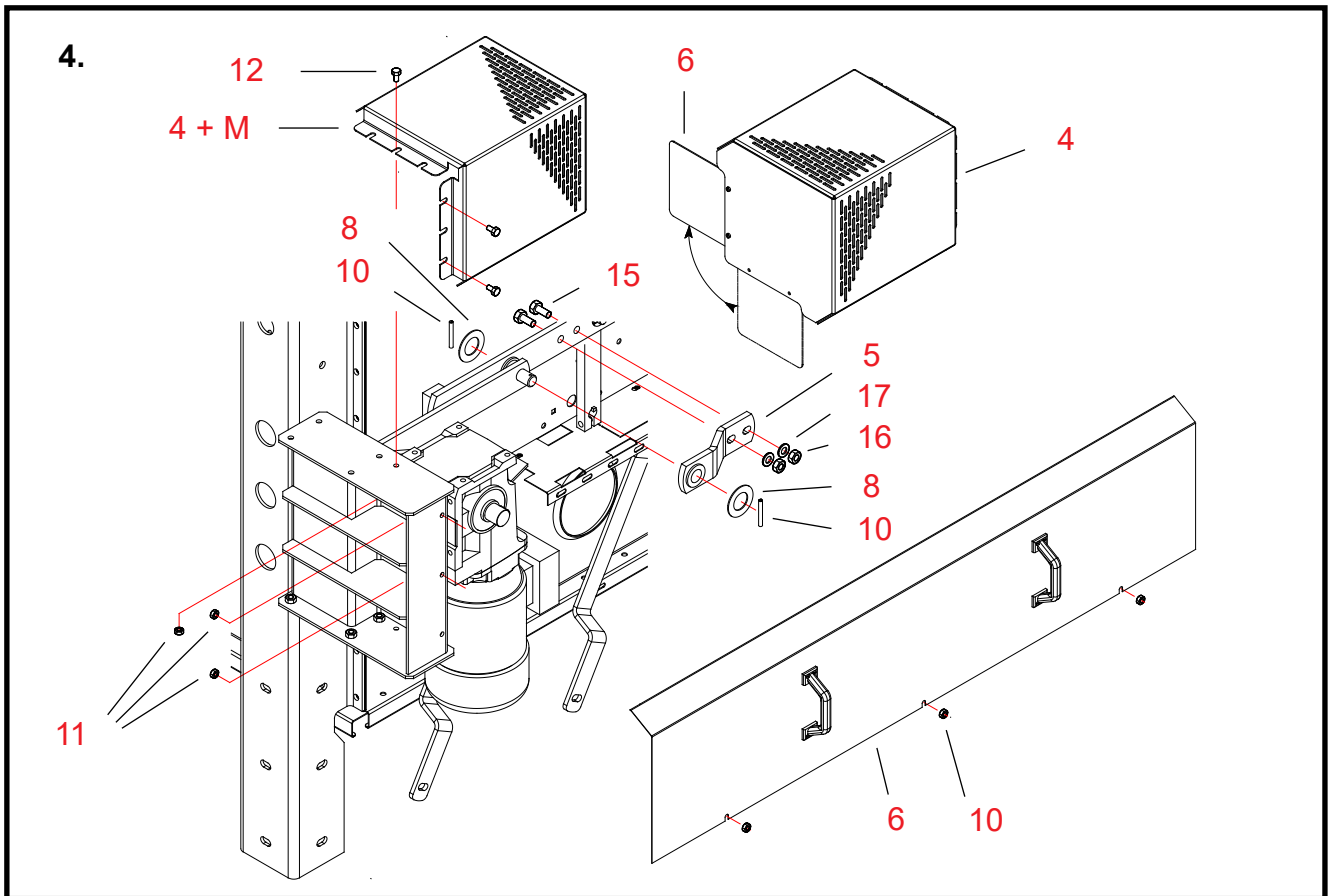
Tighten the bolt for the eccentric piece.

5 Put the motor with the eccentric piece and transmission rod back on the rack.

Check that the spacer (part 4) is still in place on the transmission rod shaft.

Align the transmission rod shaft (part 3) with the bearing sleeve for the connecting rod.

9, 10, 11 Attach the motor to the rack using bolts, washers and nuts (M8 x 35, 4 pcs.).

