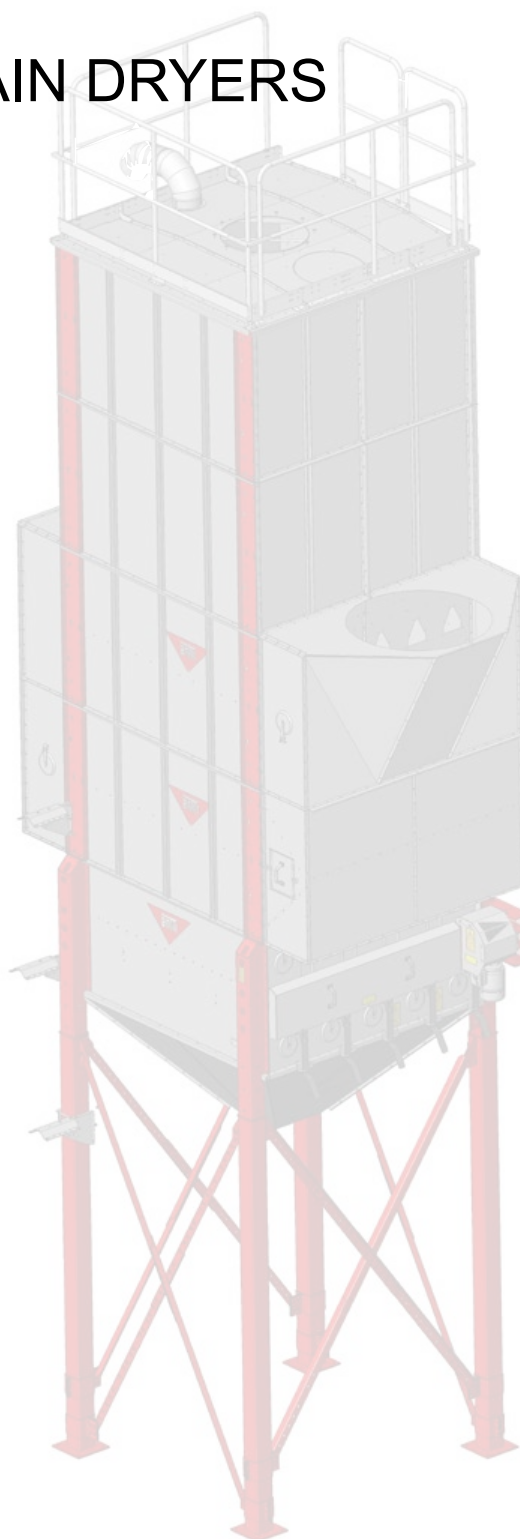


Assembly Instructions

ANTTI M06 GRAIN DRYERS BASE

408090 (en) 05-2026

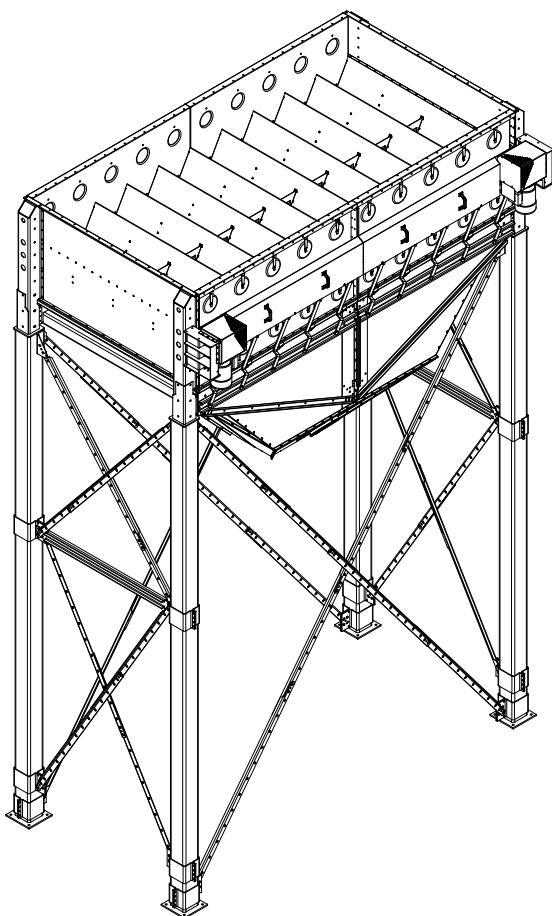


You'll see the difference

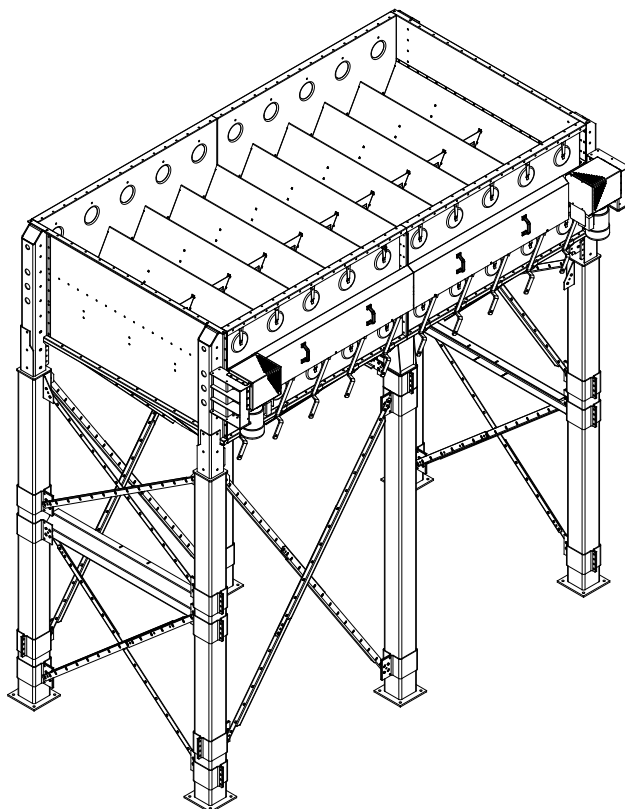
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Base 4W assembled

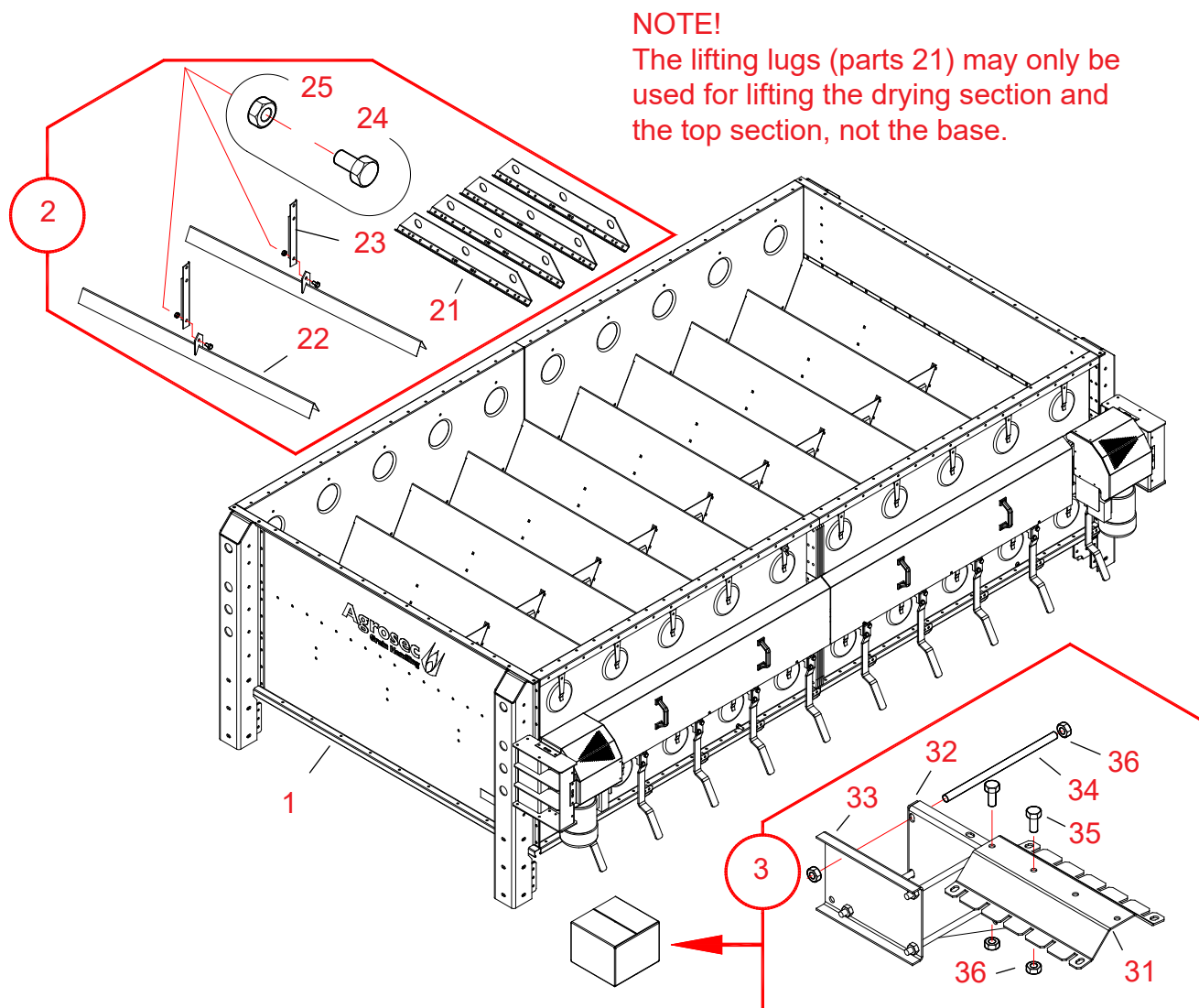


Base 4WC assembled; with double cone





Base with accessories 4W (A70431), spare parts





20061227

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	A71518	BASE WM06 4W 1.1 kW	1		1439,81	3000
2	A71519	BASE WM06 LIFTING AND TOP SECTION	1	A71519	23,61	3000
3	A71514	BASE WM06 LOCKING-CHAIN PACK	1	A71514-A	9,87	3000

A71519

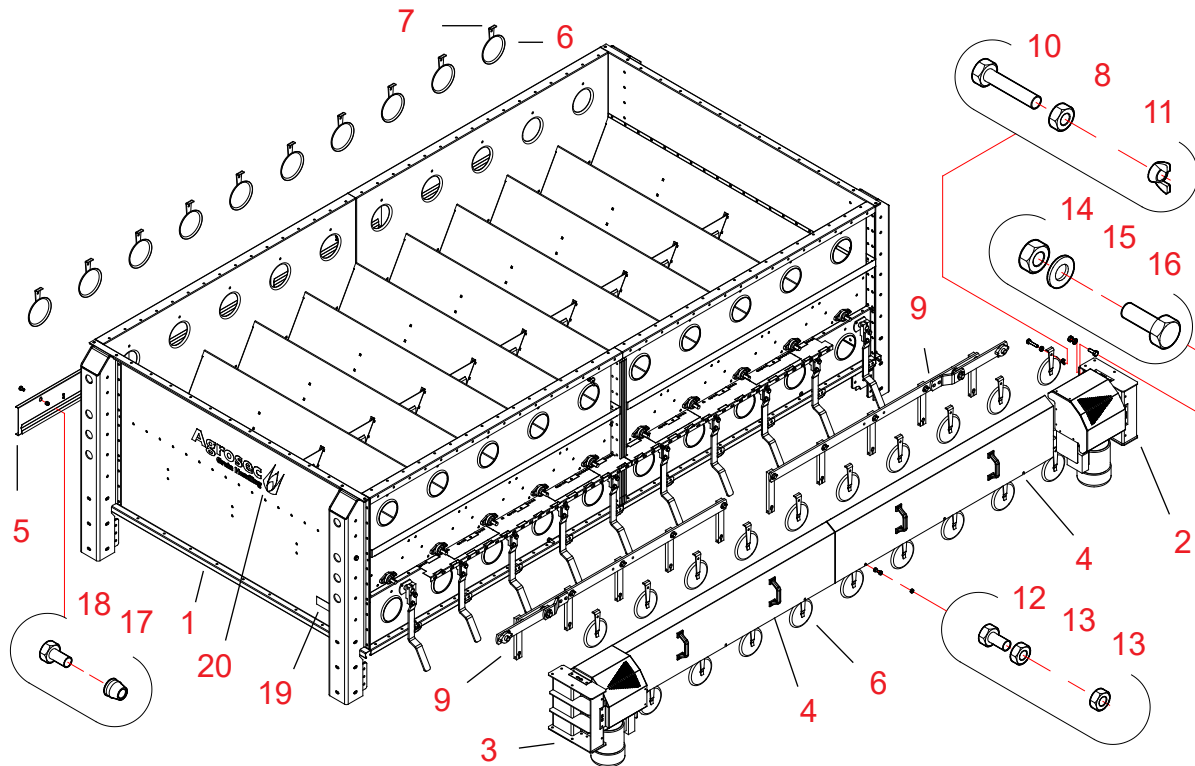
21	501010	LIFTING LUG, SECTION 4x165x900	2	S32277-D	0	3000
22	A70622	TOP SECTION WM06 BEARER LEG	1	A70622	2.86	3000
23	A70623	TOP SECTION WM06 LOWER PART OF BEARER	1	A70623	3.02	3000
24	102200	BOLT HEX ZN 8.8 – 10x25 AM DIN933	1		0	2010
25	110560	NUT ZN 8 - M10 DIN934	22		0	2010

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 4W assembled (A71518), spare parts

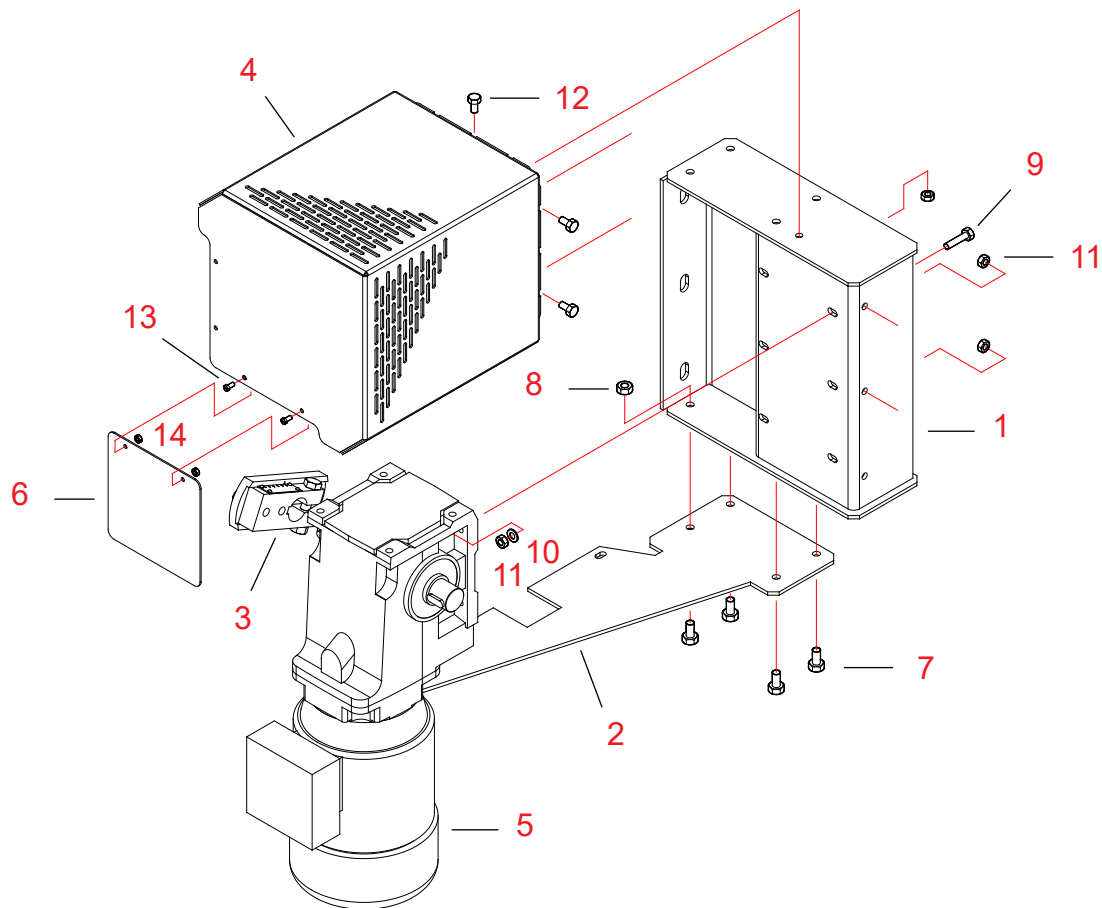


20061227

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	A70405	BASE WM06 4W FRAME	1	A70405-A	1046.87	3000
2	A70416	BASE WM06 MOTOR RACK ASSEMBLY	1	A70416	123.41	3000
3	A70432	BASE WM06 MOTOR RACK ASSY LEFT	1	A70432	123.41	3000
4	A70711	BASE WM06 2W/4W FEEDER COVER	2	A70711	6.68	3000
5	33043	BASE XL CONTROL HATCH 182x840	4	33043-A	2.46	3000
6	400140	SHUTTER D173	30	S4293	0	3500
7	400150	HATCH HOLDER	30	4461-B	0	3500
8	110560	NUT ZN 8 - M10 DIN934	30		0	2010
9	A70398	BASE WM06 2W/4W FEEDER DEVICE ASSEMBLY	2	A70398	21	3000
10	102250	BOLT HEX ZN 8.8 - 10x40 AM DIN933	30		0	2010
11	111030	NUT WING ZN - M10 DIN315	30		0	2010
12	101810	BOLT HEX ZN 8.8 - 8X16 AM DIN933	6		0	2010
13	110540	NUT ZN 8 - M8 DIN934	12		0	2010
14	110570	NUT ZN 8 - M12 DIN934	6		0	2010
15	111560	WASHER ZN - M12 DIN125	6		0	2010
16	102520	BOLT HEX ZN 8.8 - 12x35 AM DIN933	6		0	2010
17	110553	STUD NUT - M8 1.5-4.0 MM CTRSUNK	8		0	2010
18	103628	BOLT CTRSUNK SLOT ZN - 8x16 AM	8		0	2010
19	117909	PLATE STICKER 101x50 THT-55-434-1	1	41573-B	0	2900
20	117831	PLATE STICKER 150x500 AGROSEC GRAIN HANDLING	2		0	2900



Motor rack (A70416), spare parts

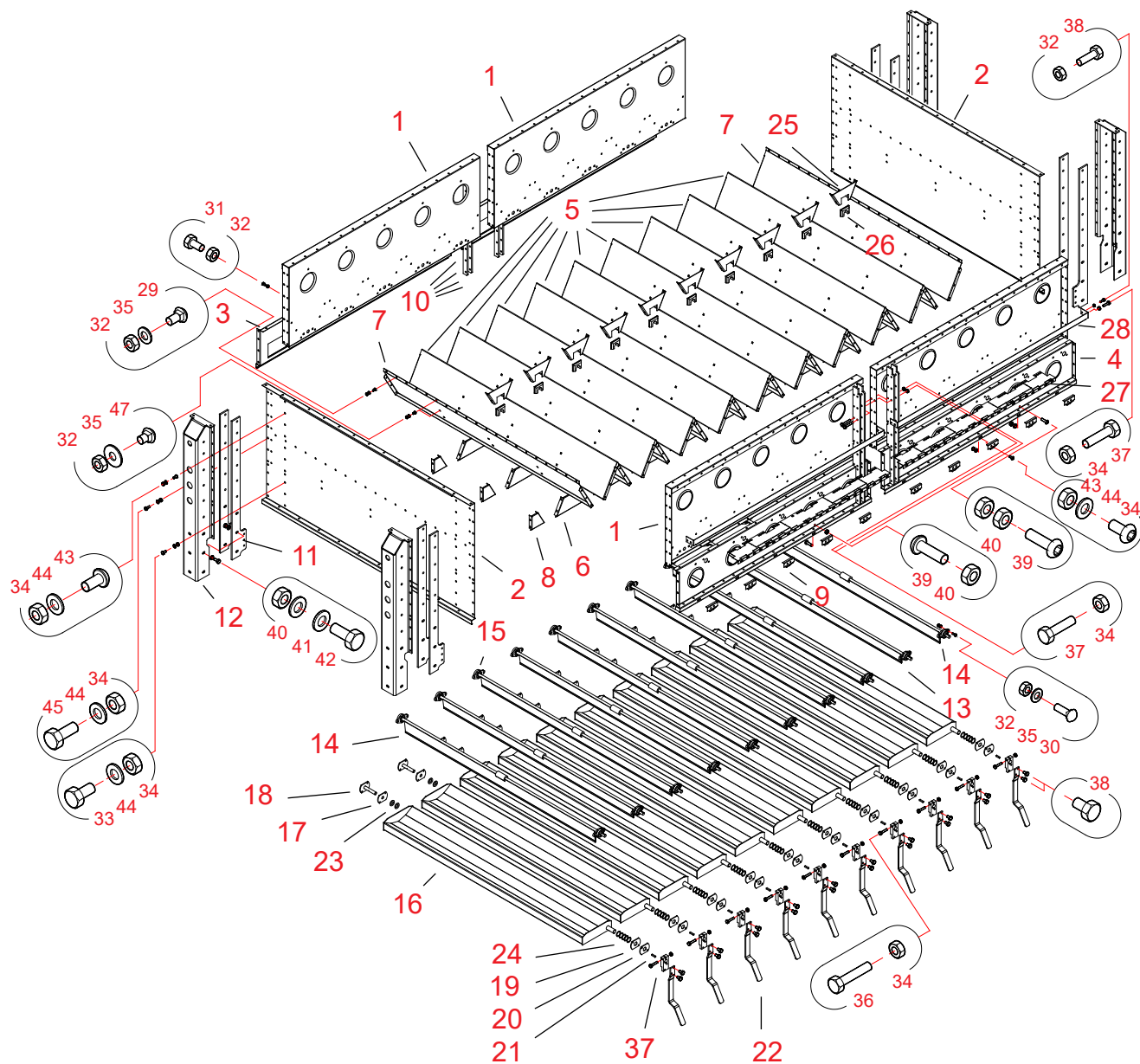


20060921

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



Base frame 4W (A70405), spare parts



20061106

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	A70701	BASE WM06 2W/4W END-PL TOP PART	4	A70701	24,79	3000
2	A70649	BASE WM06 FEEDER SIDE-PLATE	2	A70649	36,69	3000
3	A70702	BASE WM06 2W/4W END-PLATE BOTT OPEN	2	A70702	9,73	3000
4	A70510	BASE WM06 2W/4W FEEDER END-PL BOTT OPEN	2	A70510-C	11,72	3000
5	A70381	BASE WM06 2W/4W FEEDER DUCT 1/1	9	A70381-B	19,64	3000



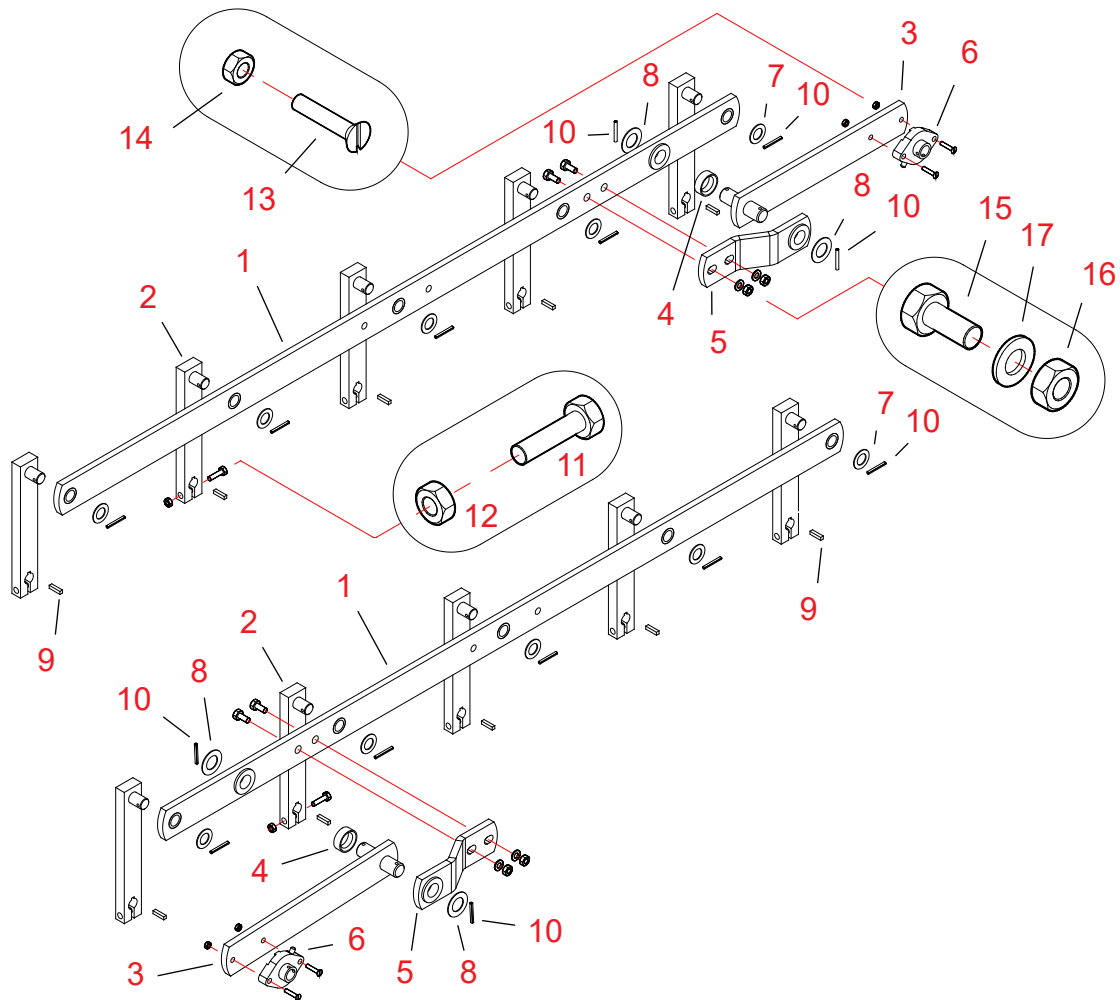
6	A70387	BASE WM06 2W/4W SUPPORT PLATE 1/1	27	A70387-A	0,61	3000
7	A70388	BASE WM06 SUCT FEEDER DUCT 1/2	2	A70388-B	10,55	3000
8	A70389	BASE WM06 SUPPORT PLATE ½ DUCT	6	A70389-A	0,31	3000
9	A70435	BASE WM06 TROUGH ROD STOPPER	10	A70435-C	0,06	3000
10	A70479	BASE WM06 4W CENTRE SUPPORT	8	A70479-B	5,08	3000
11	A70476	BASE WM06 4W LEG REINFORC	16	A70476	8,19	3000
12	A70356	BASE WM06 LEG	4	A70356	26,37	3000
13	501704	BASE FEEDER I D20-2050H=85M,XL,EL	8	32226-D	0	3000
14	501705	BASE FEEDER II D20-2050H=105M,XL,EL	2	32227-D	0	3000
15	313100	BEARING FLANGE UCFL 204 CAST P	20		0	2100
16	A70371	BASE WM06 FEED TROUGH	10	A70371	25,91	3000
17	400200	BASE ATTACH PLATE D20.5/M8	10	4606	0	3000
18	A70836	BASE WM06 TROUGH HOLDER	10	A70836	0,48	3000
19	A70385	BASE WM06 ATTACH PLATE D30.5/M8	10	A70385	0,19	3000
20	A70386	BASE WM06 ATTACH PLATE D30.5/D10	10		0,18	3000
21	A70439	KEY DIN 6885B 7x8 - 35	10	A70439	0,02	3000
22	A71320	BASE WM06 TROUGH ROD BAR 8x40	10	A71320	1,24	3000
23	400345	WASHER PL4 D41/D22.5	20		0	4500
24	400348	WASHER ZN PL1.5 D41/31	50		0	4500
25	A70399	BASE WM06 2W/4W BEARING SUPP PLATE	10	A70399	0,57	3000
26	313303	BEARING PLASTIC 55x80 MEGA 41646-A	10	41646	0	2100
27	A70524	BASE WM06 FEEDER COVER BOTTOM	2	A70524-A	2,41	3000
28	A70522	BASE WM06 2W FEEDER COVER ATTACH	2	A70522-A	2,92	3000
29	107913	LOCK SCREW ZN - M8x20 DIN603 8.8	4		0	2010
30	107902	LOCK SCREW ZN - M8x25 DIN603	40		0	2010
31	101810	BOLT HEX ZN 8.8 - 8X16 AM DIN933	236		0	2010
32	110540	NUT ZN 8 - M8 DIN934	402		0	2010
33	102200	BOLT HEX ZN 8.8 - 10x25 AM DIN933	28		0	2010
34	110560	NUT ZN 8 - M10 DIN934	154		0	2010
35	111540	WASHER ZN - M8 DIN125	56		0	2010
36	101903	BOLT HEX ZN 8.8 - 10x60 AM DIN933	46		0	2010
37	A71321	BASE WM06 TROUGH ROD SHAFT ATTACH	10	A71321	0,75	3000
38	102499	BOLT HEX ZN 8.8 - 12x20 AM DIN933	20		0	2010
39	104263	SOCK SCREW BALL-H - 12x40 AM ISO 7380	2		0	2000
40	110570	NUT ZN 8 - M12 DIN934	75		0	2010
41	111560	WASHER ZN - M12 DIN125	144		0	2010
42	101826	BOLT HEX HOT-GALV 8.8 - 12x30 AM DIN933	72		0	2000
43	104259	SOCK SCREW BALL-H - 10x20 AM ISO 7380	35		0	2010
44	111550	WASHER ZN - M10 DIN125	20		0	2010
45	102210	BOLT HEX ZN 8.8 10x25 AM DIN933	44		0	2010
46	111532	WASHER ZN FENDER - M8 DIN9021	32		0	2010
47	107910	LOCK SCREW ZN - M8x16 DIN603 8.8	122		0	2010



Base

Antti WM06

Feeding equipment 4W (2 x A70398), spare parts



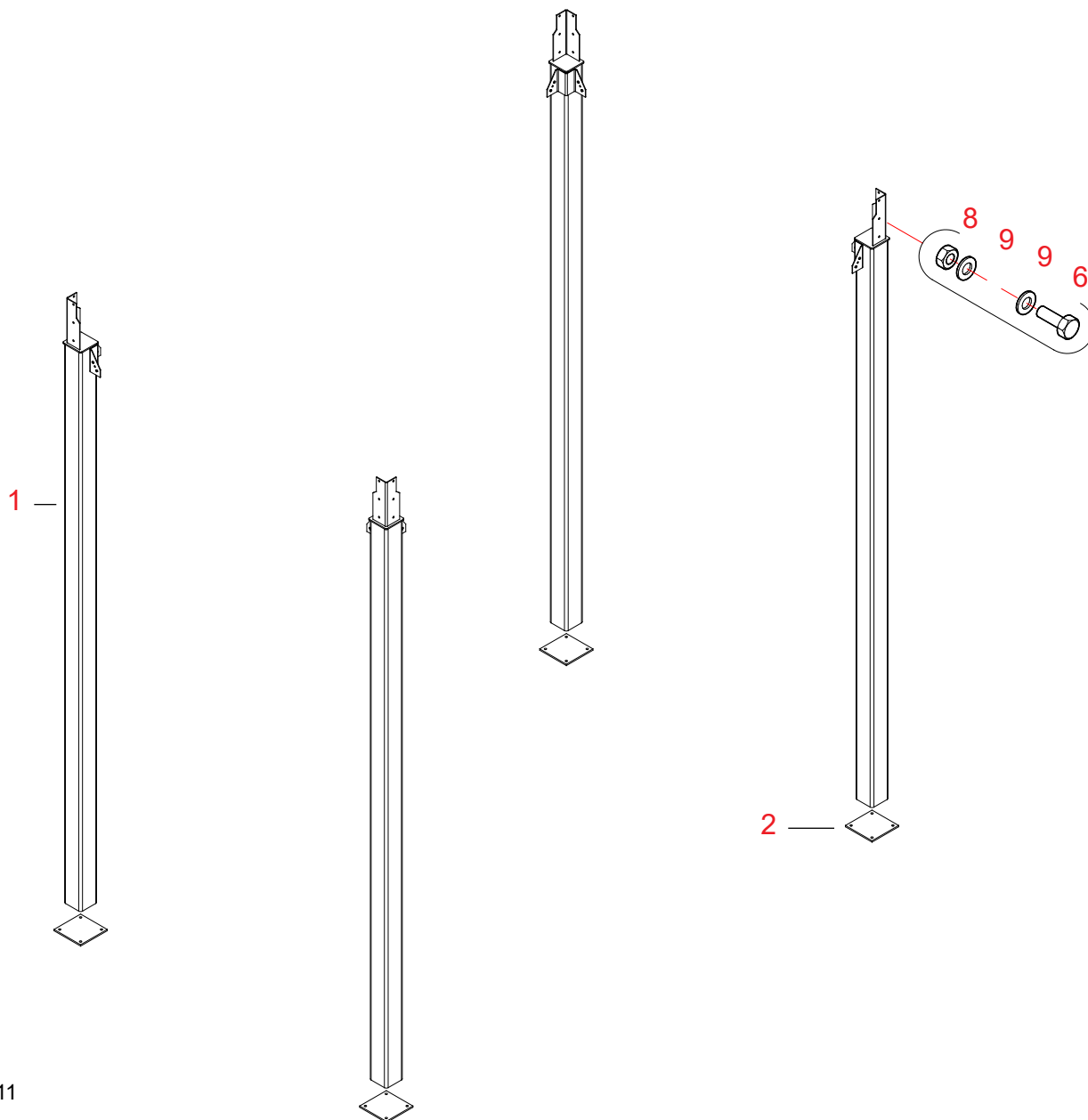


20060601

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	31696	BASE EL,XL,2W,4W CONNECT ROD. 12X60-1588	1	31696-A	8.9	3000
2	501440	BASE PENDEL ARM 20x40-265 D20/20	5	31242-A	0	3000
3	402420	BASE XL,EL TRANSMISSION ROD+SHAFT	1	A70331	0	2900
4	400185	BASE SPACER SLEEVE D40/28 L=14	1	22009-B,5	0	1600
5	402421	BASE XL,EL SUPPORT ROD	1	A70421	0	3000
6	116510	BEARING FLANGE GLCTEY20 CAST P	1		0	2100
7	400347	WASHER AISI PL1.5 D35/20.5	5		0	4500
8	400344	WASHER AISI PL1.5 D45/25,5	2	21175,4	0	4500
9	A70438	KEY 6x6 - 25	5		0.01	3000
10	112540	SPRING PIN D5x40	7		0	2010
11	102282	BOLT HEX ZN 8.8 – 10x50 CM DIN931	5		0	2010
12	110560	NUT ZN 8 - M10 DIN934	5		0	2010
13	103640	BOLT CTRSUNK SLOT ZN – 8x40 AM	2		0	2010
14	110540	NUT ZN 8 – M8 DIN934	2		0	2010
15	102540	BOLT HEX ZN 8.8 – 12x40 AM DIN933	2		0	2010
16	110570	NUT ZN 8 - M12 DIN934	2		0	2010
17	111560	WASHER ZN - M12 DIN125	2		0	2010



Extension legs 4W (A70536), spare parts; L = 5100 mm



20080711

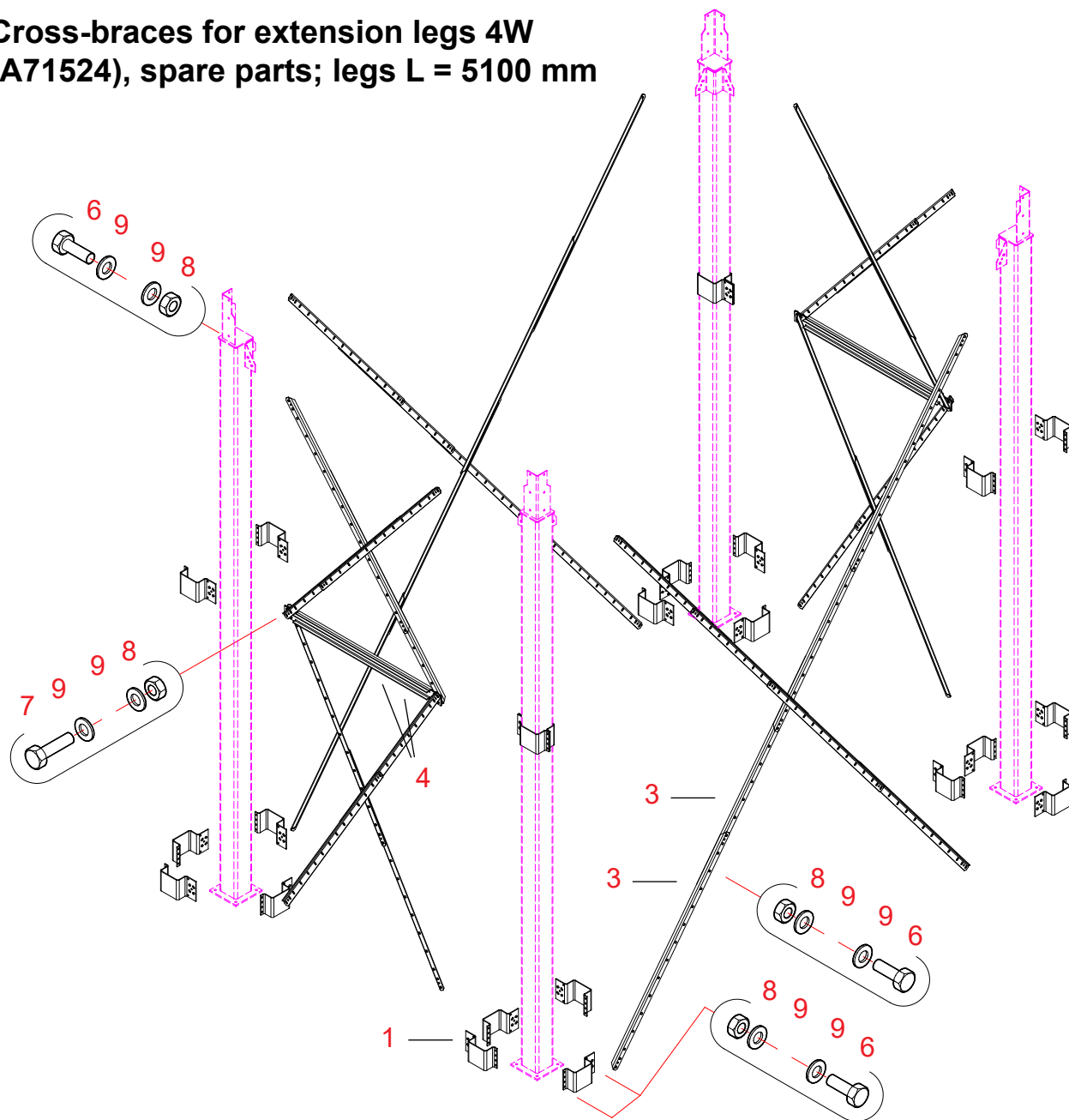
Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
-	A70536	BASE WM06 LEGS 5100 PACK.	1	A70536		3000

THE SET INCLUDES:

1	A70426	BASE M06W EXTENSION LEG 4W	4	A70426	241.16	3000
2	A70561	LEGS WM06 END-PLATE 12X280X280	4	A70561	7.29	3000
6	102520	BOLT HEX ZN 8.8 - 10X25 AM DIN933	24		0.04	2010
8	110570	NUT ZN 8 - M12 DIN934	24		0.02	2010
9	111560	WASHER ZN - M12 DIN125	48		0	2010



**Cross-braces for extension legs 4W
(A71524), spare parts; legs L = 5100 mm**



20080711

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	A70535	LEGS M06 ADJUST ATTACHMENT 3W/4	24	A70535-A	4.01	3000
2	A70528	LEGS M06W CROSS-BRACE L = 2000	32	A70528-C	5.92	3000
3	A70537	BASE M06W CONE INTERM PIPE EXTENSION LEGS	4	A70537	7.59	3000
6	102520	BOLT HEX ZN 8.8 - 10X25 AM DIN933	170		0.04	2010
7	102550	BOLT HEX ZN 8.8 - 12x45 AM DIN933	20		0	2010
8	110570	NUT ZN 8 - M12 DIN934	190		0.02	2010
9	111560	WASHER ZN - M12 DIN125	380		0	2010

