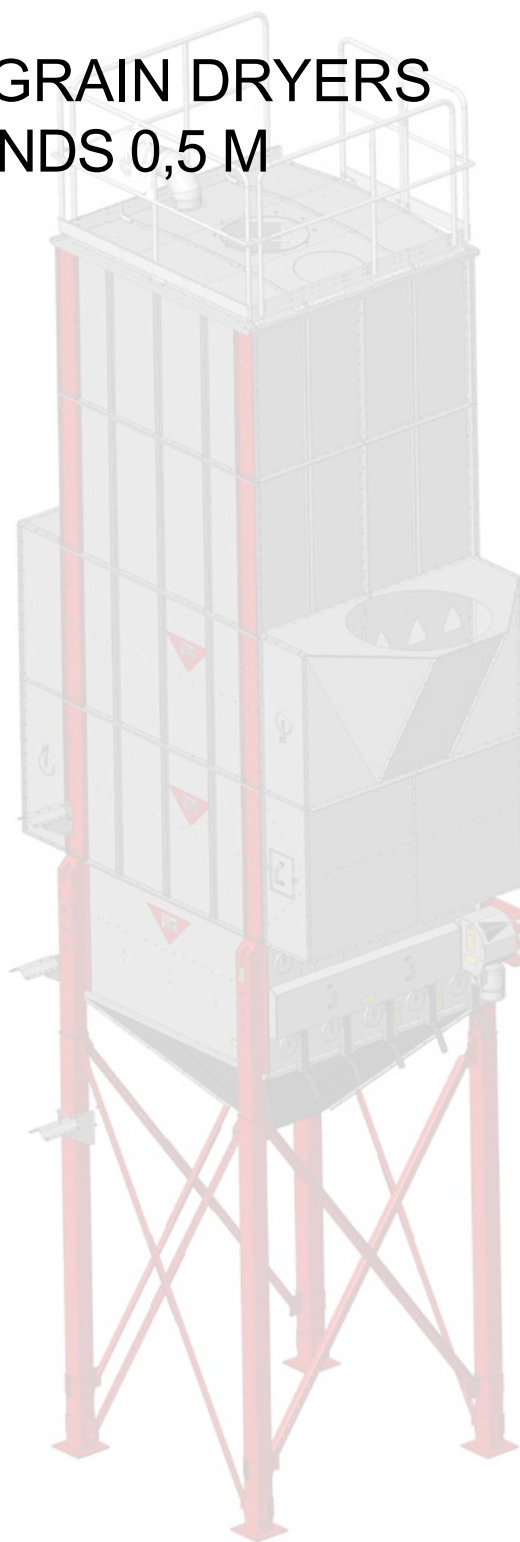


Assembly Instructions

ANTTI M06 4W GRAIN DRYERS
AIR CHANNEL ENDS 0,5 M

408094 (en) 05-2021



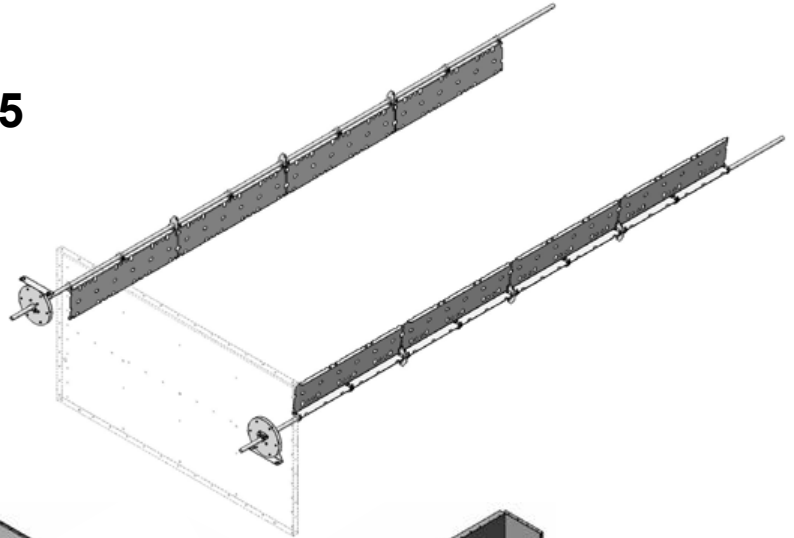
You'll see the difference

Duct row shutters 4W (A70988)	5
Air pipe connectors Ø 1000 mm, Ø 800 mm, Ø 630 mm	8
Assembling the air channel end	9
Air channel end 0,5 4W (A70663) - centre-part B	10
Air channel end 0,5 3W (A70664) - return end B	12
Air channel end 0,5 2W (A70728) - lower shutter B	16
Air channel end 0,5 4W (A70731) - upper shutter B.....	18
Air channel end 0,5 4W (A70823) - channel shutter B	20
Air channel end 0,5 4W (A70963) - lower part / upper part L, Ø 800 mm	26
Air channel end 0,5 4W (A71213) - centre-part S, Ø 1000 mm.....	30
Air channel end 0,5 4W (A71269) - lower part / upper part L, Ø 1000 mm	32
Air channel end 0,5 4W (A71412) - lower part / upper part L, 2 x Ø 800 mm	38
Air channel end 2W / 3W / 4W (A71090) - centre-part L, ø 1250 / 1000 mm.....	44
Air channel end 0,5 (A71561) - replacement air opening in the return bottom.....	48
Air channel end 0,5 (A71577) - replacement air opening in the shutter-plate	48
Air channel end (A71406), manhole hatch - end-plate	51
Air channel end 0,5 (A76263) - fan mounting parts	52



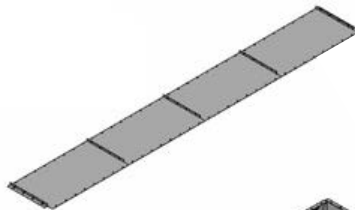
Air channel ends 4W 0,5

Duct row shutters A70988

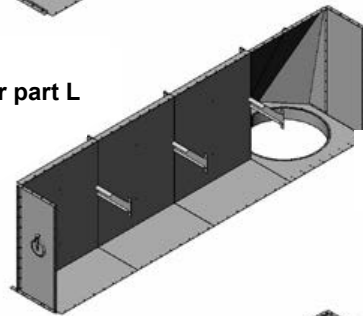


Air channel ends

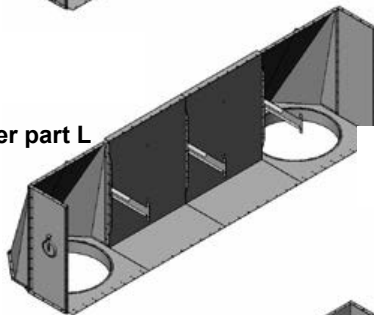
A70731
- upper shutter B



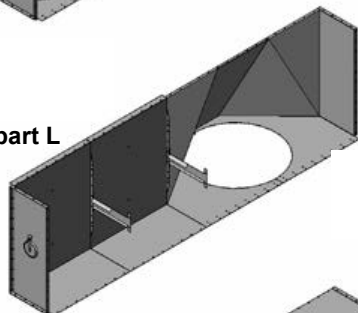
A70963
- lower part / upper part L
Ø 800 mm



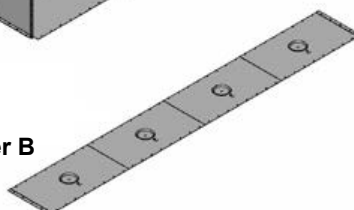
A71412
- lower part / upper part L
2 x Ø 800 mm



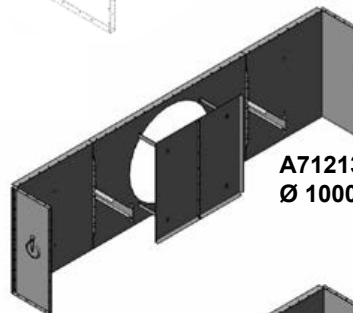
A71269
- lower part / upper part L
Ø 1000 mm