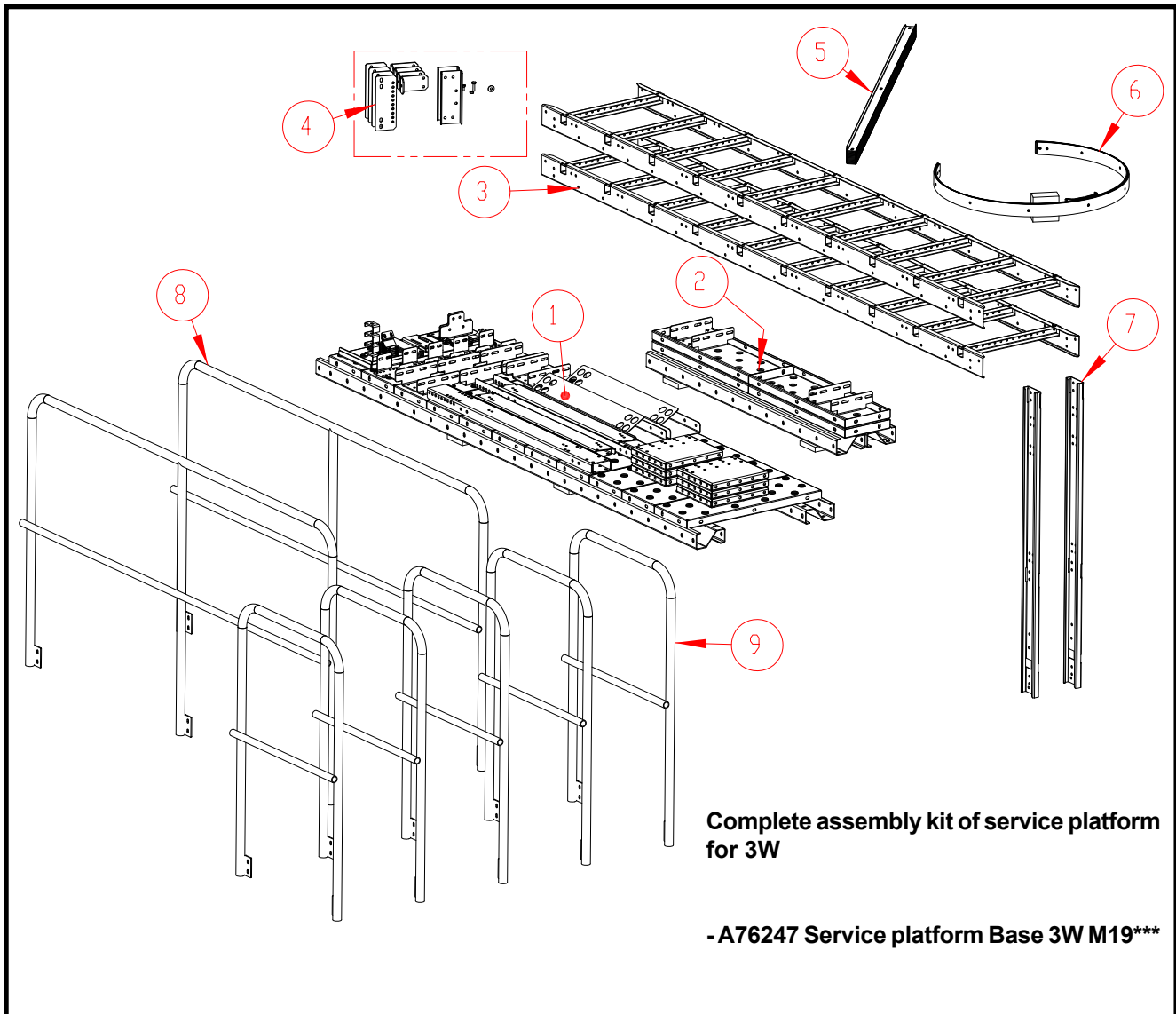


4. Installing the eccentric piece cover and the transmission rod

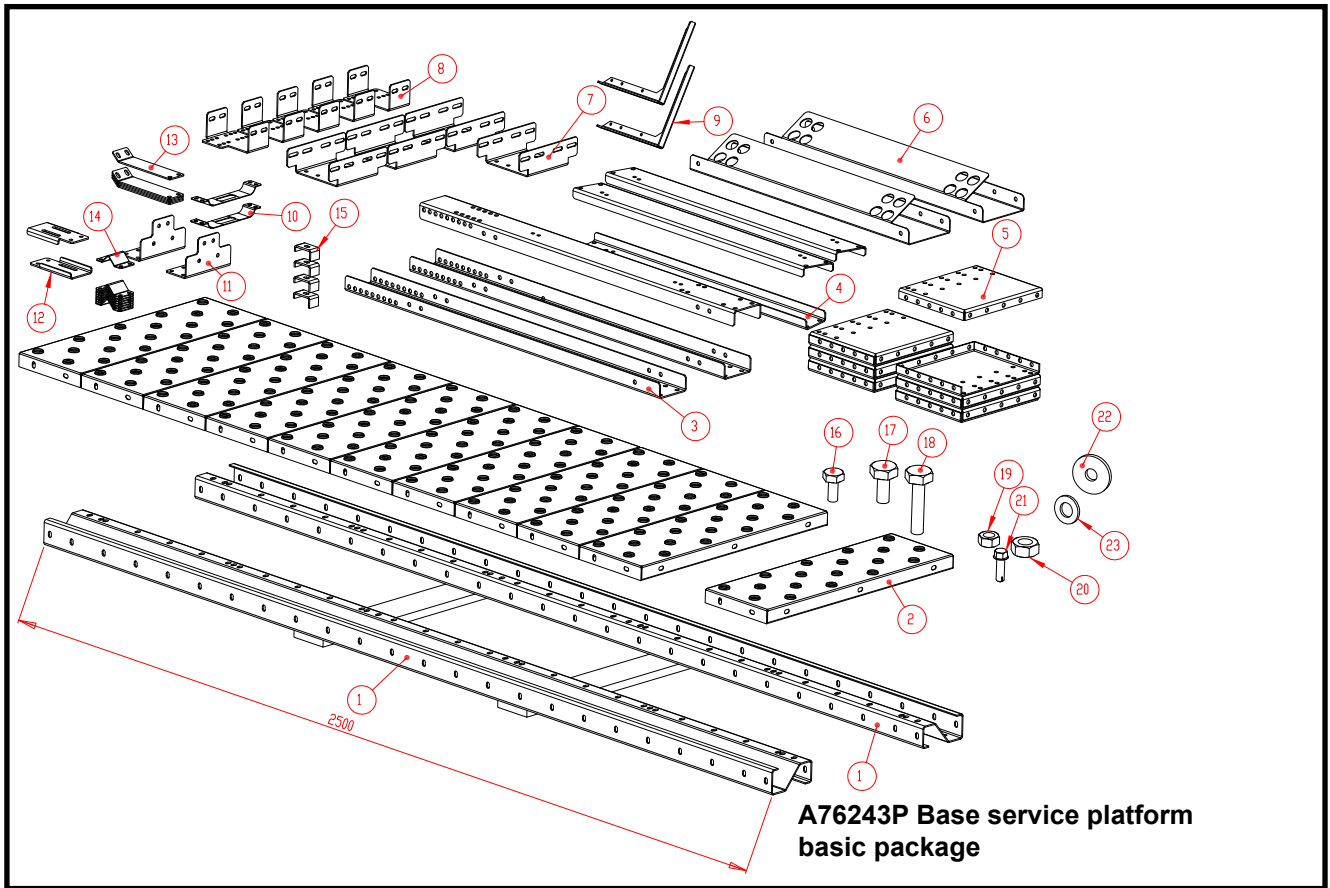
Parts The numbering of work stages refers to reference numbers in the spare parts drawings of the motor rack, feeding equipment and base assembly.

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

Structure of the service platform for the base 3W (optional)



Ref.	Part no.	Denomination	Pcs.
1	A76243P	SERVICE PLATFORM BASE BASIC PACKAGE M19	1
2	A76245P	SERVICE PLATFORM BASE SUPPLEMENT PACKAGE M19	1
3	A76224	PAK LADDER L=2900 M19	2
4	A76251	PAK LADDER ACCESSORY BOX M19	1
5	A76250	PAK LADDER BACK-RAIL PACKAGE M19	1
6	A76249	PAK LADDER GUARD-ARC PACKAGE M19	1
7	A76253	PAK LADDER UPPER EXIT RAIL M19	2
8	A76205	RAILING ELEMENTS L 2012 M19	2
9	A76208	RAILING ELEMENTS L 671 M19	5