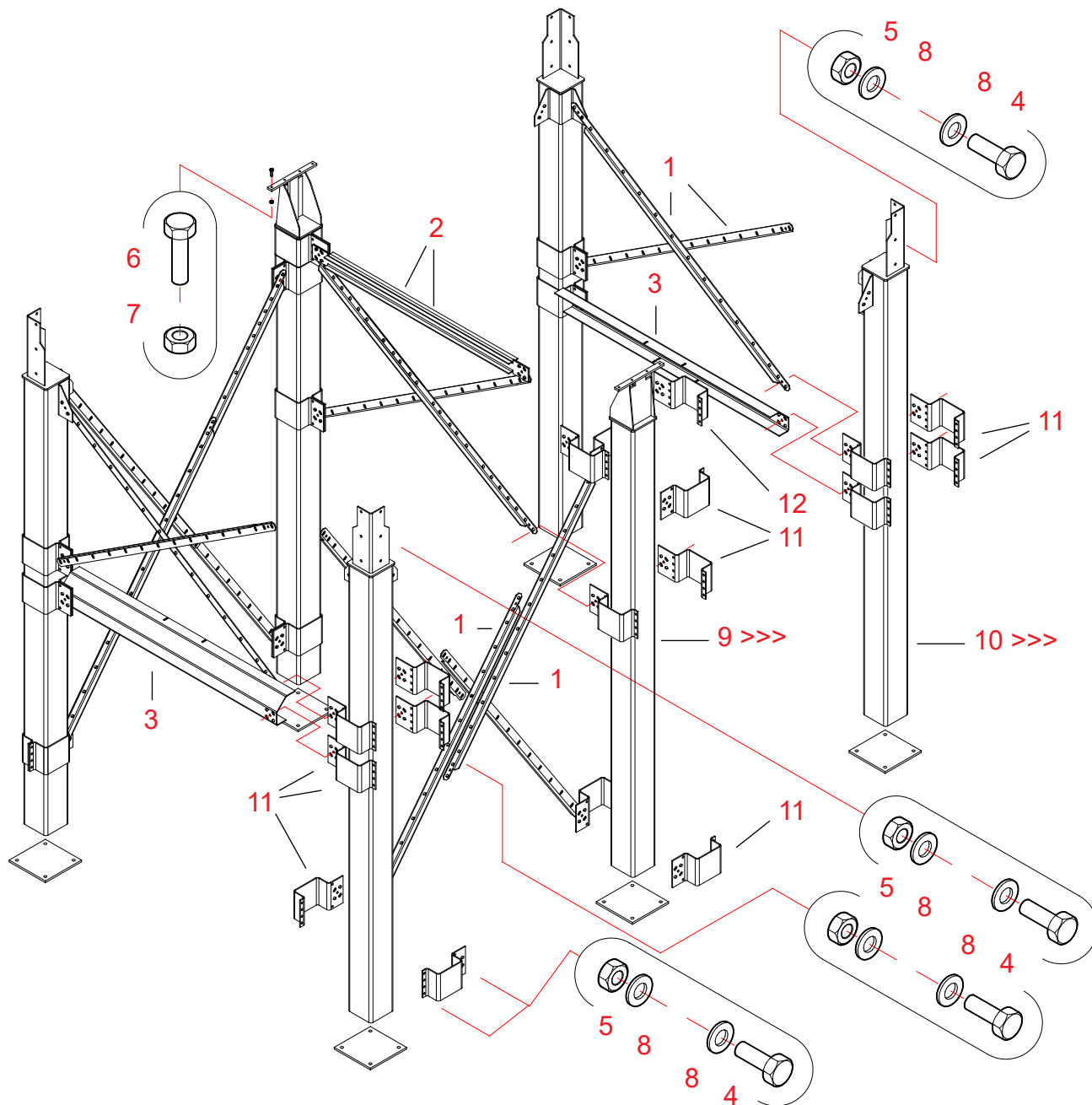


Base

Antti WM06

Extension legs 4WC (A70706), spare parts; L = 2840 mm

Model: Legs for the double cone





20080616

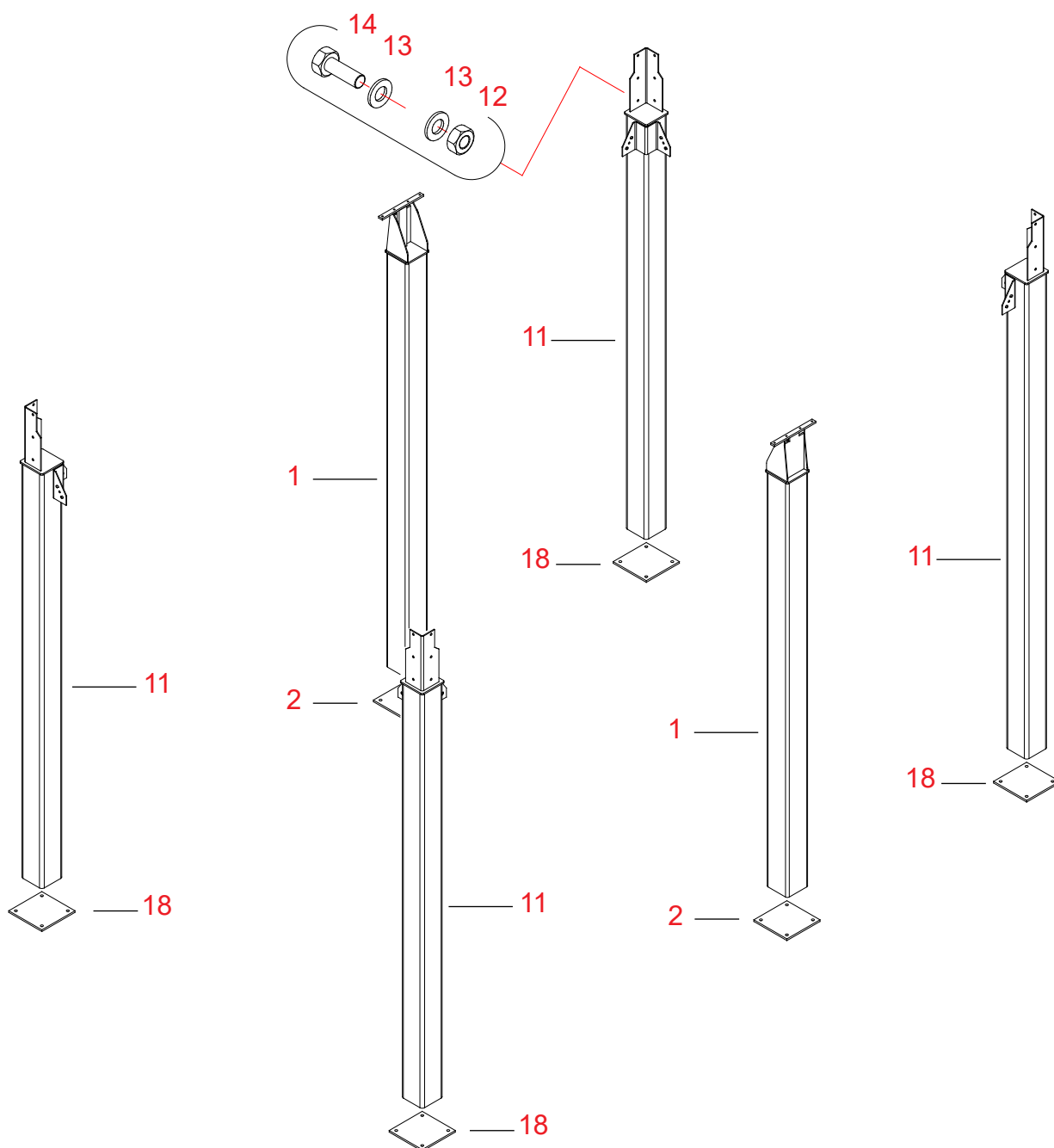
Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	A70528	LEGS WM06 CROSS-BRACE L = 2000	14	A70528-D	5,87	3000
2	A70537	BASE WM06 CROSS SUPPORT	2	A70537-0	7.59	3000
3	A70817	BASE WM06 CONVEYOR SUPPORT	2	A70817-0	21.29	3000
4	102520	BOLT HEX ZN 8.8 - 10X25 AM DIN933	212		0,01	2010
5	110570	NUT ZN 8 - M12 DIN934	212		0	2010
6	101850	BOLT HEX ZN 8.8 – 8x30 AM DIN933	8		0	2010
7	110540	NUT ZN 8 – M8 DIN934	8		0	2010
8	111560	WASHER ZN - M12 DIN125	508		0	2010
9	A71604	LEGS WM06 4W DOUBLE CONE CENTRE PACK.	1	A71604-A	223.25	3000
10	A71567	LEGS WM06 4W DOUBLE CONE CORNER LEG PACK	1	A71567-B	436.17	3000
11	A70535	LEGS WM06 3W/4W ADJUST ATTACH	32	A70535-A	4.01	3000
12	A70708	LEGS WM06 4W DOUBLE BRACKET	4	A70708	4.29	3000

>>>

LEG PACKAGE (PARTS 9 AND 10) PARTS, SEE NEXT SPREAD



Extension legs packages 4WC (A71567 and A71604), spare parts; L = 2840 mm





20080711

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
(9)	A71604	LEGS WM06 4W DOUBLE CONE CENTRE PACK.	1	A71604-A	223.25	3000

THE SET INCLUDES:

1	A70683	LEGS WM06 4W DOUBLE CONE LEG CENTRE	2	A70683	221.5	3000
2	A70561	LEGS WM06 END-PLATE 12X280X280	2	A70561-0	7.29	3000

20080711

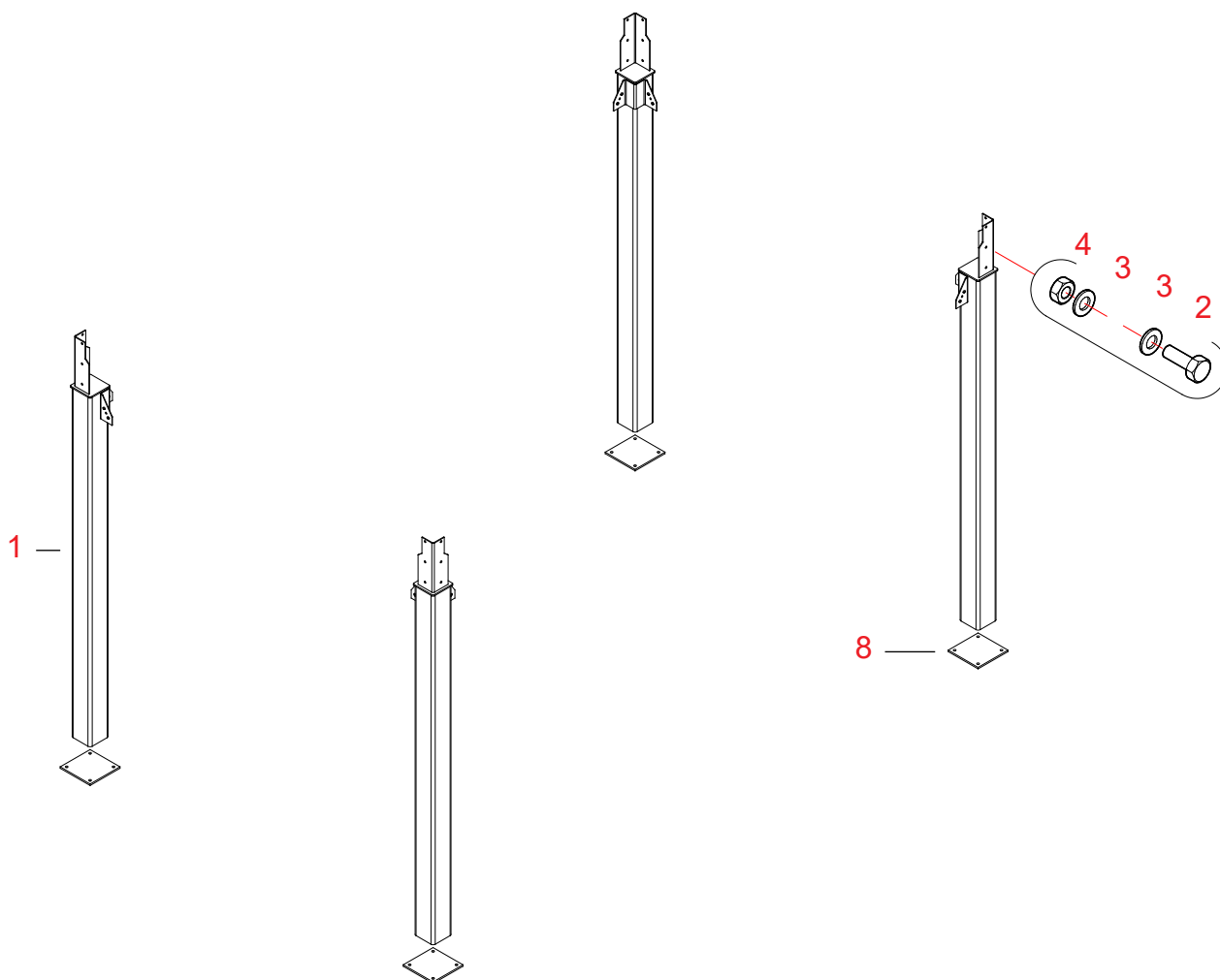
Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
(10)	A71567	LEGS WM06 4W DOUBLE CONE CORNER LEG PACK.	1	A71567-B	436.17	3000

THE SET INCLUDES:

11	A71588	BASE M06W EXTENSION LEG 4W	4	A71588-A	101.17	3000
12	102520	BOLT HEX ZN 8.8 - 12x35 AM DIN933	25		0.04	2010
13	111560	WASHER ZN - M12 DIN125	50		0	2010
14	110570	NUT ZN 8 - M12 DIN934	25		0.02	2010
18	A70561	LEGS WM06 END-PLATE 12X280X280	4	A70561-0	7.29	3000



Extension legs 4W (A71567), spare parts; L = 2840 mm

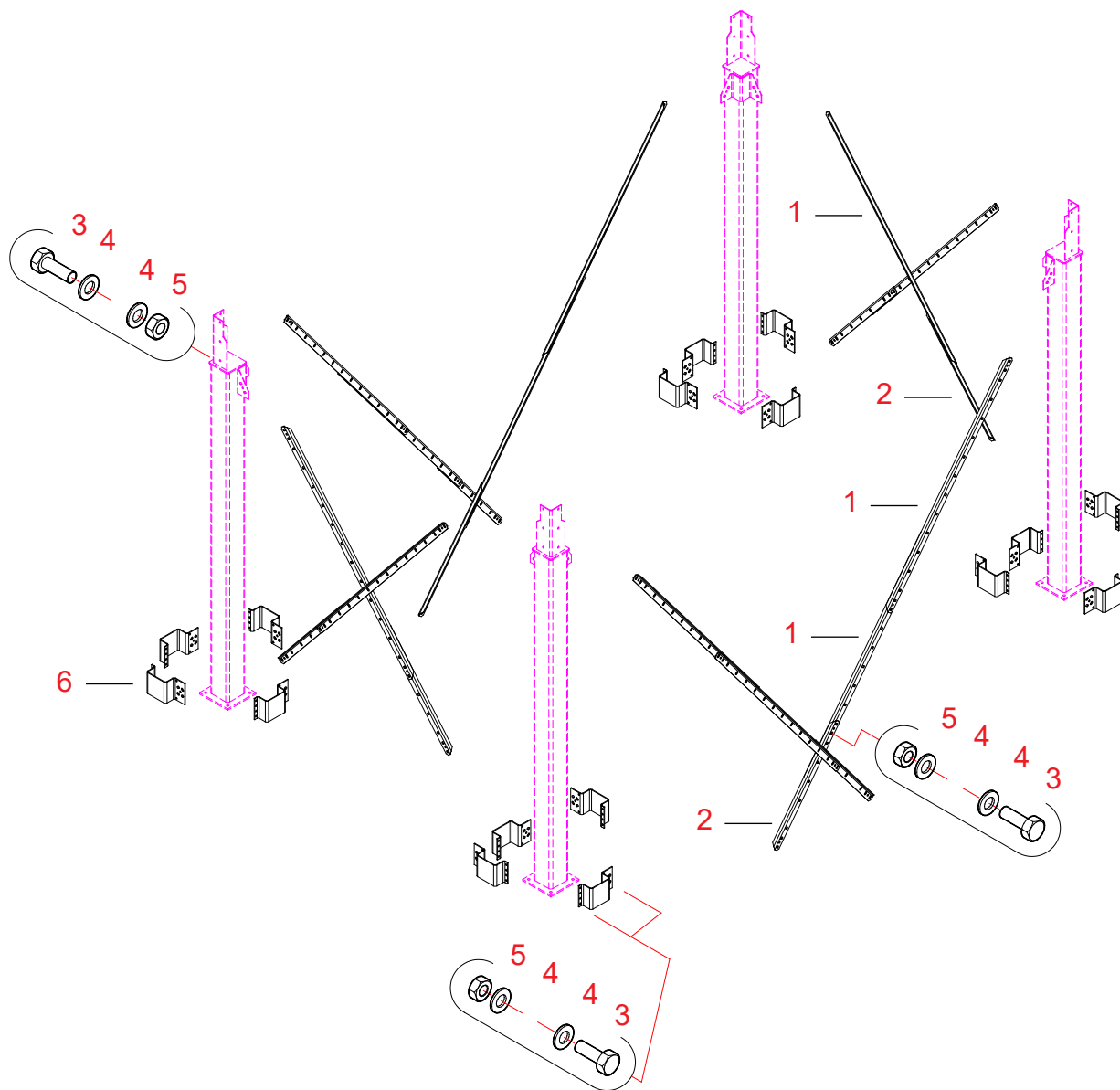


20080711

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
-	A71567	LEGS WM06 4W LEGS 2840 PACK.	1	A71567-B	436.17	3000

THE SET INCLUDES:

1	A71588	BASE M06W EXTENSION LEG 4W	4	A71588-A	101.17	3000
2	102520	BOLT HEX ZN 8.8 - 12x35 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 4W (A71568), spare parts; legs L = 2840 mm**

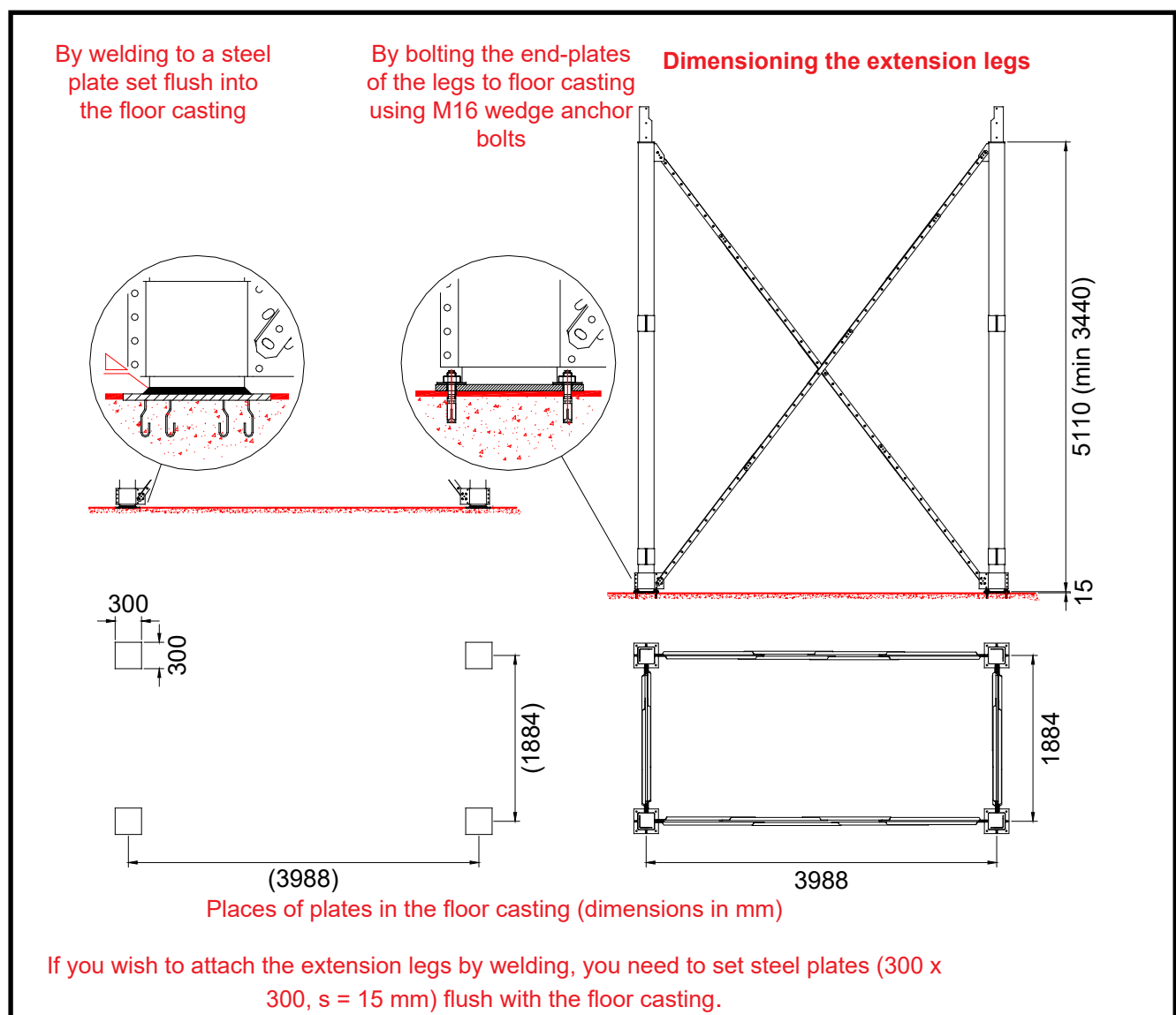
20080711

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	8	A70818-B	2.86	3000
3	102520	BOLT HEX ZN 8.8 - 12x35 AM DIN933	122		0.04	2010
4	111560	WASHER ZN - M12 DIN125	244		0	2010
5	110570	NUT ZN 8 - M12 DIN934	122		0.02	2010
6	A70535	LEGS M06 ADJUST ATTACHMENT 3W/4	16	A70535-A	4.01	3000

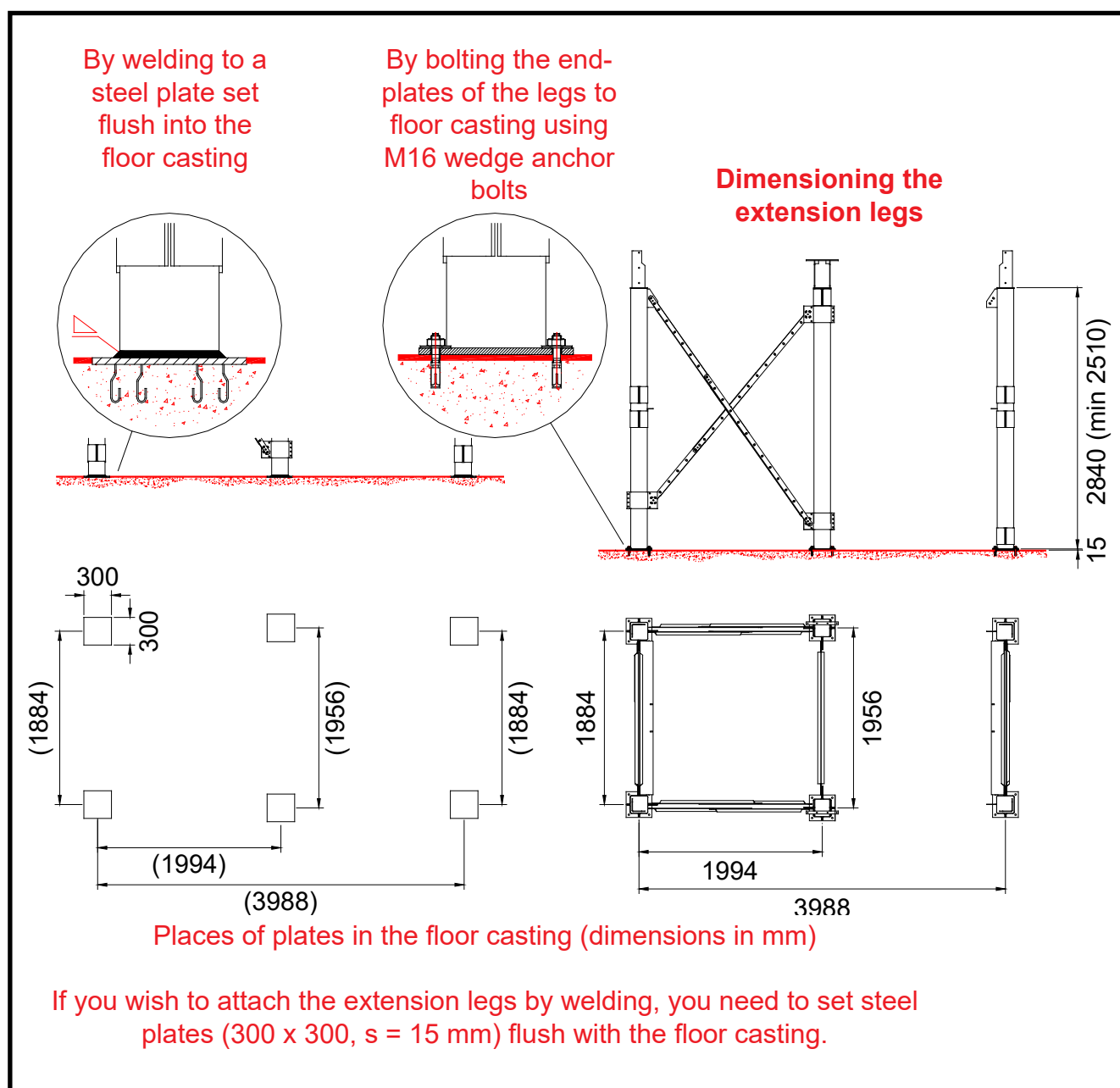
ASSEMBLING THE DRYER BASE

Optional ways to attach the lower ends of the extension legs on 4W

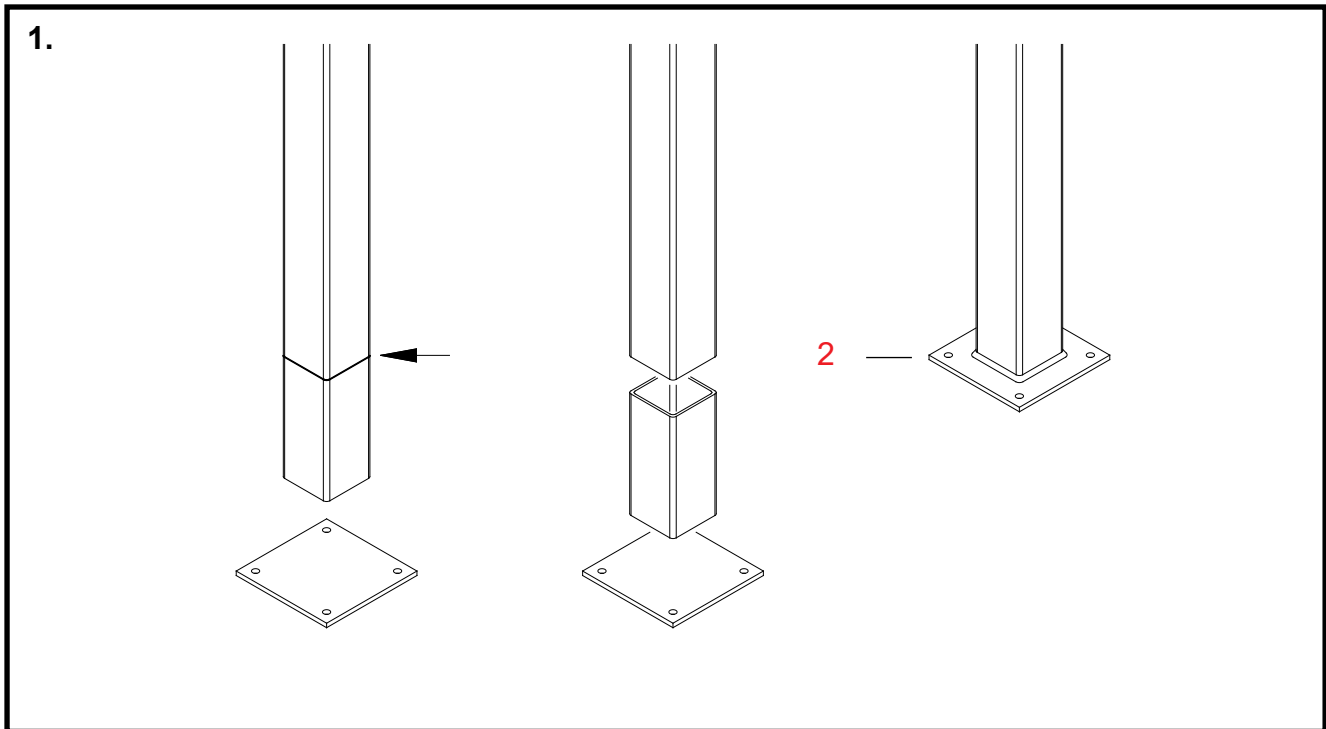
The maximum height of the machinery, to be installed outdoors using expansion anchors, is (because of the wind load) 8 rows. A machinery higher than this must be attached by welding to the bond plates embedded in the concrete. Attach the foot plates to the concrete foundation using M16x140 expansion 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.



Optional ways to attach the lower ends of the extension legs on 4WC



Attaching the extension legs to the base



1. Shortening the extension legs

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

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

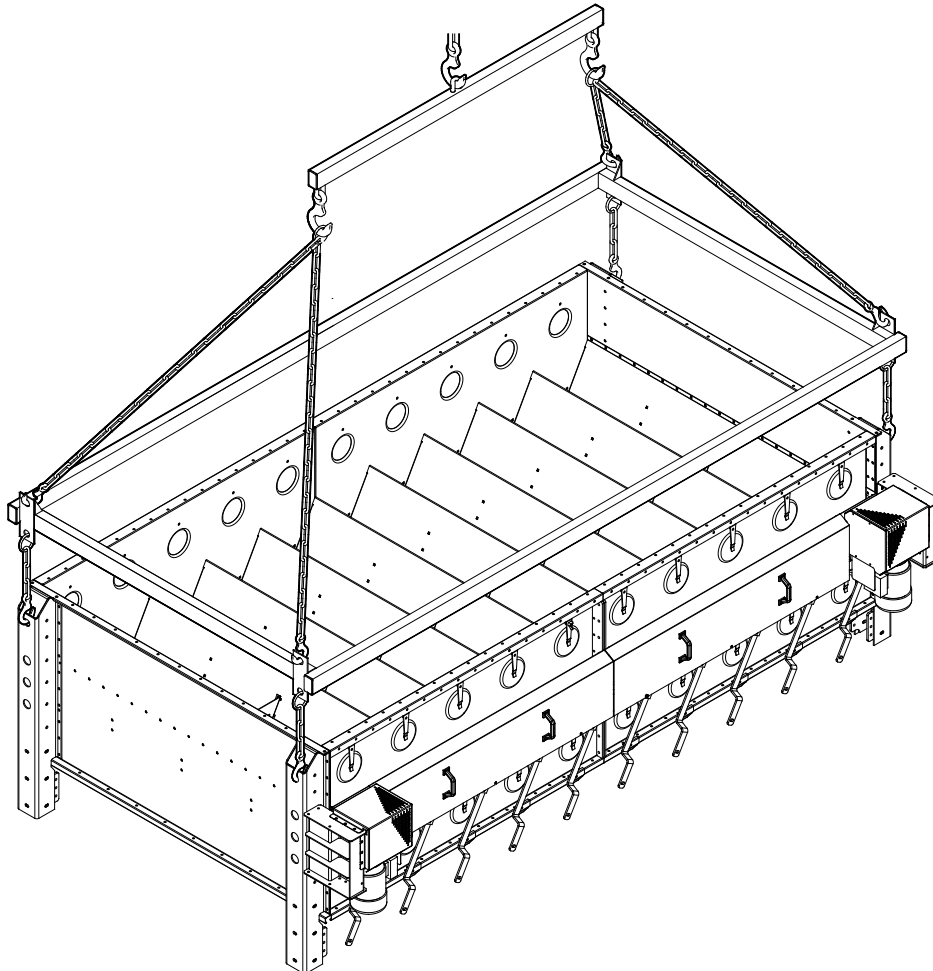
If you attach the extension legs to the floor casting using wedge anchors, note the thickness of the extension leg end-plates (12 mm) when determining the length to be cut off.

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

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

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

2.



2. Lifting the base frame of 4W

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

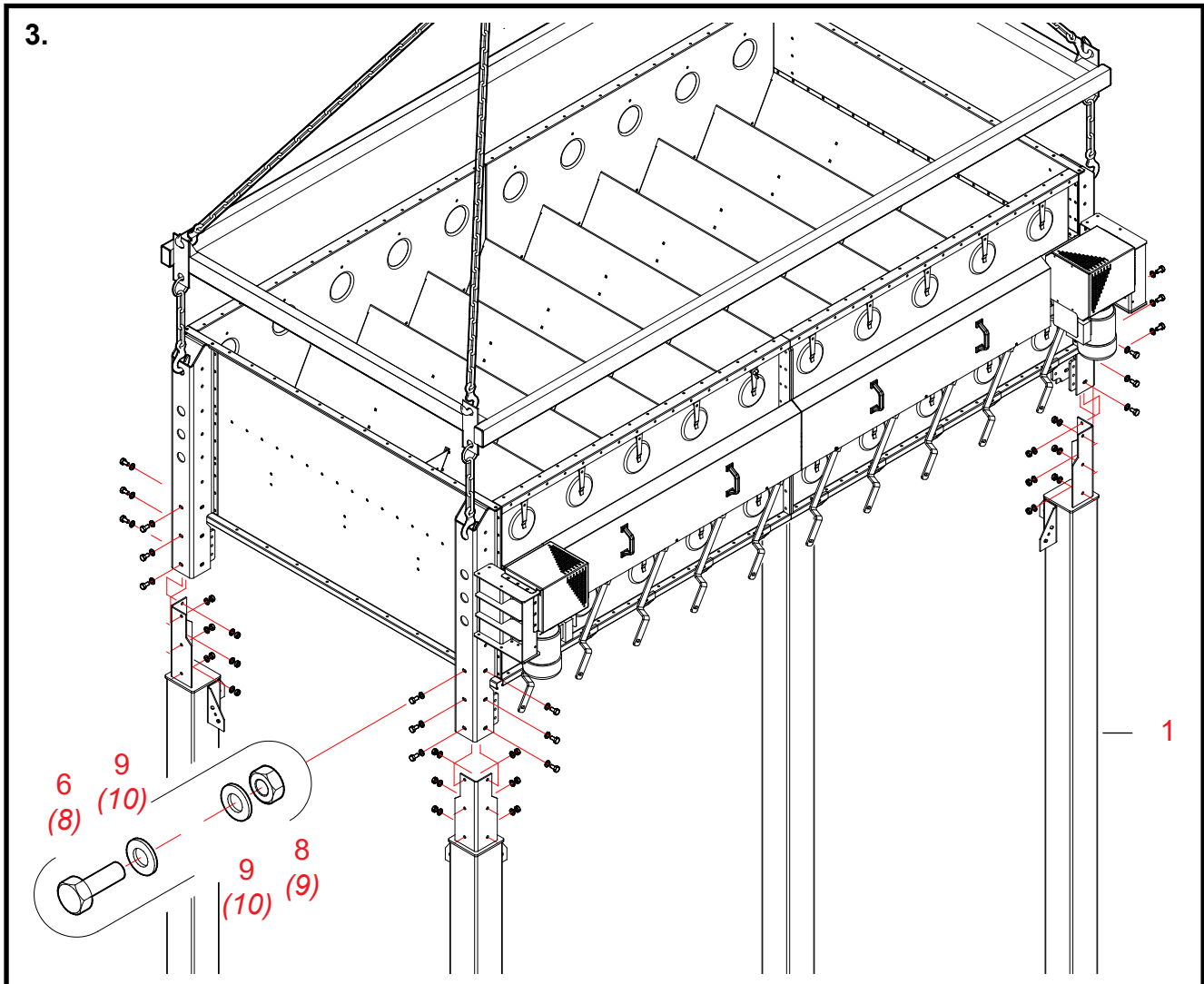
Simply tear off the plastic. Use knife, as necessary.

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 4W is about 1400 kg.



3. Installing the extension legs on 4W

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the extension legs. The reference numbers in the spare parts drawings for the double cone base are in *italics*.

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

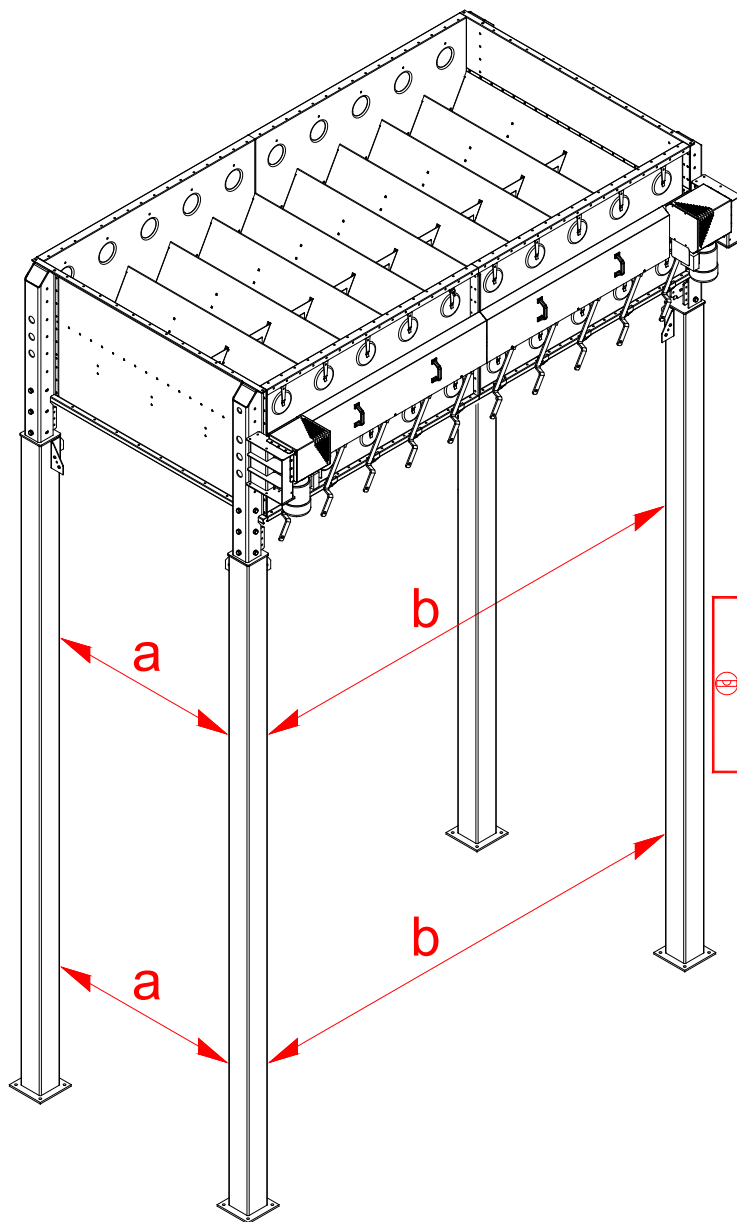
6, 8, 9 **Attach the extension legs to the base legs (bolts M12 x 35).**
(8, 9, 10)

Note!

Provide each leg with 6 bolts, washers and nuts!

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

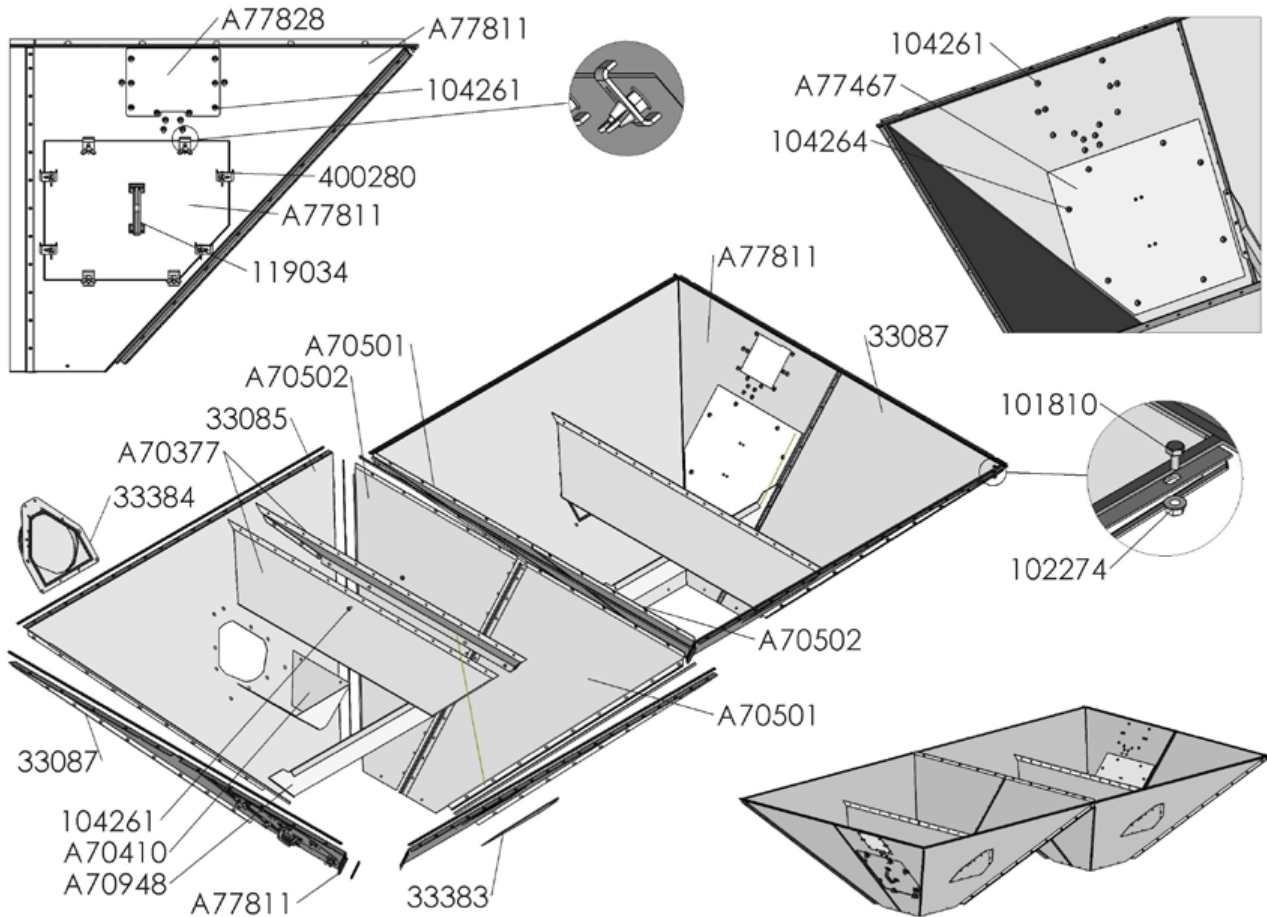
4.



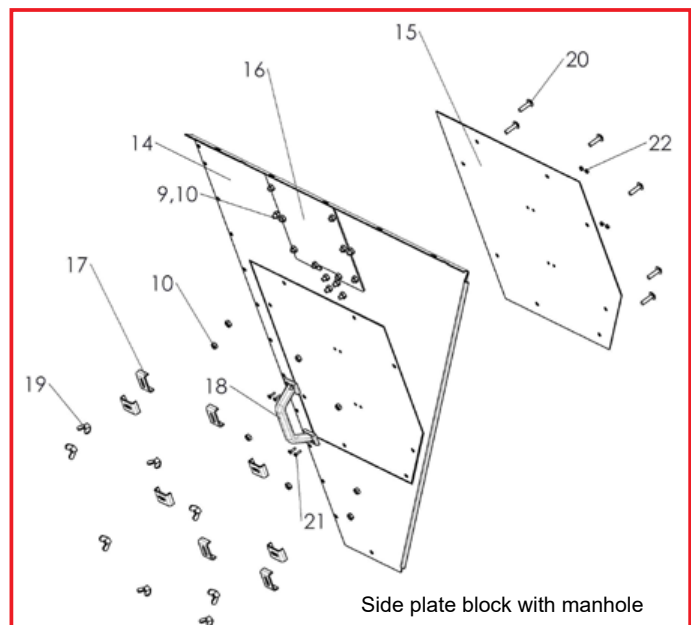
4. Checking alignment of the extension legs

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

Base cones 4WC with double base cone (A70970), spare parts



- 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.