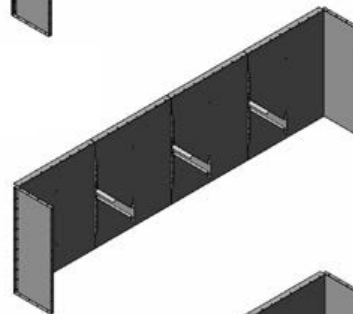
A70728 - lower shutter B



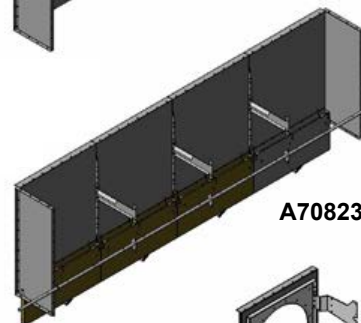
A71213 centre-part S
Ø 1000 mm



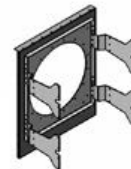
A70663
- centre-part B



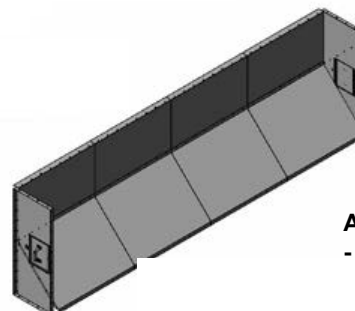
A70823 - channel shutter B



A76263
- fan
mounting parts



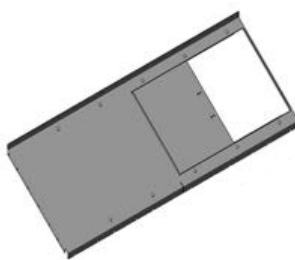
A70664
- return end B



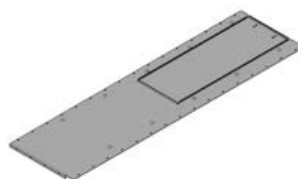


Air channel ends

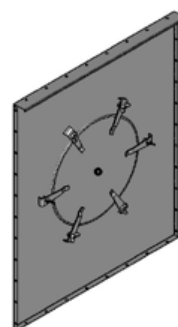
A71561 - return bottom, replacement air opening



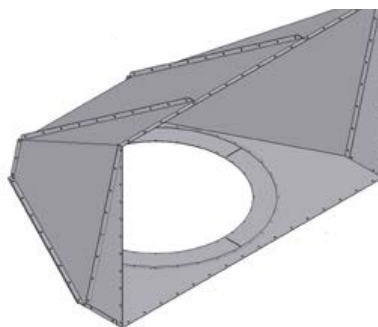
A71577 - shutter-plate, replacement air opening



A71406 manhole hatch
- end-plate

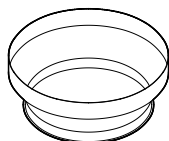


A71090 - centre-part L, $\varnothing$ 1250 / $\varnothing$ 1000 mm



Connecting parts for air pipe

508418 $\varnothing$ 800 mm / $\varnothing$ 630 mm



(A71201 $\varnothing$ 1250 mm)

A71200 $\varnothing$ 1000 mm

A71203 $\varnothing$ 1000 mm / $\varnothing$ 800 mm

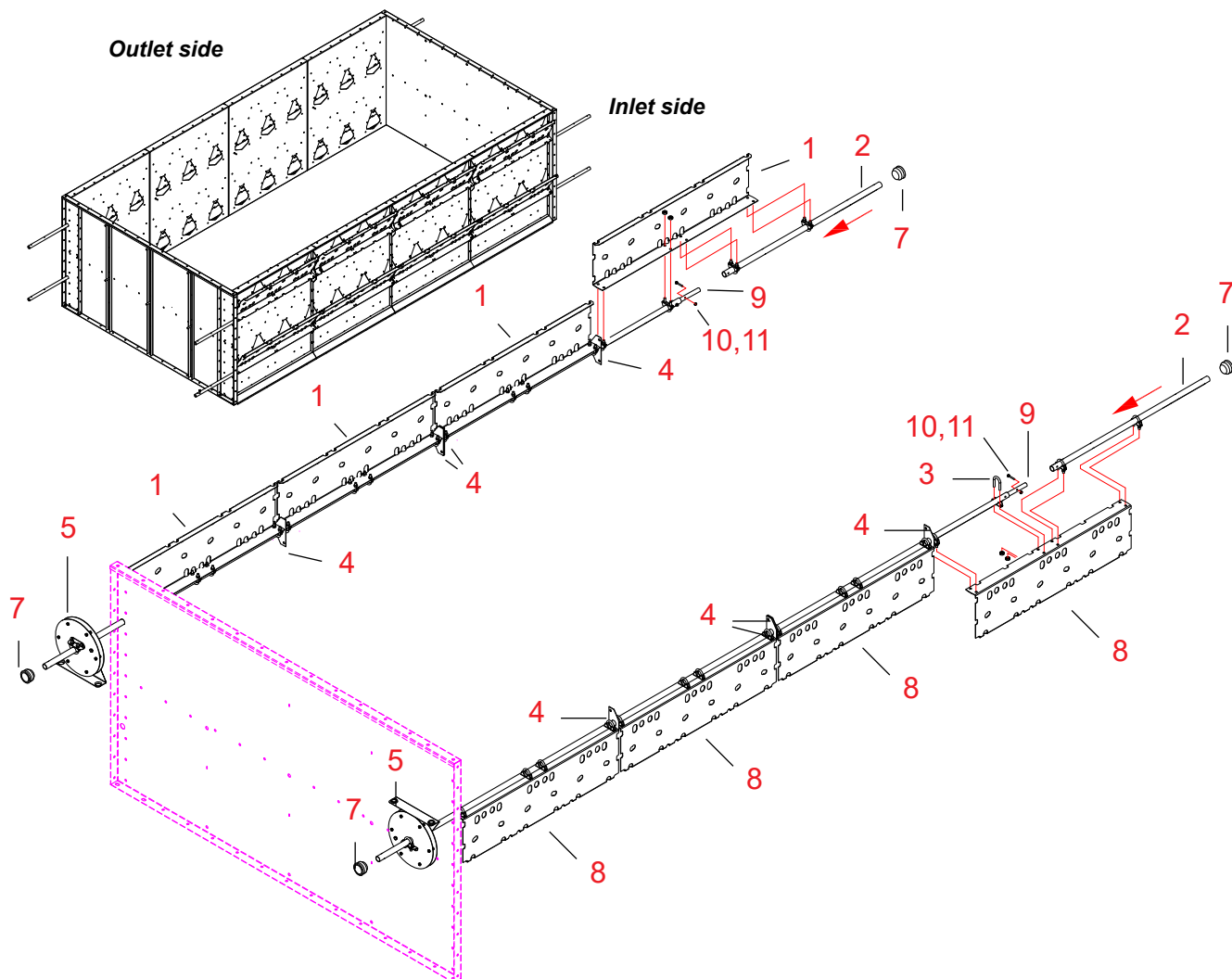
A71204 $\varnothing$ 1000 mm / $\varnothing$ 630 mm

Specifications, air channel ends with openings

D1000 (just an opening to which a suitable air pipe connector for each customer can be attached by bolts).
The air pipe connectors that always fit to the specifications are D630 (A71204), D800 (A71203) and D1000 (A71200).

The specifications include the adapter parts D1000.