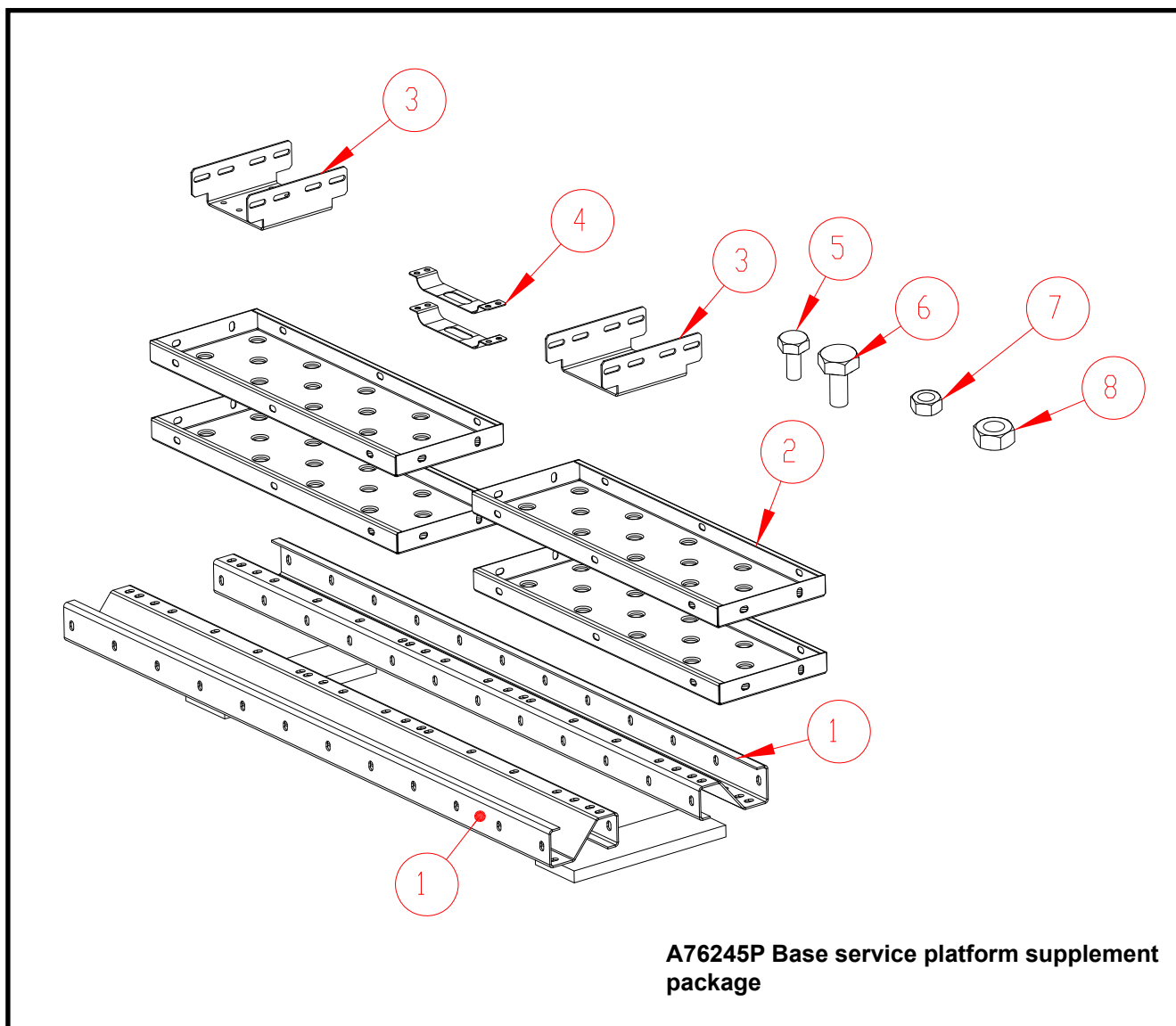


Ref.	Part no.	Denomination	Pcs.	Weight
1	A71919	Z-BEAM L=2500 WM06	2	17,58
2	A71545	PLATFORM ELEMENT FOR ELEVATOR 215 X 635 X 35	11	2,35
3	A71962	SERVICE PLATFORM BASE CROSSBAR L=1070 WM06	3	3,97
4	A76244	SERVICE PLATFORM BASE SUPPORT M19	3	2,31
5	A71963	SERVICE PLATFORM BASE BAND 225X268 WM06	12	1,69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



Base

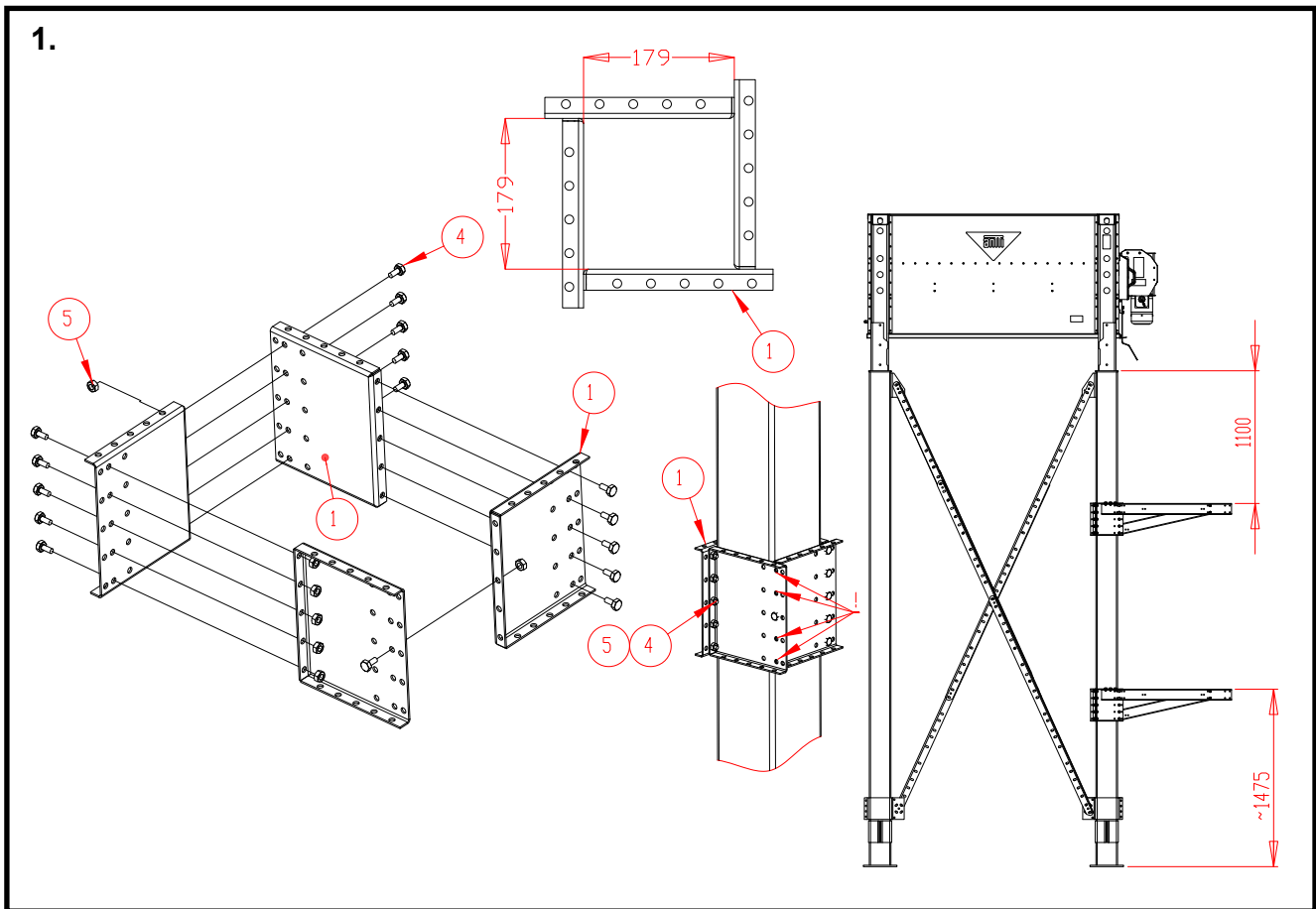
Antti WM06



Ref.	Part no.	Denomination	Pcs.	Weight
1	A71916	Z-BEAM L=1250 WM06	2	8,6
2	A71545	PLATFORM ELEMENT FOR ELEVATOR 215 X 635 X 35	4	2,35
3	A76220	SERVICE PLATFORM FASTENER PLATE M19	2	0,94
4	A76216	RAILING FASTENING PART M19	2	0,09
5	101810	BOLT HEX ZN 8.8 8X16 DIN933	13	0,01
6	102200	BOLT HEX ZN 8.8 10X20 DIN933	31	0,02
7	110540	NUT M8 ZN 8 DIN934	13	0,01
8	110560	NUT M10 ZN 8 DIN934	31	0,01

Installing the service platform for the base 3W (optional)

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



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

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

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

Position the upper edge of the lower band at a distance of about 1475 mm from the lower end of the extension leg of the base.