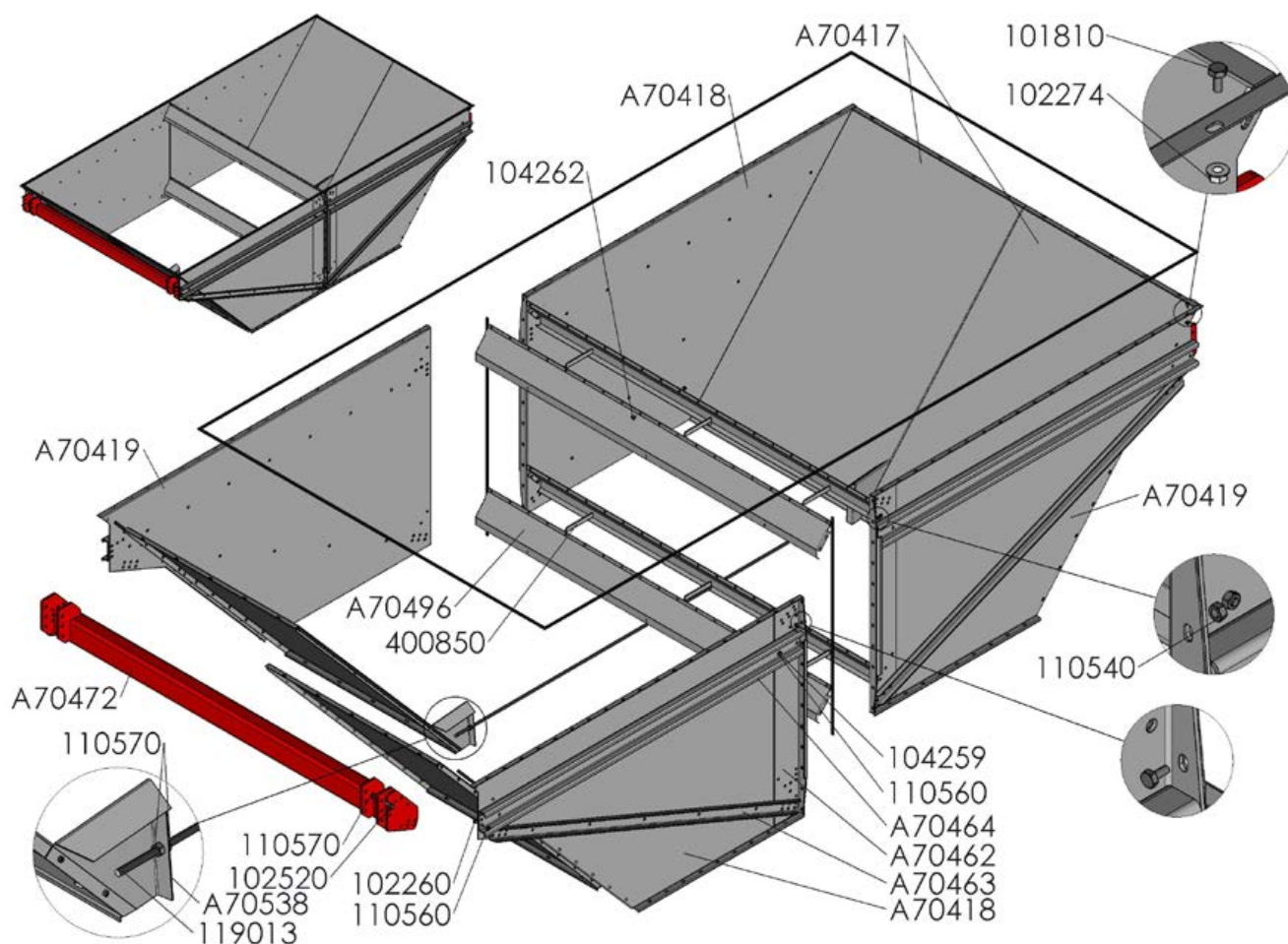




Viite	Nim.tunnus	Nim.nimi (pitkä)	kpl
1	33085	BASE CONE SIDE PLATE XL BOLT	4
2	33086	BASE CONE SIDE PLATE XL BOLT LEFT	2
3	33087	BASE CONE SIDE PLATE XL RIGHT	2
4	A70501	BASE CONE RIGHT DOUBLE 4W WM06	2
5	A70502	BASE CONE LEFT DOUBLE 4W WM06	2
6	33383	BASE CONE COVER PLATE	2
7	33384	BASE CONE SIDE PLATE XL, MEGA COVER PLATE D280	2
8	A70377	BASE INTAKE DUCT 1/2 WM06	4
9	A70410	BASE INTAKE DUCT SHUTTING PLATE WM06	2
10	104261	SCREW HEX, DOME NUT 8X16 AM ISO 7380-2	108
11	101810	BOLT HEX ZN 8.8 8X16 AM DIN933	236
12	102274	HEX FLANGE NUT M8 ZN 8 DIN 6923	360
13	115570	SEALING STRIP 4X8 EKO-40	32
14	A77811	BASE CONE SIDE PLATE WITH MANHOLE	2
15	A77467	BASE CONE BACKPLATE FOR MANHOLE	2
16	A77828	BASE CONE COVER PLATE 252x243 M25	2
17	400280	TOP SECTION COVER HOLDER	16
18	119034	HANDLE PLASTIC LIGHTGREY PISLA 805 10100550	2
19	111020	NUT WING M8 ZN DIN315	16
20	104264	SCREW HEX, DOME NUT 8X30 AM ISO 7380-2	16
21	103611	SUNK SCREW CROSS GROOVE 5 X 16 AM ZN 5X16 AM ZN	8
22	110520	NUT M5 ZN 8 DIN934	8
23	A70948	BASE CONE ADD. SUPPORT WM06 2W	2



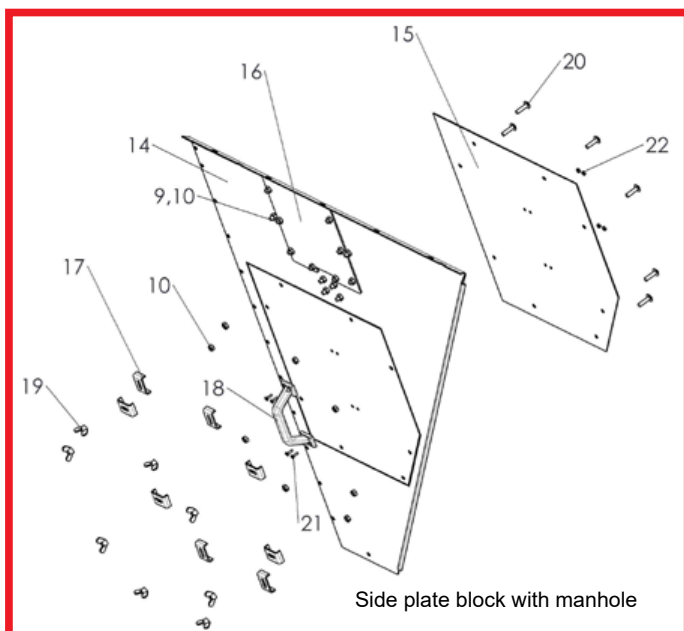
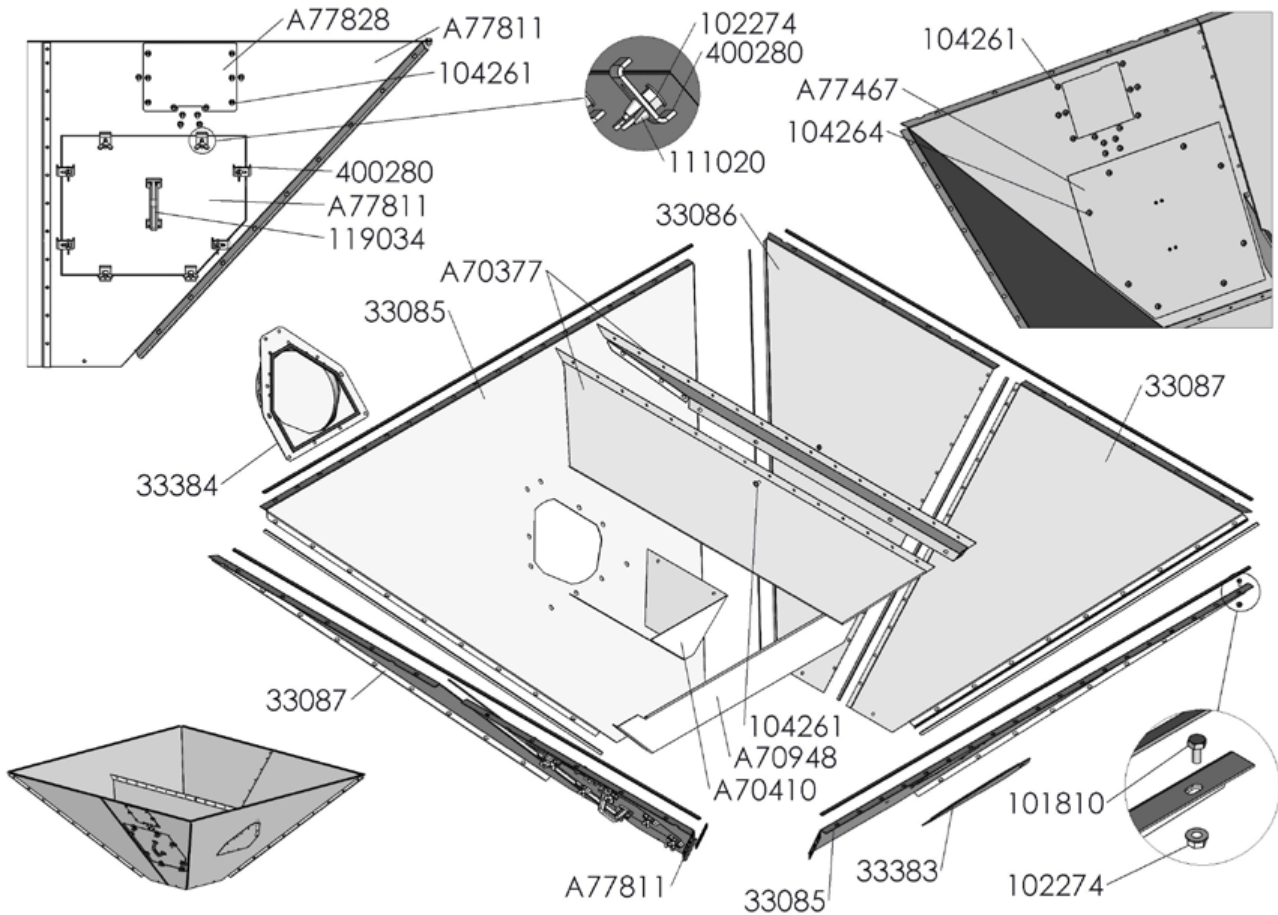
Cone extension 4W (A70436), spare parts





Ref.	Part no.	Denomination	Pcs.
1	A70418	BASE CONE, CONTINUATION RIGHT WM06 4W	2
2	A70419	BASE CONE CONTINUATION LEFT WM06 4W	2
3	A70417	BASE CONE CONTINUATION, END WM06 4W	4
4	A70538	BASE CONE CLAMP WM06 4W	2
5	A70496	BASE CONE DUCKT WM06 3W/4W	4
6	A70462	BASE VERTICAL SUPPORT BASE CONE WM06 4W	4
7	A70464	BASE UPPER SUPPORT BASE CONE WM06 4W	4
8	A70463	BASE LOWER SUPPORT BASE CONE WM06 4W	4
9	A70478	CELL CONNECTING BAR WM06 4W	2
10	119013	STUDBOLT M12X2000 MM 8.8 ZN	1
11	400850	CELL DUCKT SUPPORT WM06 3X22-153,5	6
12	102520	BOLT HEX 6K ZN 8.8 12X35 AM DIN933	24
13	110570	NUT M12 ZN8 DIN934	28
14	102260	BOLT HEX 6K ZN 8.8 10X45 AM DIM933	44
15	104259	SCREW HEX, DOME NUT ZN 10.9 10X20 AM ISO 7380-1	92
16	110560	NUT M10 ZN 8 DIN934	136
17	101810	BOLT HEX ZN 8.8 8X16 AM DIN933	196
18	102274	HEX FLANGE NUT M8 ZN 8 DIN 6923	234
19	104262	SCREW HEX, DOME NUT 8X12 AM ISO 7380-2	38
20	111532	BODY WASHER ZN M 8 DIN9021	80
21	115570	SEALING STRIP 4X8 EKO-40	21

Base cone 4W (A70374), spare parts



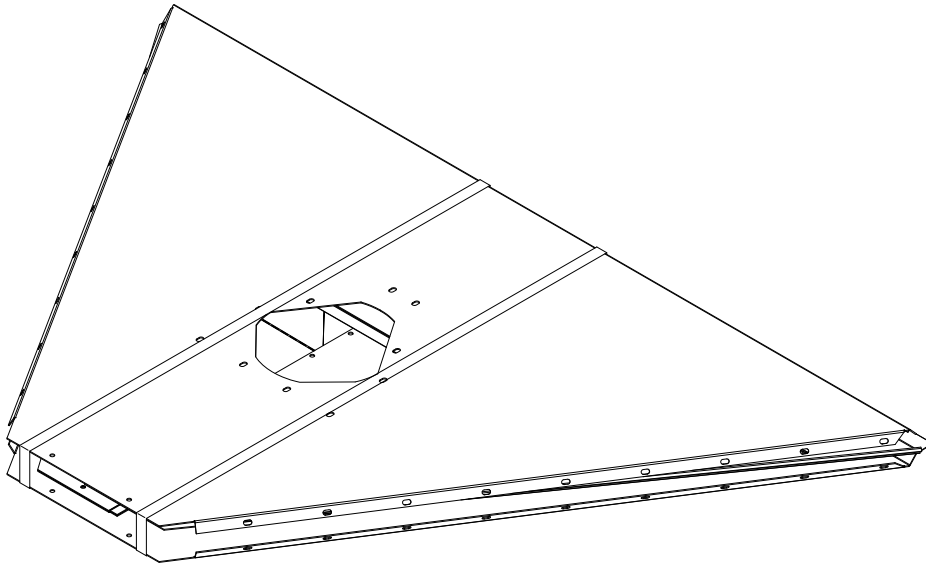
- Side plate block with manhole fits part 2 to the same points.
- The location of the manhole is always chosen on a case-by-case basis.
- If the grain dryer will be fitted with moisture measurement related sampler, so read also the sampler installation instructions before assembling the bottom cone.



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



Structure of the base cone 4W



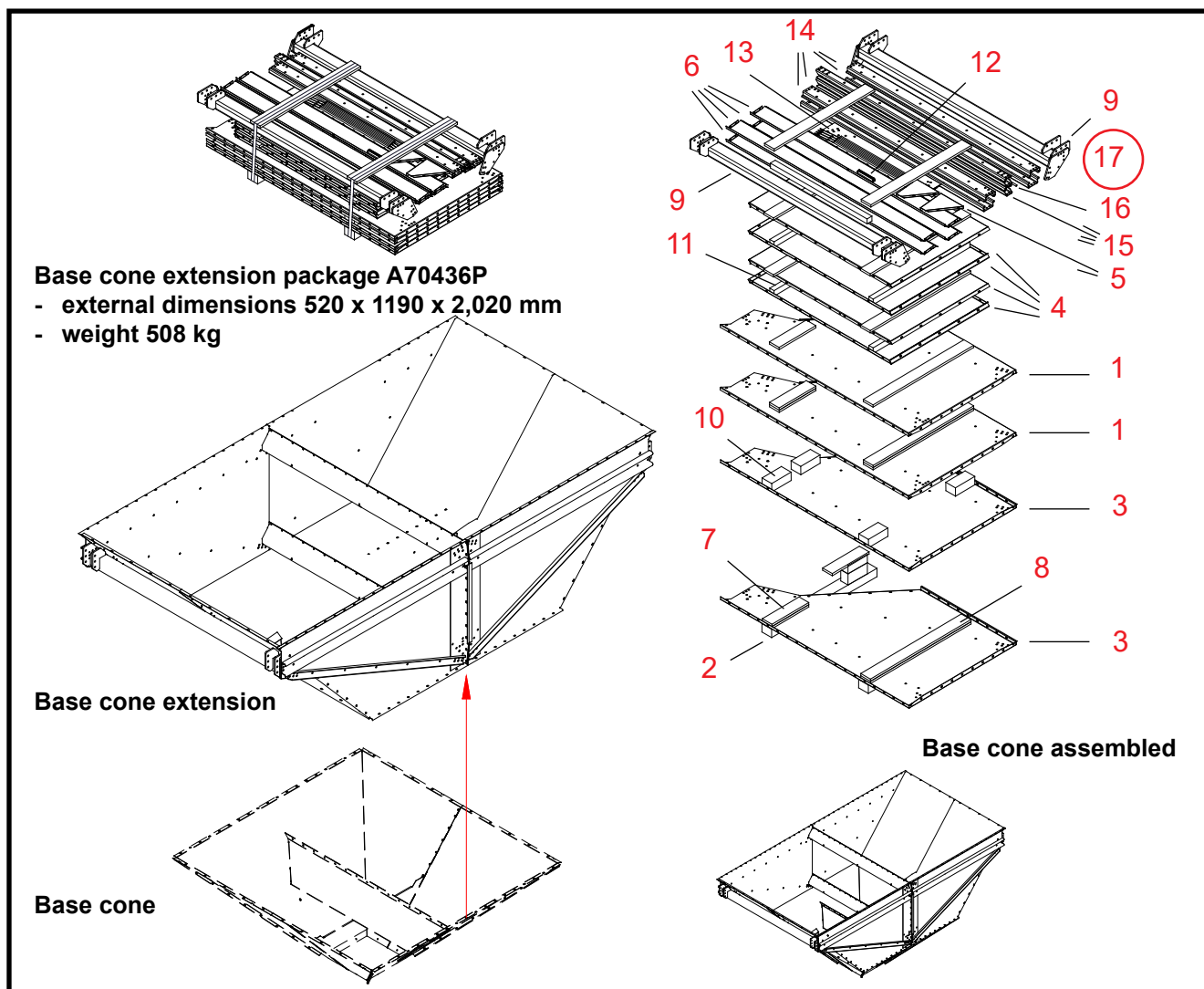
Base cone package A70374P

- external dimensions 180 x 1240 x 1985 mm
- weight 132 kg



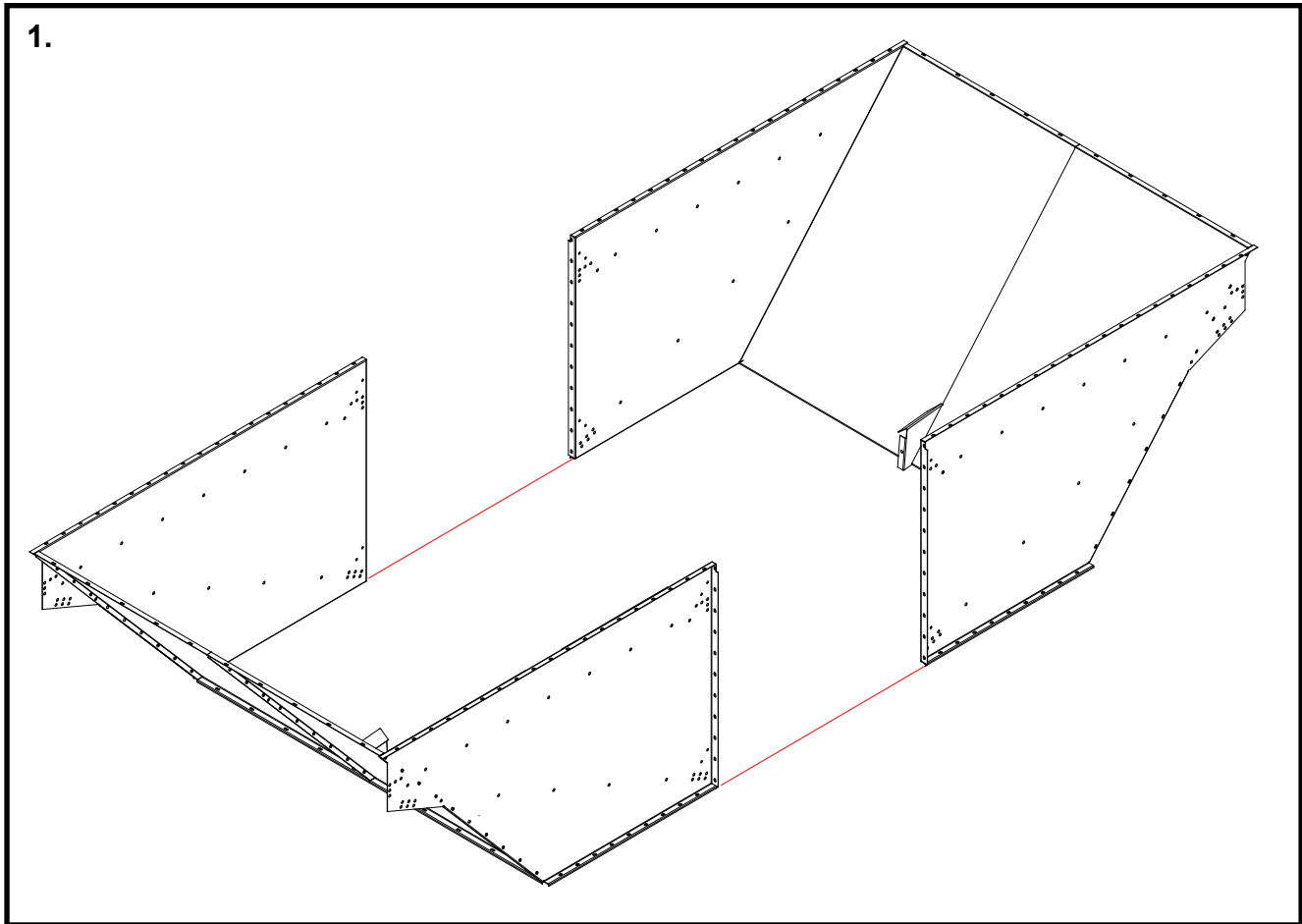
Base

Antti WM06



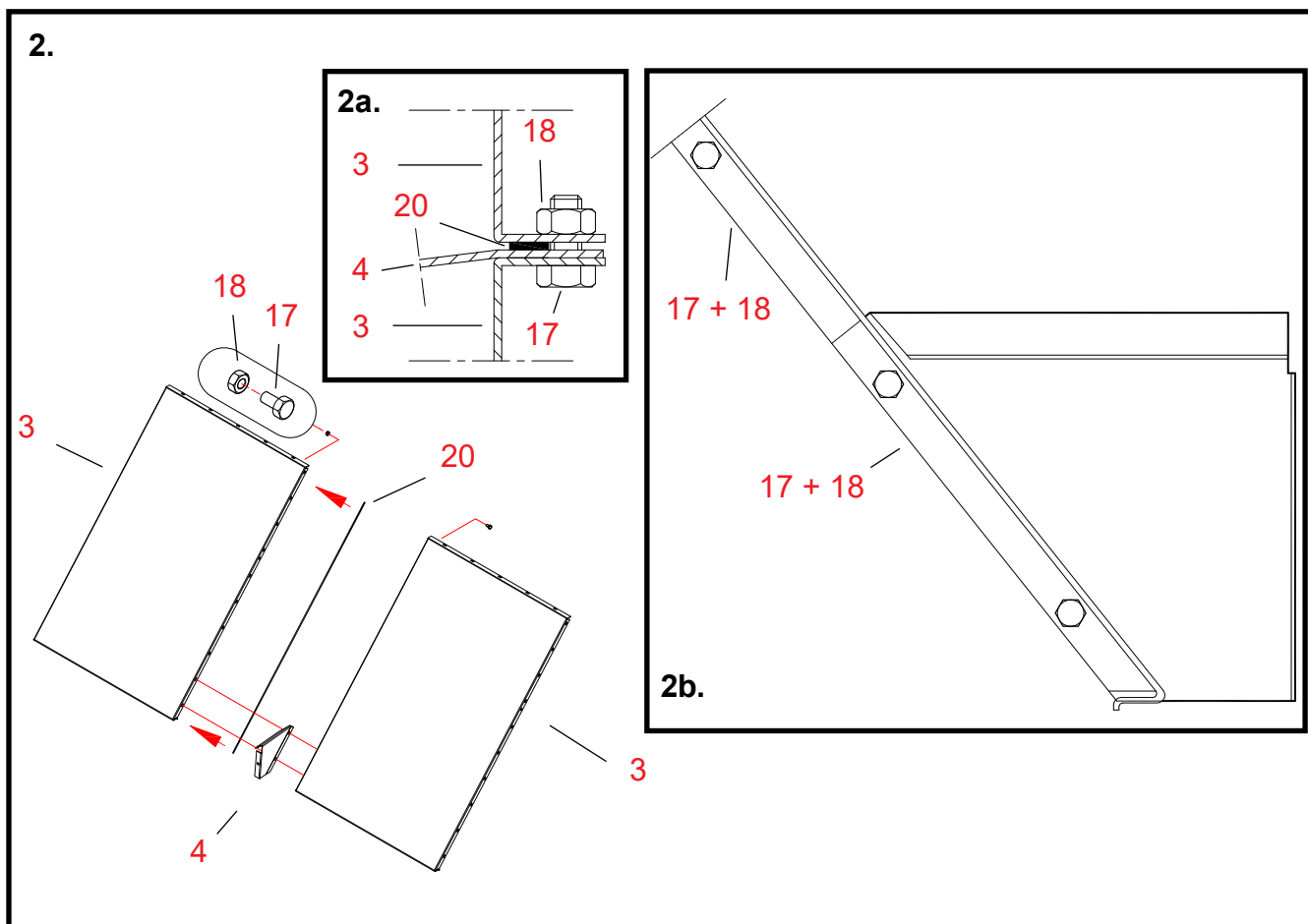
20060601

Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	A70418	BASE WM06 BASE CONE EXT RIGHT 4W	2	A70418-A	28	3000
2	315448	BATTEN L=1090 75x100	2		0	2800
3	A70419	BASE WM06 BASE CONE EXT LEFT 4W	2	A70419-A	28	3000
4	A70417	BASE M06W BASE CONE EXT END 4W	4	A70417	25.17	3000
5	A70538	BASE M06W NTERM SUPP BEARER 4W	2	A70538	0.83	3000
6	A70496	BASE M06W CONE DUCT 3W/4W	4	A70496-A	11.48	3000
7	315409	BOARD L=380 22x100	6		0	2800
8	315411	BOARD L=1040 22x100	11		0	2800
9	A70478	BASE M06W CONNECT BEAM 4W	2	A70478	53.9	3000
10	315405	BATTEN L=200 75x100	6		0	2800
11	315443	BATTEN L=1000 44x50	5		0	2800
12	400850	SECT INTERM SUPP 3X22-153.5	6	A70498	0	3000
13	A70462	BASE WM06 VERT BASE CONE SUPP 4W	4	A70462-A	6.93	3000
14	A70464	BASE M06W UPPER BASE CONE SUPP 4W	4	A70464-A	11.43	3000
15	A70463	BASE M06W LOWER BASE CONE SUPP 4W	4	A70463	6.49	3000
16	119013	THREADED ROD ZN - M12x2000 MM 8.8	1		0	2000
17	A70921	BASE CONE 4W BOLT PACK 9994200047	1	A70921-A	8.94	2010

Base cone extension assembled 4W**1. Base cone extension assembled in sections**

The instructions explain, how to assemble the extension base cone in two different sections, which can be lifted against the dryer base one by one.

The sections are identical.



2. Assembling the base cone extension end

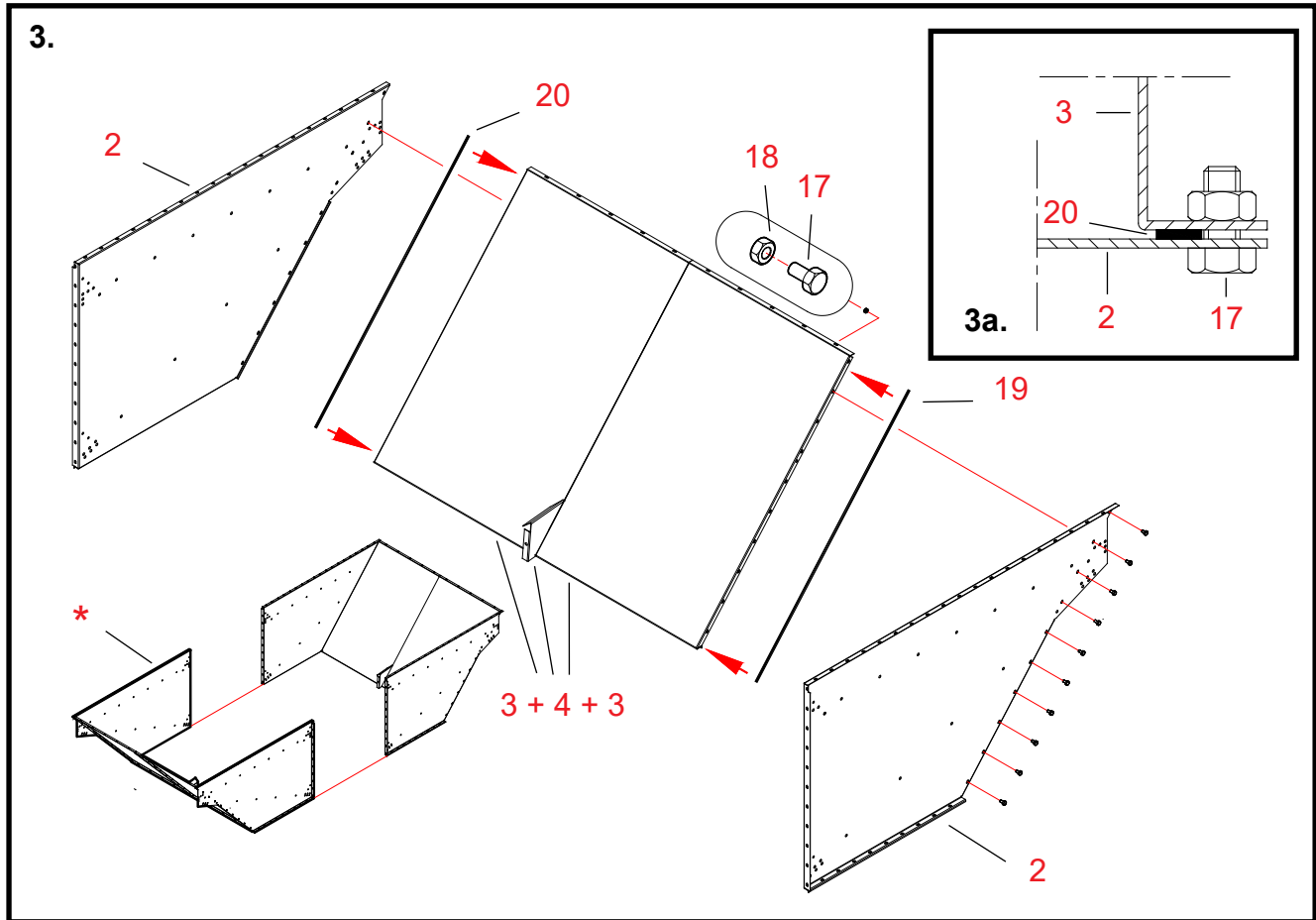
Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the base cone extension of 4W.

20 **Fix a sealing strip to one of the long flanges of one of the end-plates (part 3).**
Fix the sealing strip inside the bolthole row in the plate (see drawing 2a).

3 + 3 **Place the long flanges of the end-plates face to face.**

4 **Place the intermediate support bearer between the end-plates.**
Fix the bearer to the first and second bolt holes from the bottom. See dwg. 2b.

17, 18 **Fix the seam using bolts and nuts (M8 x 16, 10 pcs.).**



3. Assembling the sections of the base cone extension

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the base cone extension of 4W.

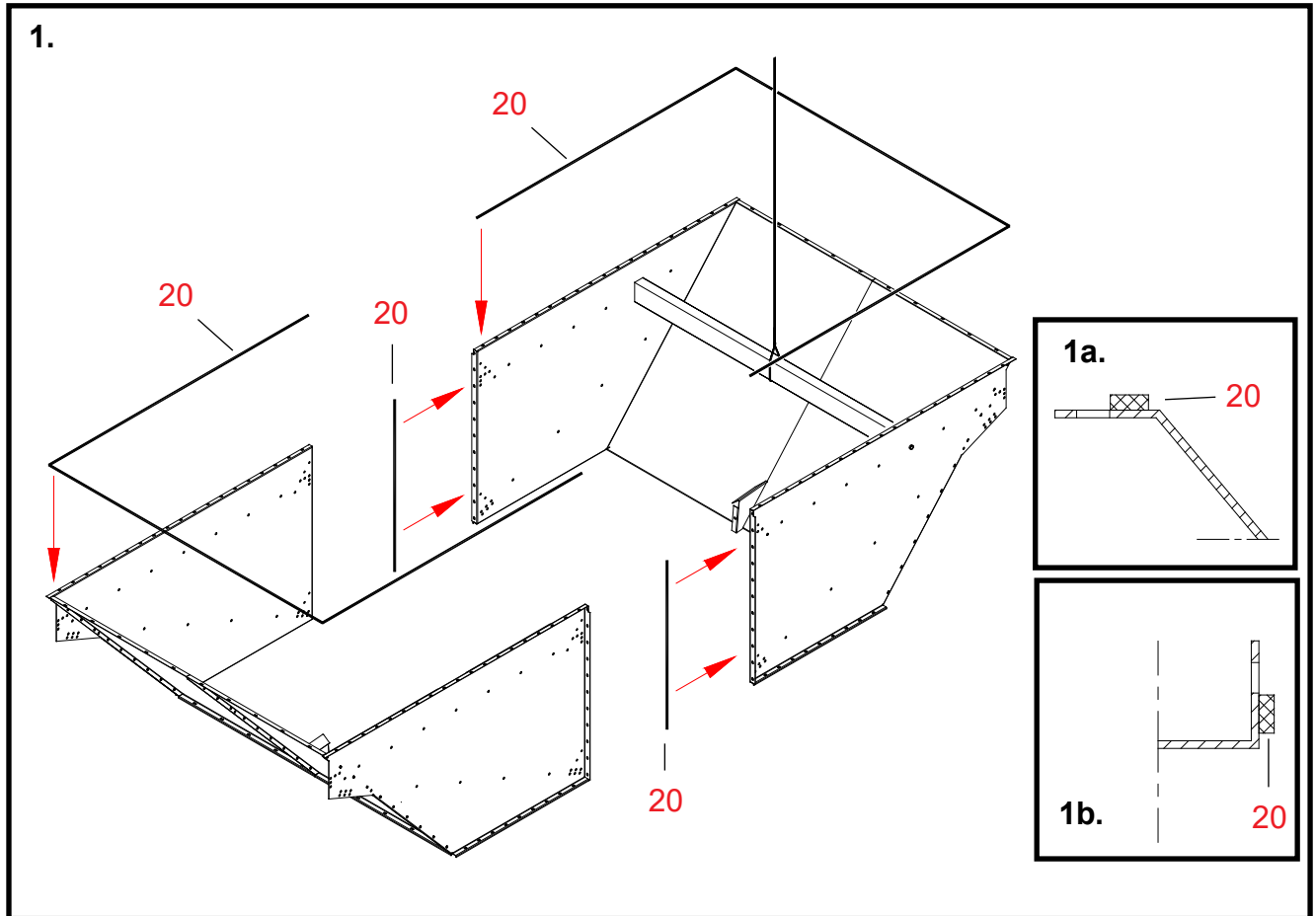
20 **Fix sealing strips to the end-flanges of the end-plates (parts 3).**
Fix the sealing strip inside the bolthole rows in the plates (see Fig. 3a).

2 + 2 **Align the holes in the side-plates with the holes in the flanges of the just assembled end-plate.**

17, 18 **Fix the seams using bolts and nuts (M8 x 16, 10 + 10 pcs.).**

***** **Assemble one more similar section of base cone extension.**

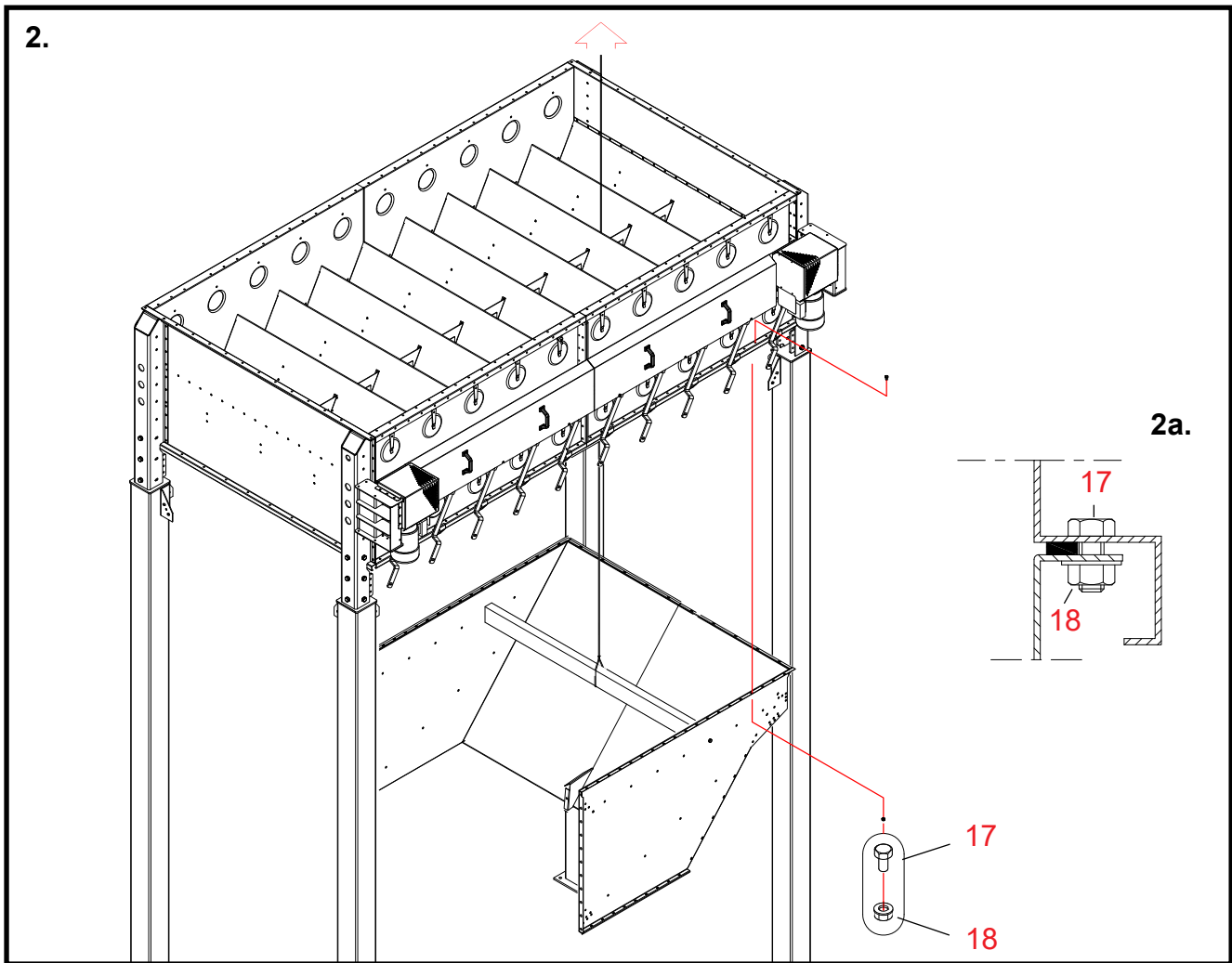
Installing base cone extension 4W



1. Preparing the sections of base cone extension for lifting and fixing the sealings

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the base cone extension of 4W.

- * **Place a batten, for example 50 x 100, inside the section to be lifted first.**
Length of the batten = internal width of the section.
Attach the batten for lifting by its ends to the pre-drilled holes in the sides of the section using coach screws.
Select the attachment point for the batten so that the section will keep its balance as well as possible.
- * **Fix the wire rope for lifting of the section to the centre of the batten.**
- 20** **Fix sealing strips to flanges on the upper surface of both sections.**
Fix the sealing strip inside the bolthole row in the flange (see drawing 1a).
- 20** **Fix sealing strips to the flanges at the centre-seam of the section to be lifted first.**
Fix the sealing strips inside the screw hole rows in the flanges (see Fig. 1b).



2. Lifting and fixing in place of the first section of base cone extension

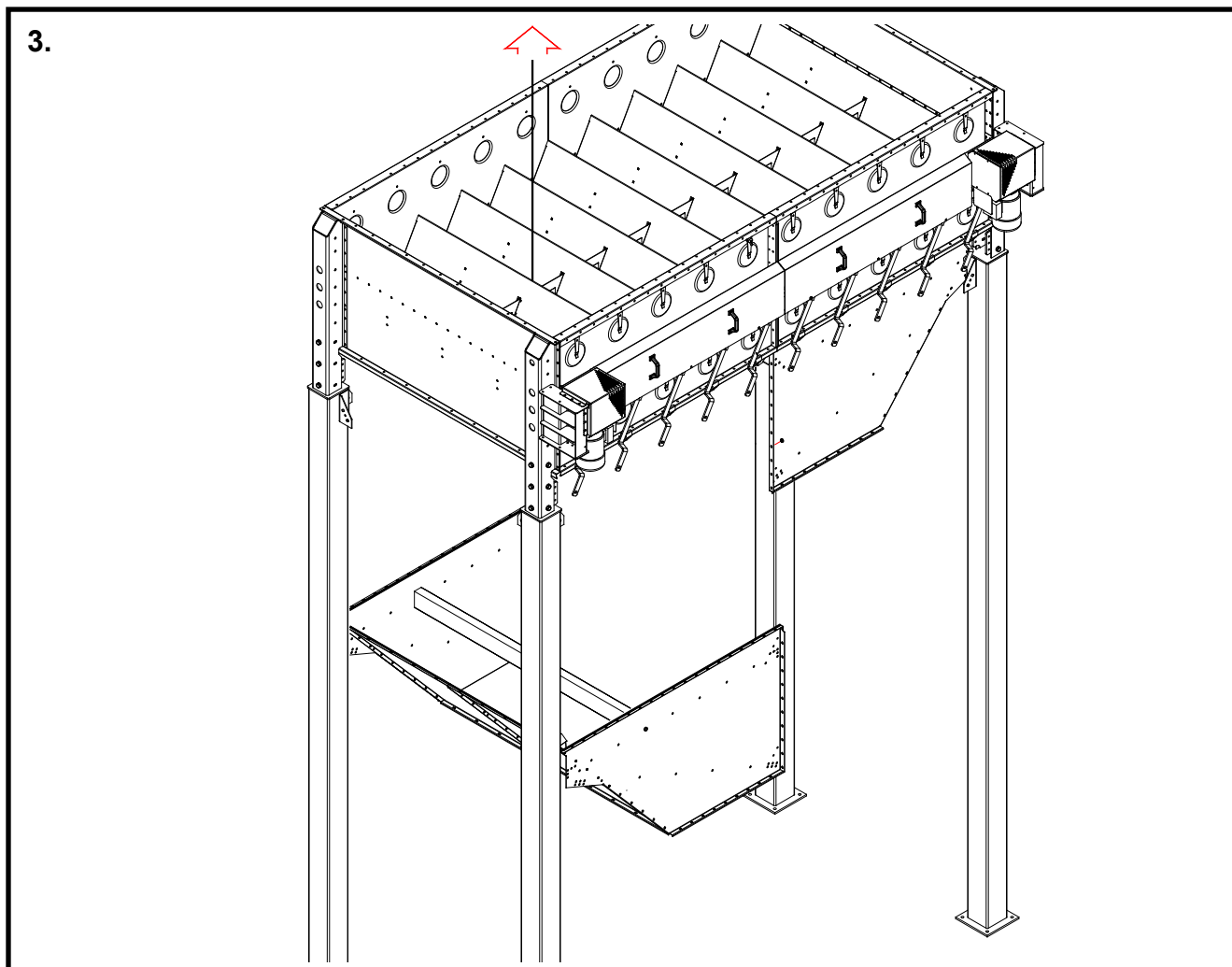
Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the base cone extension of 4W.

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

- * **Move the section of base cone extension under the base.**
- * **Lift the section using the wire rope threaded in between the air ducts in the base.**
- * **Thread in the cone carefully between the lugs in the extension legs.**
- * **Lift the section of base cone extension tight against the bottom surface of the base.**

17, 18 **Attach it using bolts and flange nuts (M8 x 16, 48 pcs.).**
See dwg. 2a.