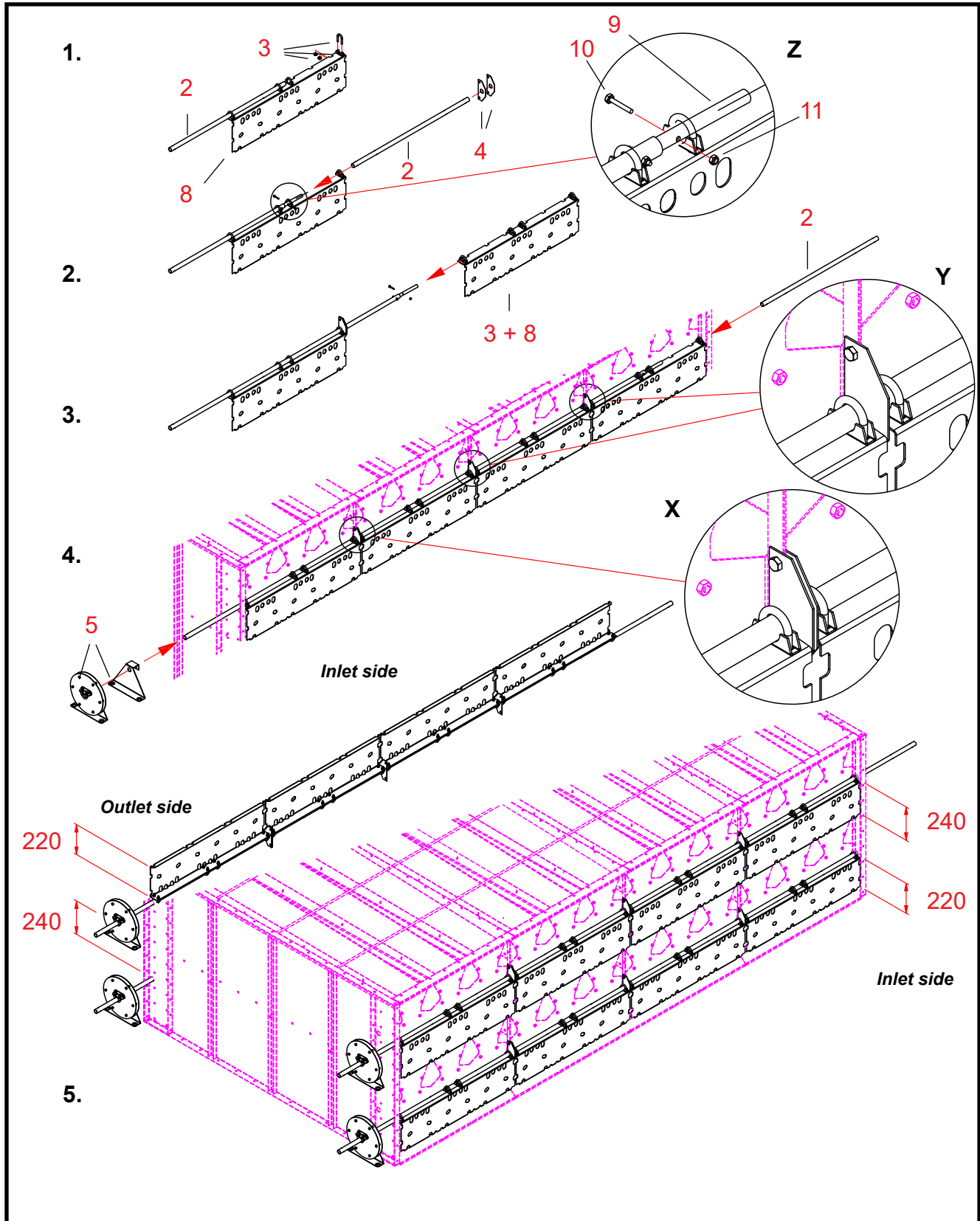
The D800/D630 (508418) air pipe connector is required for connecting the D630 pipe to air channel ends (A70963, A71412) with fixed D800 sleeve.

**Duct row shutters 4W (A70988)**
Spare parts

20061123

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Weight
1	A71283	SECTION WM06 SHUTTER	DUCT ROW PL H=220	4	4.48
2	A70548	SECTION WM06 SHUTTER	D25-958 PIPE	10	42.34
3	107930	U-BOLT FLUE PIPE BAND	M8 D=25 1883-25	32	0
4	A70551	SECTION WM06 SHUTTER	GUIDE-LUG	8	42.34
5	A70543	SECTION WM06 SHUTTER	CHAIN-WHEEL PACKAGE	2	19.92
6	114055	WIRE-LOCK	D 5	8	0
7	116065	PLASTIC PLUG	DBI 42	4	0
8	A71294	SECTION WM06 SHUTTER	DUCT ROW PL H=240	4	4.48
9	A70733	SECTION SHUTTER	EXTENSION PIPE D17,2-300	8	0,26
10	101520	BOLT HEX ZN 8.8	6X35 AM DIN933	16	0
11	110789	NUT NYLOC	6 ZN DIN985	16	0

Installing duct row shutters (A70988)



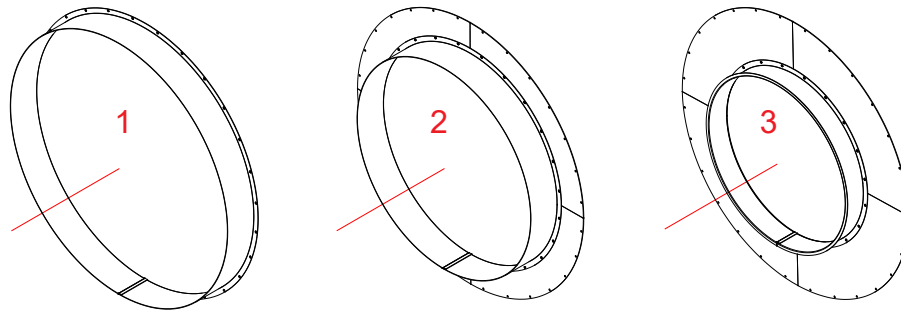


Two sets of parts A70988 are required for shutting both air duct rows in the section.