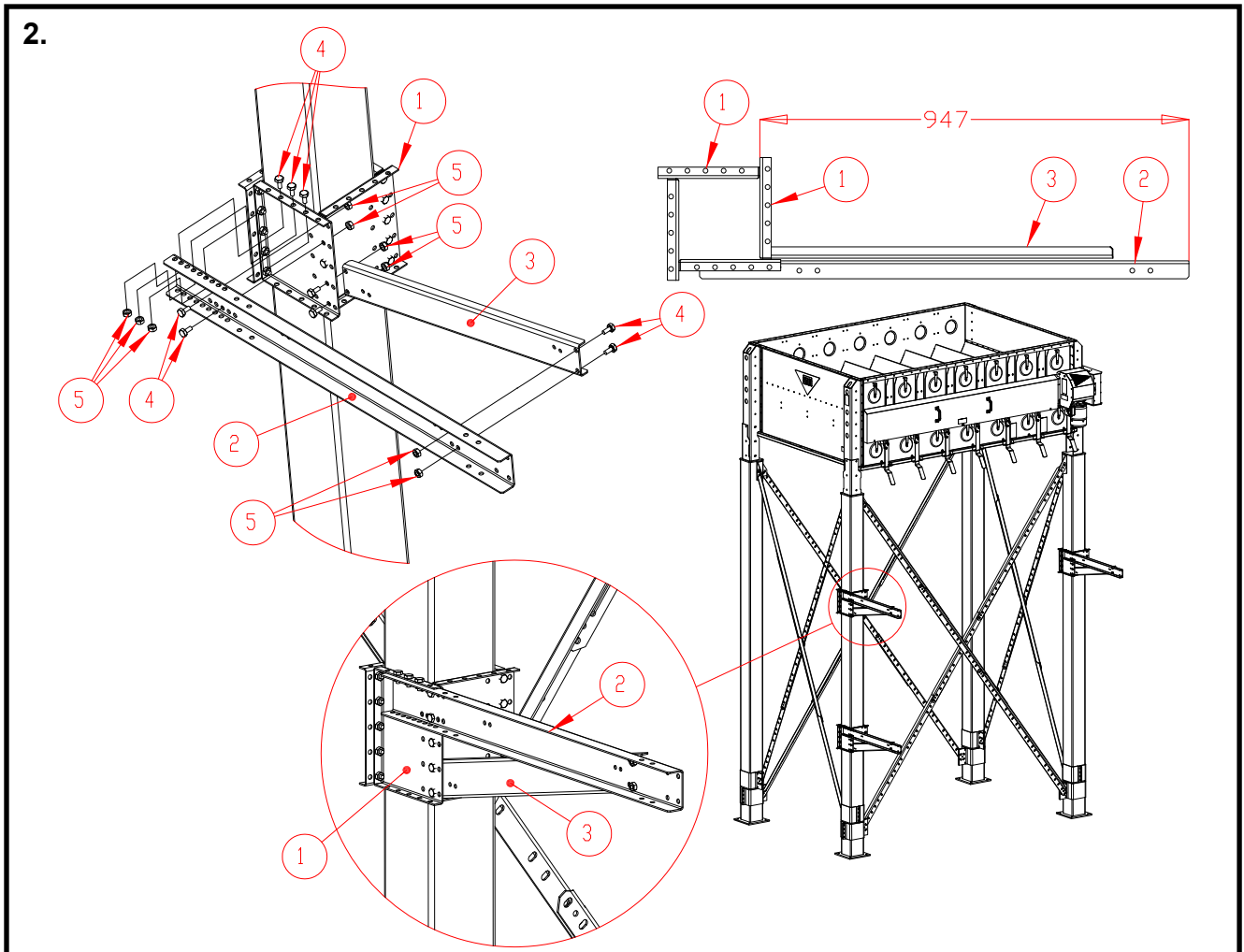
Fix the parts of the bands using nuts and bolts (M 10 x 20, 16 pcs./set-up).

Assemble the bands for the 3W dryer using the inner bolthole rows (opening in the band 139x139 mm).

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

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

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



Installing the crossbar on the service platform bearers and its support, 3W

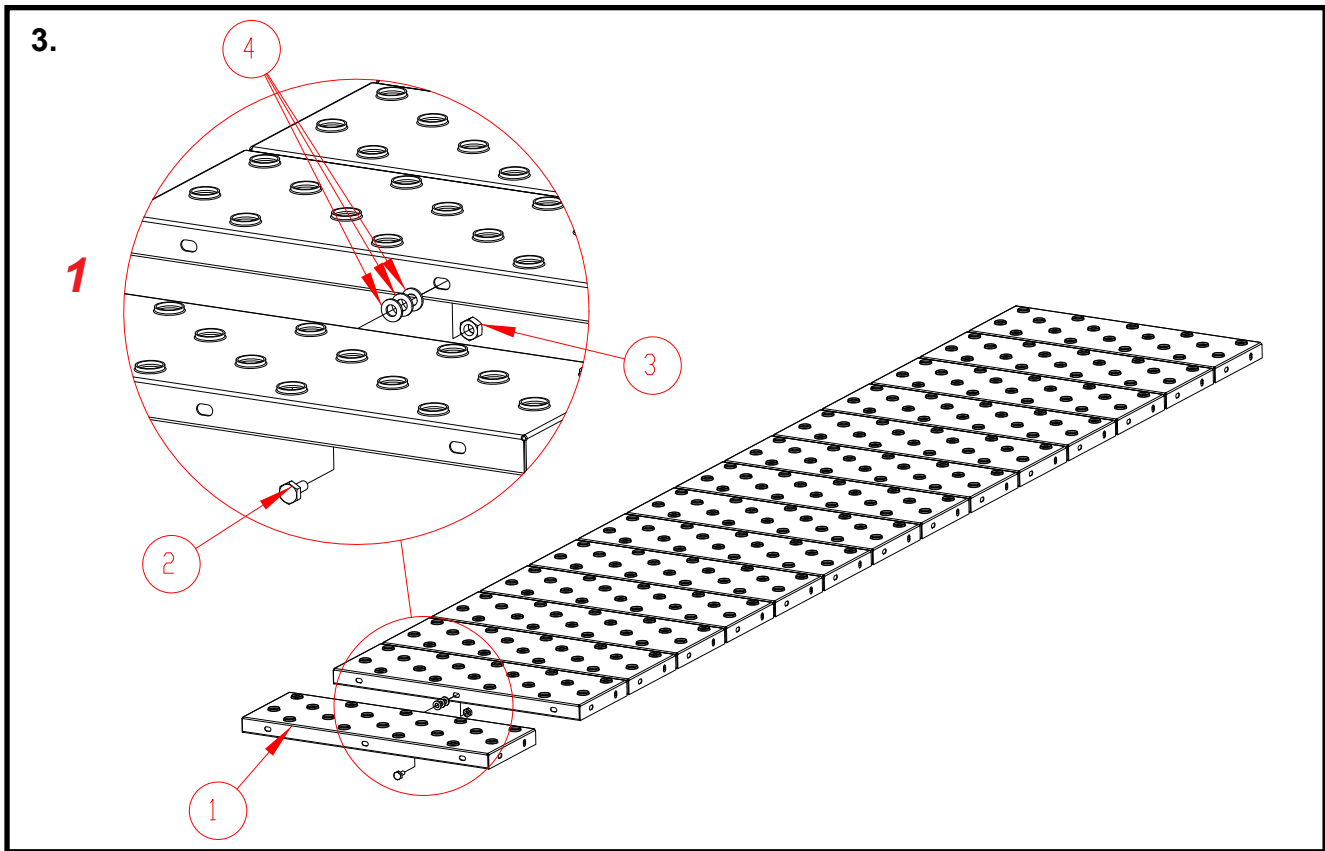
Place the crossbars of the platform bearers (parts 2) in the bands for the bearers.