- * **Remove the batten used for lifting and the coach screws from the section.**



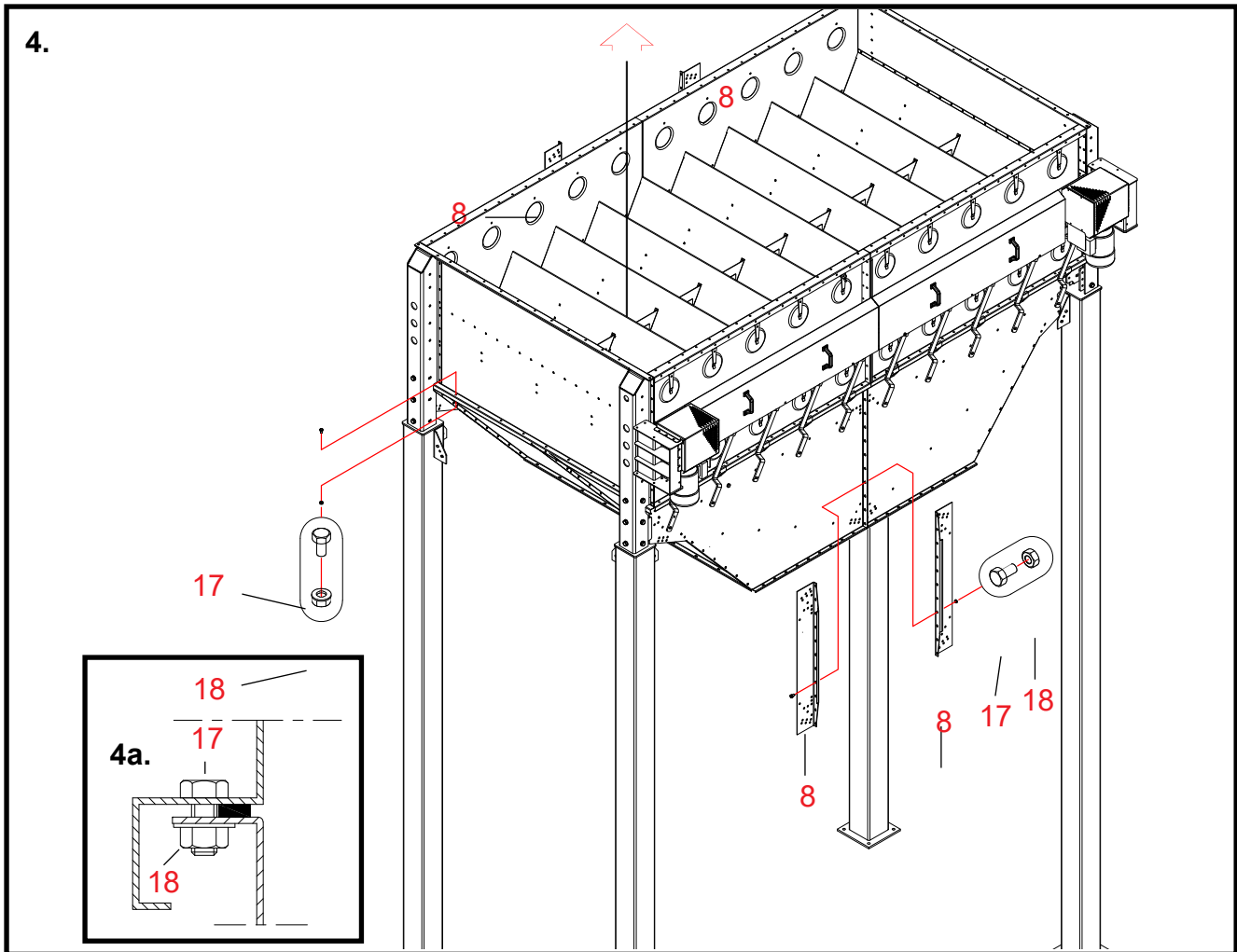
3. Lifting the other section of base cone extension

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the base cone extension of 4W.

- * **Place the batten, which was used for lifting the first section, inside the other section.**
- * **Fix the wire rope for lifting of the section to the centre of the batten.**
- * **Move the section of base cone extension under the base.**
- * **Lift the section using the wire rope threaded in between the air ducts in the base.**
- * **Thread the section carefully between the lugs in the extension legs close to the other section.**

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

- * **Lift the section of base cone extension tight against the bottom surface of the base.**



4. Fixing the other section of base cone extension

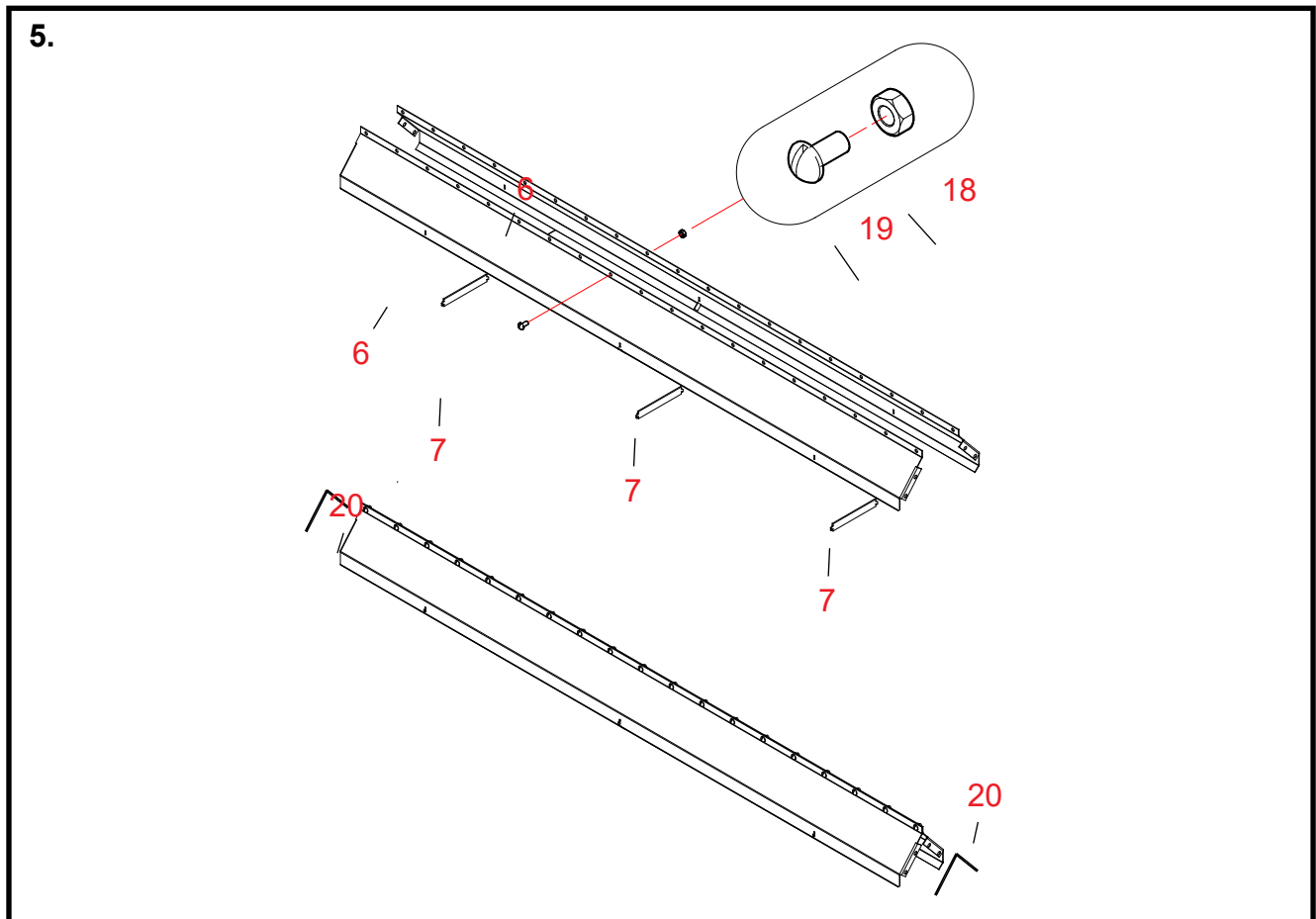
Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the base cone extension of 4W.

17, 18 **Attach the block to the base using bolts and flange nuts (M8 x 16, 48 pcs.).**
See dwg. 4a.

8 **Place vertical supports on both sides of the vertical seam between the sections of base cone extension.**

17, 18 **Fix the vertical supports and the seam of the sections using bolts and nuts (M8 x 16, 2 x 11 pcs.).**

Remove the batten used for lifting and the coach screws from the extension cone.



5. Assembling the air ducts for the base cone extension

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the base cone extension of 4W.

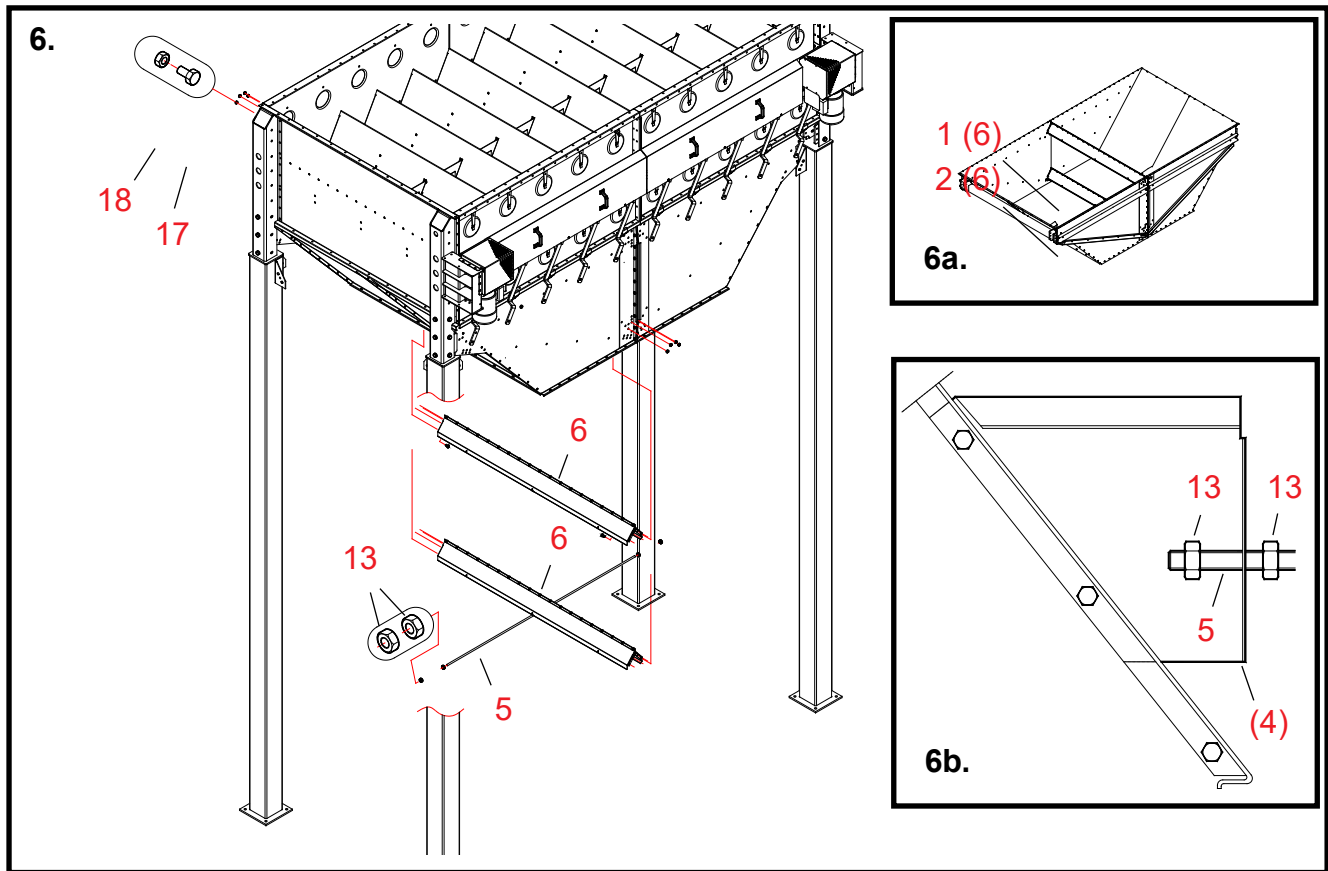
6 **Place the air duct halves for the base cone face to face.**
Make sure that the end flanges of the air duct do not "indent".

18, 19 **Join the halves together using ball-headed bolts and nuts (M8 x 10, 19 pcs./air duct).**

***** **Assemble one more similar air duct for the base cone.**

7 **Place three intermediate supports inside both air ducts.**

20 **Fix sealing strips to the end flanges of the air ducts.**

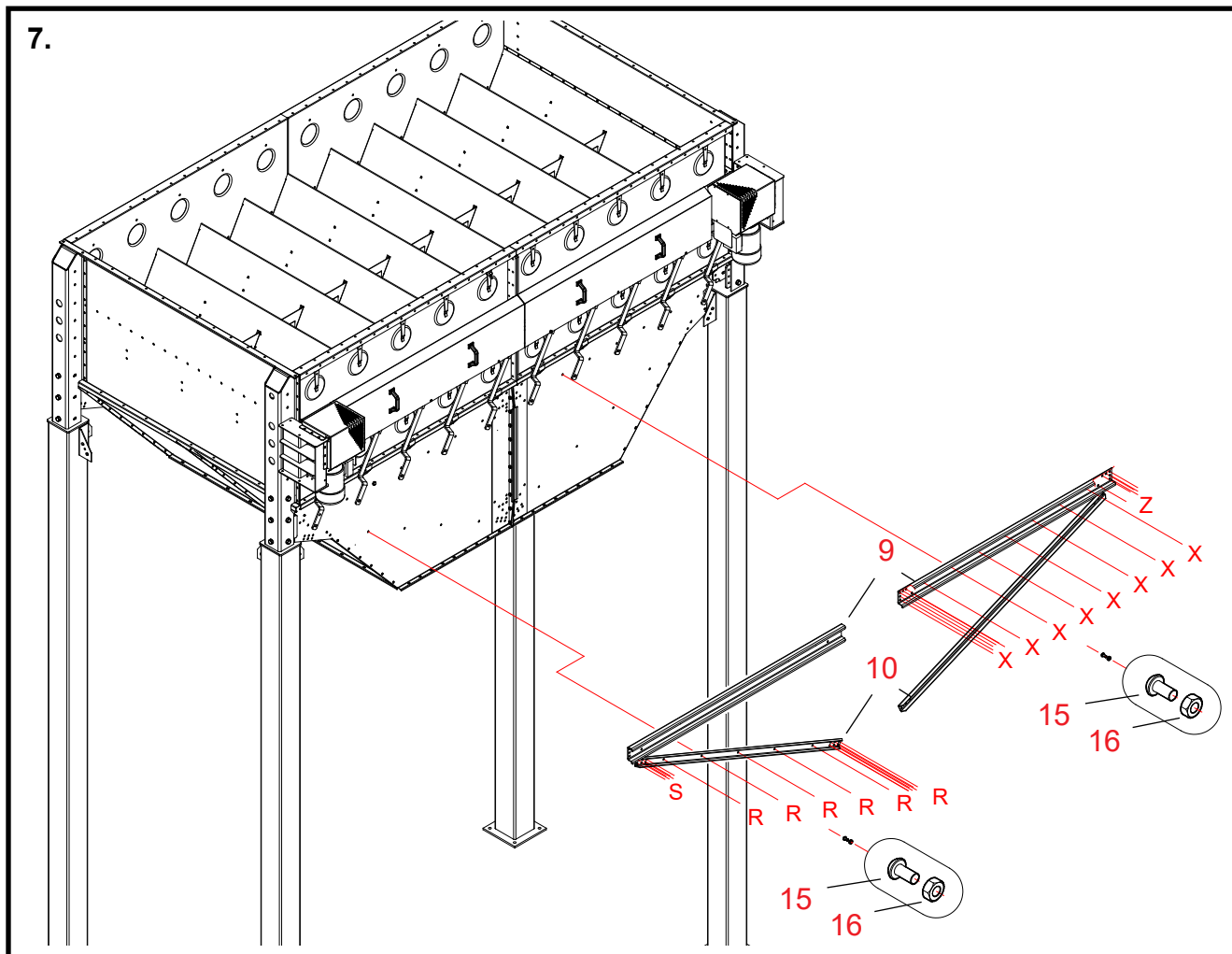


6. Installing air ducts and intermediate support for the base cone extension

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the base cone extension of 4W.

Be careful not to damage the sealing strips while installing the air ducts.

- 6** Thread the upper air duct into its place inside the cone (see Fig. 6a, part 1).
- 17, 18** Fix the air duct by its end-flanges using bolts and nuts (M8 x 16, 4 + 4 pcs.).
- 6** Install the lower air duct in the same way as you installed the upper one (see Fig. 6a, part 2).
- 5** Thread the threaded rod through the holes at the lower edge of the lower air duct.
- 13** Turn a nut (M12) onto the threads at both ends of the threaded rod.
- 5** Insert the threaded rod in the brackets (parts 4) in the base cone extension (see Fig. 6b).
- 13** Thread another nut onto both ends of the rod outside the bearers.
- *** **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.



7. Installing the intermediate supports for the base cone extension

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the base cone extension of 4W.

9 Place the upper supports in a horizontal position on both sides of the extension cone close to its upper edge.

All upper supports are identical.

15, 16 Fix the upper supports using bolts and nuts.

Insert ball-headed bolts in the holes marked X in the drawing (M10 x 20, 13 pcs./support).

Do not install the 6 bolts, marked Z in the drawing, at this stage yet.

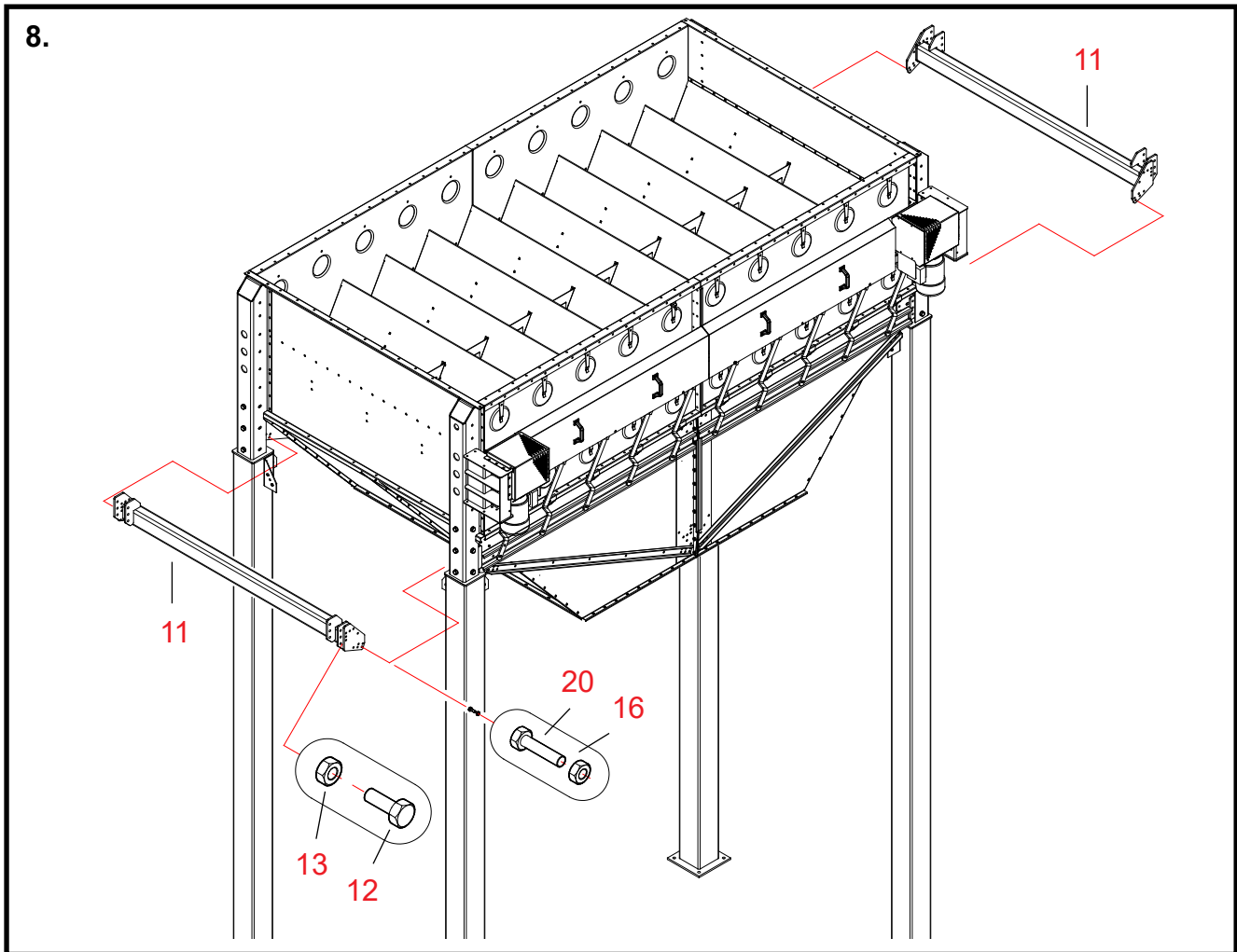
10 Place the lower supports on both sides of the extension cone from the centre at the bottom obliquely upwards.

All lower supports are identical.

15, 16 Fix the lower supports using bolts and nuts.

Insert ball-headed bolts in the holes marked R in the drawing (M10 x 20, 11 pcs./support).

Do not install the 5 bolts, marked S in the drawing, at this stage yet.



8. Installing the connecting beams for the base cone extension

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the base cone extension of 4W.

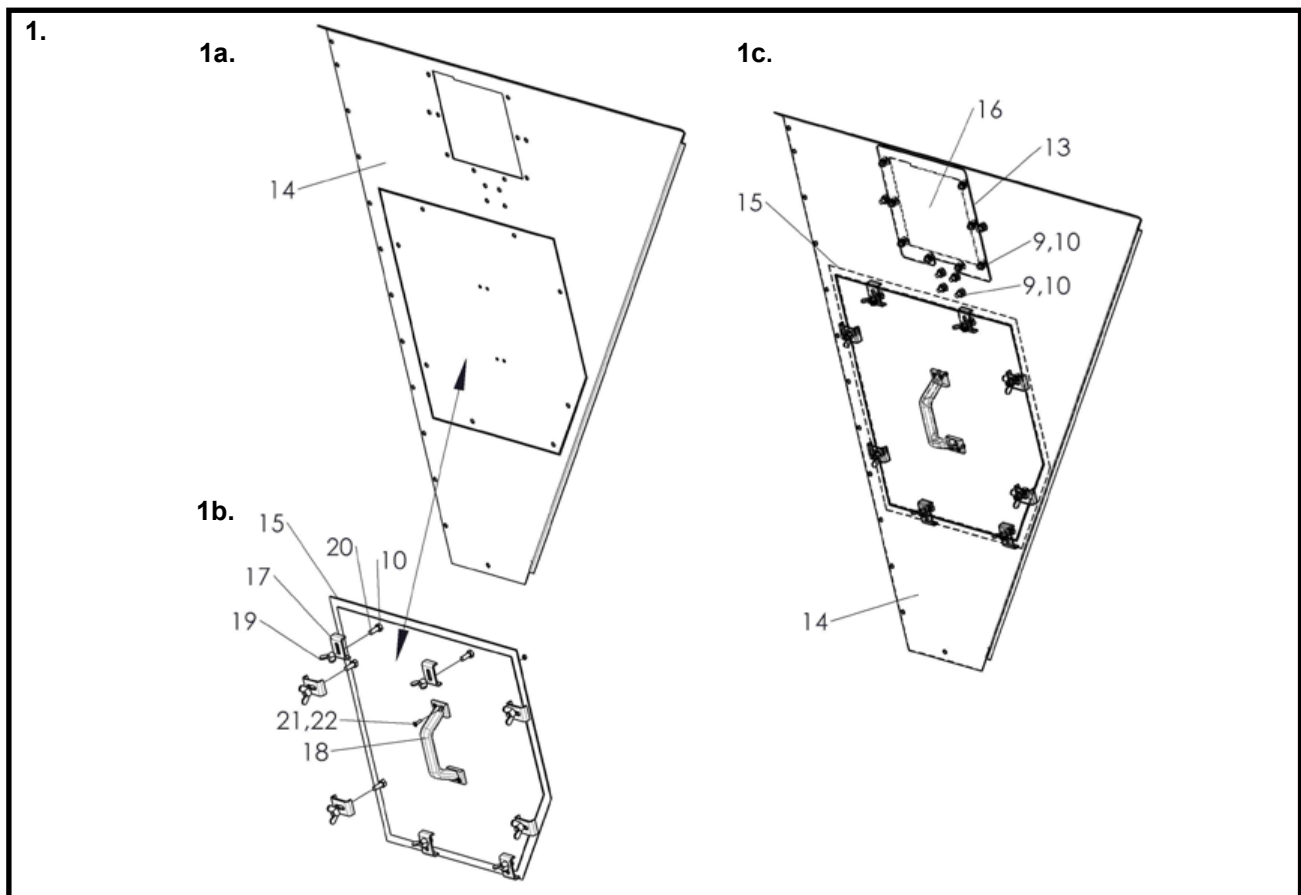
11 Place the first connecting beam between the lugs in the base legs.
All connecting beams are identical.

14, 16 Fix the connecting beam to the base cone extension using bolts and nuts (M10 x 45, 11 + 11 pcs.).

12, 13 Fix the connecting beam to the lugs in the base using bolts and nuts (M12 x 35, 12 pcs.).

11 Install the other beam in the same way.

Assembling the base cone 4W



1. Side plate block with manhole; assembly instruction

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

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

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

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

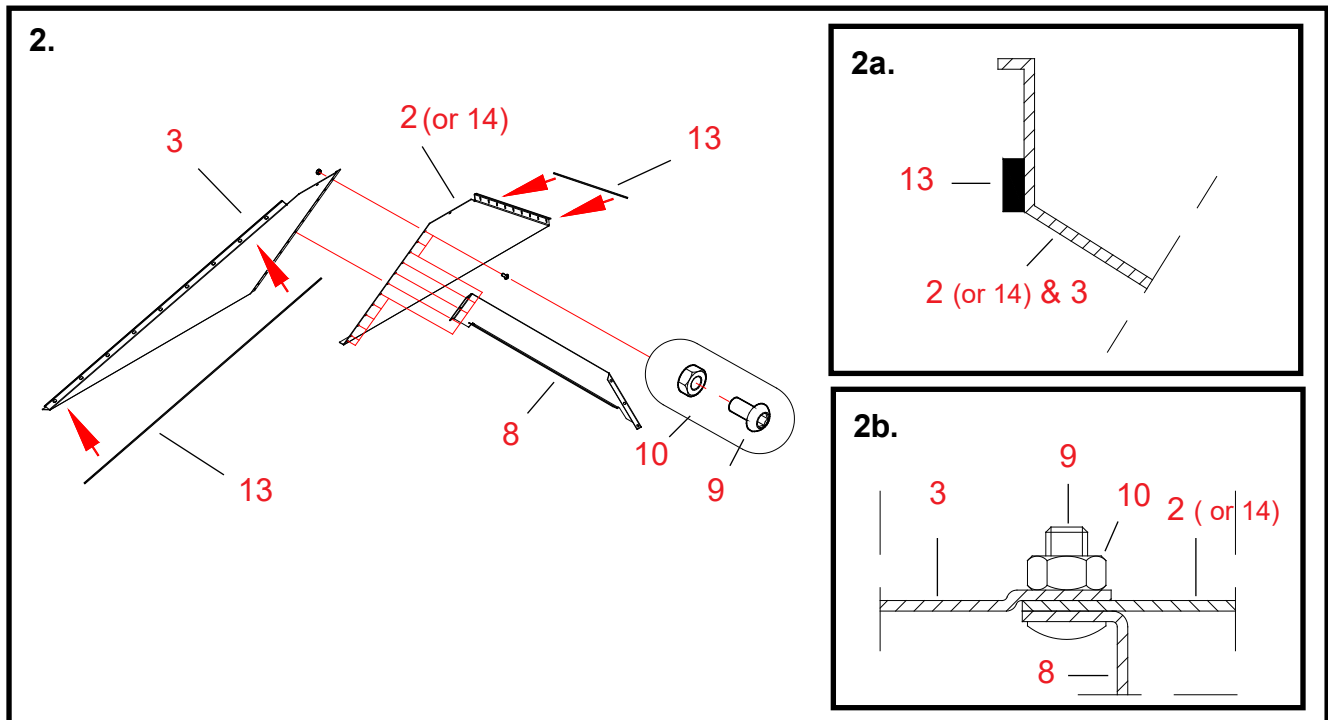
18 **Connect the handle with screws and nuts (M5x16; 4pcs). as shown in figure 1b.**

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

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

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

Assembling base cone 4W



. 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.**

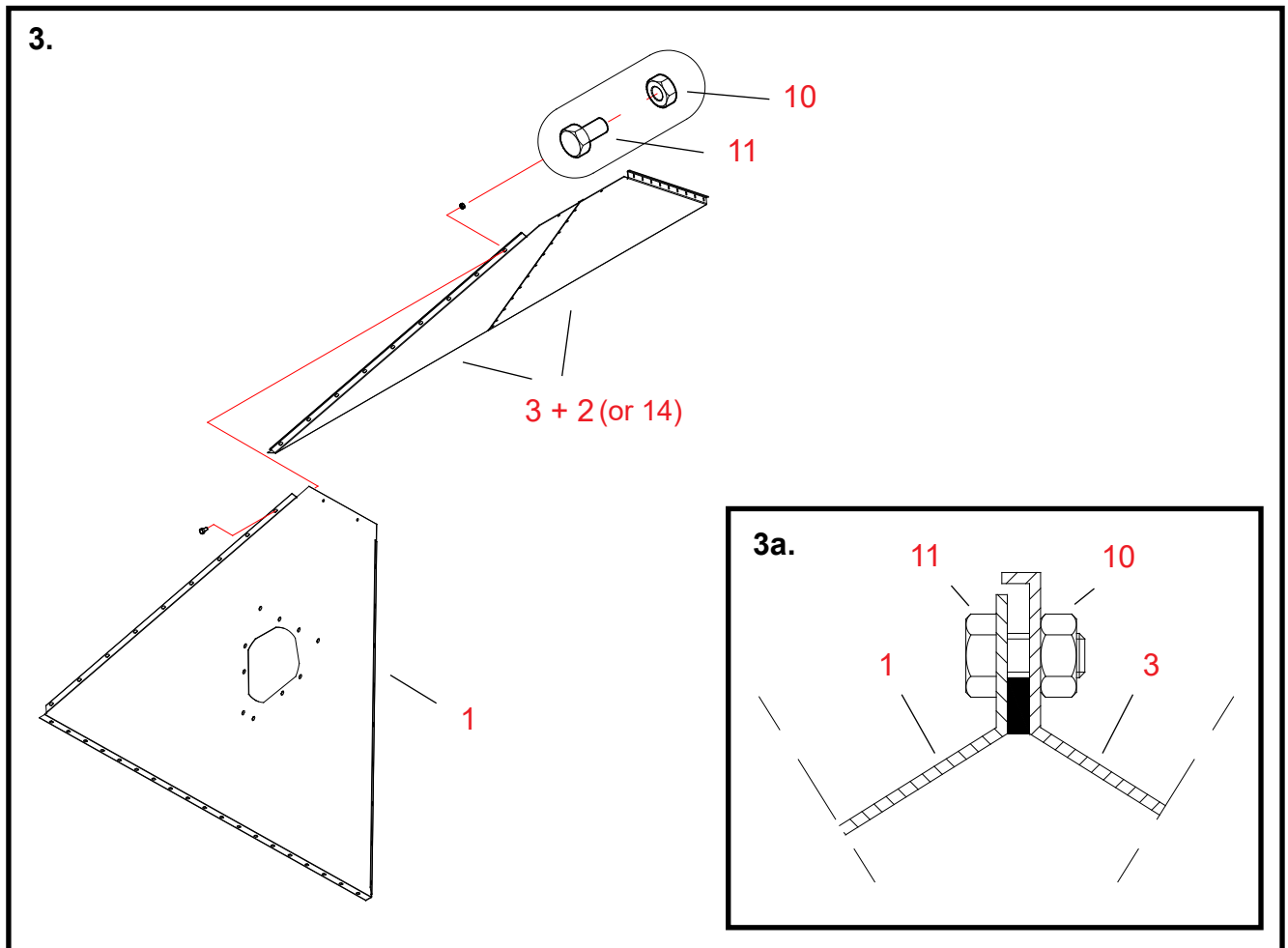
Look up the correct position and attachment point for the support in the drawing.

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.**

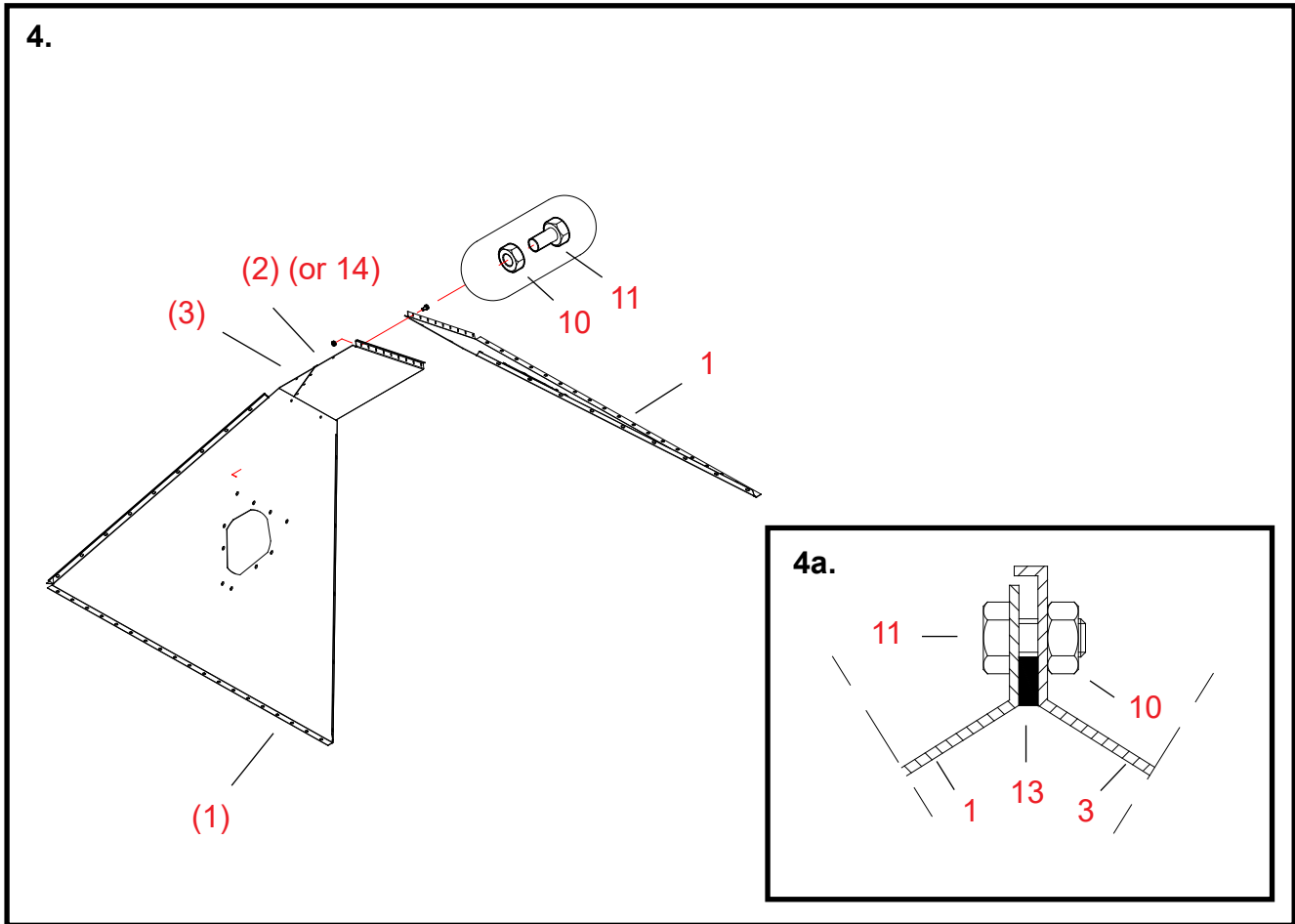
Carefully align the corner joint between the plates.

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.



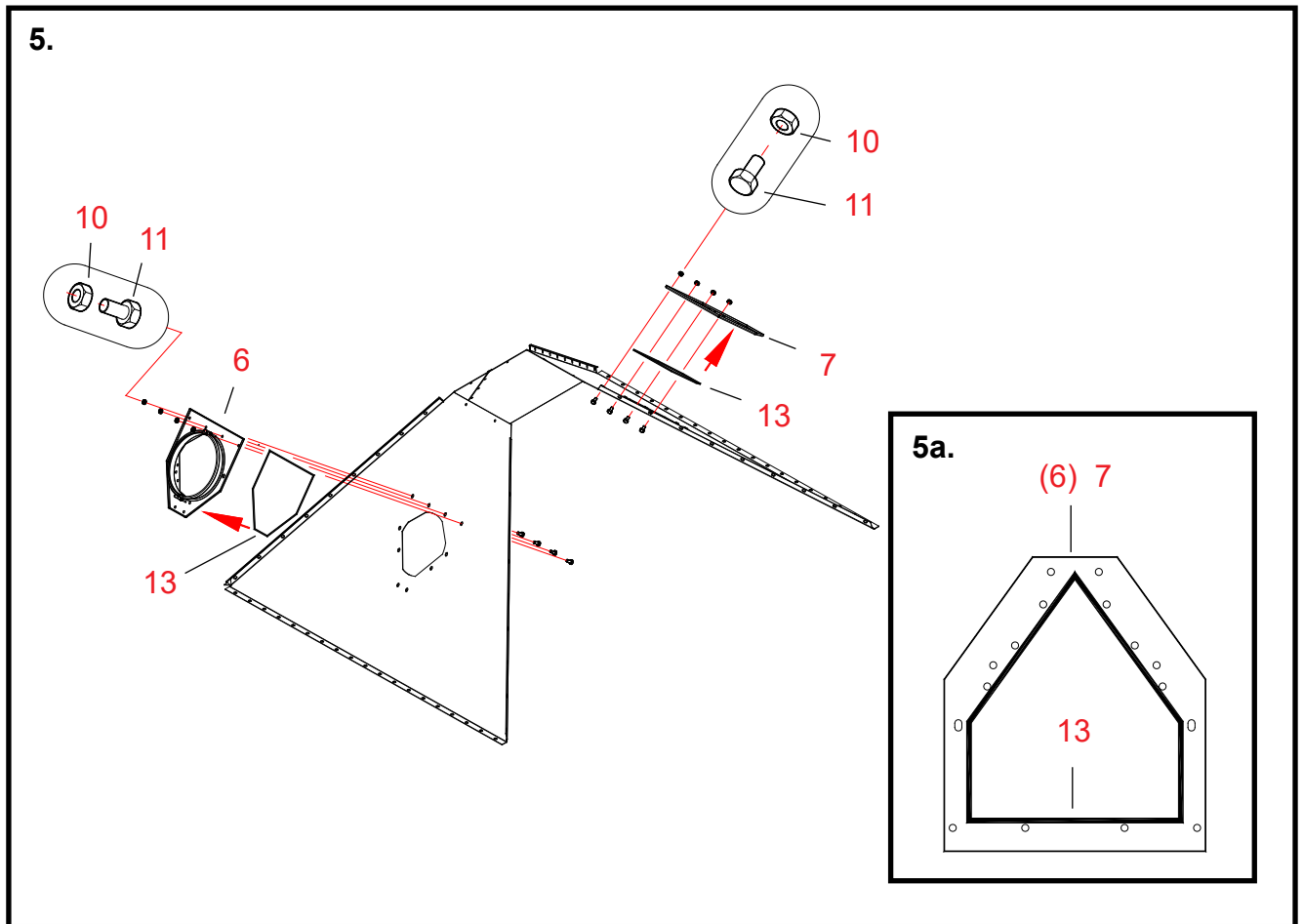
4. Fixing the fourth side-plate for the base cone

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.

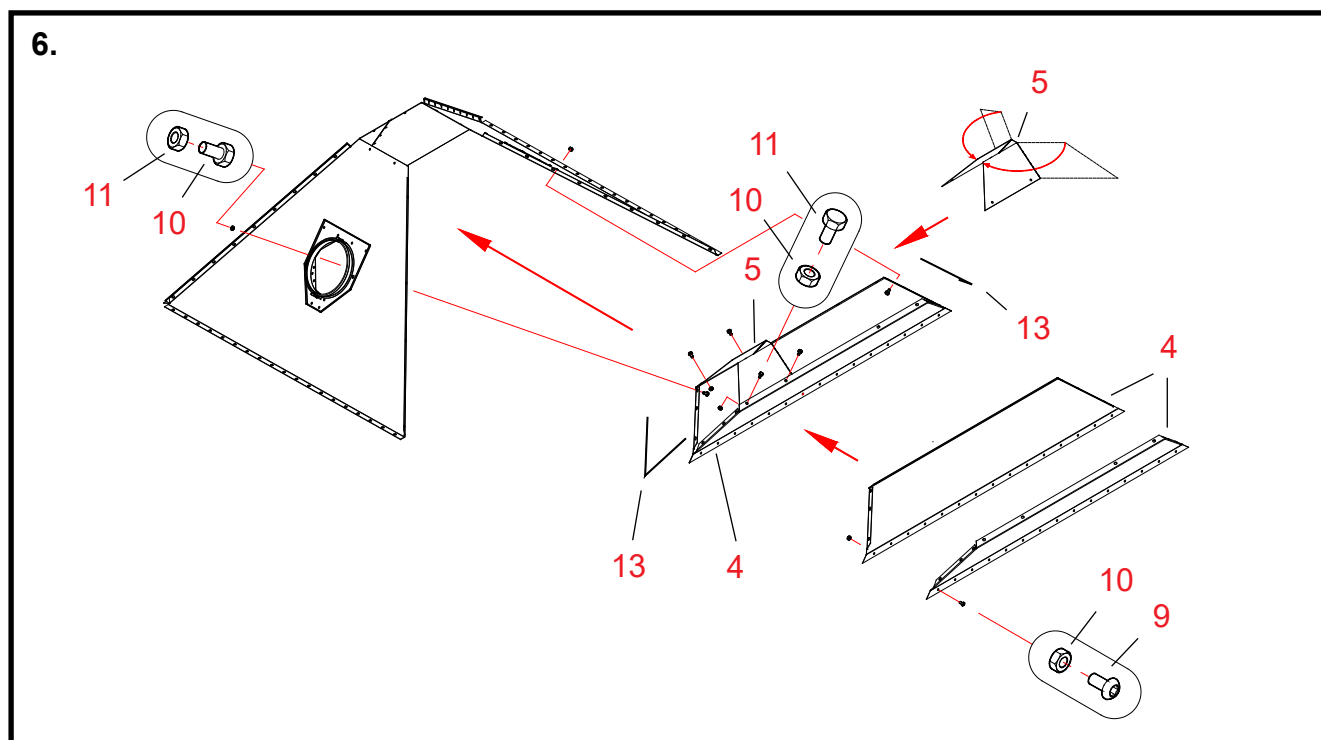
1, 3 Carefully align the corner joint between the plates.
Check that the flanges of the plates are lying tight against the assembly plane.