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

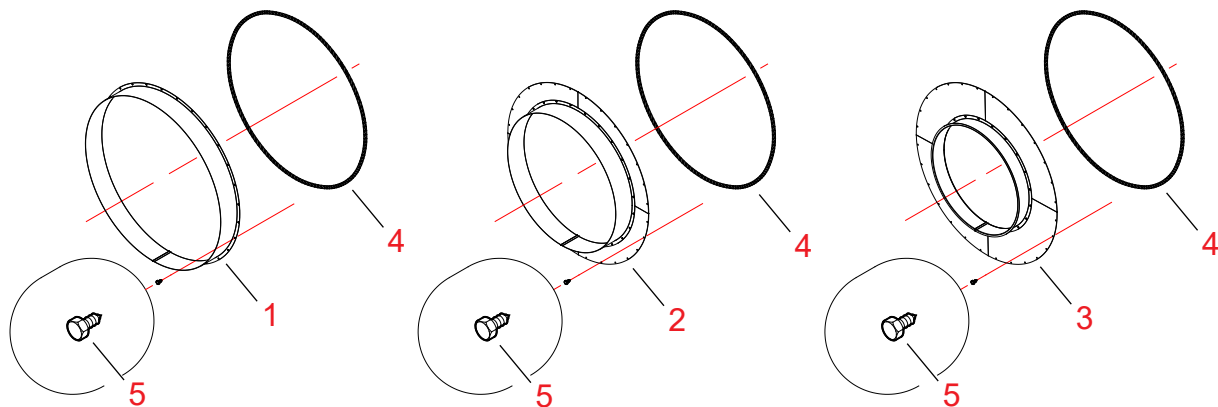
- Parts The numbering of work stages refers to reference numbers in the spare parts drawing A70988 for the air channel end.
- Fig. 1.
- 8 Select four shutter-plates, 240 mm in height, for the air duct row on the inlet side.**
- 3 Fix four U-bolt ties to flanges of all shutter-plates.**
Tighten the tie nuts only lightly to enable shifting of the shutter-plate along the shaft-pipe.
- 2 Thread one shaft-pipe through the two U-bolt ties in one of the shutter-plates.**
Place the pipe so that the pipe end remains visible between the U-bolt ties at the centre of the plate.
- Fig. 2.
- 2,9,10,11 Attach the extension pipe to the end of the shaft pipe (see detail drawing Z)**
Push the other shaft pipe inside the U-bolt ties and the extension pipe from the opposite side.
Press the pipe against the end of the pipe, installed at stage 1.
- 4 Thread two guide-lugs onto the pipe.**
- Fig. 3.
- 3, 8 Thread another shutter-plate with U-bolt ties onto the pipe.**
Place the shutter-plate on the pipe so that a free space of at least 5 mm is left between the guide-lugs.
- * Repeat the stages in accordance with drawings 2 - 3 until there are four shutter-plates in the set-up.**
Note that only one guide-lug should be placed between the other shutter-plates (detail drawing Y).
- Fig. 4.
- 8 Install the set-up, assembled as shown in the drawings 1 - 3, in the upper duct row on the inlet side of the section.**
Thread in the shaft of the set-up through the Ø 30 mm holes in the side-plate and the leg.
Remove the two bolts from the centre-seam of the section's end-plates at the guide-lugs.
Place the pair of guide-lugs on both sides of the seam and re-insert the bolts (detail drawing X).
- 2,9,10,11 Install the fourth extension pipe.**
Thread in the fifth shaft-pipe through the side-plate and the leg of the section in the U-bolt ties in the shutter-plate.
Push the pipe from the opposite side of the section against the end of the pipe, already in place.
- * Shift the shutter-plates to their correct positions on the shaft.**
Ensure, that the slots and holes in the shutter-plate are placed at the bolt-heads.
Turn the shutter-plate between its upper and lower positions.
Ensure, that the shaft-pipe ends remain in contact after the adjustment.
Align the shutter-plates and tighten the U-bolt tie nuts.
- 5 Place the chain-wheel unit onto the shutter-plate shaft.**
Thread first the chain-guide onto the shaft and, after that, the chain-wheel.
Tighten the nuts of the U-bolt ties only lightly at this stage.
- Fig. 5.
- * Install the shutter-plates, 220 mm in height, in the lower duct row on the inlet side of the section.**
- ### 2. Installing the shutter-plates on the outlet side (in both, or sometimes, in only one of the duct rows)
- * Install the shutter-plates, 220 mm in height, in the upper duct row on the outlet side.**
Install shutter-plates, 240 mm mm in height, in the lower row.

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



20061019

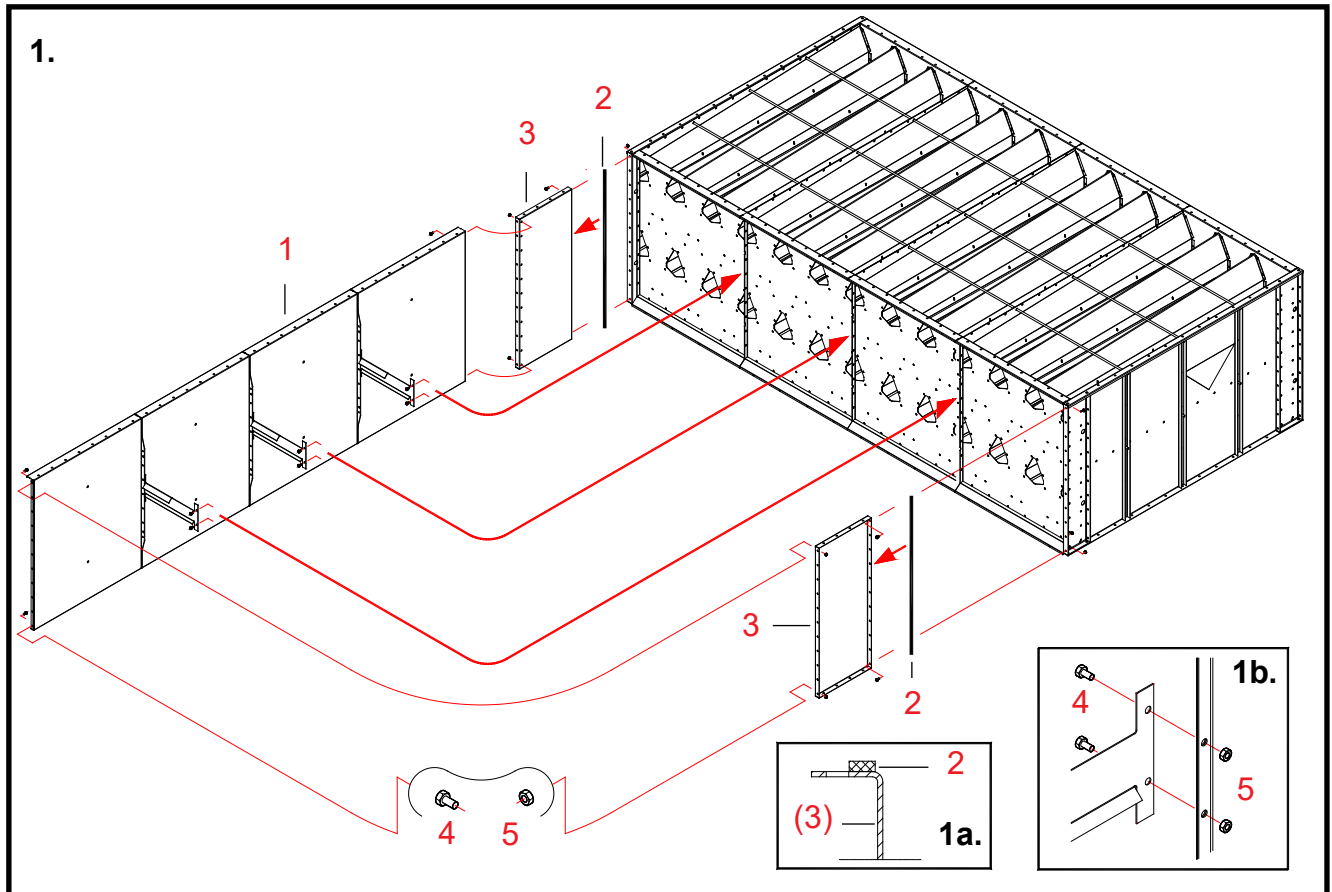
Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A71200	AIR PIPE SLEEVE	D1000X120	1	A71200	5.18	3500
2	A71203	AIR PIPE WM06	CONV PART D1000/D800	1	A71203	9.40	3000
3	A71204	AIR PIPE WM06	CONV PART D1000/D630	1	A71204	11.49	3000



Installing the air pipe connector in the air channel end

- 1 / 2 / 3 Select the air pipe connector in accordance with the size of the air pipe system (1000 mm / 800 mm / 630 mm).
- 4 Fix a sealing strip to the air pipe connector flange.
Fix the sealing strip inside the screw hole row in the connector flange.
- 5 Fix the connector to the air channel end using self-tapping screws (4,8 x 13, 28 pcs.).