Position the crossbars so that the distance from the end of the crossbar to the tube of the extension leg will be 947 mm.

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

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

Fix the supports to the bands and crossbars using nuts and bolts (M 10 x 20, 4 pcs./support).



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

Joining the platform elements, 3W

Start by joining all the 15 platform elements (A71545) together.

The service platform package for the base A76243P includes 11 pcs. of platform elements and the package A76245P includes 4 pcs.

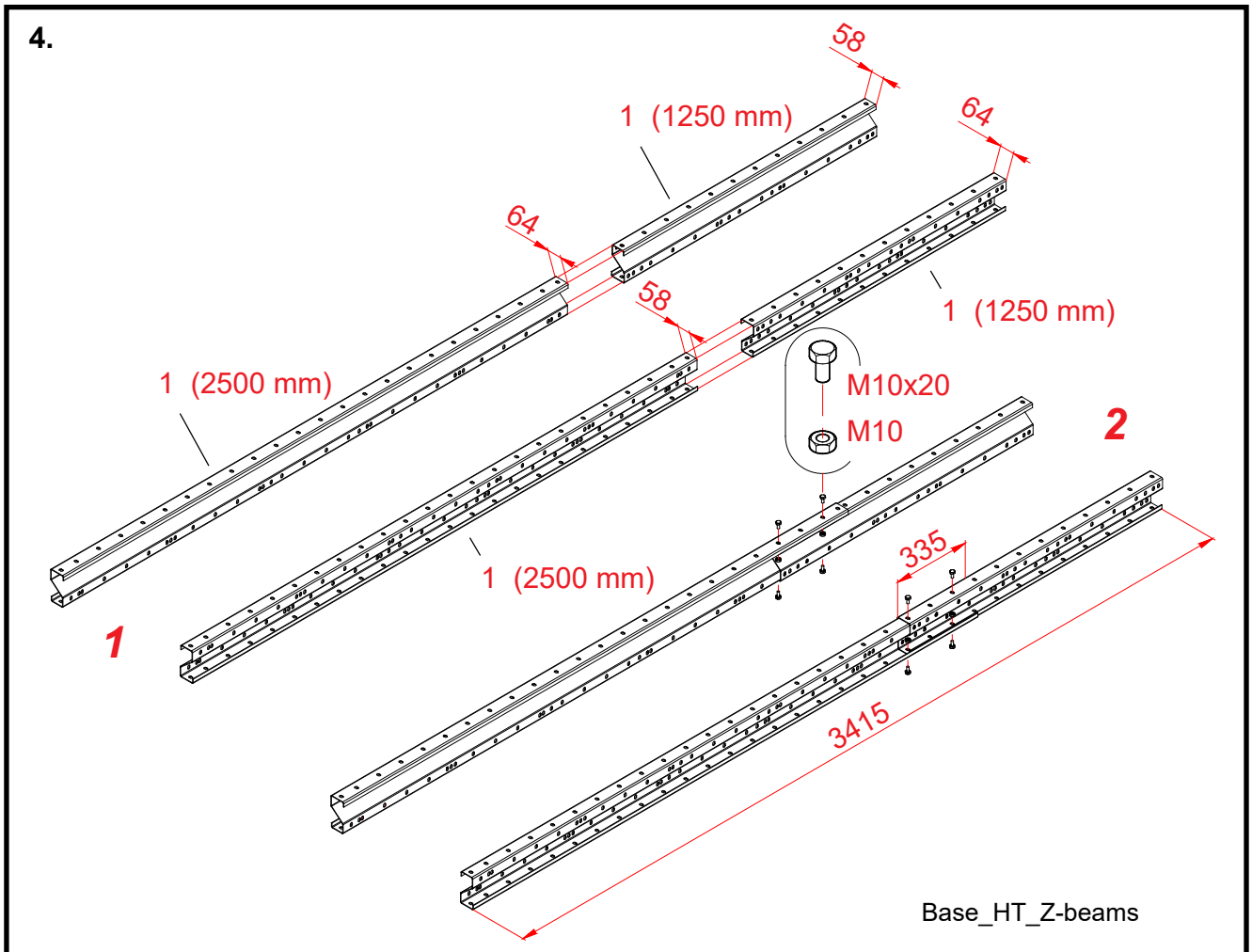
Join the platform elements together using nuts and bolts (M10x20, 1 pcs./element joint).

Put an M10x20 bolt and an M10 nut in the midmost boltholes in the longer edges of the elements.

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

See detail drawing 1.

It is advisable not to wrench the attachment bolts of the platform elements to their final tightness until the elements have been attached to the Z-beams. (see the stage "Installing the Z-beams and the end-beams of the service platform of 3W") on page 59.



Assembling the Z-beams, 3W

Assemble two Z-beam set-ups of 2500 mm and 1250 mm long Z-beams (A71916 and A71919).

The service platform package for the base A76243P includes 2 pcs. of 2500 mm long Z-beams.

The service platform package for the base A76245P includes 2 pcs. of 1250 mm long Z-beams..

Overlap and join together the 2500 mm long Z-beam and the 1250 mm long Z-beam.

The joining position of the beams is illustrated in the drawing 1 (put the 58-mm flange inside the 64-mm flange).

Join the Z-beam so that its length will be 3415 mm (overlapping 335 mm). See drawing 2.

Join the Z-beams together using nuts and bolts (M10x20, 4 bolts/Z-beam joint).

Install two nuts and bolts in both flanges of the Z-beams.