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 bolts and nuts (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.**

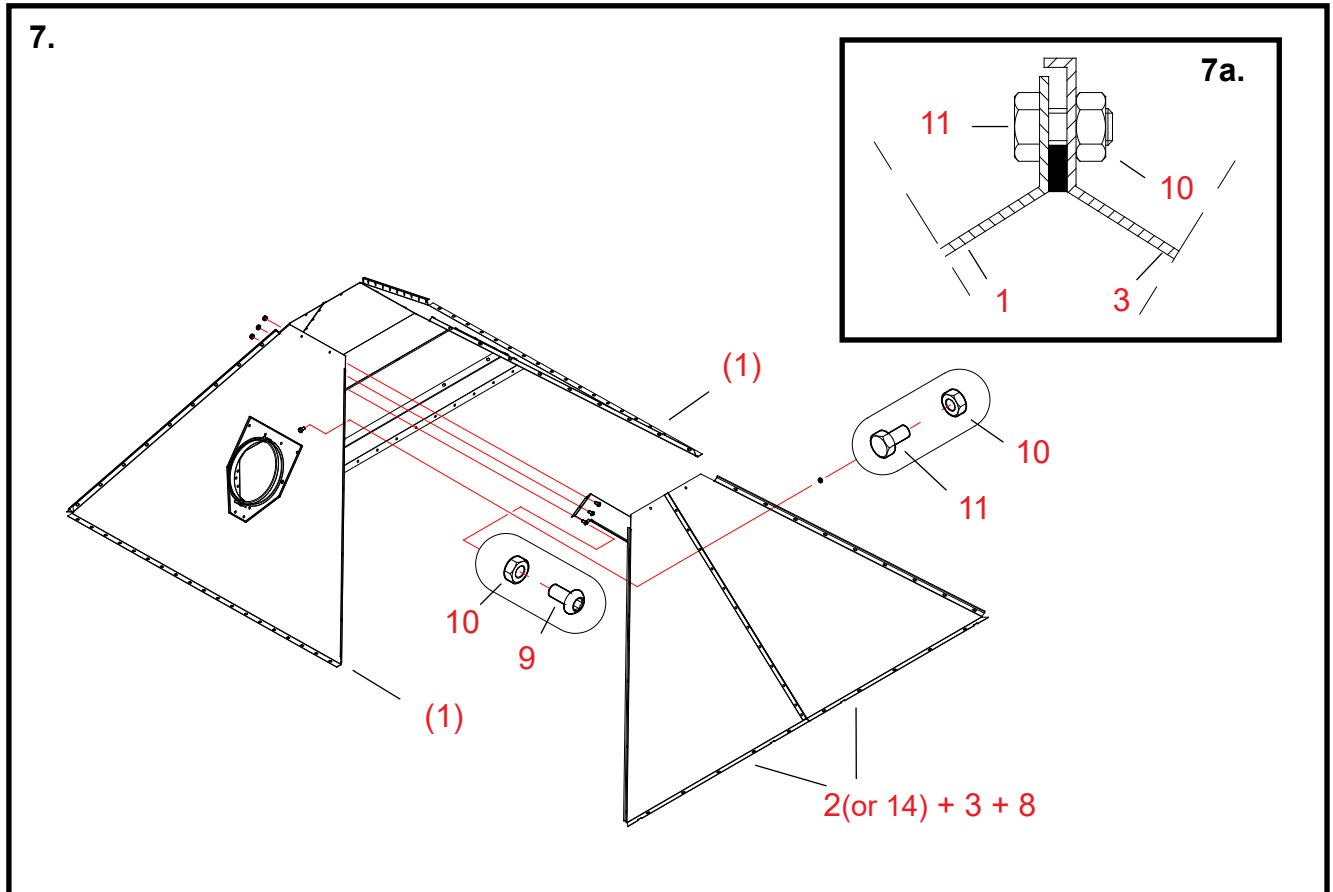
4 **Place the suction air channel with the stop plate attached inside the base cone.**

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.

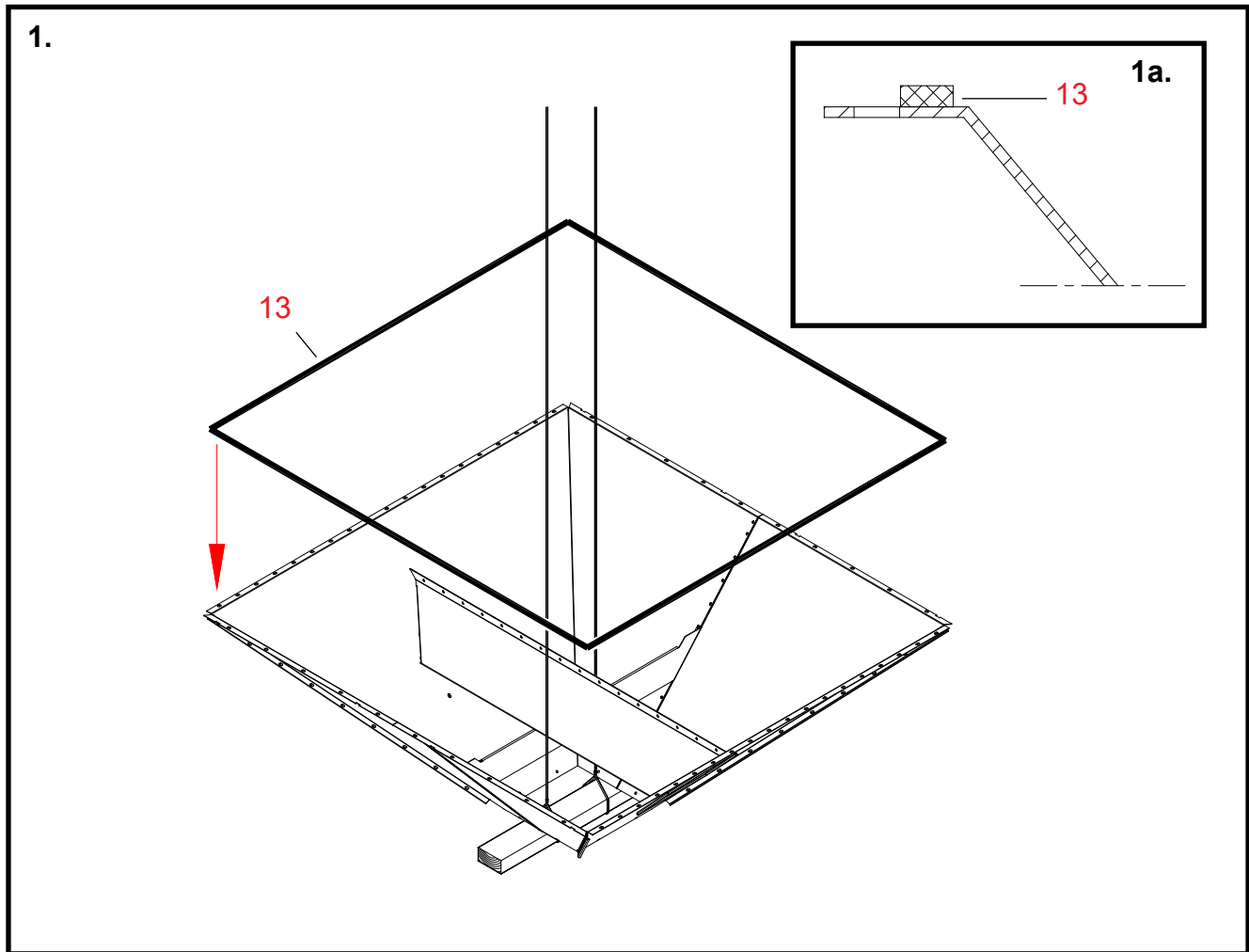
10, 11 Fix the corner joints using bolts and nuts (M8 x 16, 9 + 9 pcs.).

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.

Installing the base cone 4W



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.

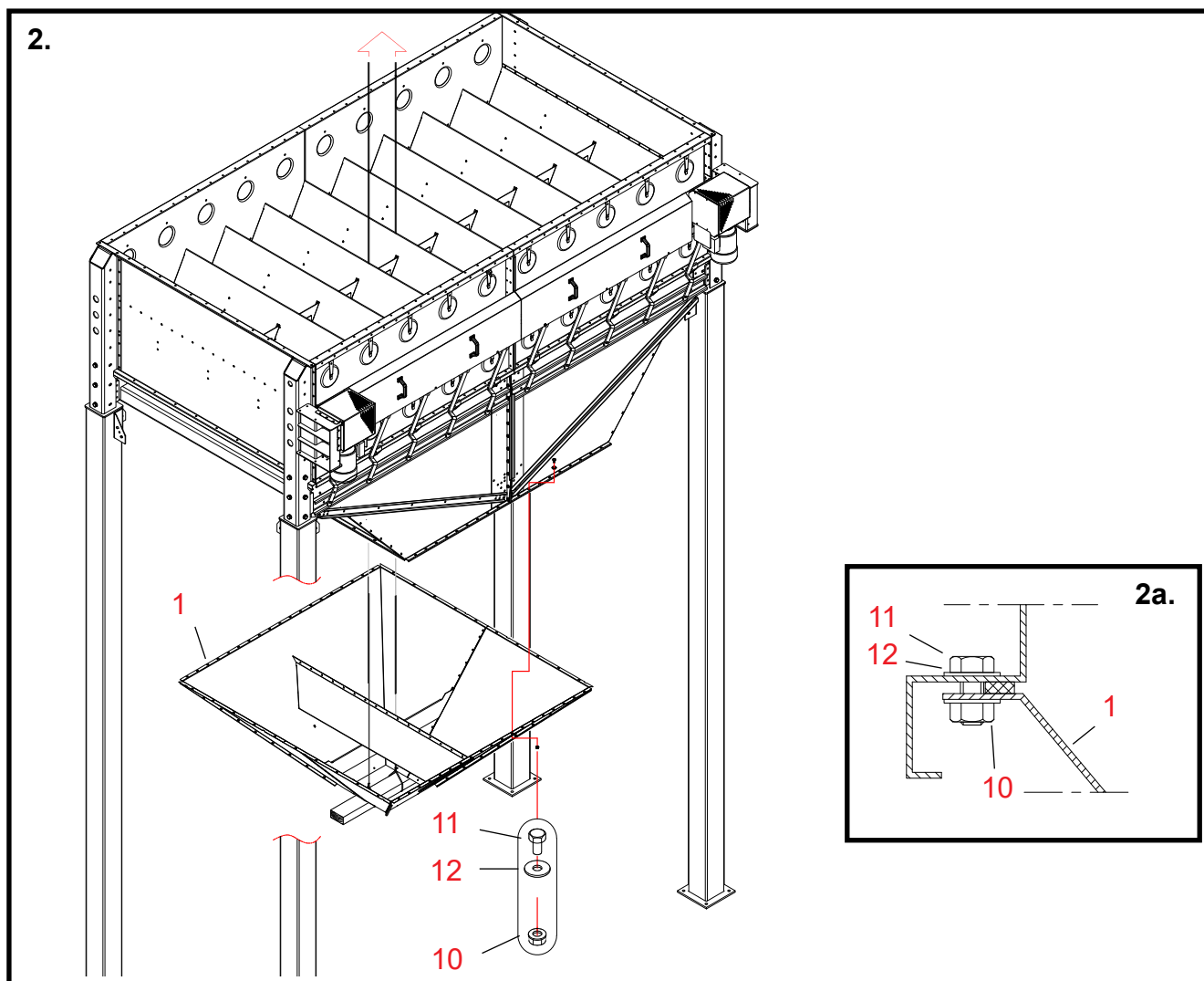
* **Turn the base cone to a position where the attachment flange comes on the upside.**

* **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 bolt hole 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.**

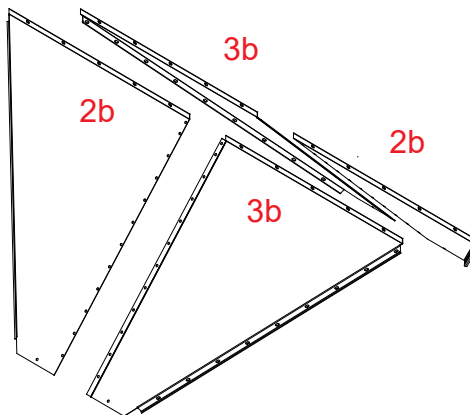
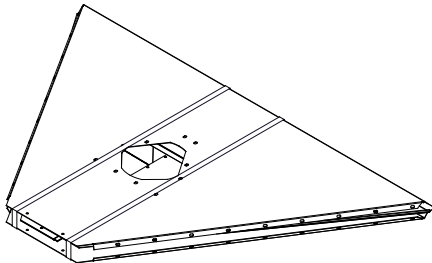
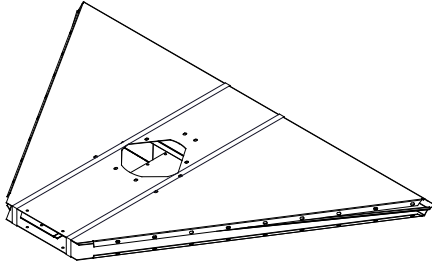
1 **Lift the base cone against the lower surface of the cone extension.**

10, 11,12 **Attach it using bolts, washers and flange nuts (M8 x 16, 58 pcs.).**
See dwg. 2a.

Structure of the base cone 4WC; Double cones

Base cone package A70374P, 2 pcs.

- external dimensions 180 x 1240 x 1985 mm
- weight 132 kg



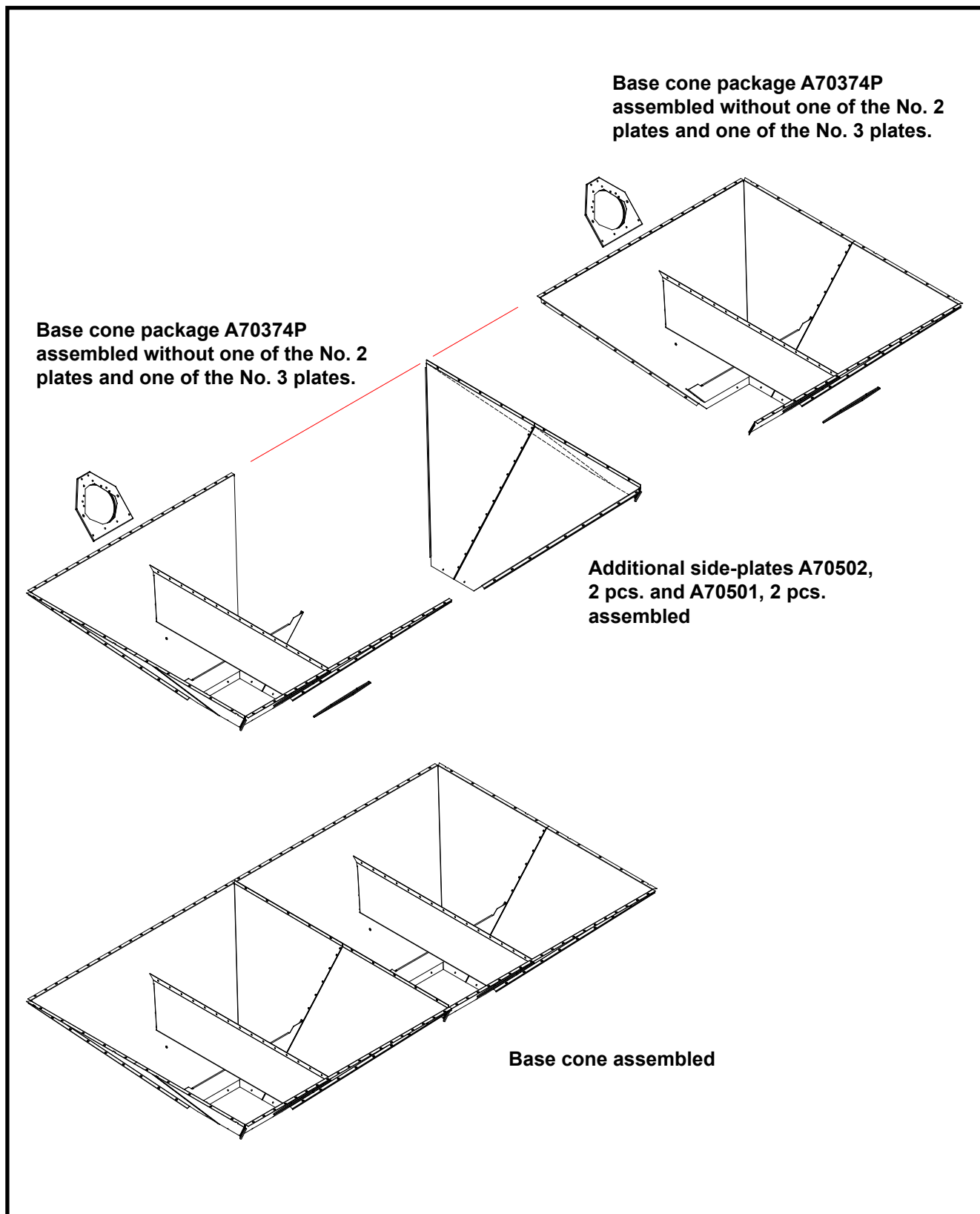
Side-plates for the double base cone (additional parts)

2b A70502, 2 pcs.

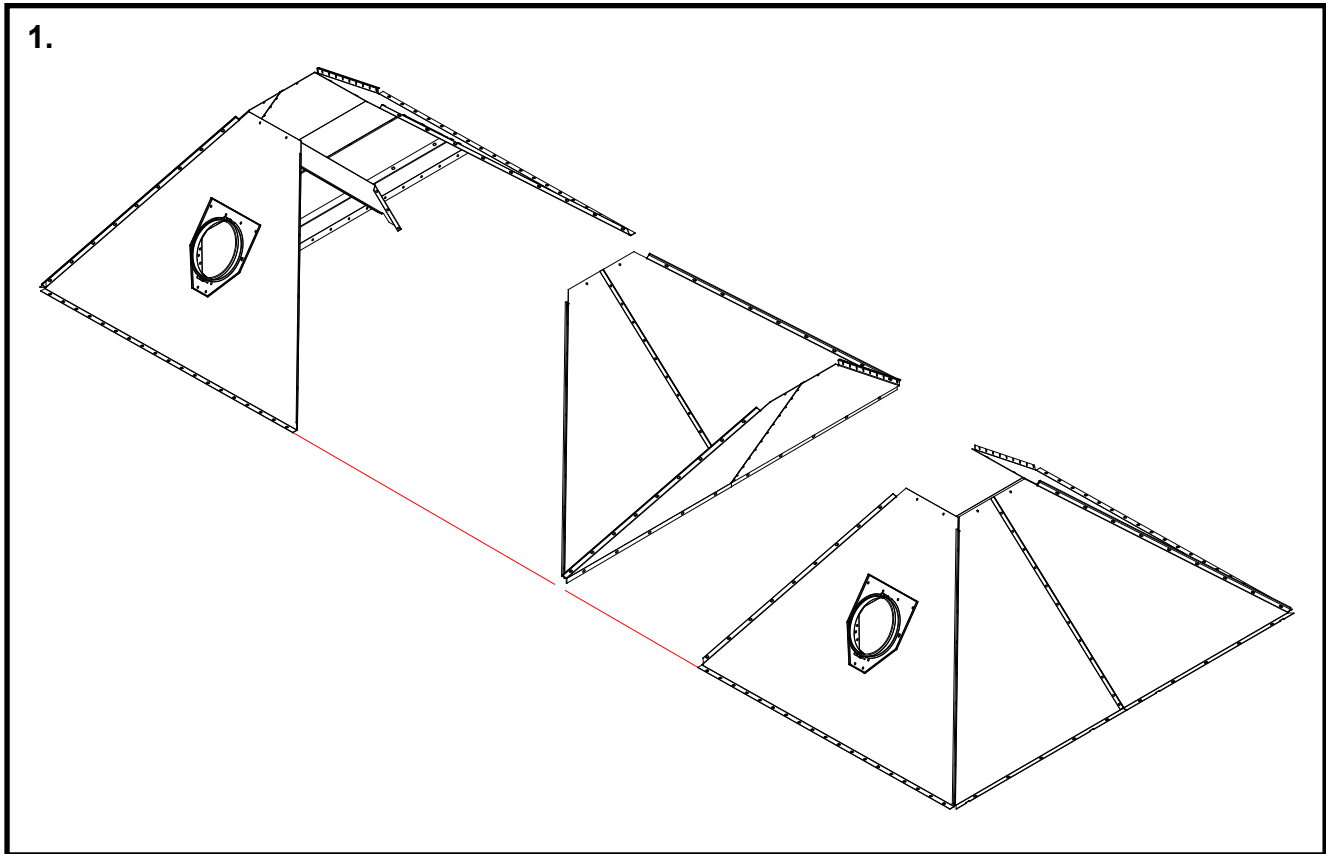
3b A70501, 2 pcs.

- delivered as loose parts

In both base cone packages, one of the No. 2 plates is replaced by plate 2b, and one of the No. 3 plates is replaced by plate 3b.



Assembling the base cones 4WC; Double base cones



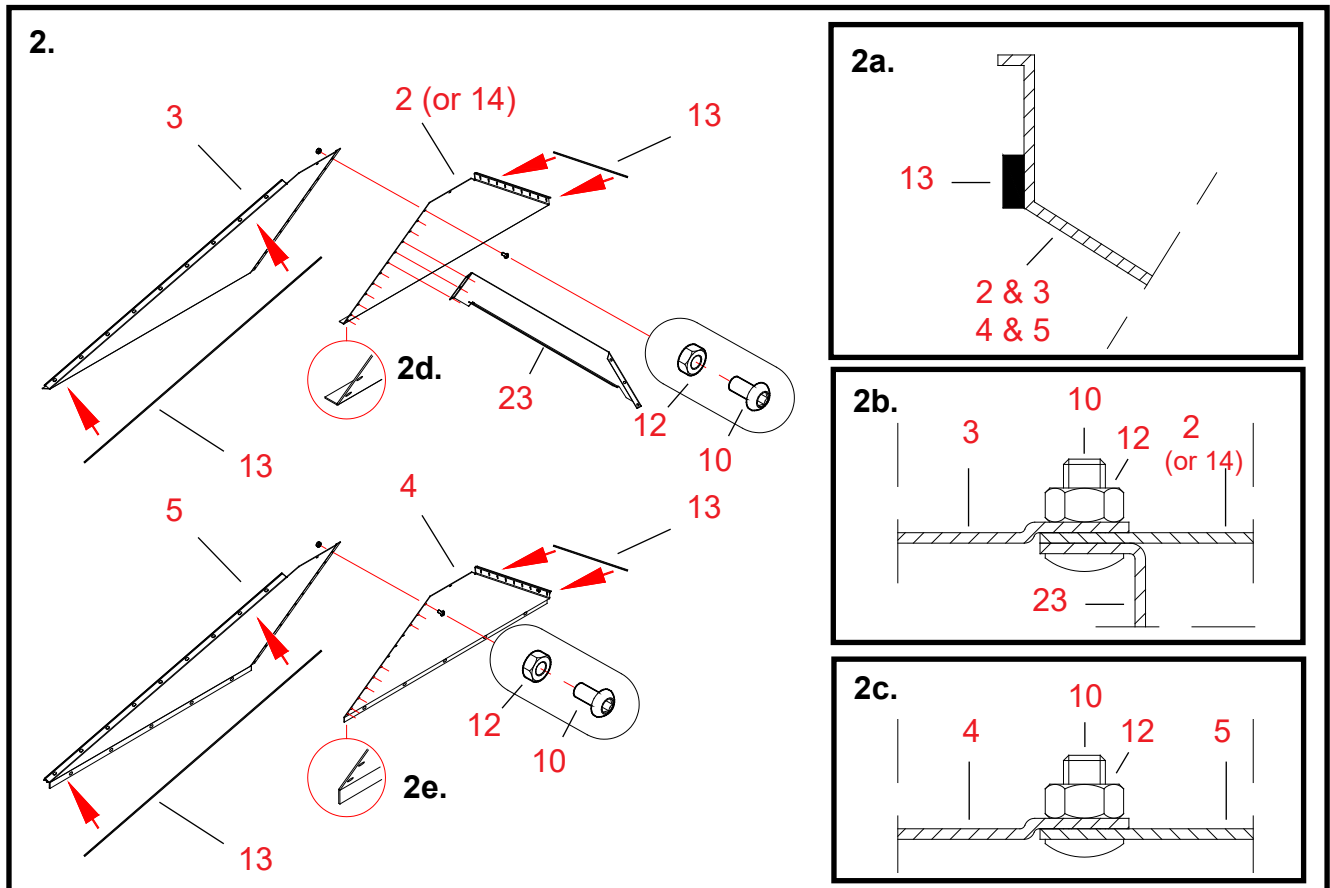
1. Base cones assembled in sections

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

The instructions explain, how to assemble the double base cone in three different sections, which can be lifted tight against the dryer base one by one.

The outermost sections of the cones, which will be assembled first, are identical with the exception of the connecting part, the stop plate for the suction air duct and location of the cover plate, which are mirror images with respect to the other section.

See also the placement and assembly of cone blocks with manholes on pages 26 and 45.



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 for the base cone of 4WC

13 **Fix sealing strips to the corner flanges of the side-plates (parts 2, 3, 4 and 5).**

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.

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 (see Fig. 2b).

23 **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.

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

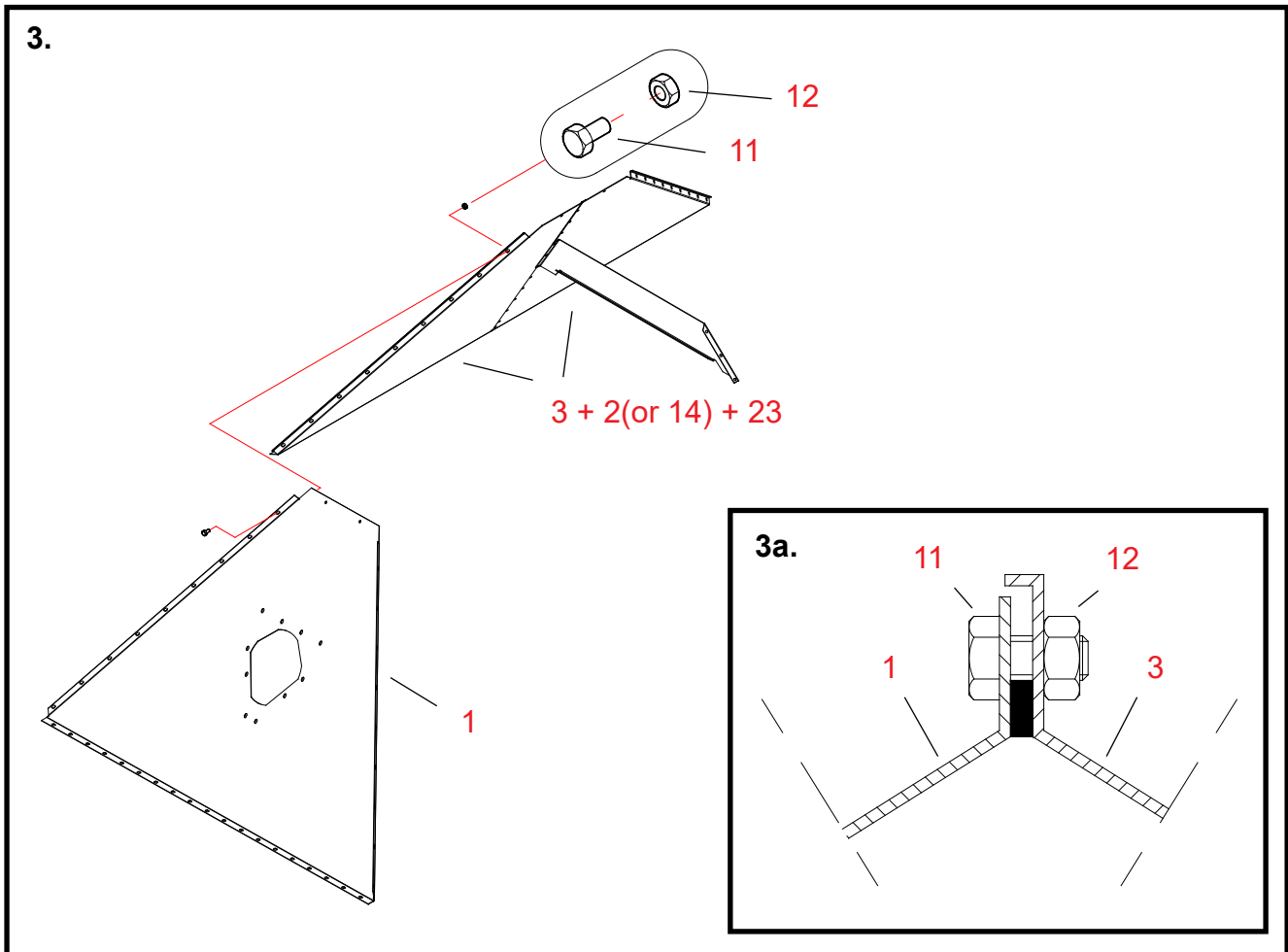
Place the bolt heads on the grain space side (see Fig. 2b).

2 + 3 + 23 **Assemble one more identical side-plate of parts 2, 3 and 23.**

4 + 5 **Assemble two more identical side-plates without additional support (part 23) of parts 4 and 5.**

Observe, that the flanges of plates 4 and 5 are bent in opposite directions (see Fig. 2e).

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

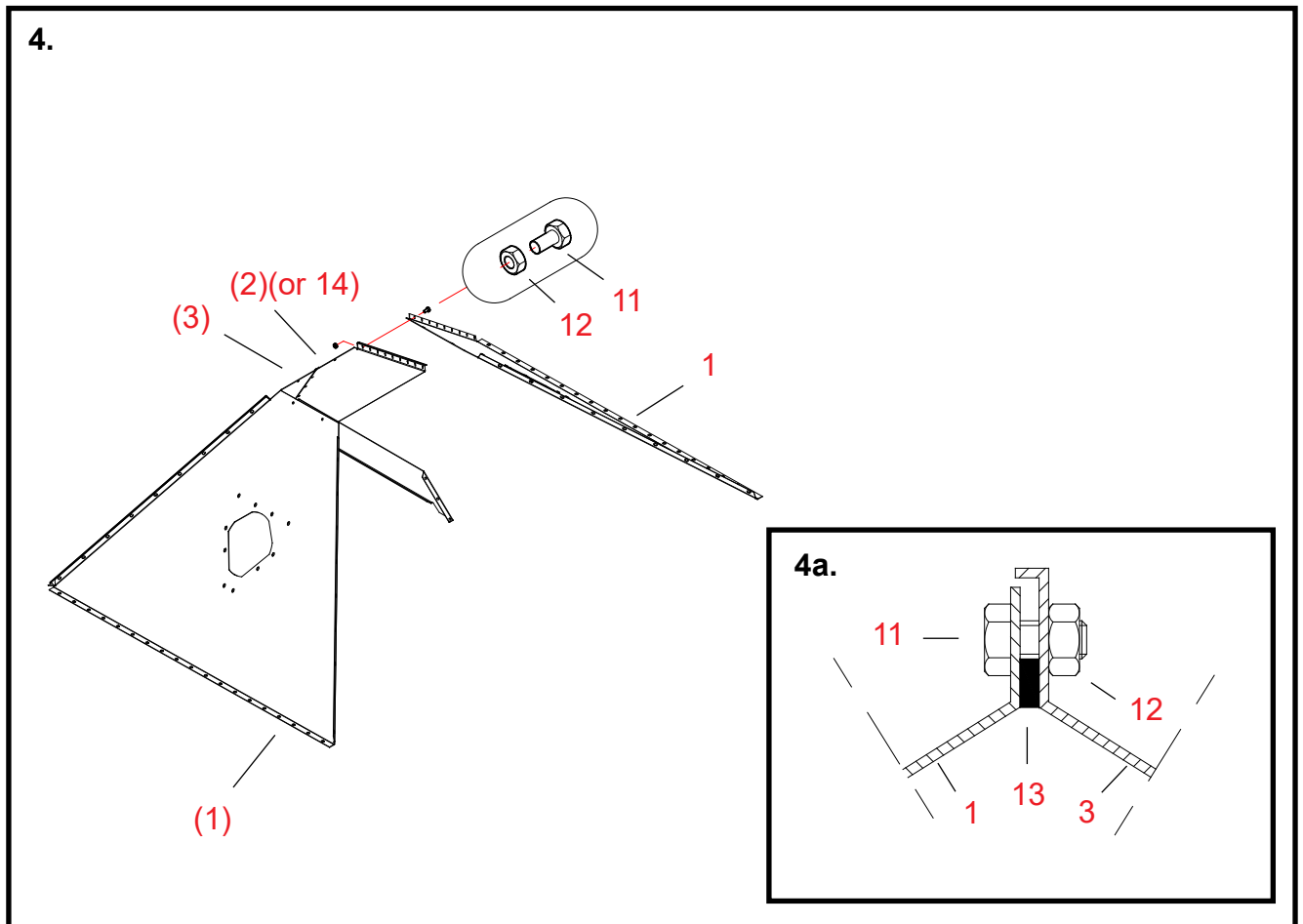
Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the base cone of 4WC.

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.

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

2 + 3 + 23 Lift one of the recently assembled side-plates, the one with additional support, tight 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.

11, 12 Fix the seam using bolts and nuts (M8 x 16, 9 pcs.).
See dwg. 3a.
Do not tighten the bolts yet.



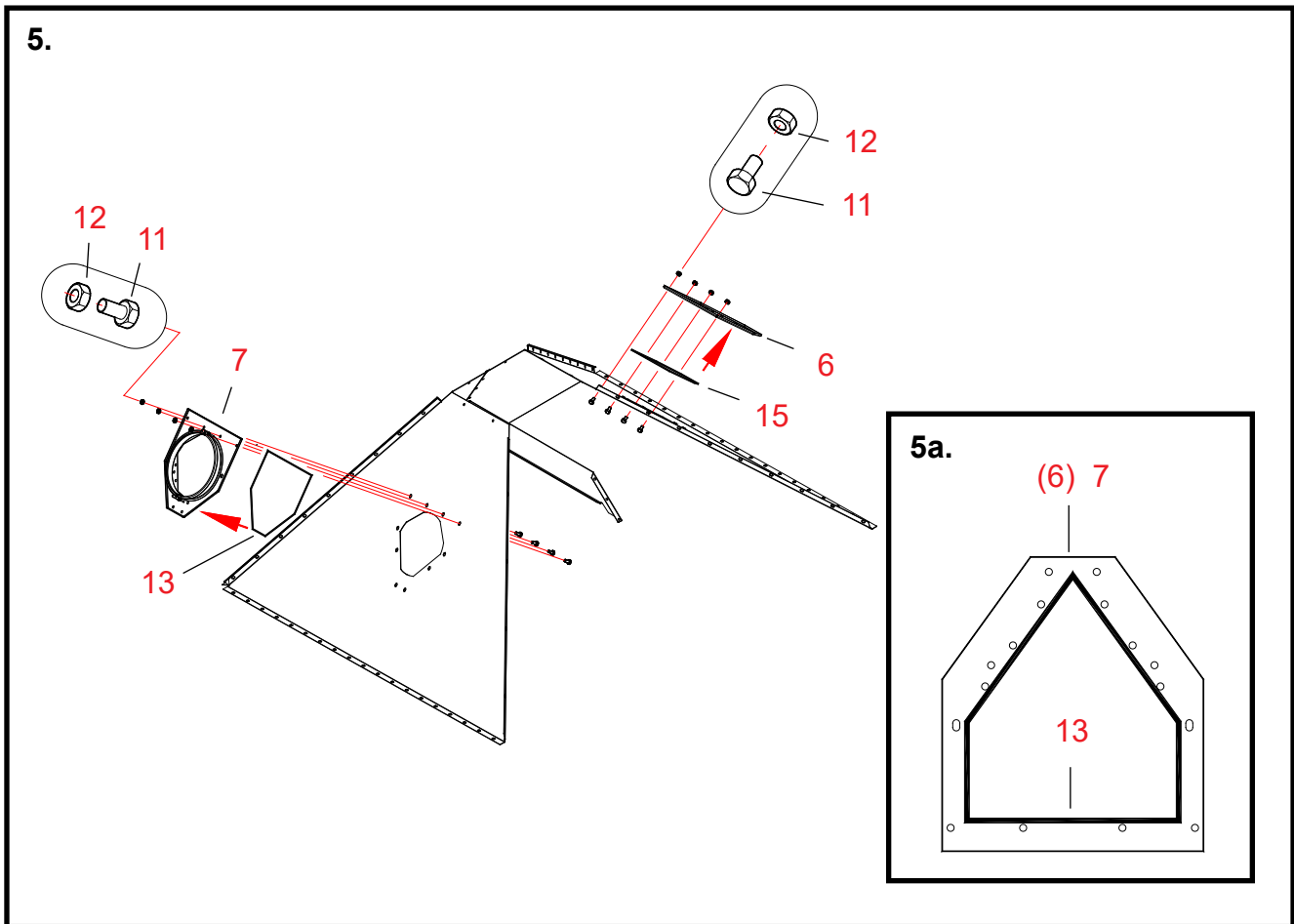
4. Fixing the fourth side-plate for the base cone

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the base cone of 4WC.

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.

11, 12 **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 for the base cone of 4WC.

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).

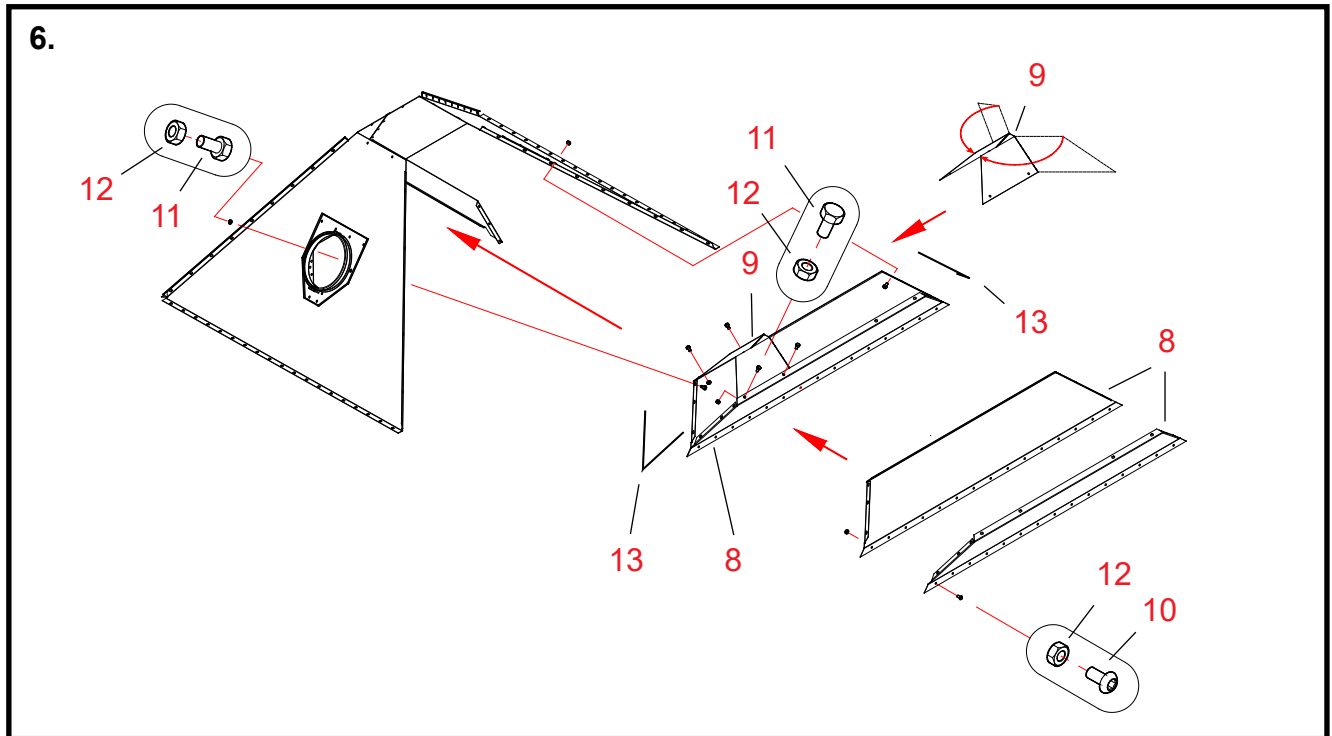
6 **Install the connecting part with opening to the base cone on the bottom suction fan side.**

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

7 **Install the cover plate on the opposite side.**

11, 12 **Fix the connecting part and the cover plate to the base cone using nuts and bolts (M8 x 16).**

Place hexagon bolts and nuts (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 for the base cone of 4WC.

8 Place the suction air duct halves face to face.

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

10, 12 Join the halves together using ball-headed nuts and bolts (M8 x 16, 15 pcs.).

9 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.

11, 12 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.

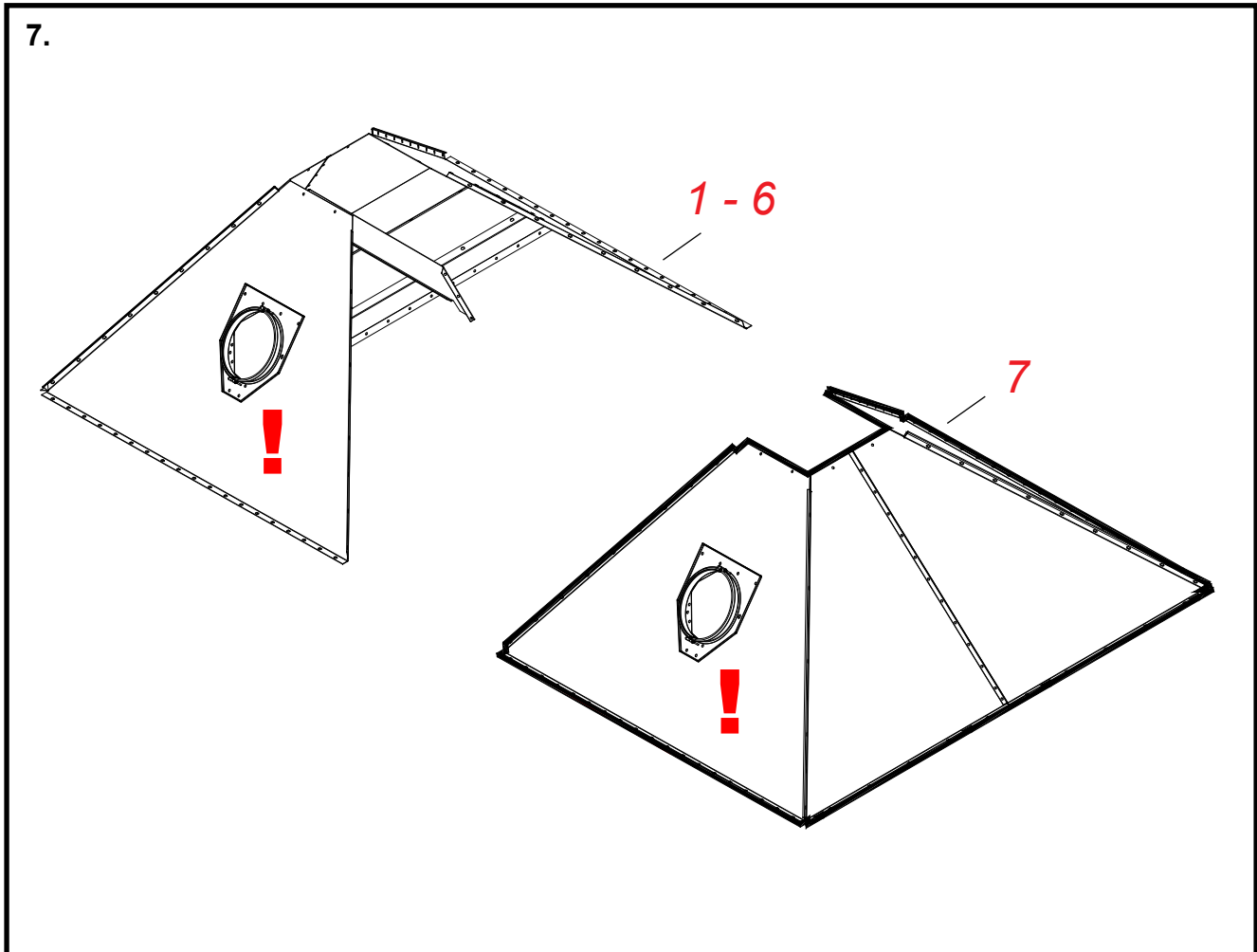
8 Place the suction air channel with the stop plate attached inside the base cone.

11, 12 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).