Assembling the air channel end



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

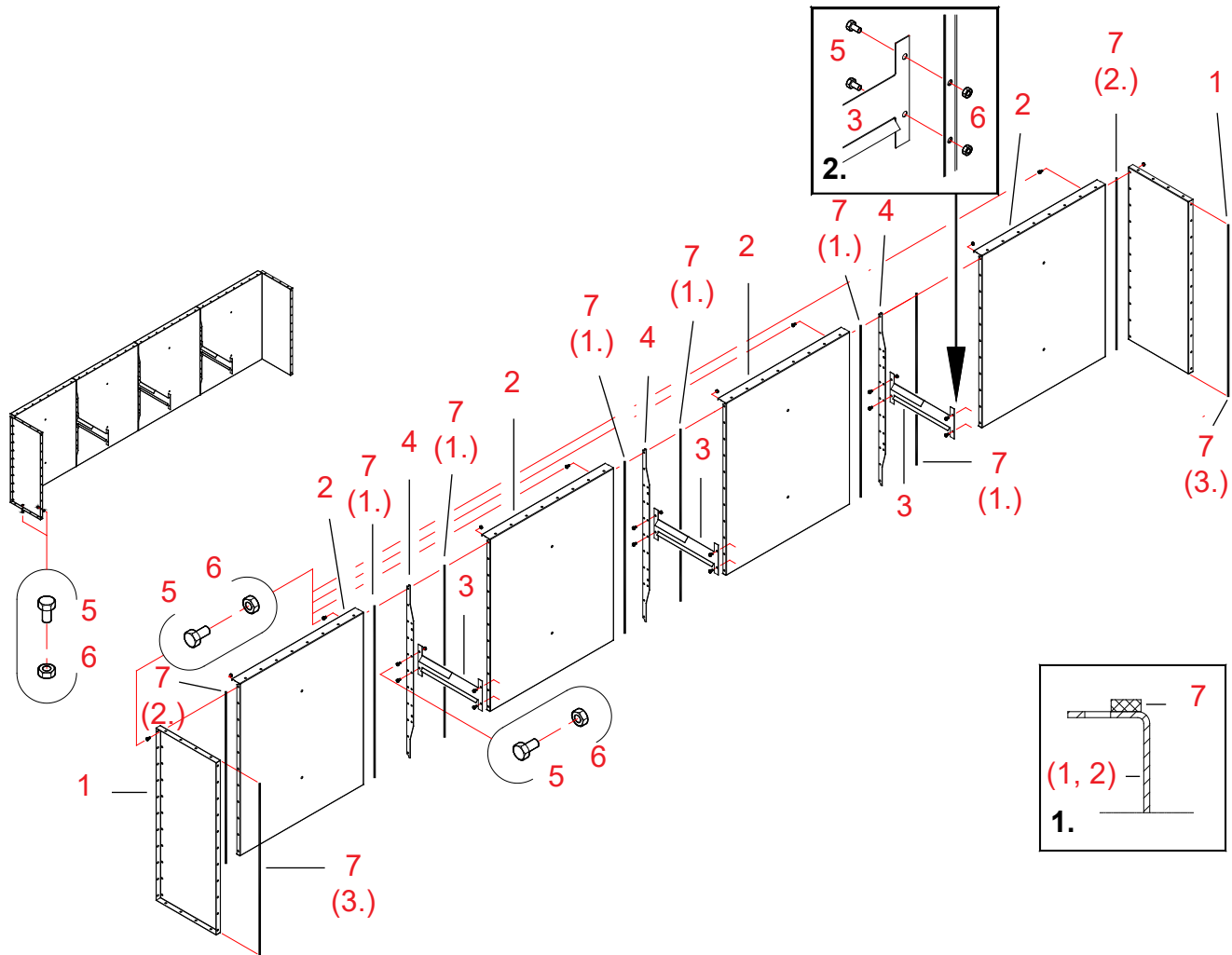
Parts

- 1 **Assemble a sub-assembly of the air channel end end-plates in accordance with separate instructions for each air channel end model.**
If an upper or a lower shutter-plate are included in the set-up, make a separate sub-assembly of them as well.
- (4, 5) **Remove the bolts and nuts (2 pcs.) from the section (from the attachment point of the air channel end's straight support).**
Only in case that the air channel end to be installed has a straight support. Fig. 1b.
- 2 **Fix sealing strips to the attachment flanges of the side-plates (parts 3) to be attached to the drying section.**
- 3 **Move the side-plates tight against the ends of the section.**
- 4, 5 **Fix the side-plates using bolts and nuts (M8 x 16, 11 pcs. /side-plate).**
- 1 **Move the shutter-plate or the end-plate sub-assembly, if any, against the side-plates.**
Position the air channel end support on the same side of the drying section's centre seam as it is at the end.
Attach the set-up(s), assembled at stage 1 to (the section and) the side-plates.
Fix the straight supports for the air channel end to the section.
- * **Check the joints and rectangular shape of the air channel end. Tighten all bolts.**



Air channel end 0,5 4W (A70663) - centre-part B

Spare parts



20061106

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A70635	AIR CHANN END WM06 0.5	SIDE-PLATE	2	A70635	7.52	3000
2	A70563	TOP SECTION/AIR CH END	END-PLATE	4	A70563-A	14.65	3000
3	A70660	AIR CHANN END WM06 0.5	STRAIGHT SUPPORT	3	A70660-A	0.77	3000
4	A70810	TOP SECTION WM06	VERTICAL SUPPORT PL3	3	A70810-B	1.12	3000
5	101810	BOLT HEX ZN 8.8	8X16 AM DIN933	131		0	2010
6	110540	NUT ZN 8 M 8	DIN934	131		0	2010
7	115570	SEALING STRIP	4X10 MAPA	27		0	2600



Assembling air channel end A70663

1. Assembling the end-plate set-up for the air channel end

Parts The numbering of work stages refers to reference numbers in the spare parts drawing A70663 for the air channel end.

*We recommend carrying out assembly of the air channel end on an even plane.
This ensures the ready-assembled air channel end is straight.*

- 7 (1.) **Fix sealing strips to the flanges of the four end-plates (parts 2) to be joined together.**
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).
- 4 **Place the vertical supports between the end-plates.**
Be careful not to damage the sealing strips while installing the vertical support.
- 5, 6 **Fix the end-plates and the vertical supports using bolts and nuts (M8 x 16, 11 + 11 + 11 pcs.).**
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 3 **Install the straight supports for the air channel end in the vertical supports (parts 4).**
Look up correct position for the supports in the drawing.
- 5, 6 **Fix the supports using bolts and nuts (M8 x 16, 2 pcs./support).**
- 7 (2.) **Fix sealing strips to the end-flanges of the ready-assembled end-plate set-up.**
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).