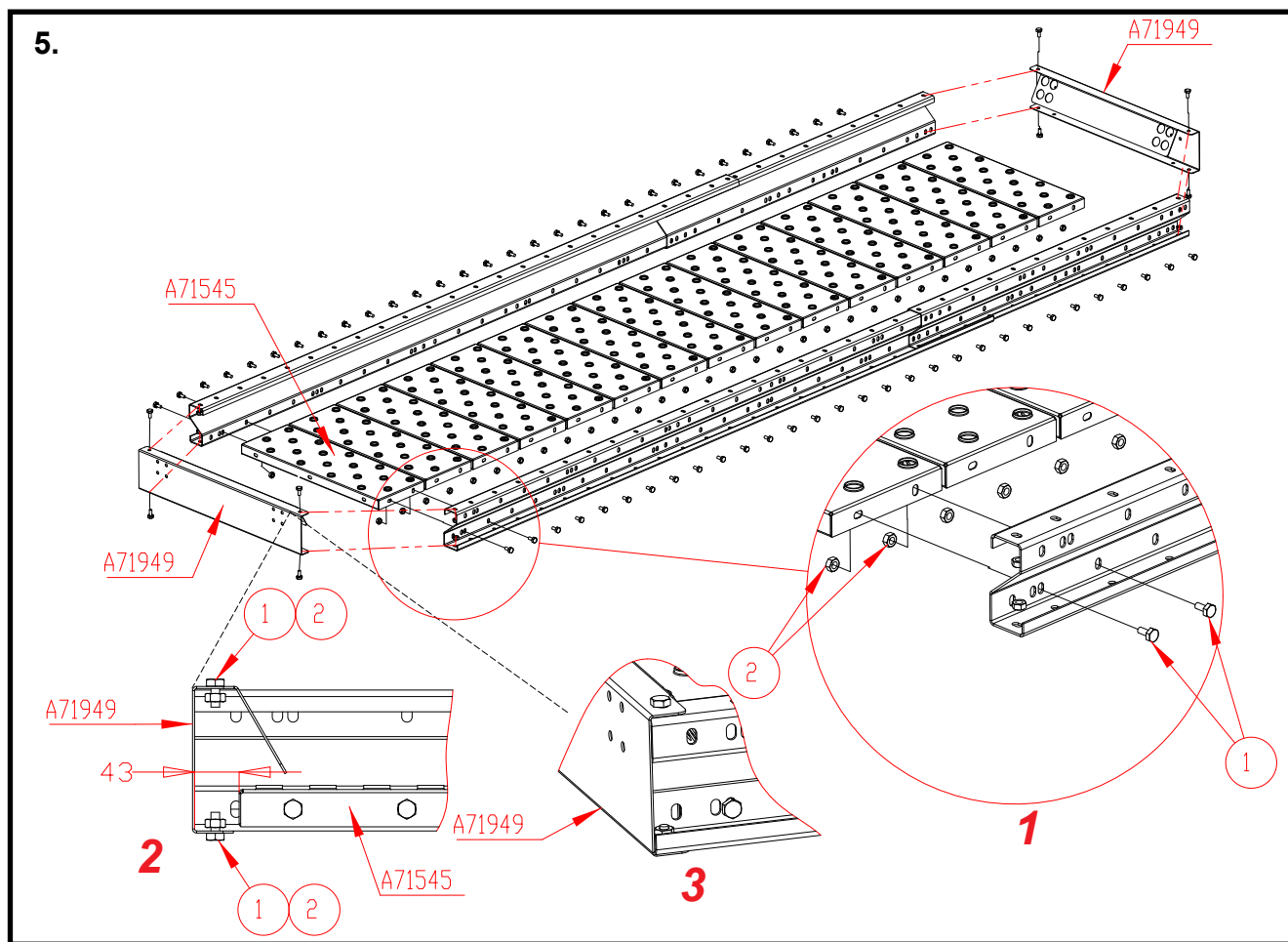
Also see the point "Installation of the attachment plates for the railing elements" on page 61

The attachment plate may be attached by the same bolt as the joint of the two Z-beams. (Helps reduce labour, if taken in account at an earlier stage)



Base

Antti WM06



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

Installing the Z-beams and the end-beams of the service platform, 3W

Install a Z-beam set-up (A71916+A71919) at both sides of the service platform.

Check the position of the platform elements and the Z-beams with respect to one another in the detail drawings 1 and 2.

Fix the Z-beams to the sides of the platform element set-ups.

Fix each element by its both ends using two nuts and bolts (M10x20).

Install an end-beam (A71949) in both ends of the service platform.

Check the position of the end-beam and the Z-beam with respect to one another in the detail drawings 2 and 3.

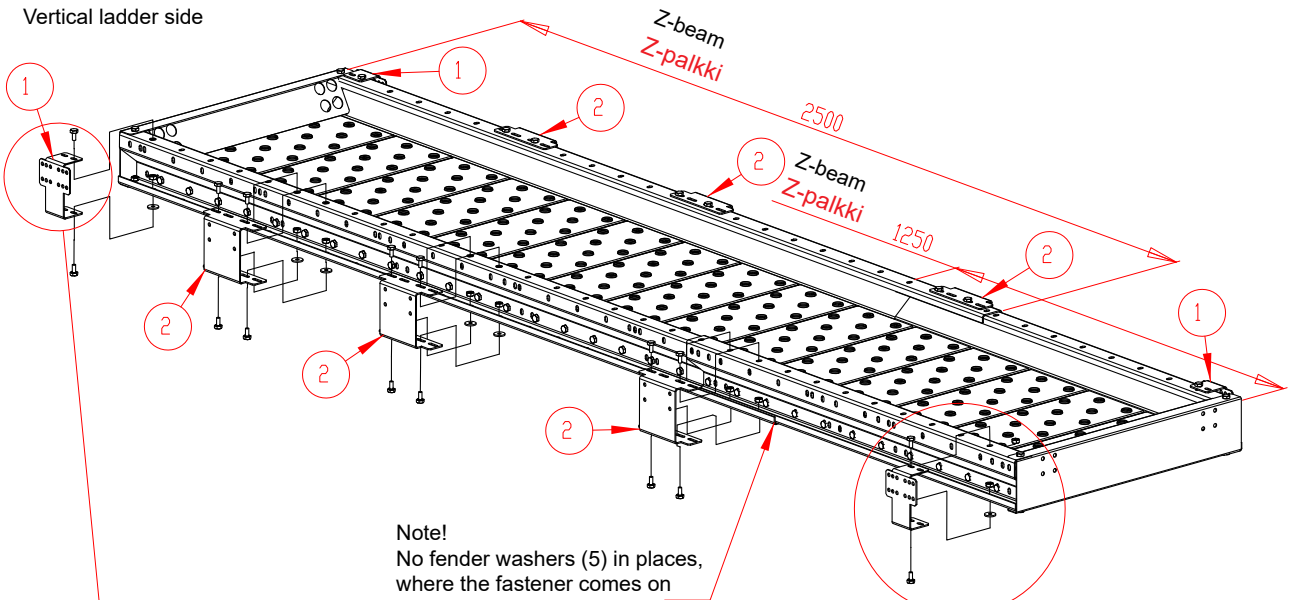
Fix the end-beams to the ends of the Z-beam set-ups.

Fix each end-beam by its both ends using two nuts and bolts (M10x20).

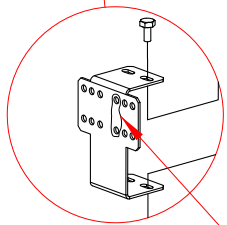
6.

Vertical ladder side

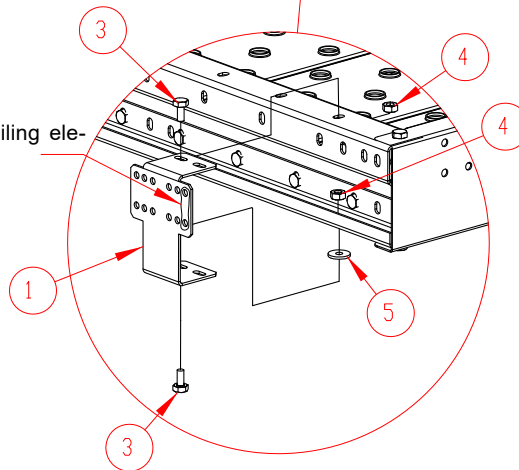
Look this side of the drawing for the positions, where the fasteners (1 and 2) shall be attached by bolts.



Note!
No fender washers (5) in places, where the fastener comes on overlapping Z-profiles.



Attachment holes for the railing elements



Ref.	Part no.	Denomination
1	A76221	SERVICE PLATFORM FASTENER PLATE M19
2	A76220	SERVICE PLATFORM FASTENER PLATE M19
3	102200	BOLT HEX ZN 8.8 10X20 DIN933
4	110560	NUT M10 ZN 8 DIN934
5	111563	FENDER WASHER M10 D34/D11x3 DIN440R ZN



Installation of the attachment plates for the railing elements

Install the attachment plates (parts 1 and 2) exactly in the positions shown in the drawing.

Look up the correct positions in the drawing by counting the holes in the Z-beams to be left unused between the fasteners.