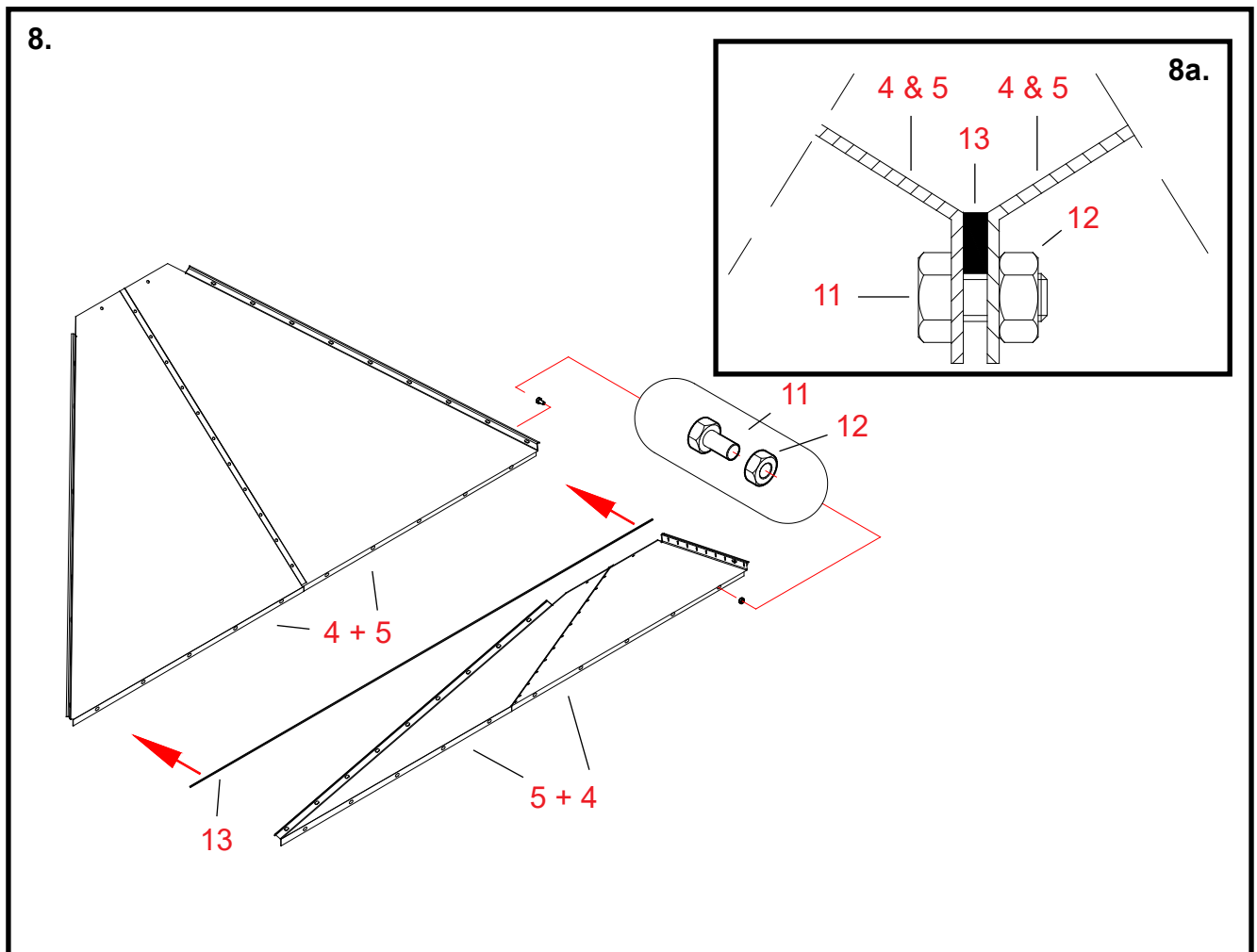


7. Assembling the other outer sections for the base cones

Assemble another identical section, in accordance with points 1 – 6.

The other assembled section differs from the one that was assembled first only by the connecting part, the stop plate for the suction air duct and location of the cover plate.

These items are mirror images with respect to the first section.



8. Joining the plate pair at the centre of the base cones

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the base cone of 4WC.

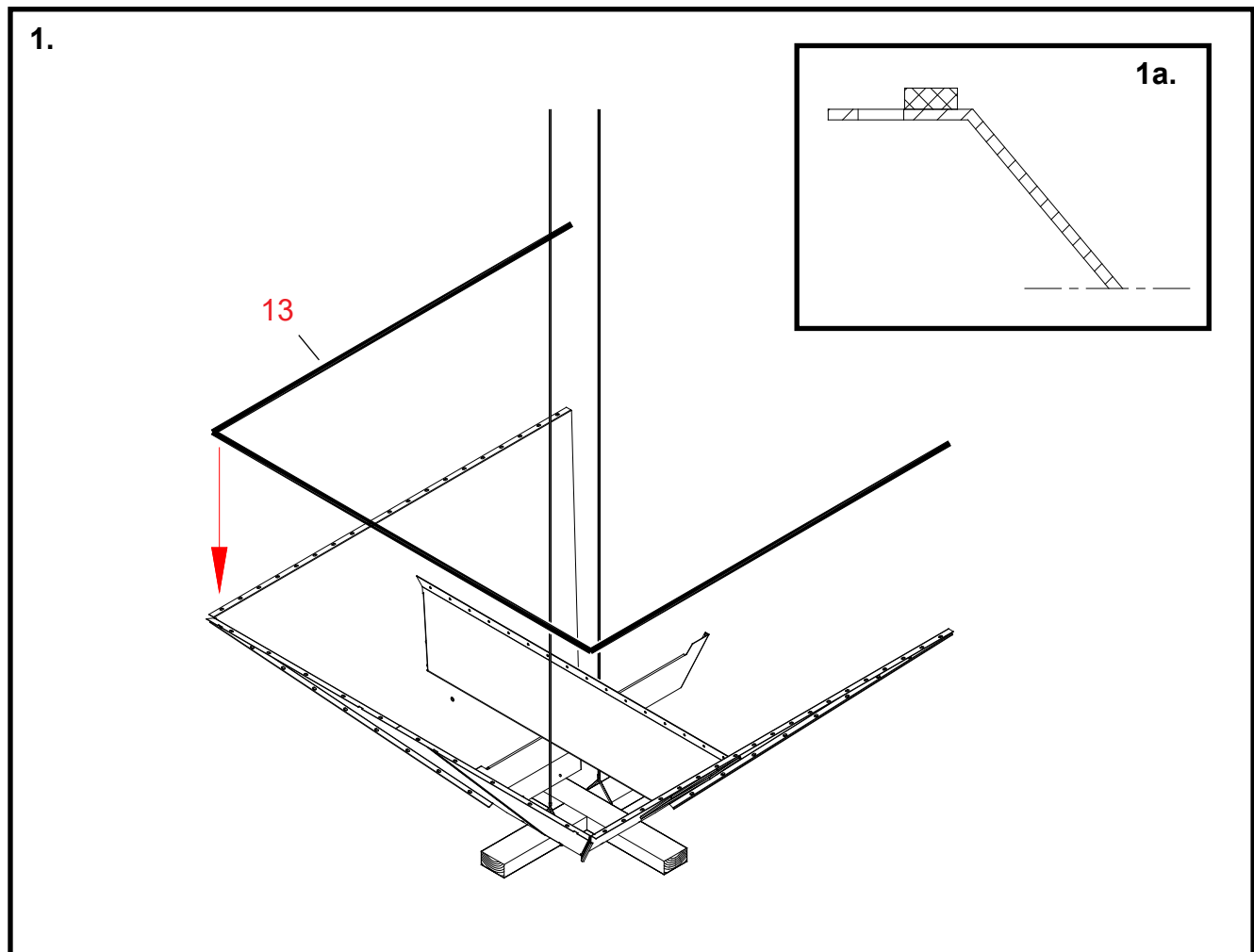
13 Fix a sealing strip onto the flange of one of the plate pairs (parts 4 + 5).
Fix the sealing strip inside the bolthole row in the plate pair (see Fig. 8a).

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

4 + 5 Place the flanged edges of the side-plate pairs face to face, as illustrated in the drawing.

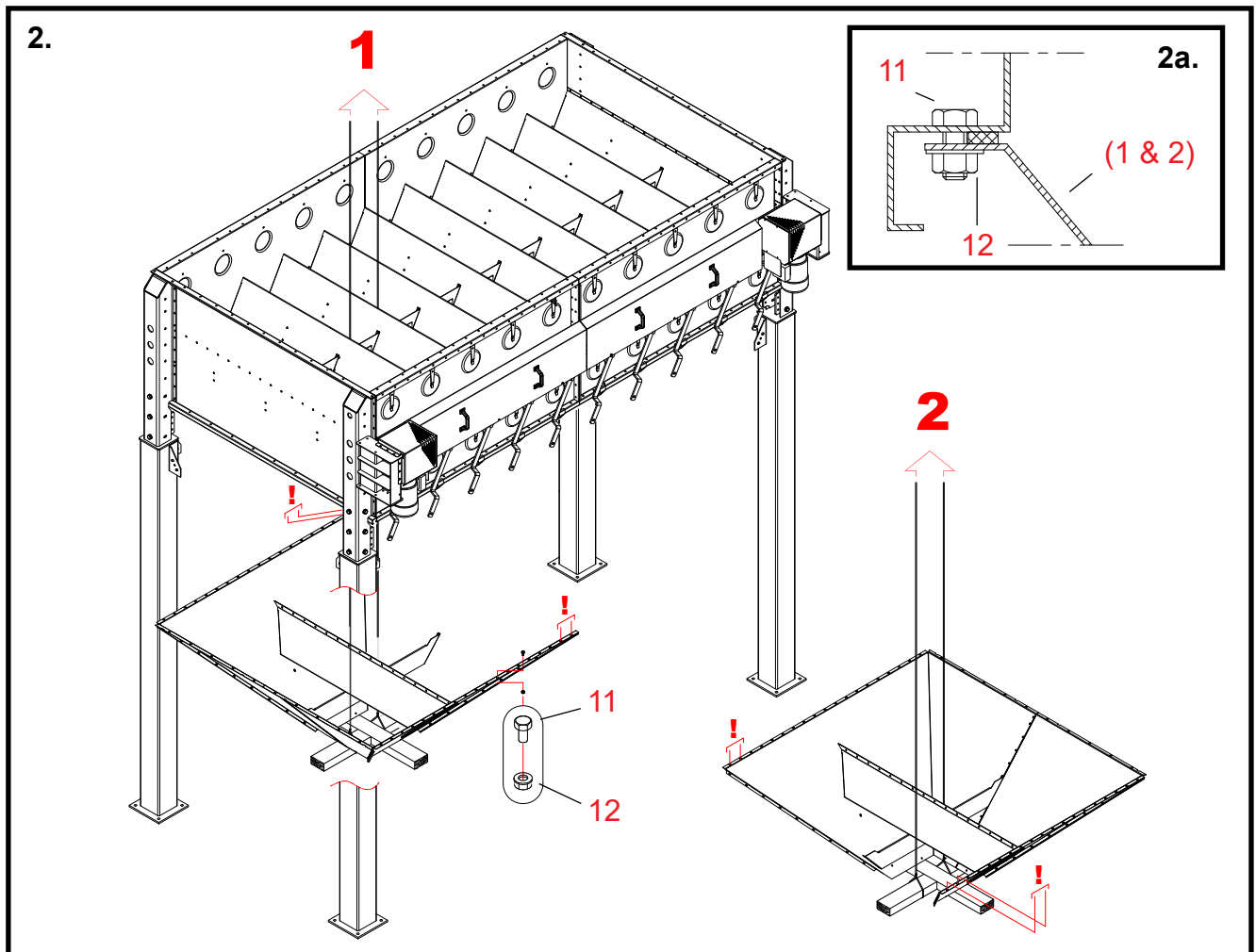
11, 12 Fix the seam using hex bolts and nuts (M8 x 16, 10 pcs).

Installing the base cone 4WC



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 for the base cone of 4WC. |
| * | Turn the other outer section of the base cone to a position where its attachment flange comes on the upside. |
| * | Place a cross, made of two 50 x 100 mm pieces of batten, under the section. |
| * | Attach the wire ropes for lifting the cone to one of the battens on both sides of the suction air duct. |
| 13 | <p>"Fix sealing strips to the three flanges on the upper surface of the section."</p> <p>Fix the sealing strip inside the bolthole row in the flange (see drawing 1a).</p> |



2. Lifting and fixing the outer base cone sections

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the base cone of 4WC.

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

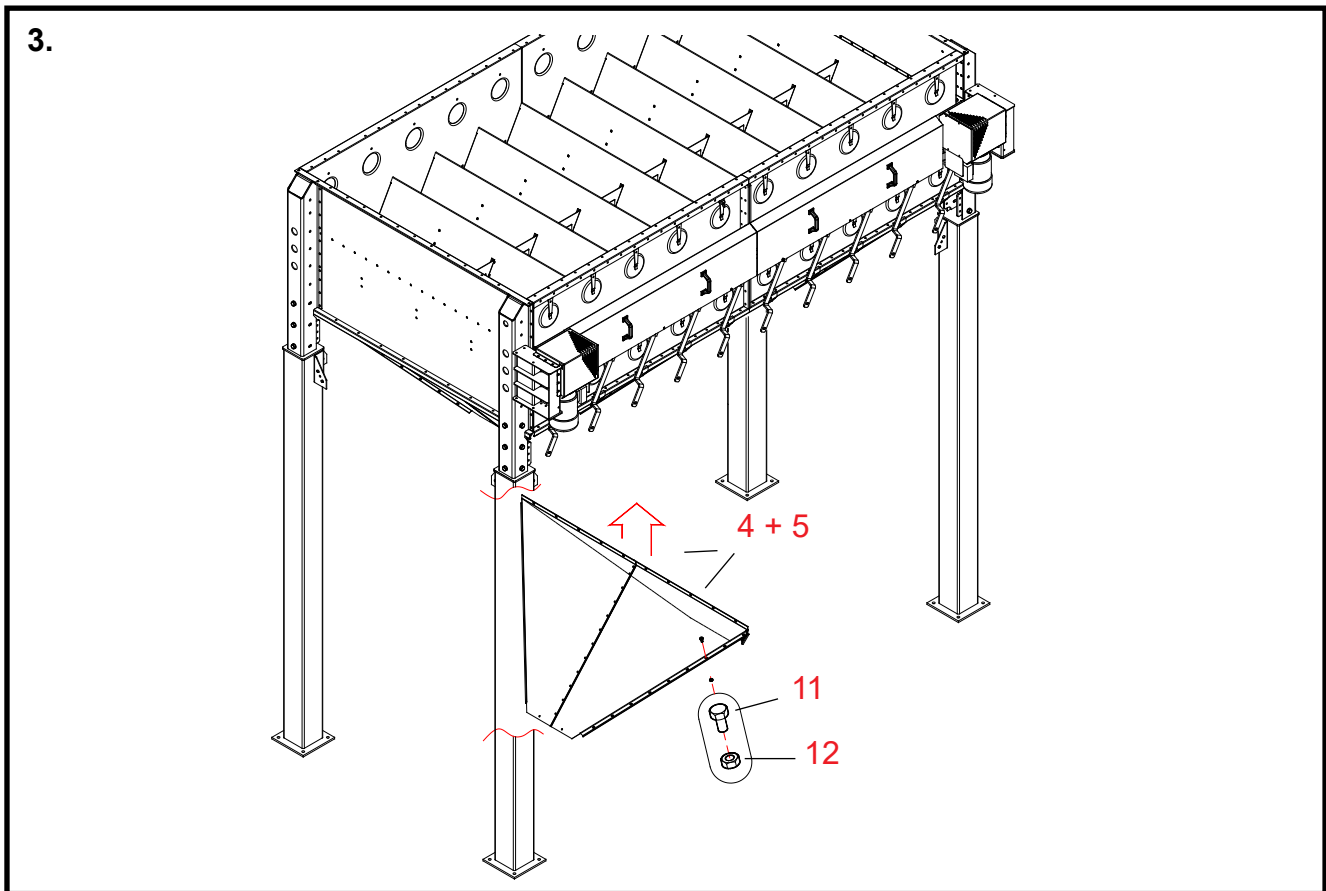
- * **Move the first base cone section under the base.**
- * **Lift the section using the wire ropes threaded between the air ducts in the base.**
- * **Thread the cone carefully past the lugs in the extension legs.**

(1) Lift the first outer base cone section tight against the bottom surface of the base.

11, 12 Attach it using bolts and flange nuts (M8 x 16, 48 pcs.).
Do not install the bolts (2 + 2), marked (!) in the drawing, at this stage yet.
See dwg. 2a. Do not tighten the bolts yet.

(2) Lift the second outer base cone section tight against the bottom surface of the base.

12, 13, 14 Fix the second base cone section in place in the same way.



3. Lifting and fixing in place the midmost plate pair for the base cones

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the base cone of 4WC.

* **Move the most central plate pair under the base.**

4, 5 **Lift the plate pair between the outer cone sections.**
Place the part, watching the sealing strips, against the flanges of the outer sections. Align the boltholes.

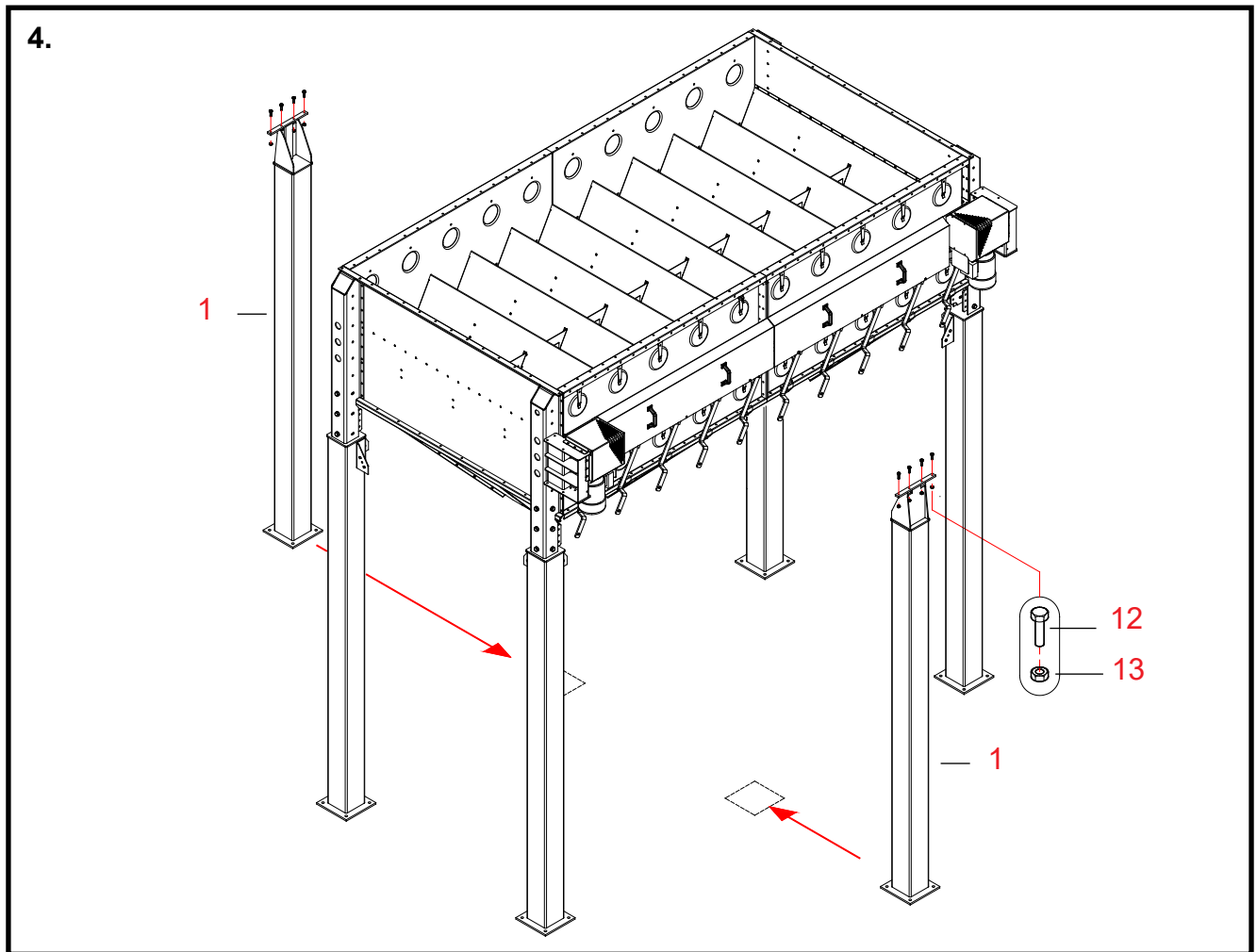
11, 12 **Fix the part using bolts and nuts (M8 x 16, 4 + 9 pcs.).**
Do not tighten the bolts yet.

* **Ensure that the base cones settle in the correct position against the bottom surface of the base.**

' **Tighten all attachment bolts of the base cone in the corners and to the base.**

10 **Align the holes in the free ends of the additional cone supports with the holes in the side-plates.**

10, 12 **Fix the ends of the additional supports using ball-headed bolts and nuts (M8 x 16, 3 x 3 pcs.).**
Place the bolt heads on the grain space side.



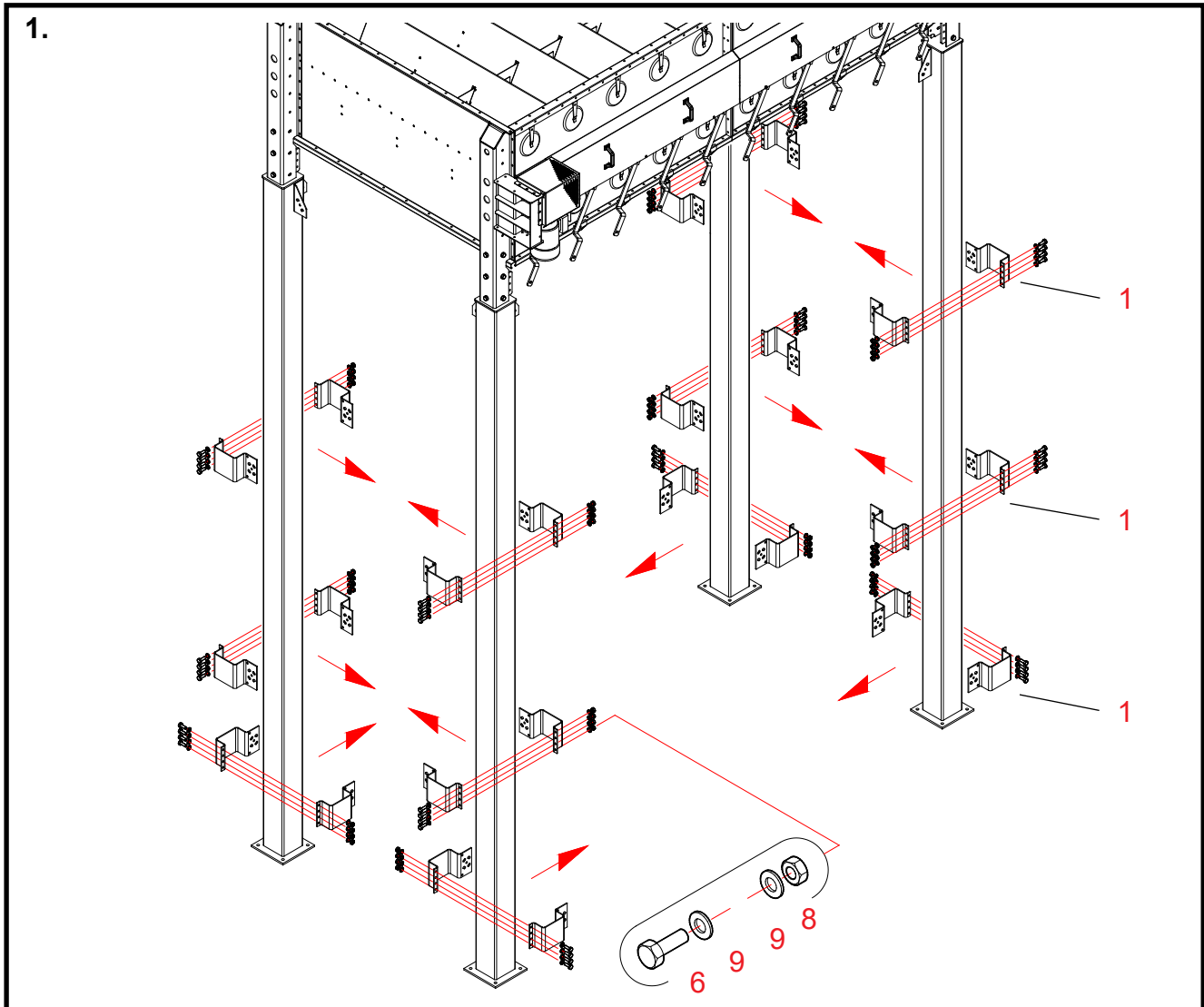
4. Installing the middle extension legs on 4WC

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the extension legs on 4WC.

1 **Install the middle extension legs at the centre of each side.**
Place the upper part of the leg at the bolt holes in the double base cone, still without bolts.
Point the open upper end of the extension leg towards the base cone.

12, 13 **Attach the extension legs to the lower surface of the base frame (bolts M8 x 30, 4 + 4 pcs.).**

Installing cross-braces for the extension legs on 4W

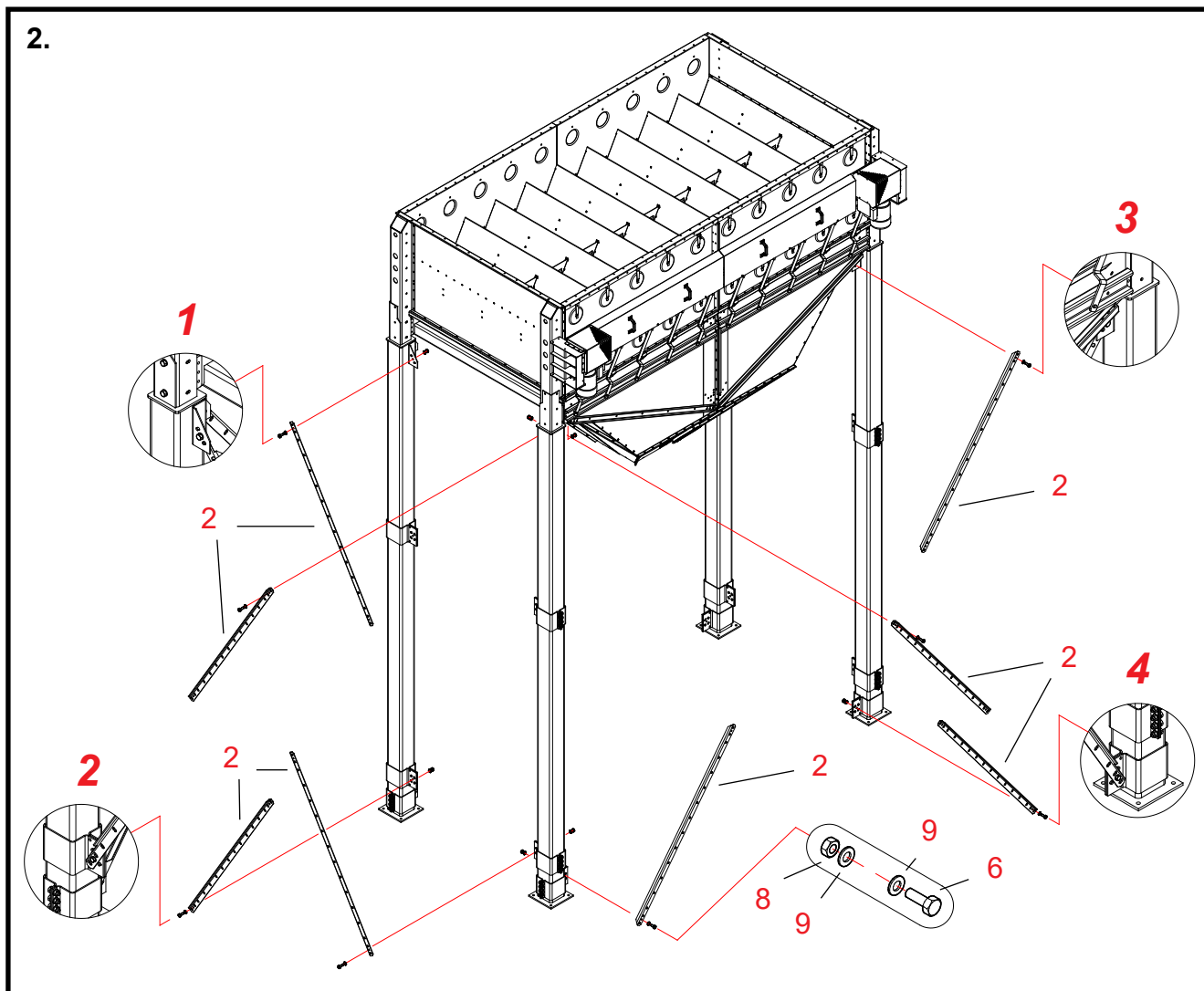


1. Installing the adjustable cross-brace brackets on the extension legs of 4W

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for cross-braces for the extension legs on 4W.

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

6, 8, 9 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 4W

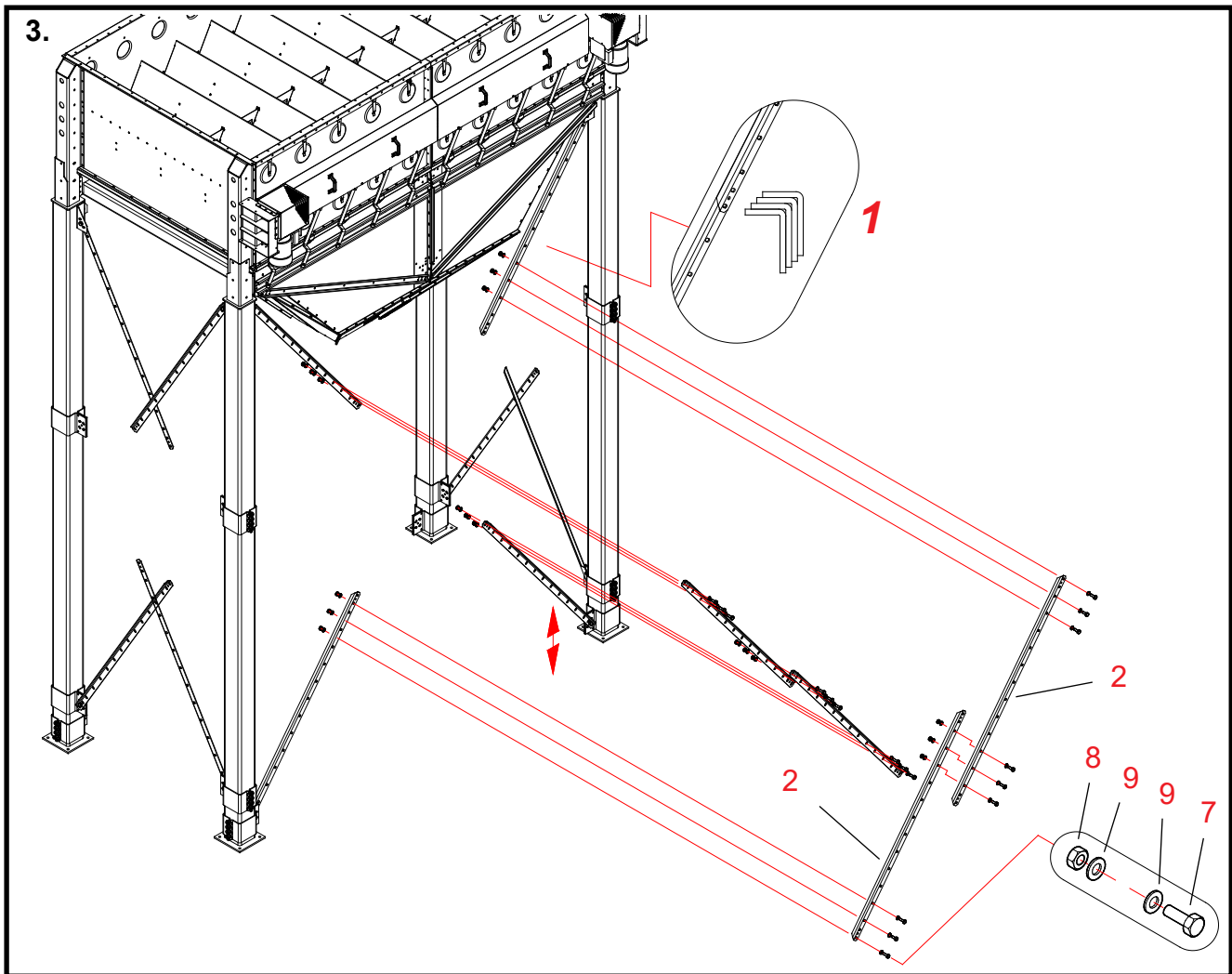
Parts The numbering of work stages refers to reference numbers in the spare parts drawing for cross-braces for the extension legs on 4W.

2 Put in place the cross-brace parts in the upper and lower brackets on the shorter 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.

2 Put in place the cross-brace parts in the upper and lower brackets on the longer side of the base.
Select the direction and position for the cross-braces at the side of the bracket, as illustrated in drawings 3 and 4.

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 for the cross-braces in the same way on the other sides of the base.



3. Installing the bolts in the centre parts and the joints of the cross-braces on 4W (on the longer side of the base)

Parts	The numbering of work stages refers to reference numbers in the spare parts drawing for cross-braces for the extension legs on 4W.
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2 Join up the brace of the third and fourth part of the cross-brace.

Place the parts one inside the other, as shown in detail drawing 1.

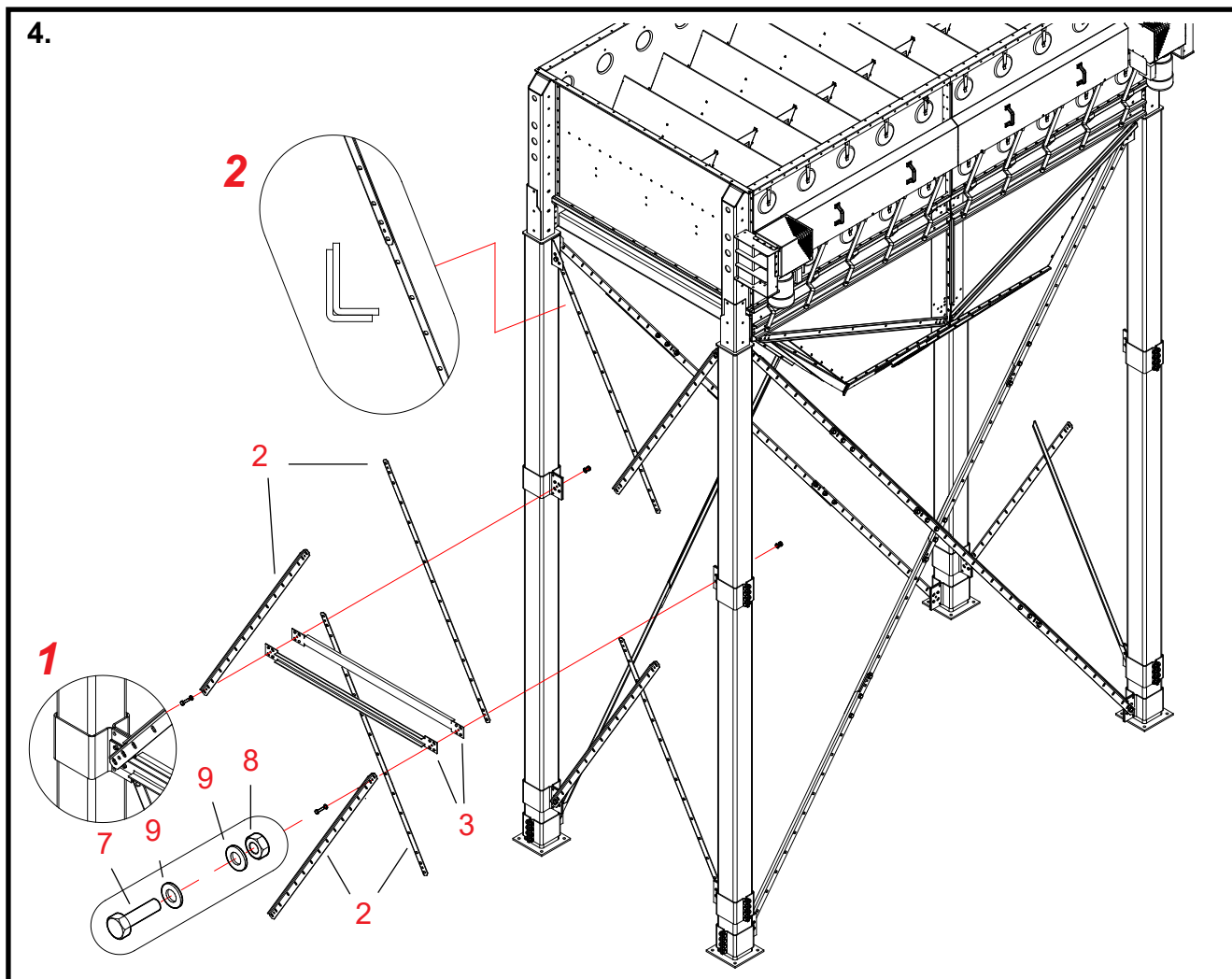
* **Move the lower cross-brace bracket along the extension leg.**

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).

6, 8, 9 Put in place and tighten the bolts at the cross-brace joints (M12 x 35, 3 pcs.).

* Join the cross-braces at the opposite longer side of the base in the same way.



4. Installing intermediate beams and centre parts for the cross-braces on 4W (on the shorter side of the base)

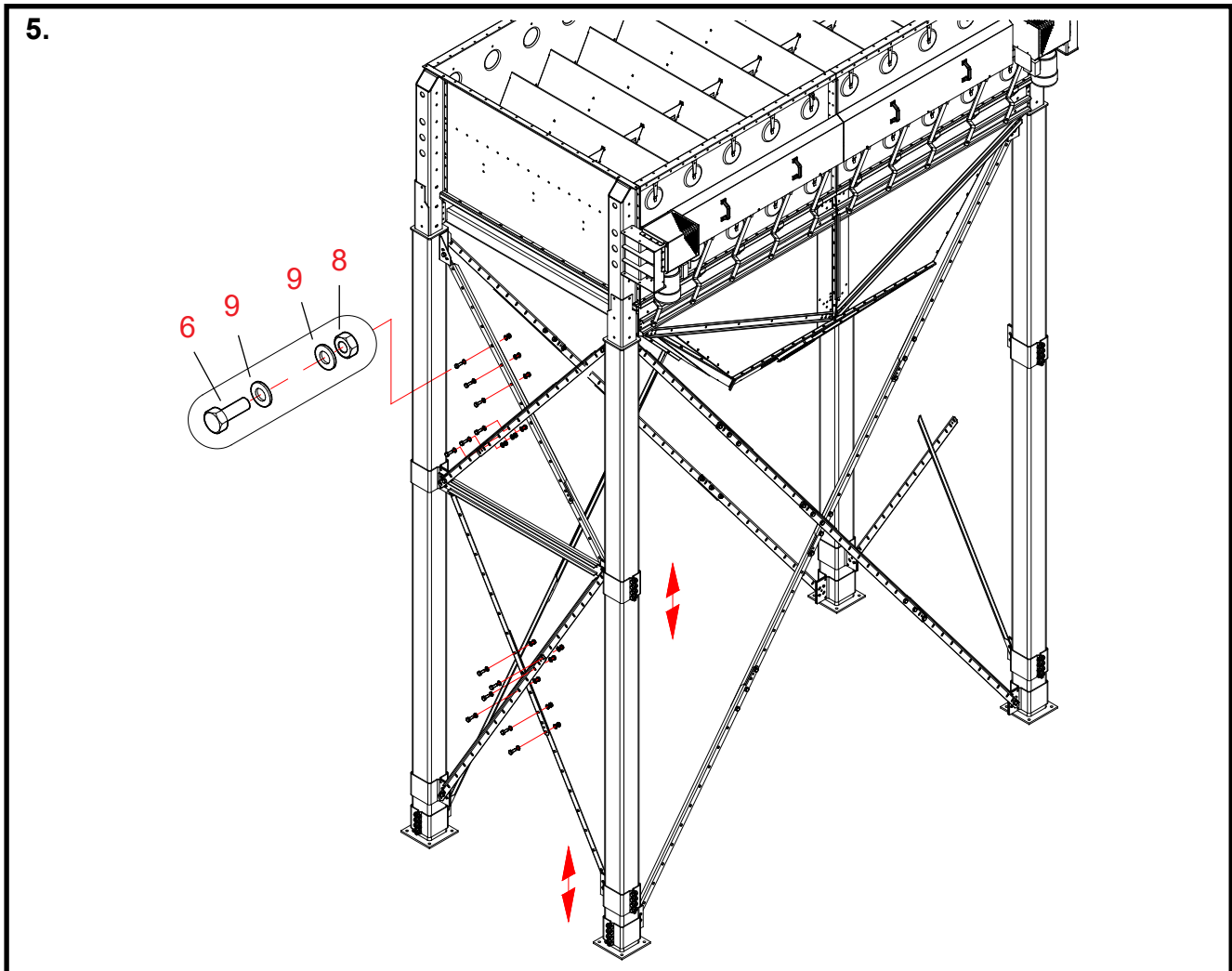
Parts The numbering of work stages refers to reference numbers in the spare parts drawing for cross-braces for the extension legs on 4W.

3 **Place two intermediate beams for the extension legs between the upper adjustable cross-brace brackets.**
Place the flanges of both beams outside the adjustable bracket, as shown in drawing **1**.

2 **Also place the parts for the cross-braces at the attachment points for the intermediate beams.**
Select the direction and position for the cross-braces at the side of the bracket, as illustrated in drawing **1**.
Place the braces one inside the other, as shown in detail drawing **2**.

7, 8, 9 **Put in place and tighten the bolts for the intermediate beams (M12 x 45, 2 pcs.).**
Tighten the bolts only lightly before fixing the cross-braces.

***** **Install the corresponding parts on the other shorter side of the base.**



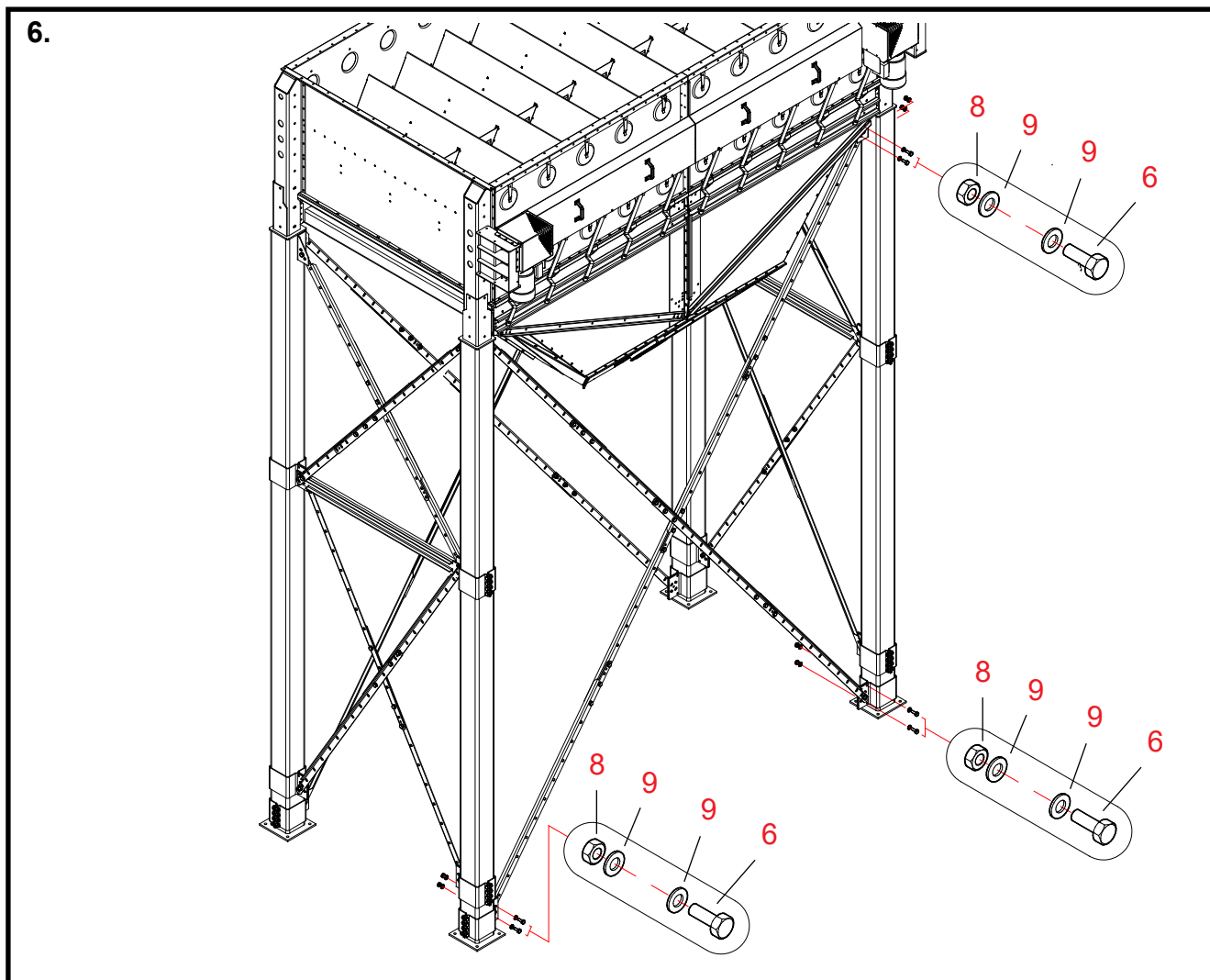
5. Installing the bolts in the cross-brace joint on 4W (on the shorter side of the base)

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for cross-braces for the extension legs on 4W.