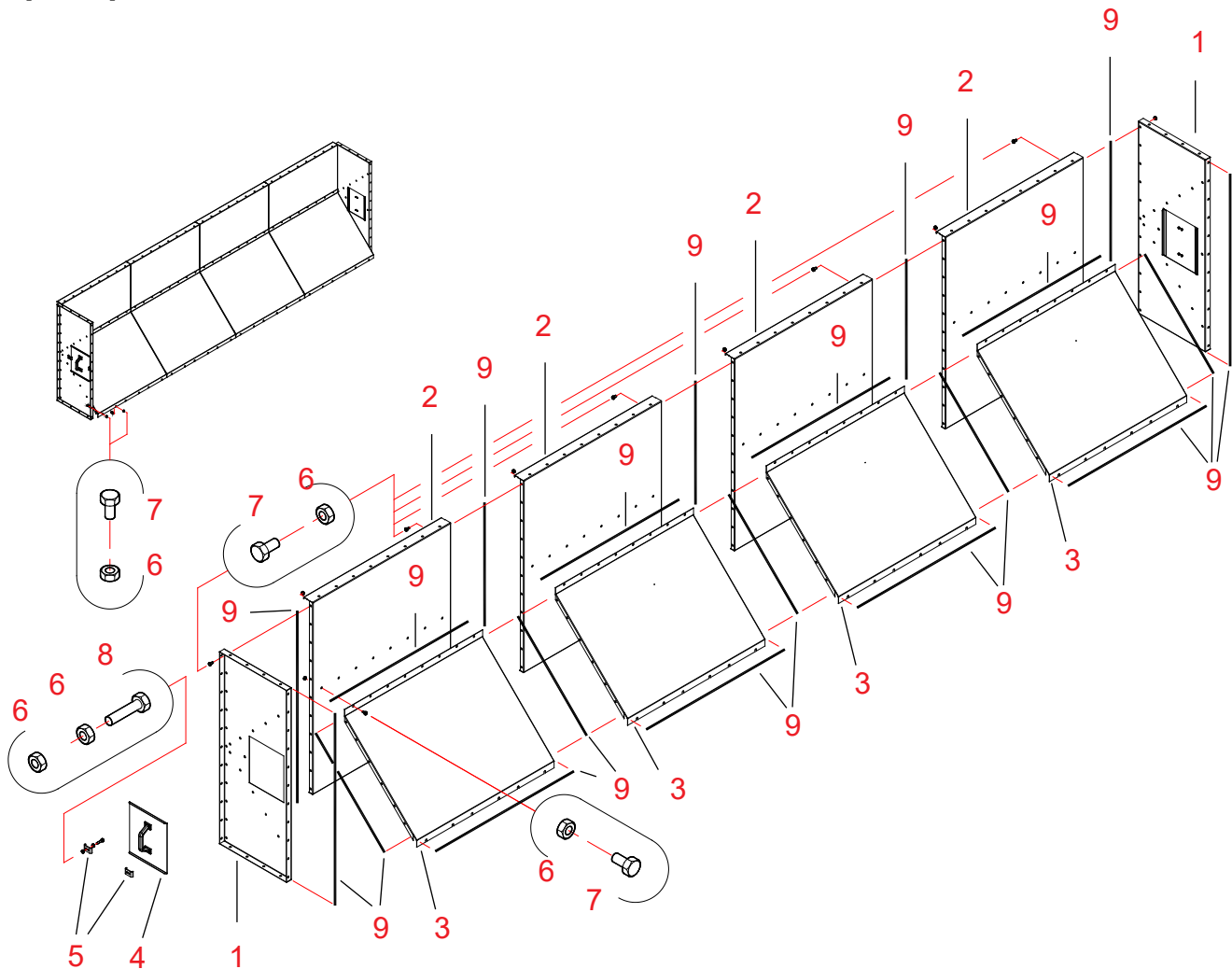
2. Assembling the air channel end

- 7 (3.) **Fix sealing strips to the attachment flanges of the side-plates (parts 1) to be attached to the drying section.**
Fix the sealing strips inside the bolthole rows (see detail drawing 1).
- 1 **Move the side-plates tight against the ends of the section.**
Be careful not to damage the sealing strips while installing the side-plates.
- 5, 6 **Fix the side-plates using bolts and nuts (M8 x 16, 11 pcs. /side-plate).**
Tighten the bolts only lightly so that you can straighten the air channel end later.
- (1) **Move the set-up, assembled at stage 1 against the side-plates.**
Be careful not to damage the sealing strips while moving the set-ups.
- 5, 6 **Fix the set-up, assembled at stage 1, using bolts and nuts (M8 x 16, 11 + 11 pcs.).**
- 5, 6 **Fix the straight supports for the air channel end to the section using bolts and nuts (M 8 x 16, 2 pcs./ support).**
See detail drawing 2. Tighten the bolts only lightly so that you can straighten the air channel end later.
- * **Check the joints and rectangular shape of the air channel end. Tighten all bolts.**



Air channel end 0,5 3W (A70664) - return end B

Spare parts



20061106

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A70652	AIR CHANN END WM06 0.5	SIDE-PL RETURN END	2	A70652	6.71	3000
2	A70651	AIR CHANN END WM06 0.5	END-PLATE RETURN END	4	A70651-A	14.65	3000
3	A70644	AIR CHANN END WM06 0.5	RETURN BOTTOM	4	A70644-A	9.16	3000
4	501763	SECTION AIR CH SIDE-PL	HATCH MEGA	2	32214-A	0	3000
5	400280	TOP SECTION COV	HOLDER	4	S4668-A	0	3000
6	110540	NUT ZN 8 M 8	DIN934	159		0	2010
7	101810	BOLT HEX ZN 8.8	8X16 AM DIN933	151		0	2010
8	101860	BOLT HEX ZN 8.8	8X35 AM DIN933	4		0	2010
9	115570	SEALING STRIP	4X10 MAPA	32		0	2600



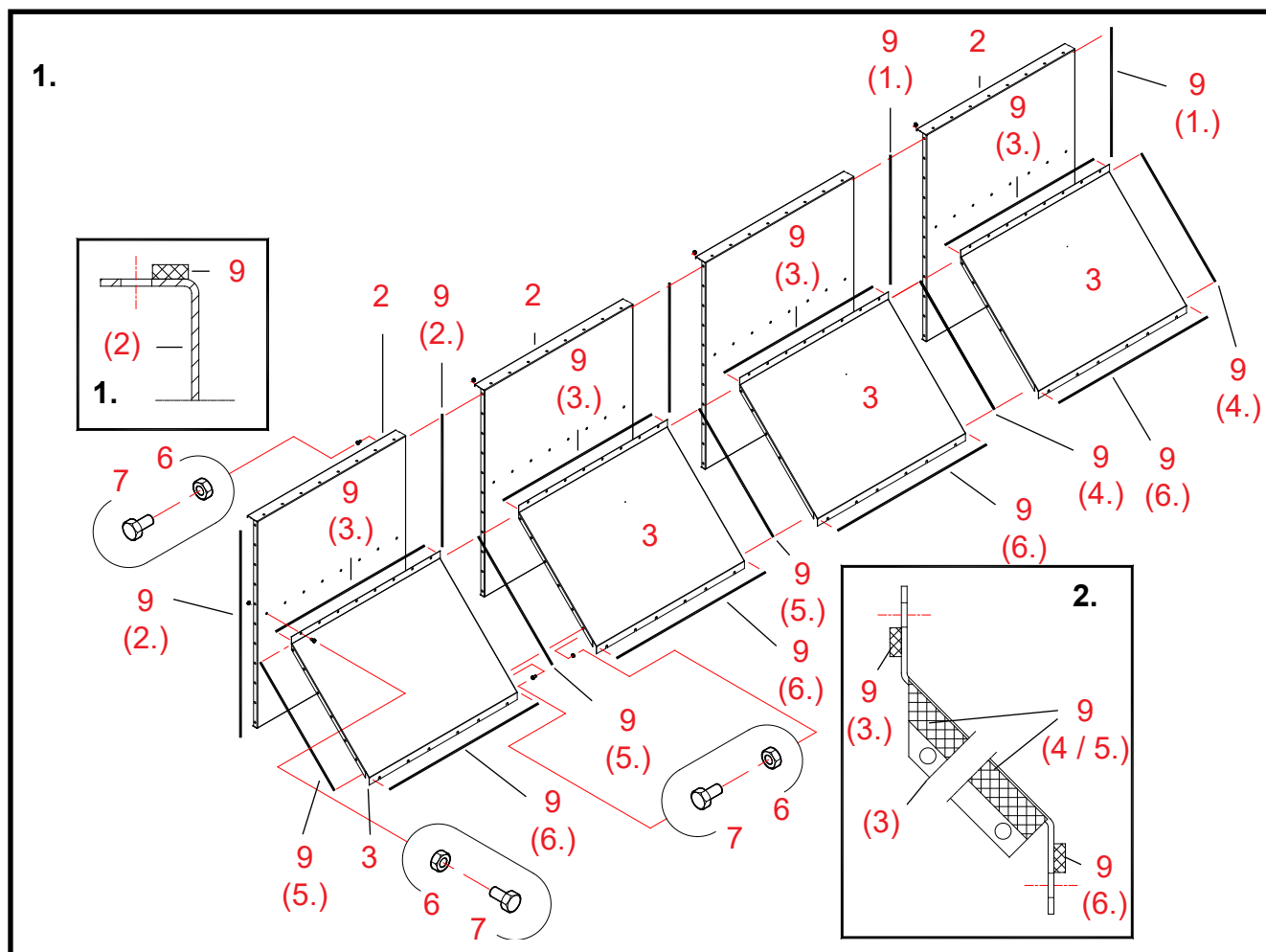
Assembling air channel end A70664

1. Assembling the end-plate set-up for the air channel end

Parts The numbering of work stages refers to reference numbers in the spare parts drawing A70664 for the air channel end.