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

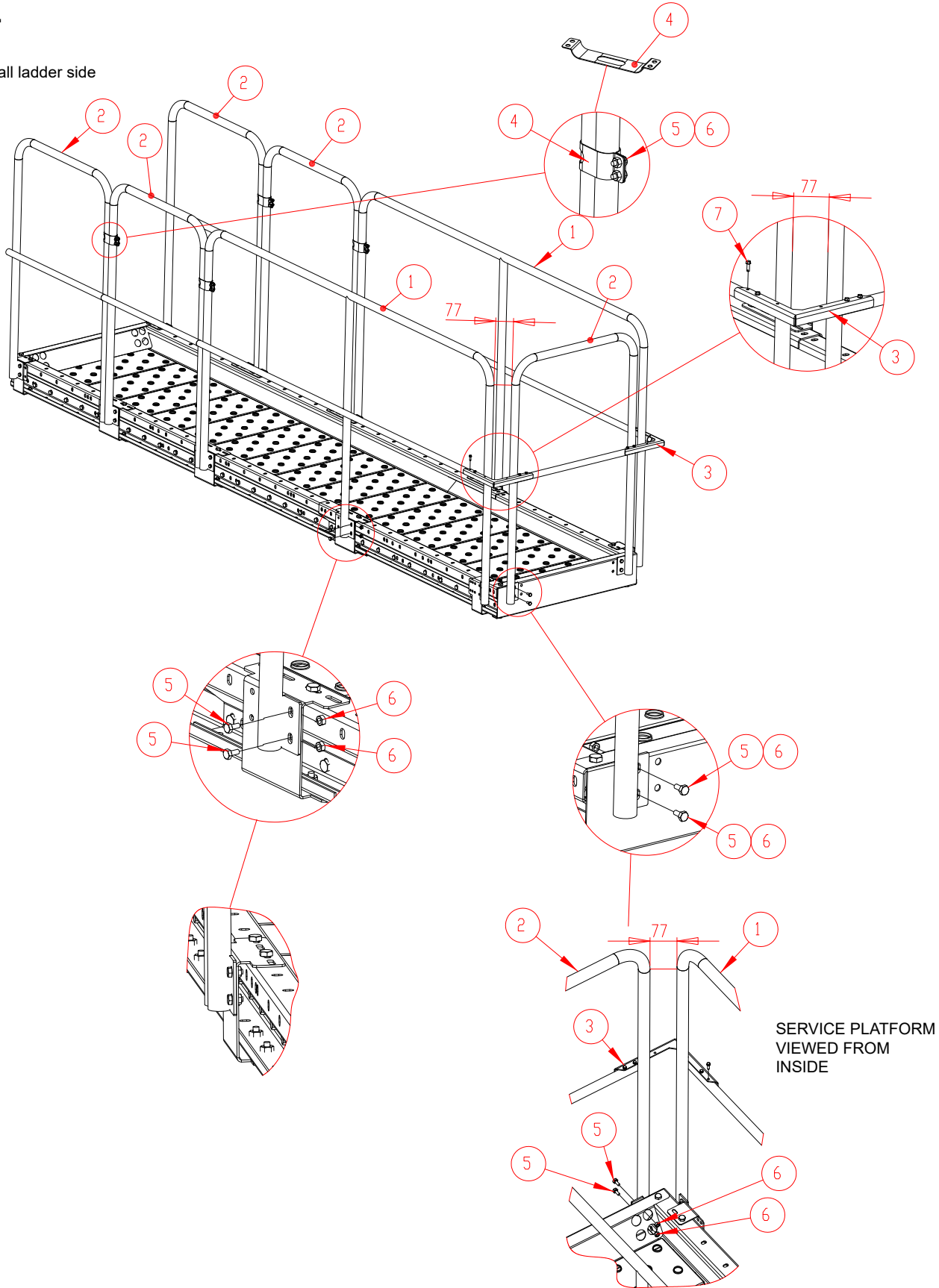
Attach the fastener plates using M10 nuts and M10x25 bolts.

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

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

7.

Wall ladder side





Ref.	Part no.	Denomination
1	A76205	RAILING ELEMENTS L 2012 M19
2	A76208	RAILING ELEMENTS L 671 M19
3	A76214	RAILING SUPPORT PART M19
4	A76216	RAILING FASTENING PART M19
5	101810	BOLT HEX ZN 8.8 8X16 DIN933
6	110540	NUT M8 ZN 8 DIN934
7	107523	DRILL SCREW 6HEX 5,5X19 ZN DIN7504-K

Installing the service platform railings

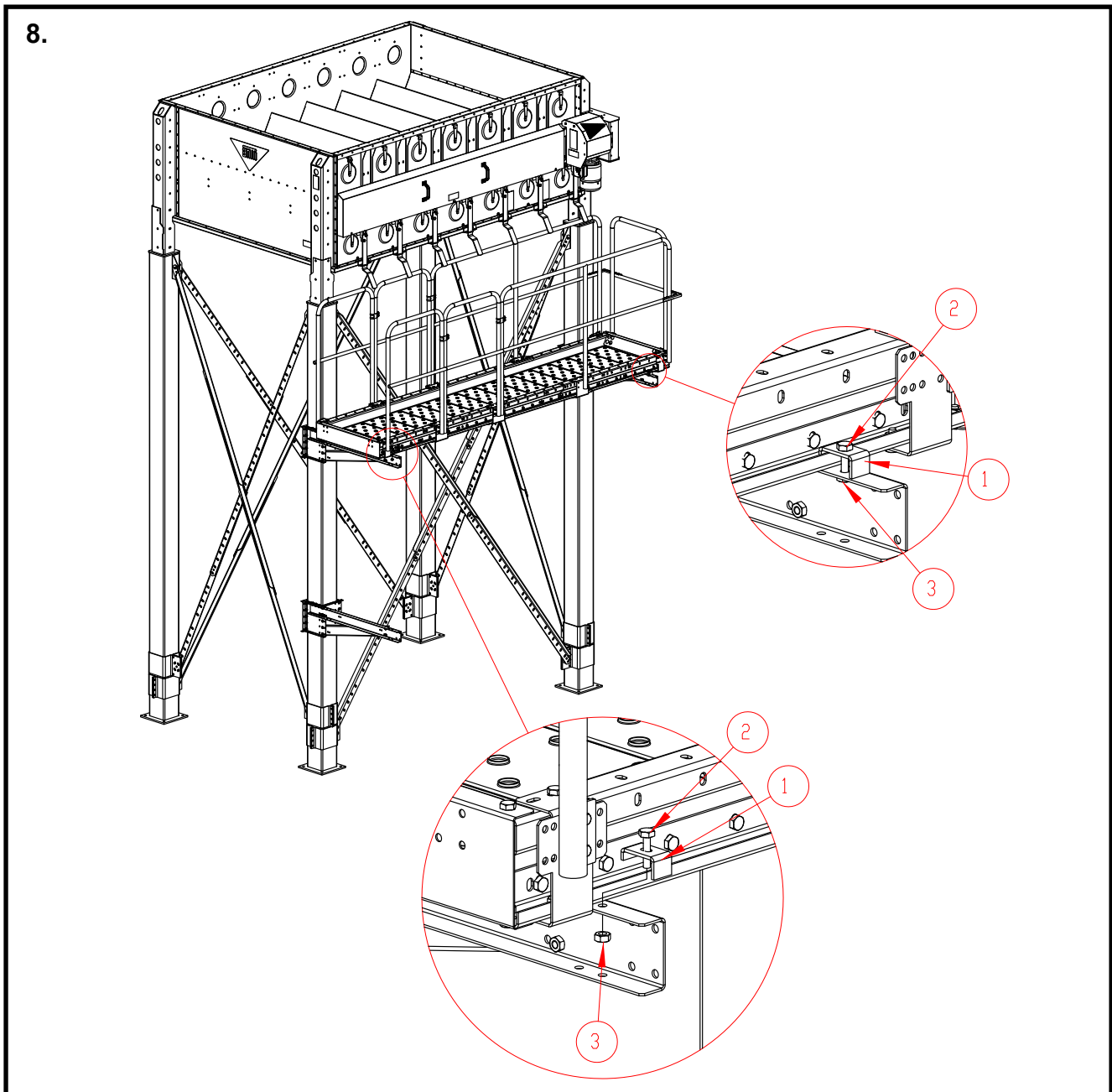
The installation order presented in these instructions follows the pattern, where the railings will first be attached to the service platform, and after that, the service platform will be lifted in place on their crossbar bearers. If the space at the installation location is limited, it may be necessary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