***** **Move the lower bracket for the cross-brace and the intermediate beam bracket along the extension leg.**
Position the intermediate beam halfway between the upper and lower brackets for the cross-brace.
Select the positions so that it is possible to install three bolts in every cross-brace joint.
Extend the cross-braces as much as possible (move the lower bracket to as low as it goes).

6, 8, 9 **Put in place and tighten the bolts at the cross-brace joints (M12 x 35, 3 pcs.).**
At the same time, wrench the attachment bolts for the intermediate beam to their final tightness.

***** **Install the corresponding parts on the other shorter side of the base.**



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

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for cross-braces for the extension legs on 4W.

6, 8, 9 Put in the place the missing bolts (M12 x 35) in all adjustable brackets.

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

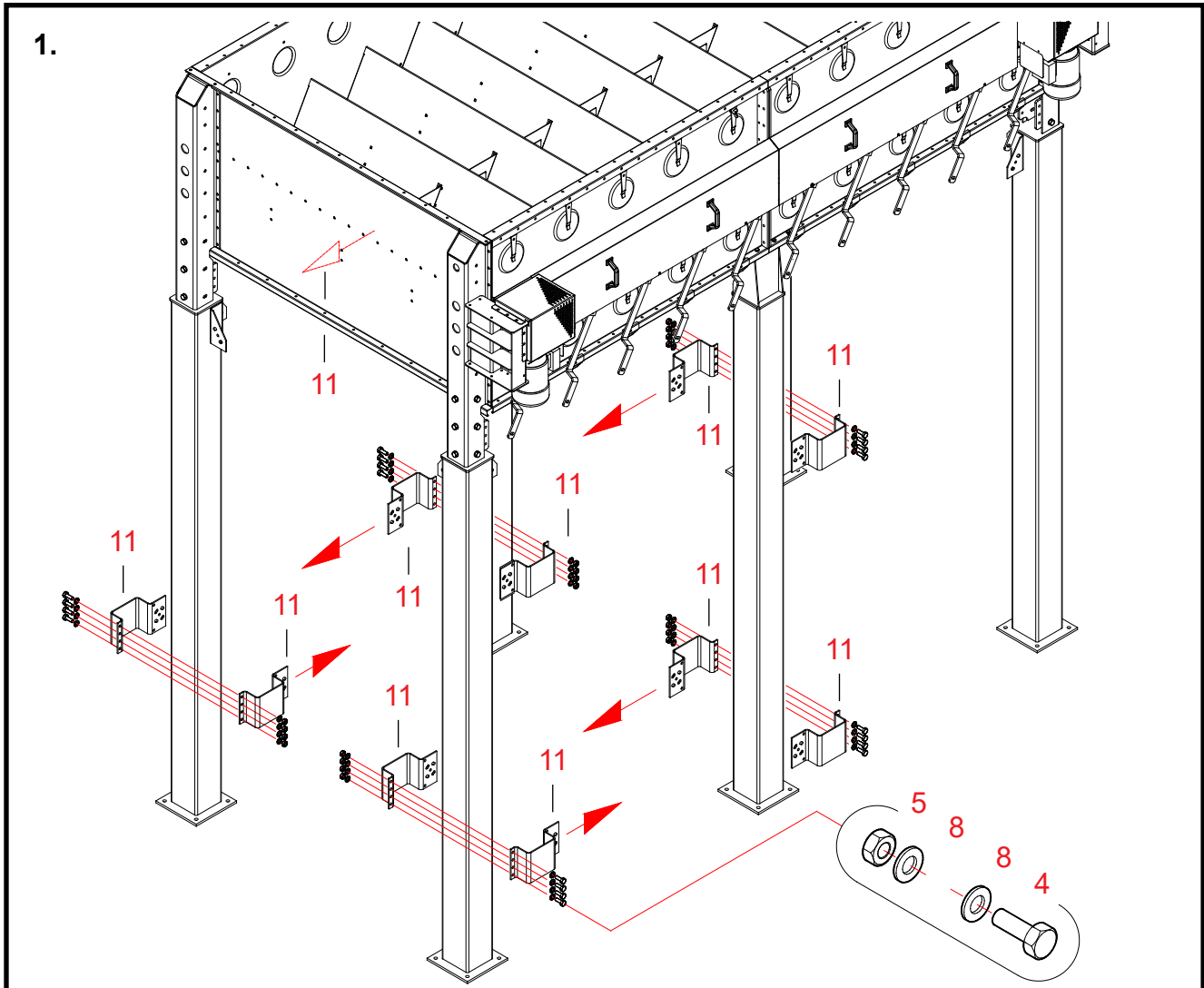
6, 8, 9 Put in place the missing bolts (M12 x 35) in the upper and lower ends of each cross-brace.

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.

Installing cross-braces for the extension legs on 4WC; Model with double cone



1. Installing adjustable brackets on the extension legs, 4WC with double base cone (brackets for the upper ends of the long cross-braces)

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the extension legs on 4WC.

11 Put the halves of the adjustable brackets on the extension legs.

Provide both legs, in the front of the drawing, with one bracket each placing it near the lower end.

Provide both legs in the middle with two brackets each.

On each extension leg, place one of the brackets near the upper end of the leg and the other one near its lower end.

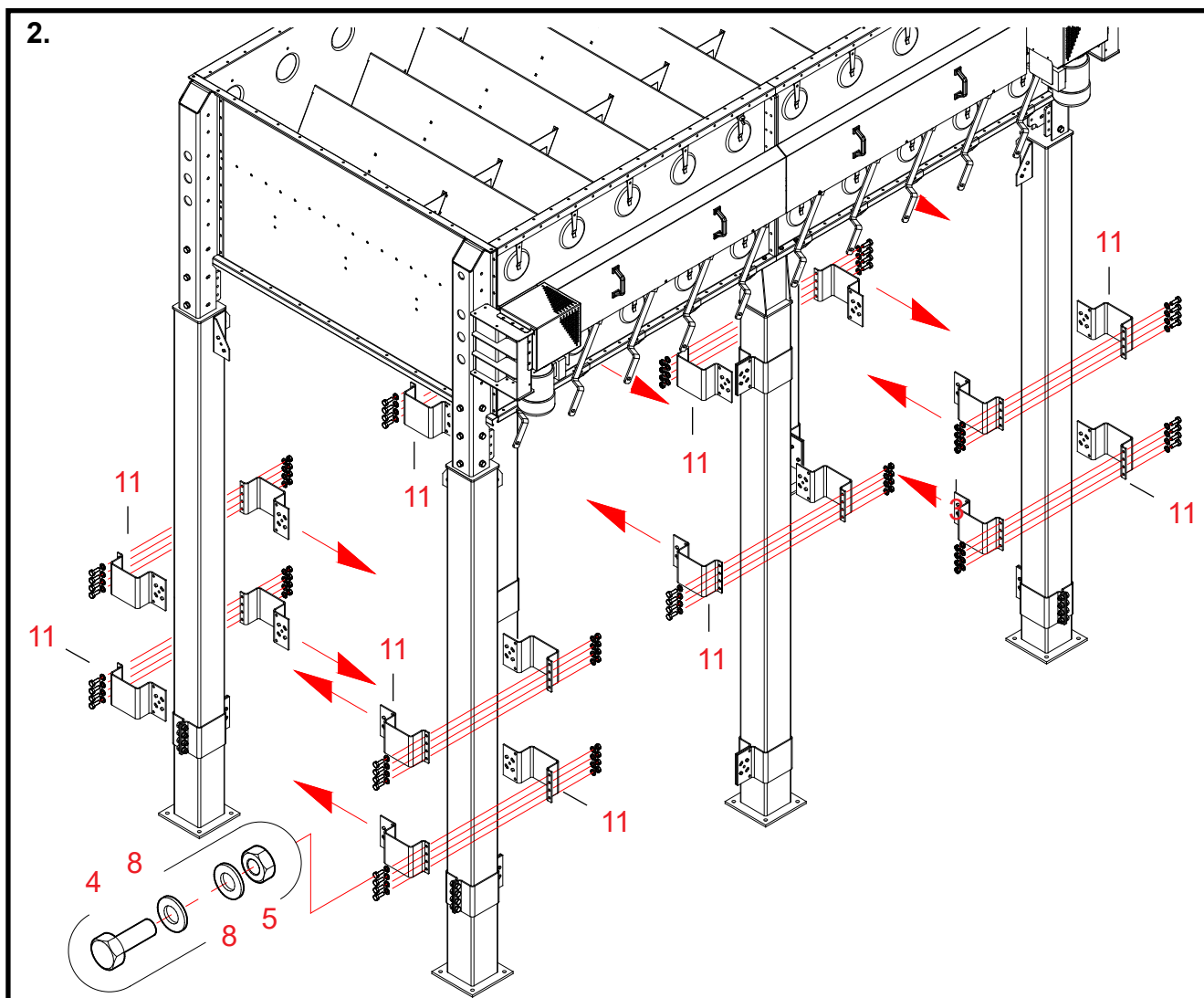
Check the correct direction for the bracket flange with 7 holes in the drawing.

4, 5, 8 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. Installing adjustable brackets on the extension legs, 4WC with double base cone (brackets for the upper ends of the short cross-braces and the brackets for the conveyor)

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the extension legs on 4WC.

11 Put the halves of the adjustable brackets on the extension legs.

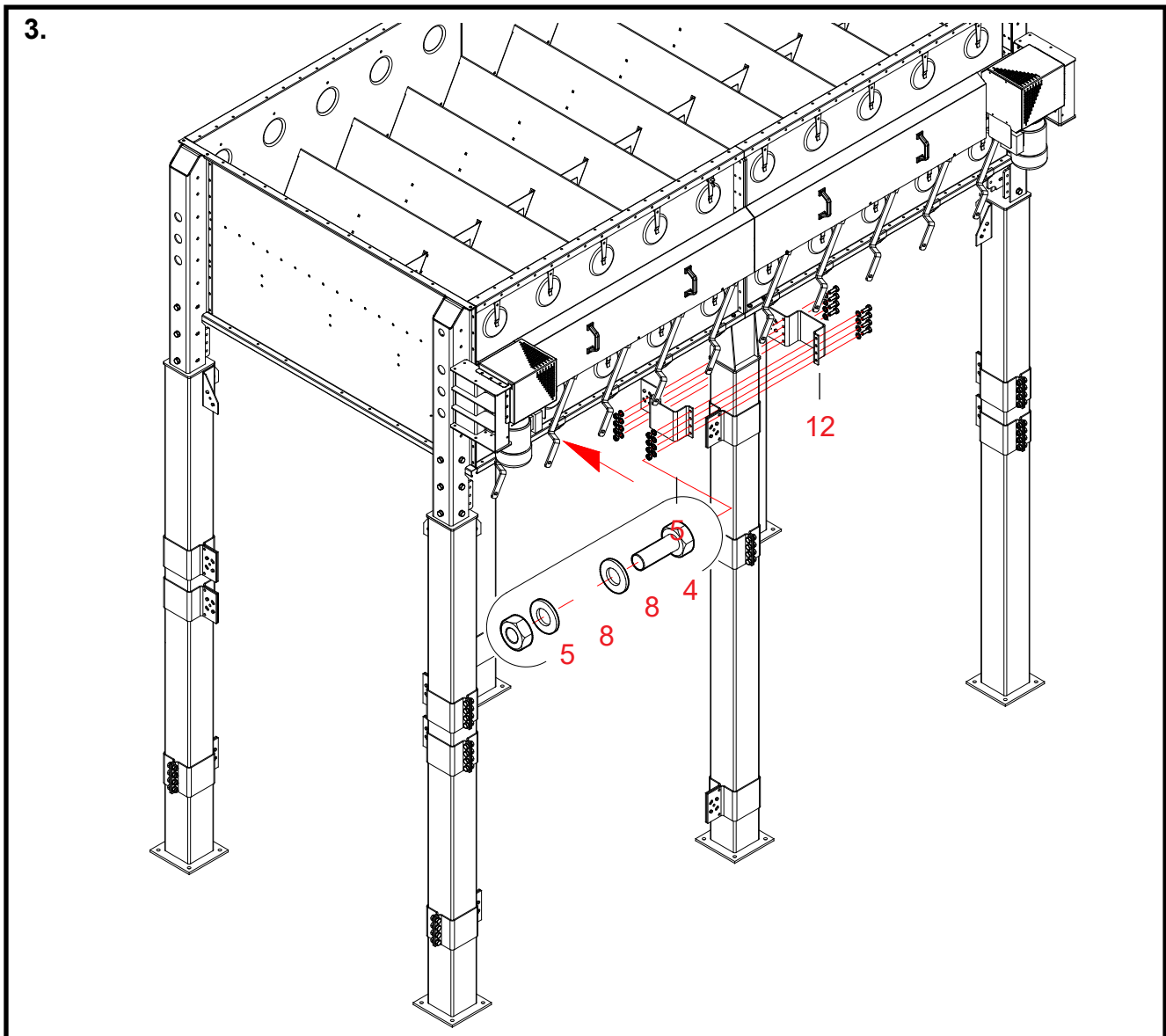
Provide the two legs, in the front of the drawing, with two brackets placing them near the centre of the leg.
Provide both legs, in the middle of the drawing, with one bracket each placing it near the centre of the leg.
Provide also the legs, in the rear of the drawing, with two brackets each placing them near the centre of the leg.
Check the correct direction for the bracket flange with 7 holes in the drawing.

4, 5, 8 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.



3. Installing intermediate beam brackets, 4WC with double base cone (at the upper ends of the extension legs at the centre of the base)

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the extension legs on 4WC.

12 Install the halves of the intermediate beam brackets on the upper ends of the extension legs.

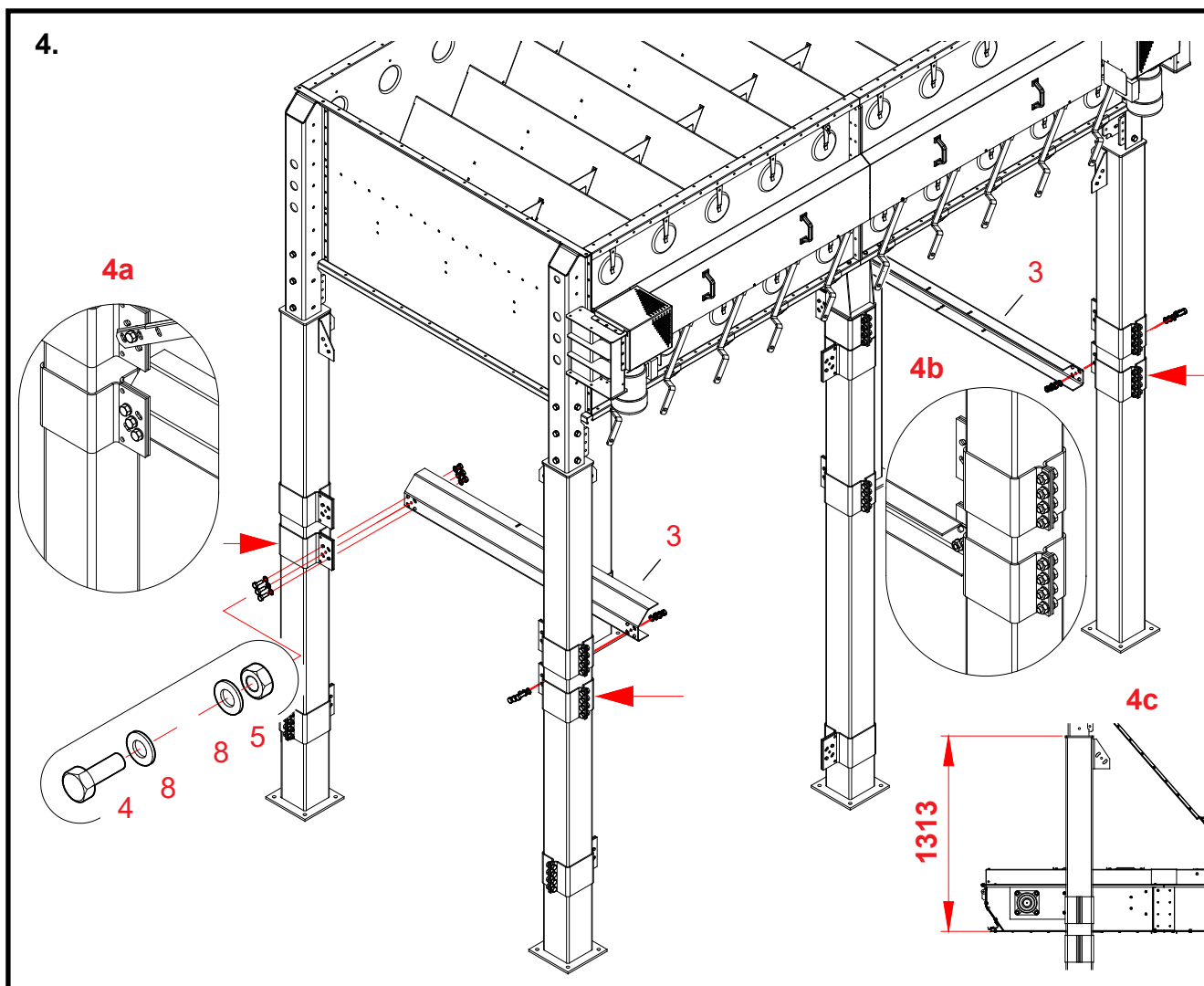
Provide both legs in the middle with one bracket, consisting of two halves.

Aim the flanges with nine holes in the brackets towards the centre of the base.

Shove the brackets against the upper flanges of the extension legs.

4, 5, 8 Install and tighten the bolts, washers and nuts (M12 x 35, 8 + 8 pcs.) in the brackets.

Look up the correct position for the bolts in the drawing.



4. Installing supporting beam for the conveyor, 4WC with double base cone

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the extension legs on 4WC.

3 Place the support beams for the conveyor in the brackets on the extension legs (see arrows).

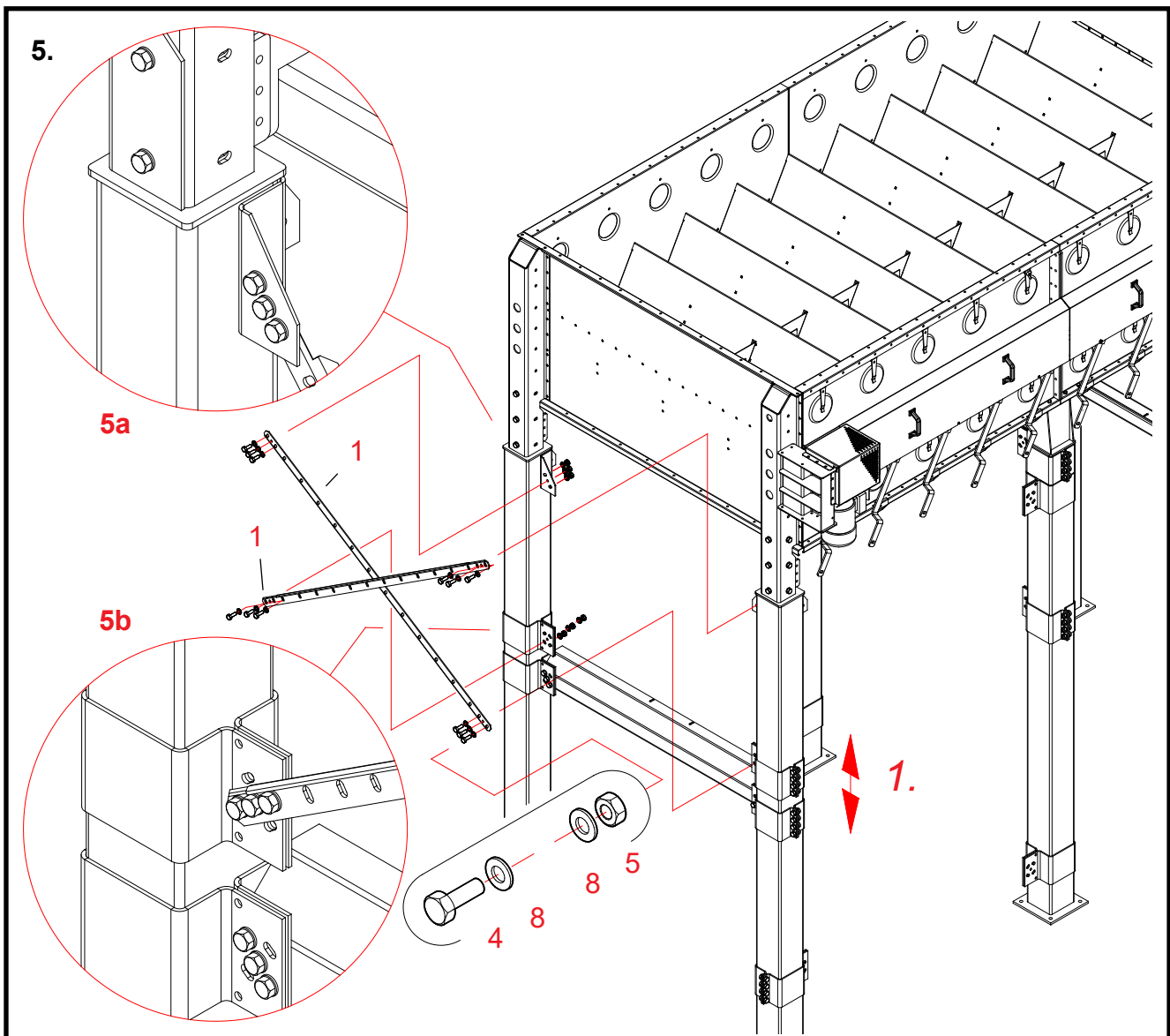
Position the support beams in the brackets as illustrated in the drawings **4a** and **4b**.

Move the beams with their brackets to such a height position, where it is possible to shove the conveyor under the base cones.

4, 5, 8 Fix the ends of the support beams to the brackets (bolts M12x35).

* Move the support beams with their brackets to the height position (1,313 mm) presented in the dimension drawing **4c**.

* Tighten the bolts of the support beam brackets.



5. Installing the upper cross-braces for the extension legs, 4WC with double base cone (on the shorter side of the base)

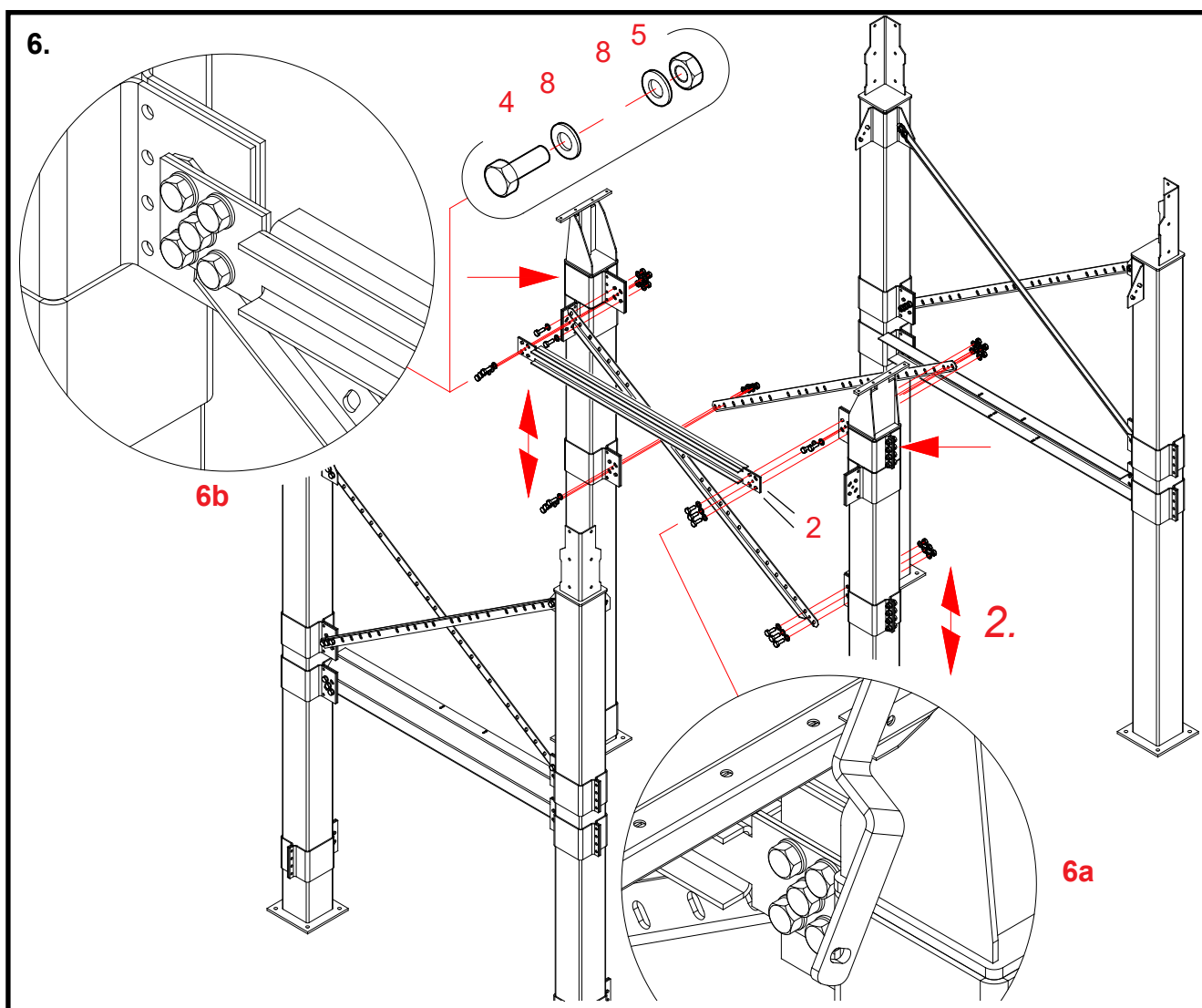
Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the extension legs on 4WC.

1 Place cross-braces in the upper brackets on the shorter side of the base (in the pair of legs in the front). Attach the lower ends of the cross-brace to the brackets on the extension legs. Select the direction and position for the cross-braces at the side of the bracket as illustrated in the drawings **5a** and **5b**.

* Move the brackets of the cross-brace to a suitable position on the extension legs (see *kohta 1*).

4, 5, 8 Fix the ends of the cross-brace using bolts, washers and nuts (M12 x 35). Look up the correct position for the bolts in the drawing. Fix the cross-braces by their both ends using three bolts.

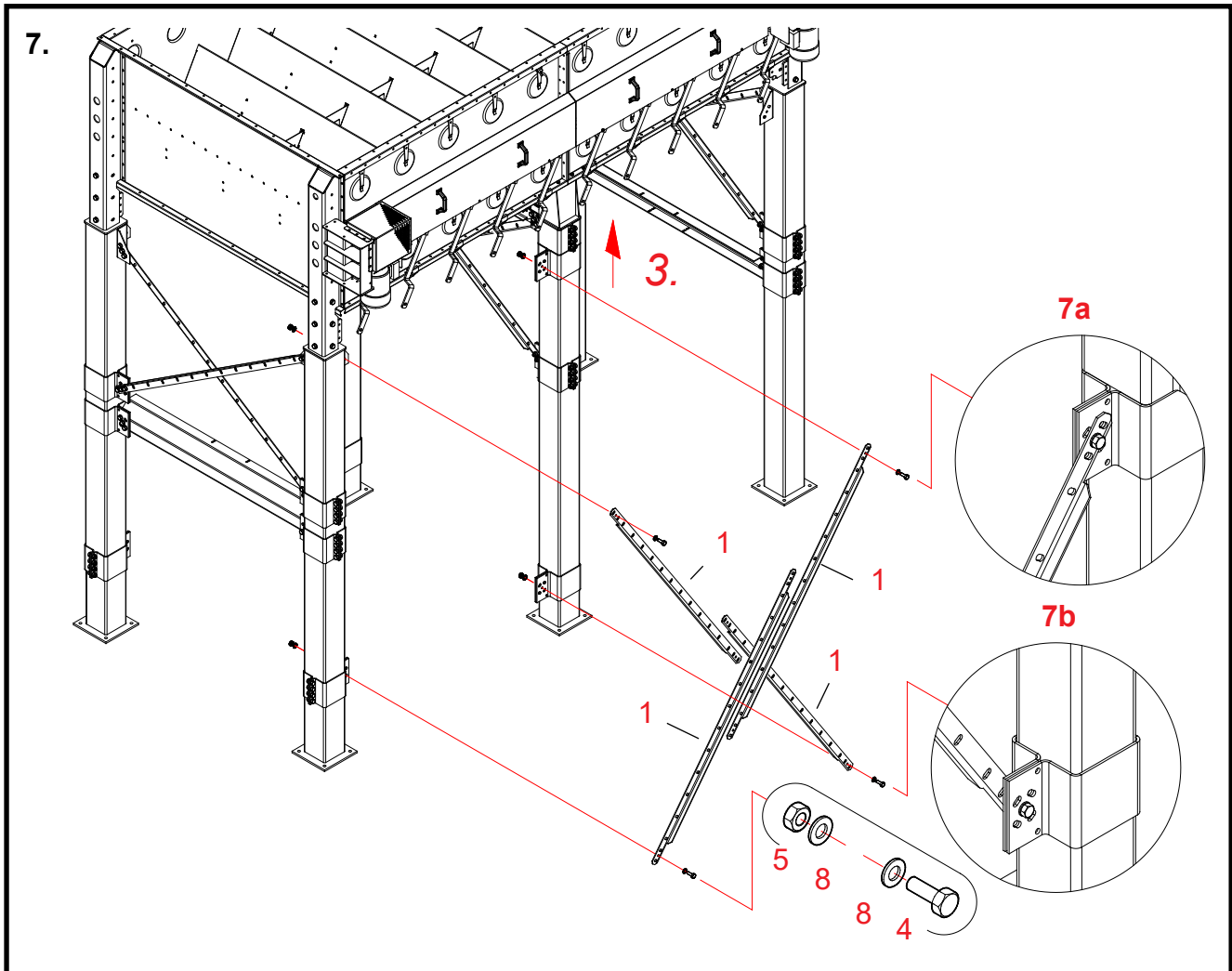
* Install correspondingly the cross-braces on the other shorter side of the base.



6. Installing the intermediate beam for the extension legs and the upper cross-braces, 4WC with double base cone

The base is not illustrated in the drawing on this page so as to preserve the legibility of the drawing.

- | | |
|----------------|--|
| Parts | The numbering of work stages refers to reference numbers in the spare parts drawing for the extension legs on 4WC. |
| 2 | Place the intermediate beam for the extension legs in the intermediate beam brackets (arrow).
The beam consists of two identical parts. Put the parts in place with the webs of the U-profiles one against the other.
Place the flanges of both beams on the same side of the bracket, as shown in the drawings 6a and 6b . |
| 1 | Place the cross-braces in the same brackets.
In the drawing 6a the cross-brace is placed on the opposite side of the bracket to the intermediate beam.
In the drawing 6b the end of the cross-brace is between the bracket and the intermediate beam. |
| * | Move the brackets of the cross-brace to a suitable position on the extension legs (see kohta 2). |
| 4, 5, 8 | Fix the intermediate beams and the ends of the cross-braced using bolts, washers and nuts (M12x35).
Fix the intermediate beam and the cross-braces by their upper ends using five bolts and the lower ends of the cross-braces using three bolts. |



7. Fixing the ends of the cross-braces for the extension legs, 4WC with double base cone (on the longer side of the base)

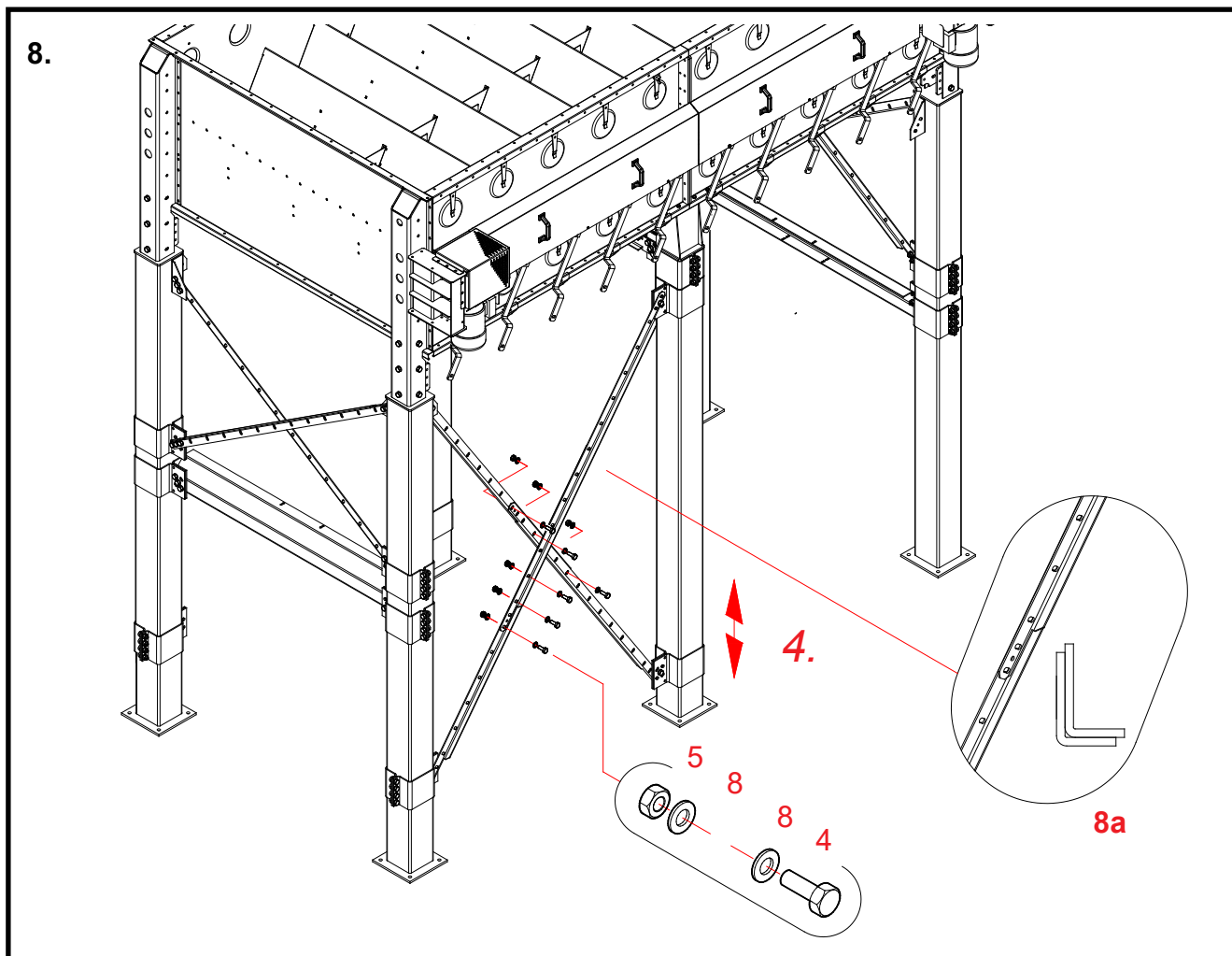
Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the extension legs on 4WC.

1 Put in place the cross-brace parts in the upper and lower brackets on the other longer side of the base. Select the direction and position for the cross-braces at the side of the bracket as illustrated in the drawings 7a and 7.

***** Move the cross-brace bracket on the middle leg against the intermediate beam bracket.
Point 3.

4, 5, 8 Fix the ends of the cross-brace using bolts, washers and nuts (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 cross-braces at the opposite longer side of the base in the same way.



8. Putting in place the bolts in the joints of the cross-braces for the extension legs, 4WC with double base cone (on the longer side of the base)

Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the extension legs on 4WC.

Place the cross-brace parts one inside the other, as shown in detail drawing **8a**.

- * **Move the lower cross-brace bracket along the extension leg. Point 4.**
Select the position so that you can install a bolt in each of the three holes at the cross-brace joint.
Extend the cross-brace as much as possible (move the lower bracket to as low as it goes).

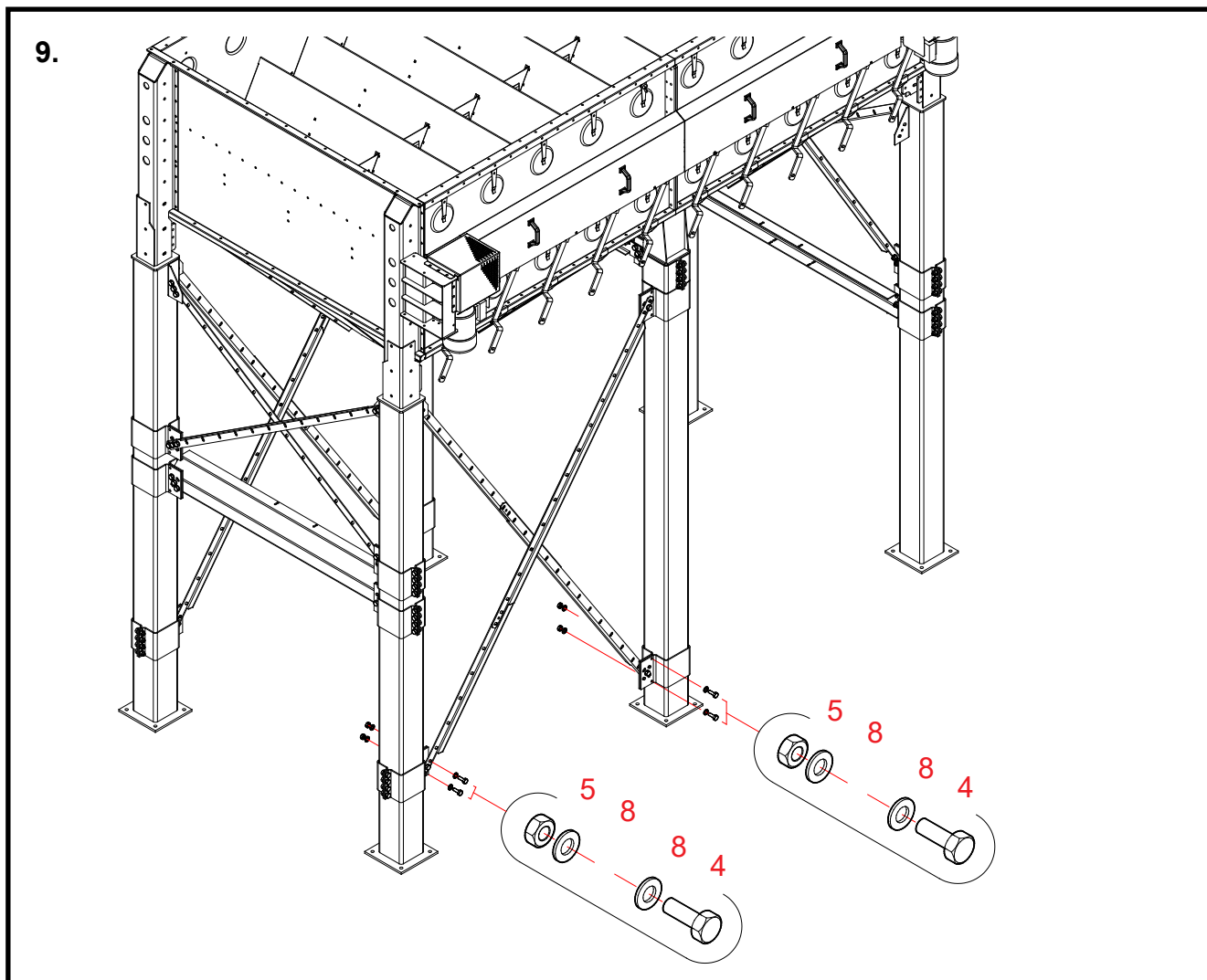
- 4, 5, 8** **Put in place and tighten the bolts at the cross-brace joints (3 pcs. M12 x 35).**
Look up the correct position for the bolts in the drawing.

- * **Put in place the bolts at the opposite longer side of the base in the same way.**



Base

Antti WM06



9. Final attachment of the upper and lower ends of the cross-braces for the extension legs, 4WC with double base cone (on the all sides of the base)

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

4, 5, 8 Put in the place the missing bolts (M12 x 35) in all adjustable brackets.