*We recommend carrying out assembly of the air channel end on an even plane.
This ensures the ready-assembled air channel end is straight.*

- 9 (1.) **Fix sealing strips to both end-flanges of one of the end-plates (part 2).**
9 (2.) **Fix a sealing strip to the other end-flange of three of the end-plates (part 2).**
 Fix the sealing strip inside the screw hole row in the flange (see detail drawing 1).
- 2 **Place the end-flanges of the end-plates face to face.**
 Observe, that there will be only one sealing strip between the flanges.
 Be careful not to damage the sealing strip while installing the end-plate.
- 6, 7 **Fix the end-plates using bolts and nuts (M8 x 16, 11 + 11 + 11 pcs.).**
 Tighten the bolts only lightly so that you can straighten the air channel end later.
- 9 (3.) **Fix sealing strips to the upper flanges of all return bottoms (parts 3).**
 Fix the sealing strip inside the screw hole row in the flange (see detail drawing 2).
- 9 (4.) **Fix sealing strips to both end-flanges of one of the return bottoms (part 3).**
9 (5.) **Fix sealing strips to the other end-flange of three of the return bottoms (part 3).**
 Fix the sealing strips inside the screw hole row in the flange (see detail drawing 2).
- 3 **Fix the return bottoms to the hole rows at the centre of the end-plates (parts 2).**
 Observe, that there will be only one sealing strip between the centre-flanges of the return bottoms.
- 6, 7 **Fix the return bottoms to the end-plates using bolts and nuts (M 8 x 16, 8 pcs./bottom).**
 Place the bolt caps on the return bottom side.
- 6, 7 **Fix the return bottoms together using bolts and nuts (M8 x 16, 6 + 6 + 6 pcs.).**
- 9 (6.) **Fix sealing strips to the lower flange of all return bottoms (parts 3).**
 Fix the sealing strips inside the screw hole row in the flange (see detail drawing 2).
- See illustration of this stage on next page.

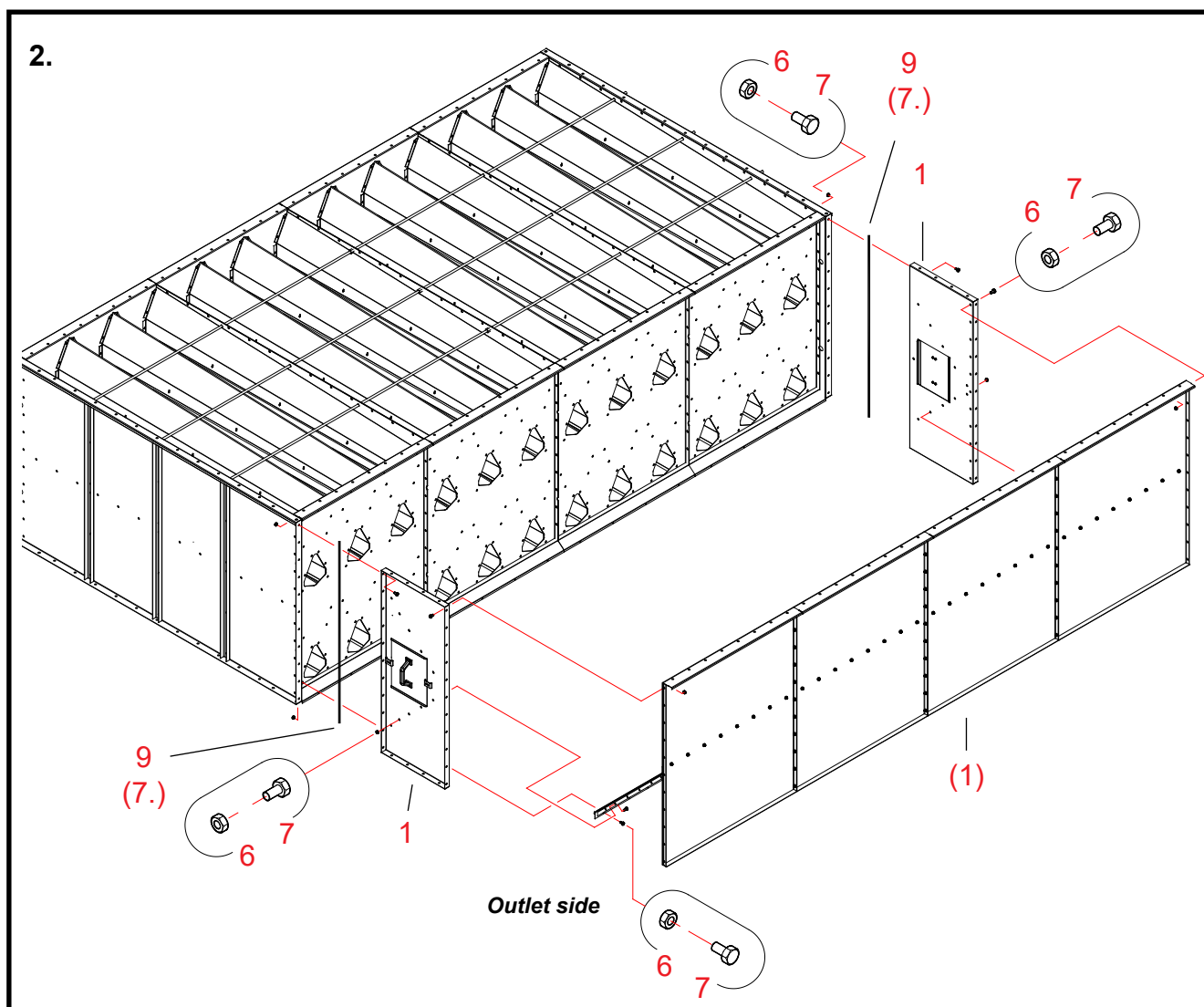


Assembling air channel end A70664, continues

2. Assembling the air channel end

- 9 (7.) **Fix sealing strips to the attachment flanges of the side-plates (parts 1) to be attached to the drying section.**
Fix the sealing strips inside the bolthole rows.
- 1 **Move the side-plates tight against the ends of the section.**
Be careful not to damage the sealing strips while installing the side-plates.
- 6, 7 **Fix the side-plates using bolts and nuts (M8 x 16, 11 pcs. /side-plate).**
Tighten the bolts only lightly so that you can straighten the air channel end later.
- (1) **Move the set-up, assembled at stage 1 against the side-plates.**
Be careful not to damage the sealing strips while moving the set-ups.
- 6, 7 **Fix the set-up, assembled at stage 1, to the side-plates using bolts and nuts (M8 x 16, 11 + 11 pcs.).**
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 6, 7 **Fix the return bottoms to the side-plates using bolts and nuts (M8 x 16, 6 pcs. /side-plate).**
Tighten the bolts only lightly so that you can straighten the air channel end later.

>>>



6, 7 Fix the return bottoms to the section using bolts and nuts (M8 x 16, 6 + 6 + 6 + 6 pcs.).
Tighten the bolts only lightly so that you can straighten the air channel end later.