Assemble the parts of the railing as shown in the drawing. Check that all the railing sections are in line. A gap, about 77mm wide, shall be left between the railing pipes at the end and between the railing elements on the long side.

Twine the fasteners (part 4) around the railing pipes and fasten them using M8x16 bolts.

Fix the part 3 to the railing pipes using self-tapping screws. There are holes for the self-tapping screws in the part 3. The railing pipes have no ready-drilled holes, because the screw will drill a hole for itself in the pipe. The corner support (part 3) shall be attached to the railing pipes by self-tapping screws (4 pcs). One of the attachment holes for the corner support will be left unused.

To avoid making excess holes in the railing pipes, do not fix the parts 3 by self-tapping screws until you have first ensured that all the parts have been installed correctly in their proper places.



Installing the service platform on the bearers, 3W

Put the ready-assembled service platform onto its bearers.

See the detail drawings for the correct position of the platform with respect to the crossbar bearers.

Fix the service platform to the bearers using clamps (400282), nuts and bolts (M10x40).

Fix the shorter end of the clamp on top of the Z-beam of the service platform.

Fix the service platform at four points (at every corner), see detail drawings



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

Installing the service platform ladder

Install the ladder as shown in the drawings (see pages 66-67).

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

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

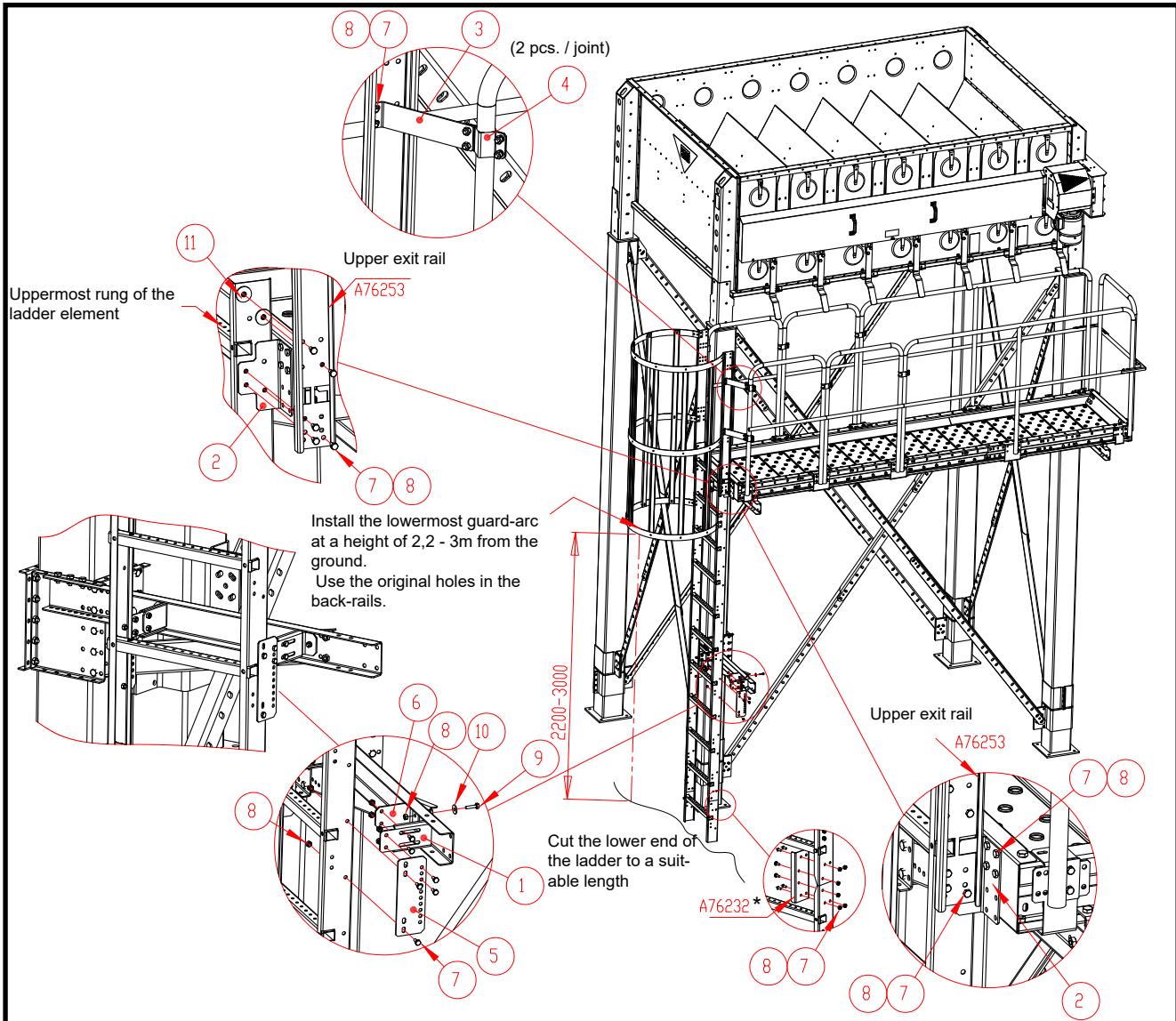
Attachment using M8x16 bolts. Also put two fender washers (part 11) in the joint between the upper exit rail and the ladder element. See detail drawing. Install the fastener and the upper exit rail on the other side of the ladder element as shown in the detail drawing.

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

Cut the lower end of the lower ladder element to a suitable length.

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

Installing the ladder on the service platform of 3W



Ref.	Part no.	Denomination	
1	A76240	SERVICE PLATFORM BASE LADDER CLAMP	()
2	A76239	SERVICE PLATFORM BASE LADDER CLAMP	()
3	A76241	SERVICE PLATFORM BASE LADDER CLAMP	()
4	A76242	ATTACH PLATE TO RAILING M19	()
5	A76234	PAK LADDER ATTACH PLATE A M19	*
6	A76235	PAK LADDER ATTACH PLATE B M19	*
7	101810	BOLT HEX ZN 8.8 8X16 DIN933	* ()
8	110540	NUT M8 ZN 8 DIN934	* ()
9	101850	BOLT HEX ZN 8.8 8X30 AM DIN933	*
10	111532	WASHER ZN M 8 DIN9021	*
11	111563	FENDER WASHER M10 D34/D11x3 DIN440R ZN	()

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

* Parts in the ladder package A76251



Assembly of the ladder; overview