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

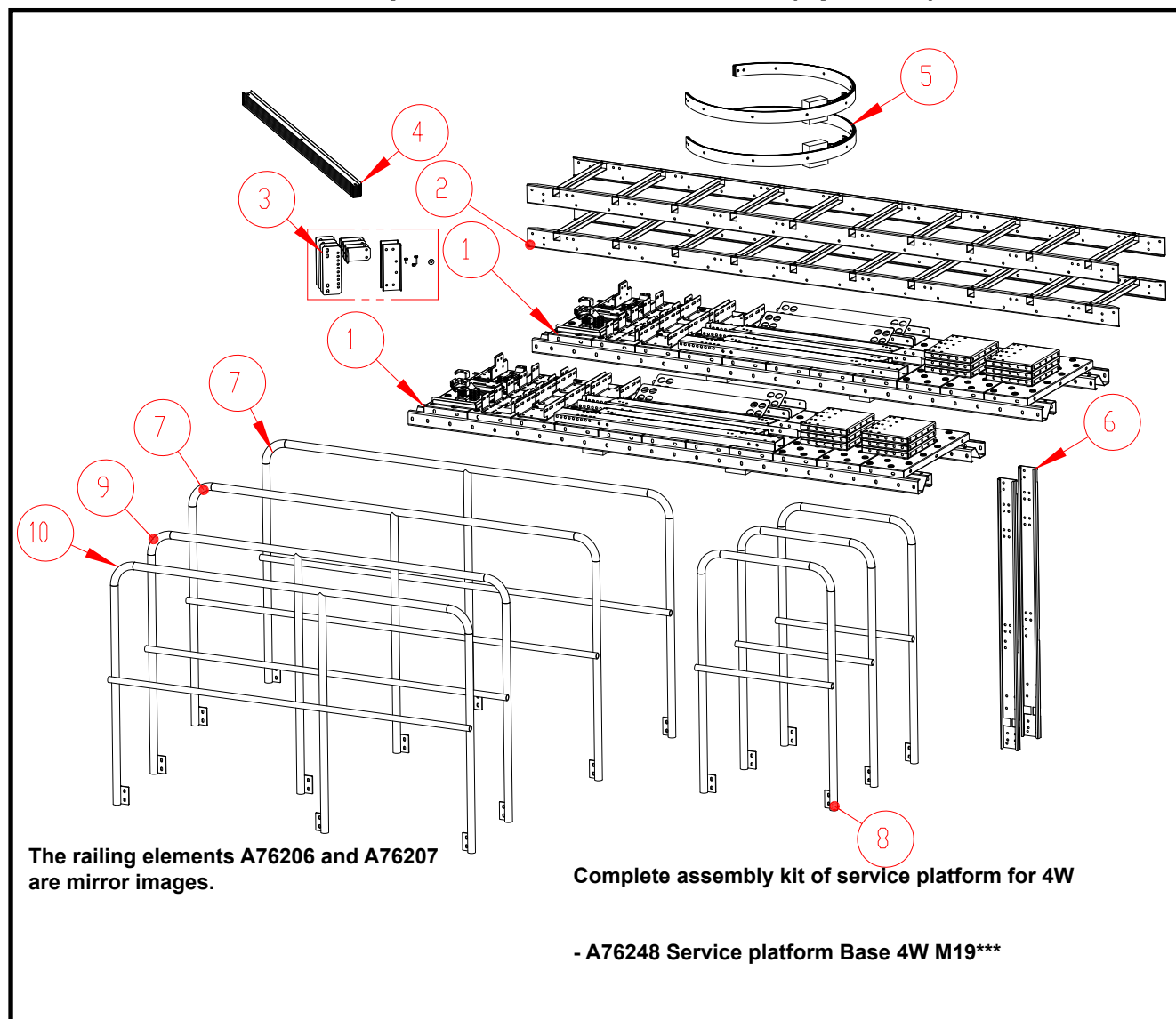
4, 5, 8 Put in place the missing bolts (M12 x 35) in the upper and lower ends of each cross-brace.

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.**

Structure of the service platform for the base 4W (optional)

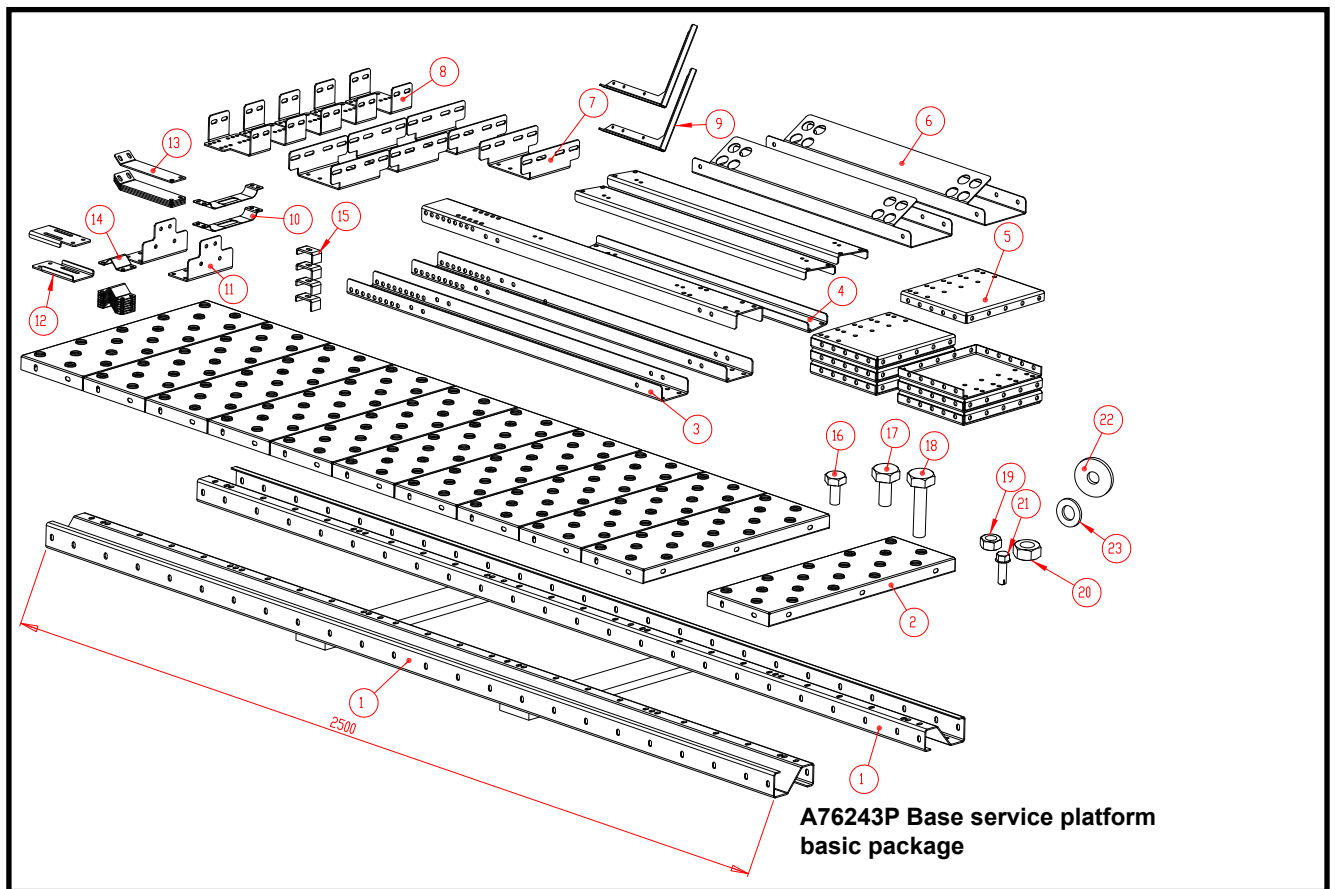


Ref.	Part no.	Denomination	Pcs.	Weight
1	A76243P	SERVICE PLATFORM BASE BASIC PACKAGE M19	2	119.12
2	A76224	PAK LADDER L=2900 M19	2	16.94
3	A76251	PAK LADDER ACCESSORY BOX M19	1	3.38
4	A76250	PAK LADDER BACK-RAIL PACKAGE M19	1	13.92
5	A76249	PAK LADDER GUARD-ARC PACKAGE M19	2	9.36
6	A76253	PAK LADDER UPPER EXIT RAIL M19	2	2.71
7	A76205	RAILING ELEMENTS L 2012 M19	2	13.28
8	A76208	RAILING ELEMENTS L 671 M19	3	6.49
9	A76206	RAILING ELEMENTS L 1773 A M19	1	12.46
10	A76207	RAILING ELEMENTS L 1773 B M19	1	12.46



Base

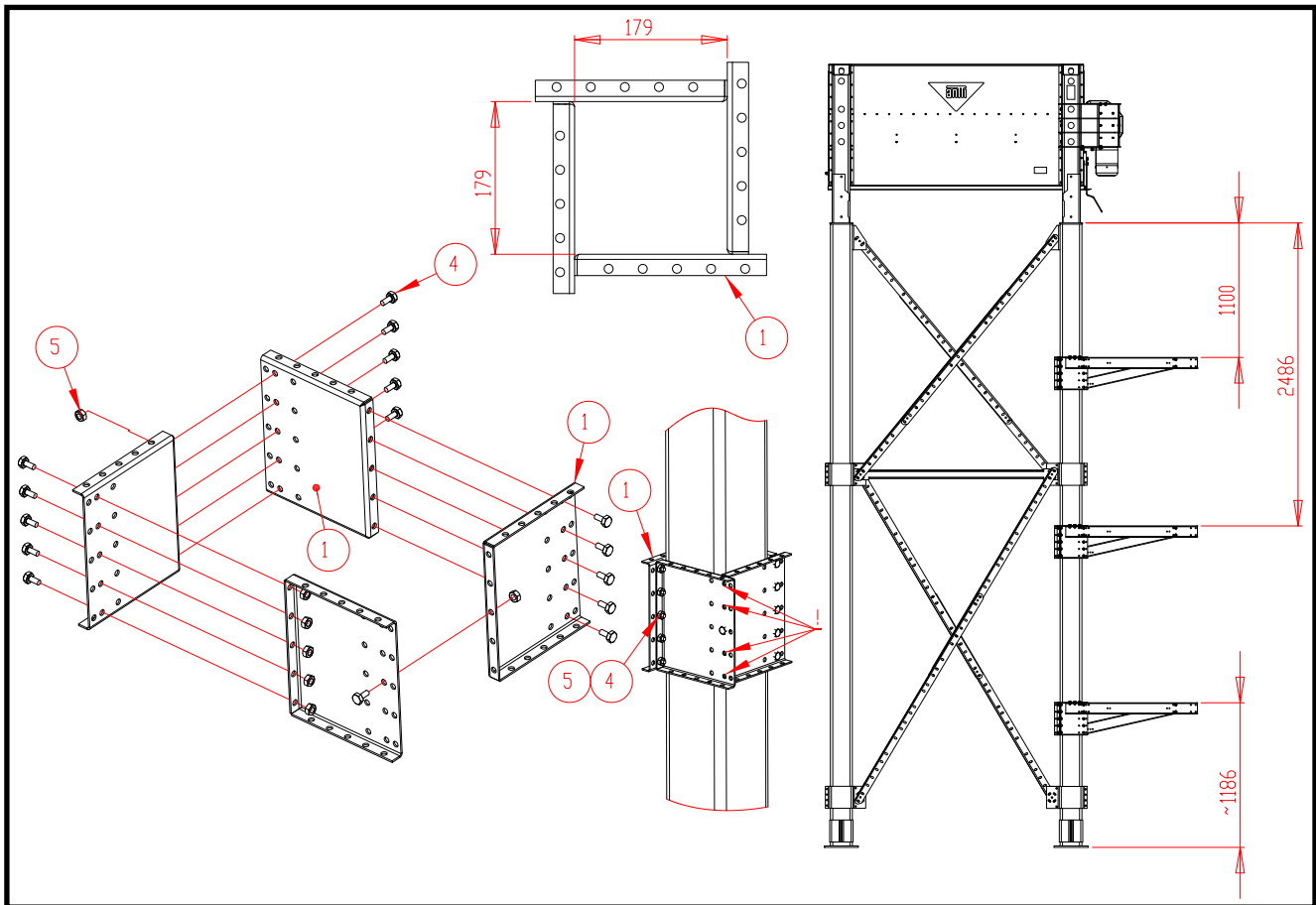
Antti WM06



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	BOLT HEX ZN 8.8 8X16 DIN933	74	0.01
17	102200	BOLT HEX ZN 8.8 10X20 DIN933	175	0.02
18	102250	BOLT HEX ZN 8.8 10X40 DIN933	5	0.01
19	110540	NUT M8 ZN 8 DIN934	74	0.01
20	110560	NUT M10 ZN 8 DIN934	179	0.01
21	107523	DRILL SCREW 6HEX 5,5X19 ZN DIN7504-K	12	0.01
22	111563	FENDER WASHER M10 D34/D11x3 DIN440R ZN	23	0.01
23	111550	WASHER ZN M10 DIN 125	46	0.01

Installing the service platform for the base 4W (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 two bands 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 edges of the lower bands according to the dimensions shown the drawing.

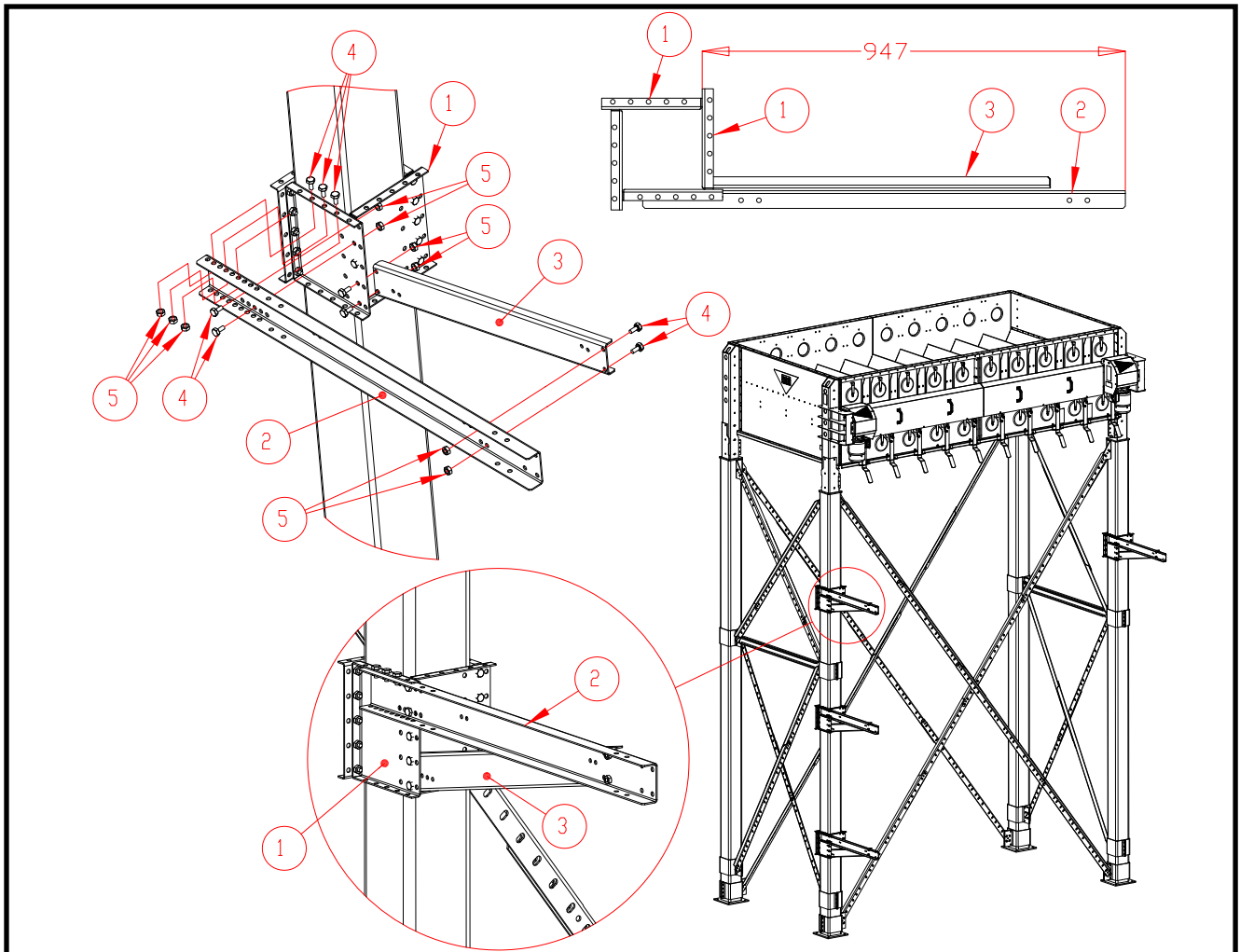
Fix the parts of the bands using nuts and bolts (M10x20,16 pcs./set-up).

Assemble the bands for the 4W dryer using the bolthole rows in the centre. (opening in the band 179x179 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, 4W

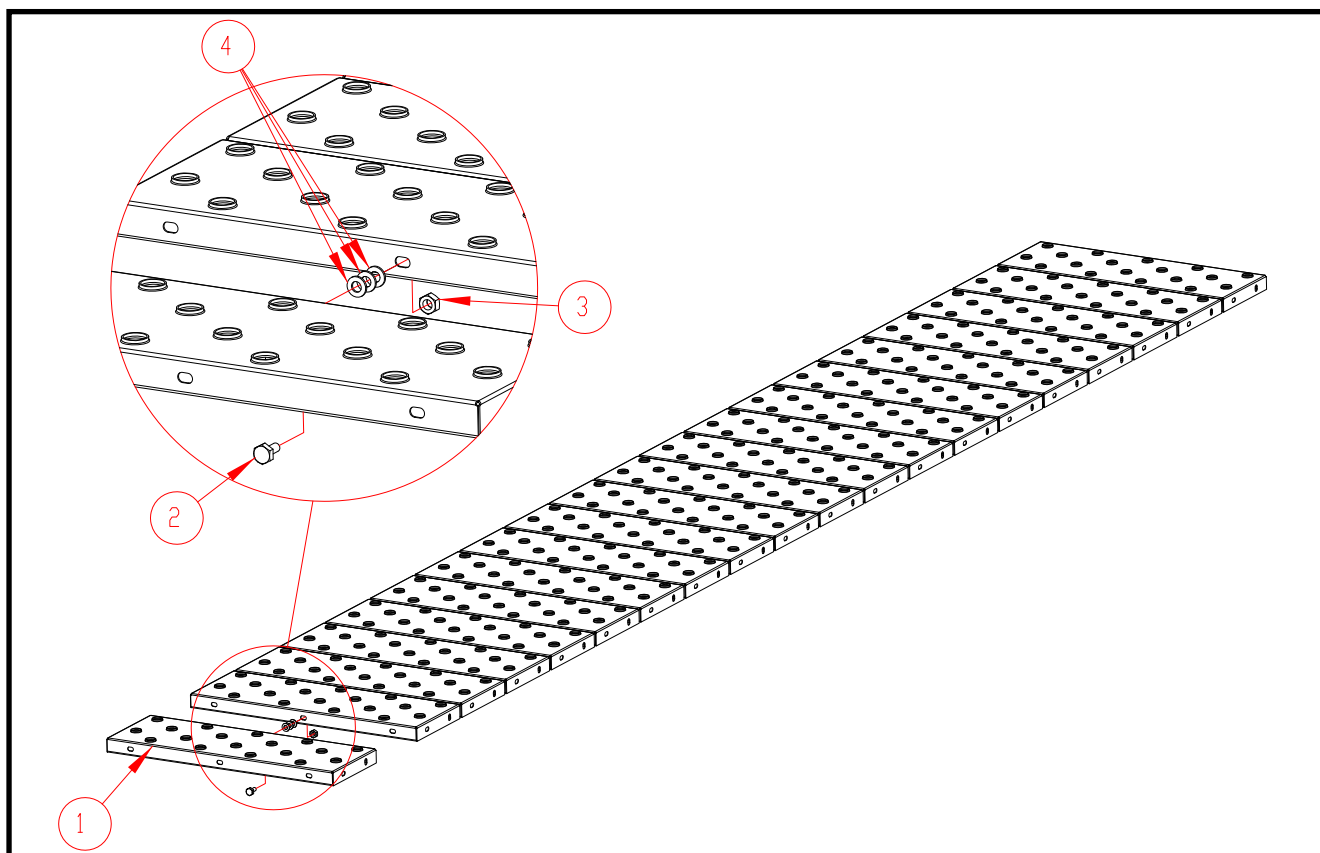
Place the crossbars of the platform bearers (parts 2) in the bands for the bearers.

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

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

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

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



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

Joining the platform elements, 4W

Start by joining 20 pcs. of platform elements (A71545) together.

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

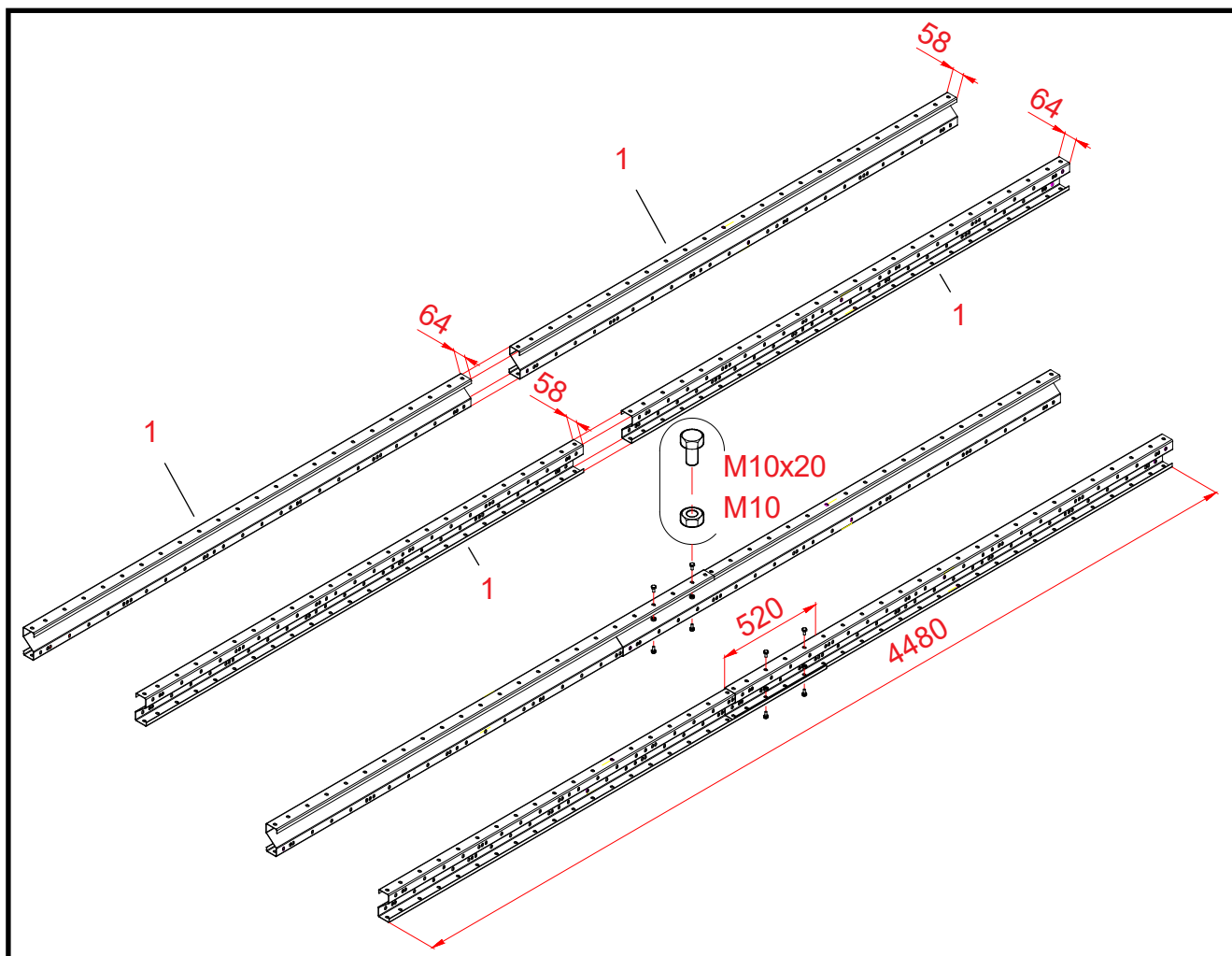
Join the platform elements together using nuts and bolts (M10x20, 1 pcs./element joint).

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

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

See detail drawing 1.

It is advisable 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 4W") on page 90.



Assembling the Z-beams, 4W

Assemble two Z-beam set-ups of Z-beams (A71919).

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

Overlap and join together two 2500-mm long Z-beams.

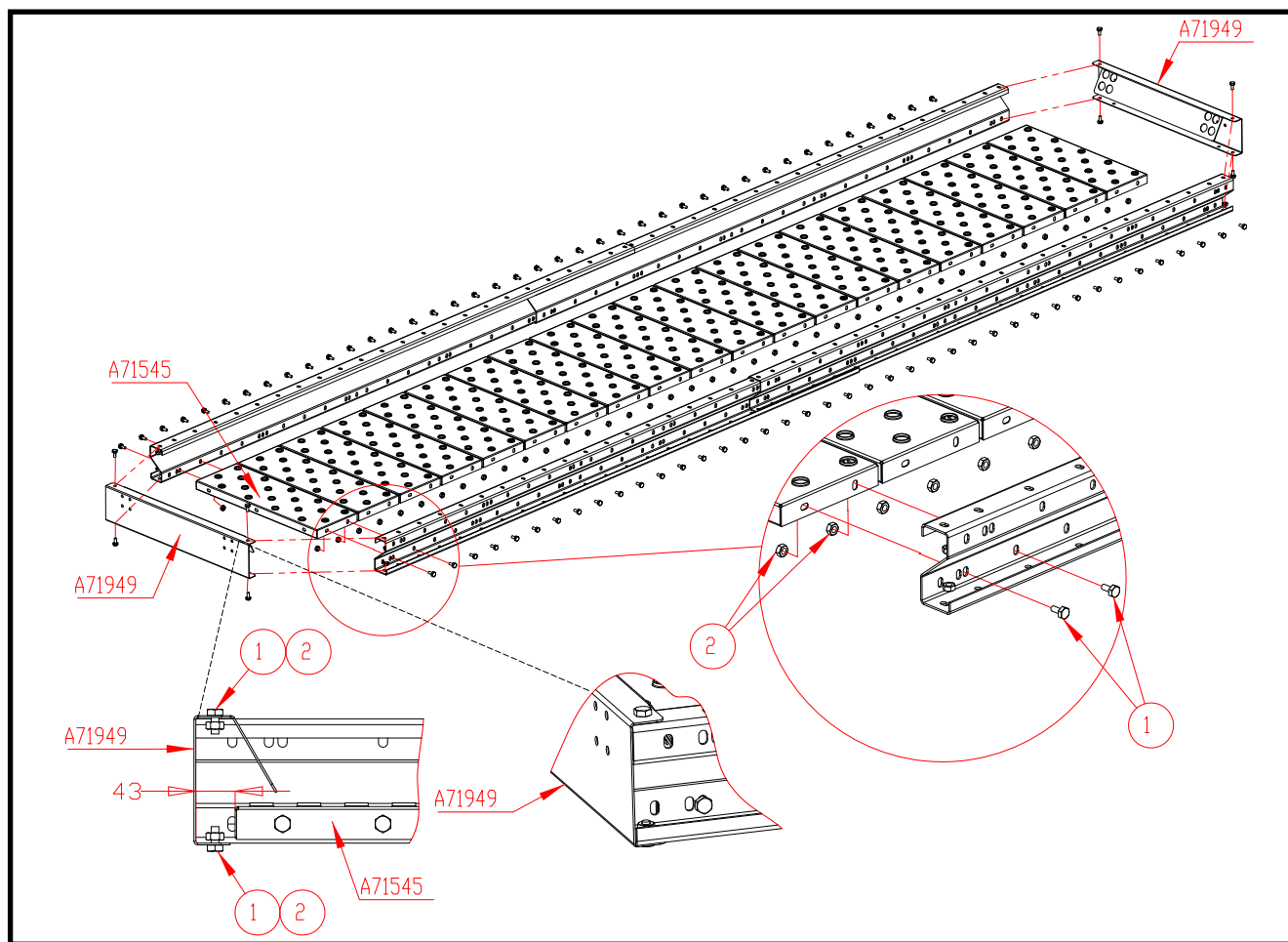
The joining position of the beams is illustrated in the drawing 1 (put the 58-mm flange inside the 64-mm flange). Join the Z-beam so that its length will be 4,480 mm (overlapping 520 mm). See drawing 2.

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 93

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



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, 4W

Install a Z-beam set-up (A71919+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.

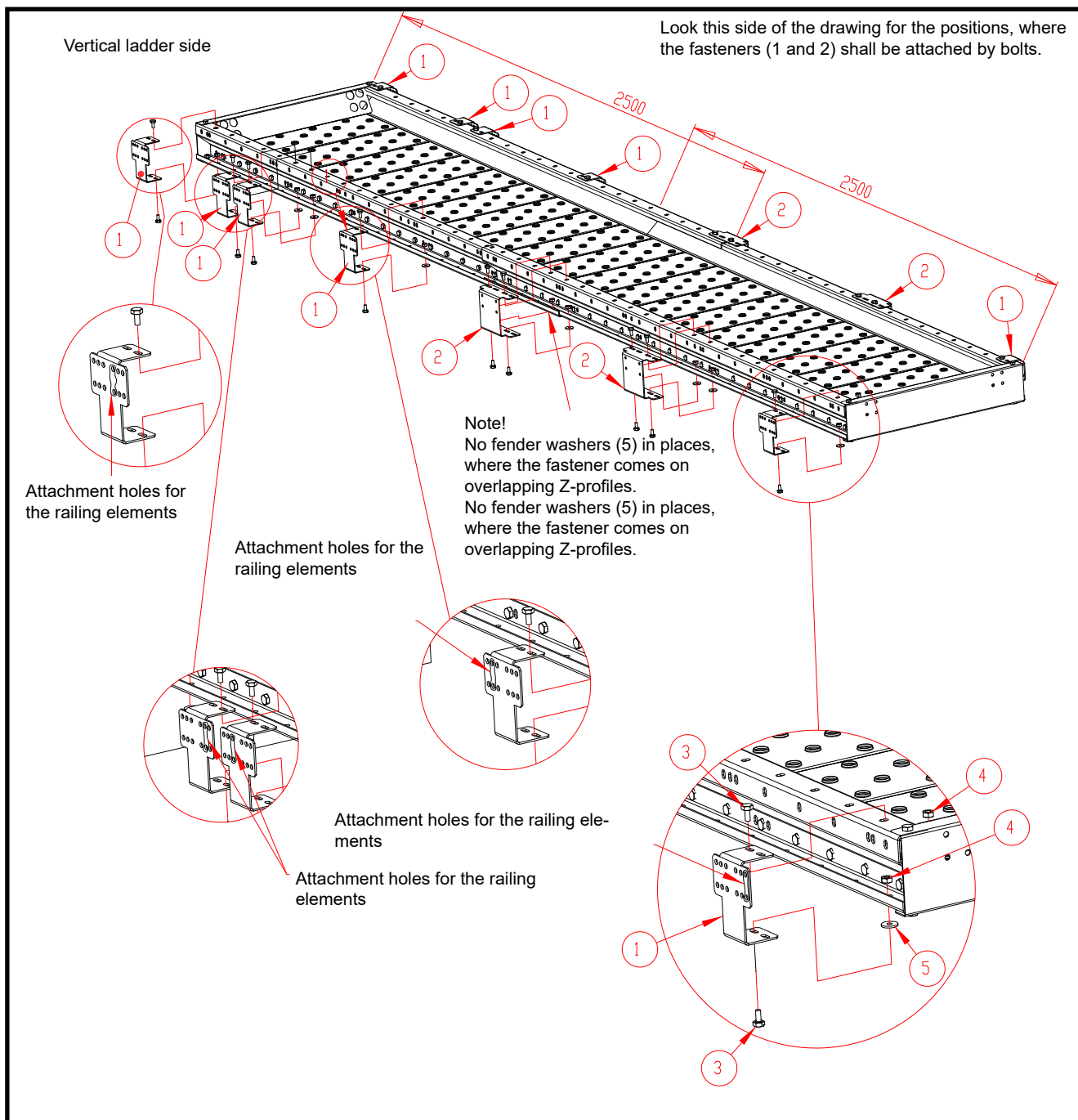
Fix each element by its both ends using two nuts and bolts (M10x20).

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).



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



Base

Antti WM06



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.

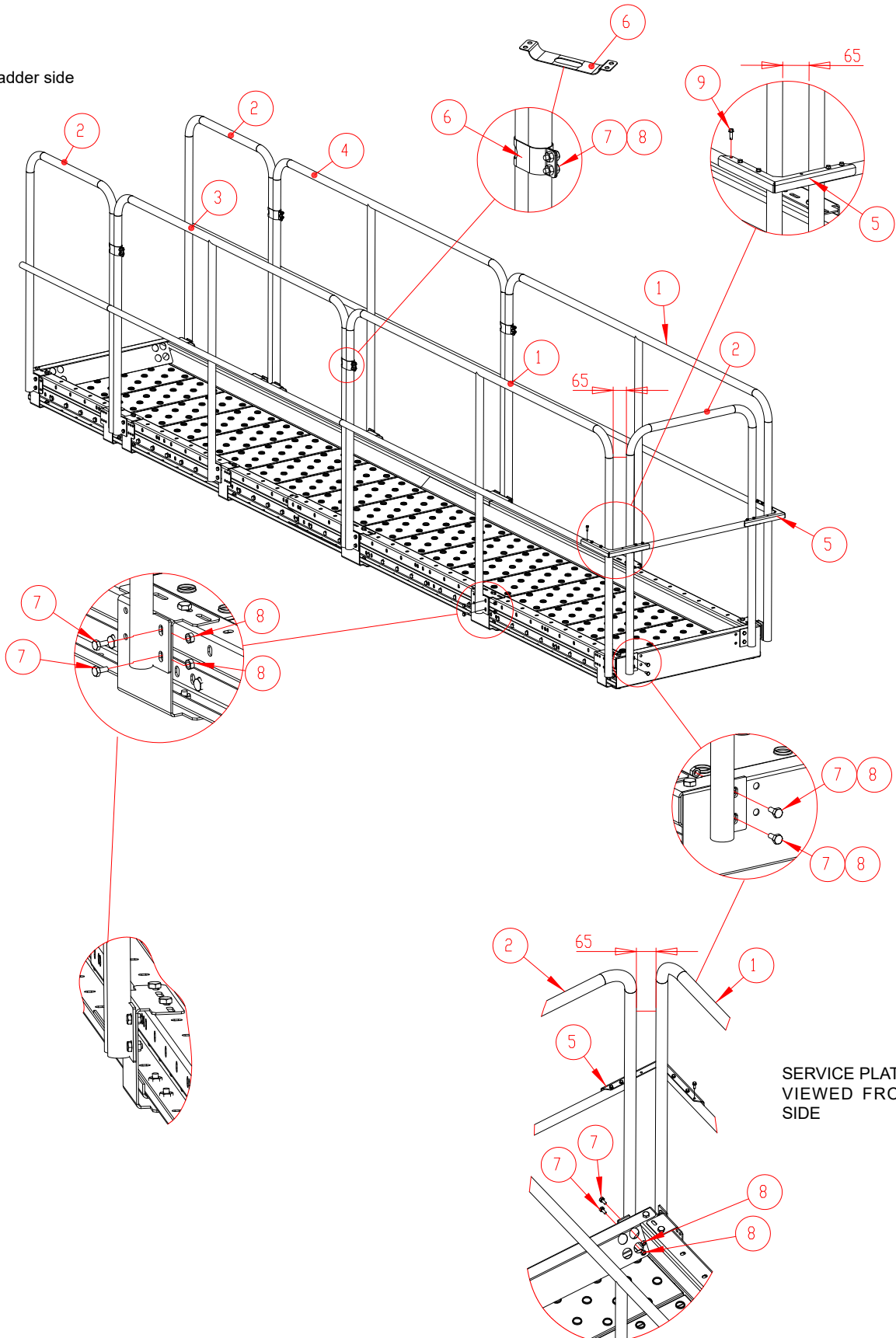
Put a fender washer (part 5) between the fastener plate and the lower edge of the Z-beam in each bolt joint, except the joints with overlapping Z-beams.

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.

Wall ladder side



SERVICE PLATFORM
VIEWED FROM IN-
SIDE



Ref.	Part no.	Denomination
1	A76205	RAILING ELEMENTS L 2012 M19
2	A76208	RAILING ELEMENTS L 671 M19
3	A76206	RAILING ELEMENTS L 1773 A M19
4	A76207	RAILING ELEMENTS L 1773 B M19
5	A76214	RAILING SUPPORT PART M19
6	A76216	RAILING FASTENING PART M19
7	101810	BOLT HEX ZN 8.8 8X16 DIN933
8	110540	NUT M8 ZN 8 DIN934
9	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.

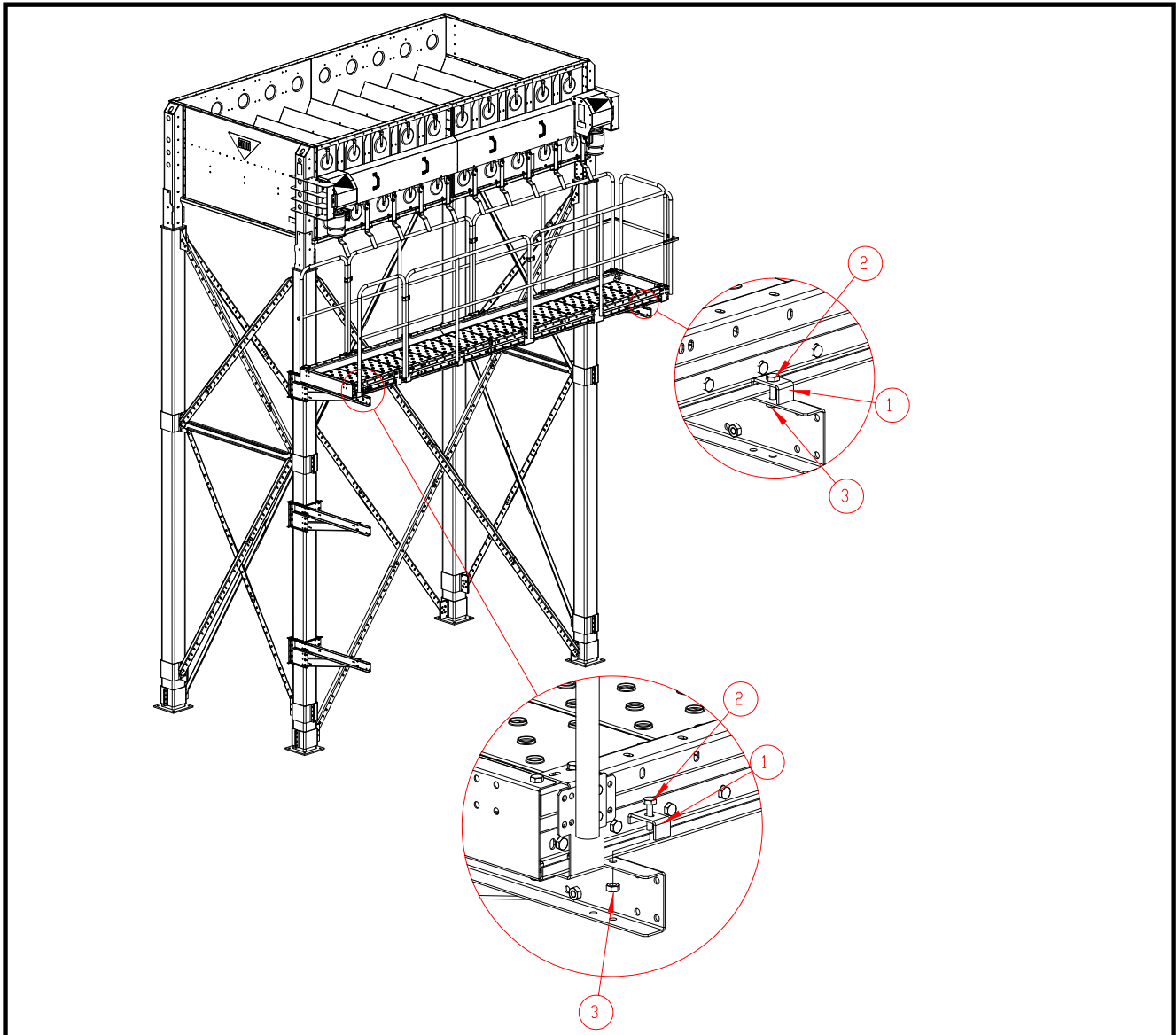
Assemble the parts of the railing as shown in the drawing. Check that all the railing sections are in line. A gap, about 65mm wide, shall be left between the railing pipes at the end and between the railing elements on the long side.

Twine the fasteners (part 6) around the railing pipes and fasten them using M8x16 bolts.

Fix the part 5 to the railing pipes using self-tapping screws. There are holes for the self-tapping screws in the part 5. The railing pipes have no ready-drilled holes, because the screw will drill a hole for itself in the pipe. The corner support (part 5) shall be attached to the railing pipes by self-tapping screws (5 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 5 by self-tapping screws until you have first ensured that all the parts have been installed correctly in their proper places.

Observe that the railing elements 3 and 4 are mirror images.



Installing the service platform on the bearers, 4W

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 98-99).

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.

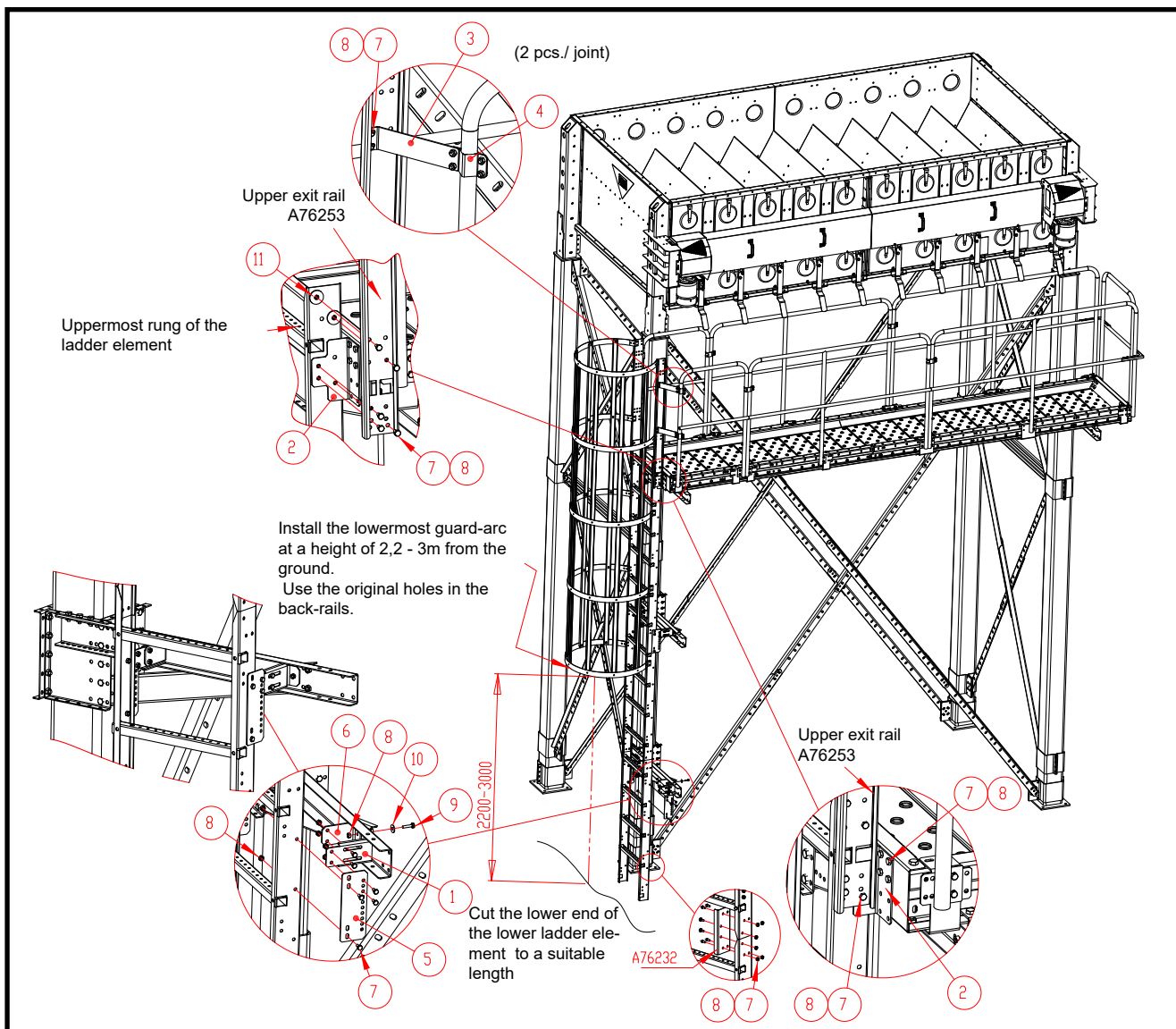
Attachment using M8x16 bolts. Also put two fender washers (part 11) in the joint between the upper exit rail and the ladder element. See detail drawing. Install the fastener and the upper exit rail on the other side of the ladder element as shown in the detail drawing.

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 4W



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	FENDER 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