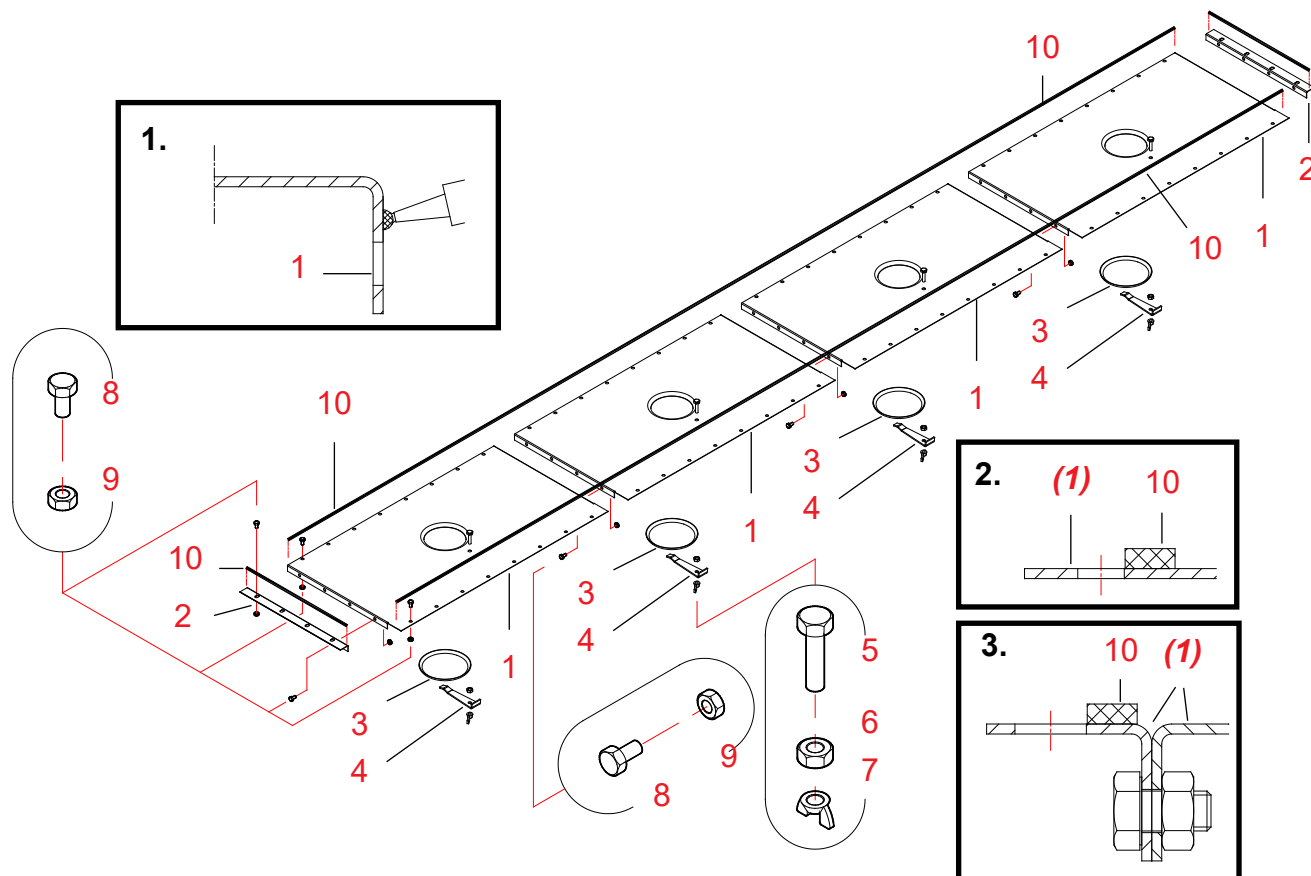
***** Check the joints and rectangular shape of the air channel end. Tighten all bolts.

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



Air channel end 0,5 2W (A70728) - lower shutter B

Spare parts



20080715

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A70639	AIR CHANN END WM06 0.5	SHUTTER-PL CLEAN HATCH	4	A70639	5.99	3000
2	A70637	AIR CHANN END WM06 0.5	CORNER-STRIP	2	A70637-A	0.31	3000
3	400140	SHUTTER D173		4	S4293	0	3500
4	400150	HATCH HOLDER		4	4461-B	0	3500
5	102250	BOLT HEX ZN 8.8	10X40 AM DIN933	4		0	2010
6	110560	NUT ZN 8 M10	DIN934	4		0	2010
7	111030	NUT WING ZN M10	DIN315	4		0	2010
8	101810	BOLT HEX ZN 8.8	8X16 AM DIN933	92		0	2010
9	110540	NUT ZN 8 M 8	DIN934	92		0	2010
10	115570	SEALING STRIP	4X10 MAPA	9		0	2600
11	800271	MASTIC SEALING/GLUE	GREY 310 ML	1			2600

Installing lower shutter for the air channel end A70728

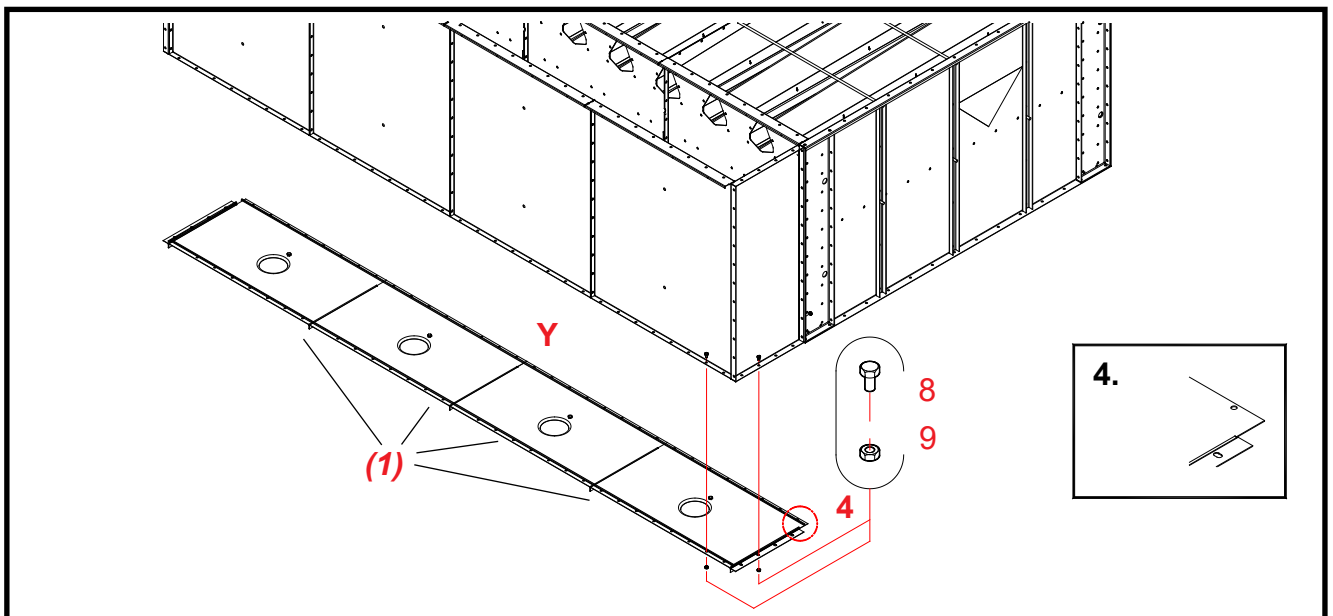
1. Joining together the shutter-plates and the corner-strips

Parts The numbering of work stages refers to reference numbers in the spare parts drawing A70728 for the lower shutter of the air channel end.

- * **Apply sealing mastic on the outside of both end flanges (parts 1).**
Apply sealing mastic inside the bolthole rows in the supports (see detail drawing 1).
Try to keep the mastic strip as even and continuous as possible.
- 8, 9 **Join the shutter-plates together using bolts and nuts (M8 x 16, 4 pcs./joint).**
Be careful not to damage the sealing mastic strip while joining the plates.
- 2 **Fix the corner-strips against the flanges at the outer ends of the shutter-plate set-up.**
Be careful not to damage the sealing mastic strip while installing the corner-strips.
- 8, 9 **Fix them in place using bolts and nuts (M 8 x 16, 4 pcs./corner-strip).**
- 10 **Fix sealing strips to the upper surfaces of the shutter-plate/corner-strip assembly.**
Fix the sealing strips inside the bolthole rows in the shutter-plates (see detail drawing 2).
Fix the sealing strips inside the bolthole rows in the corner-strips (see detail drawing 3).

2. Fixing the shutter-plate to the lower end of the air channel end

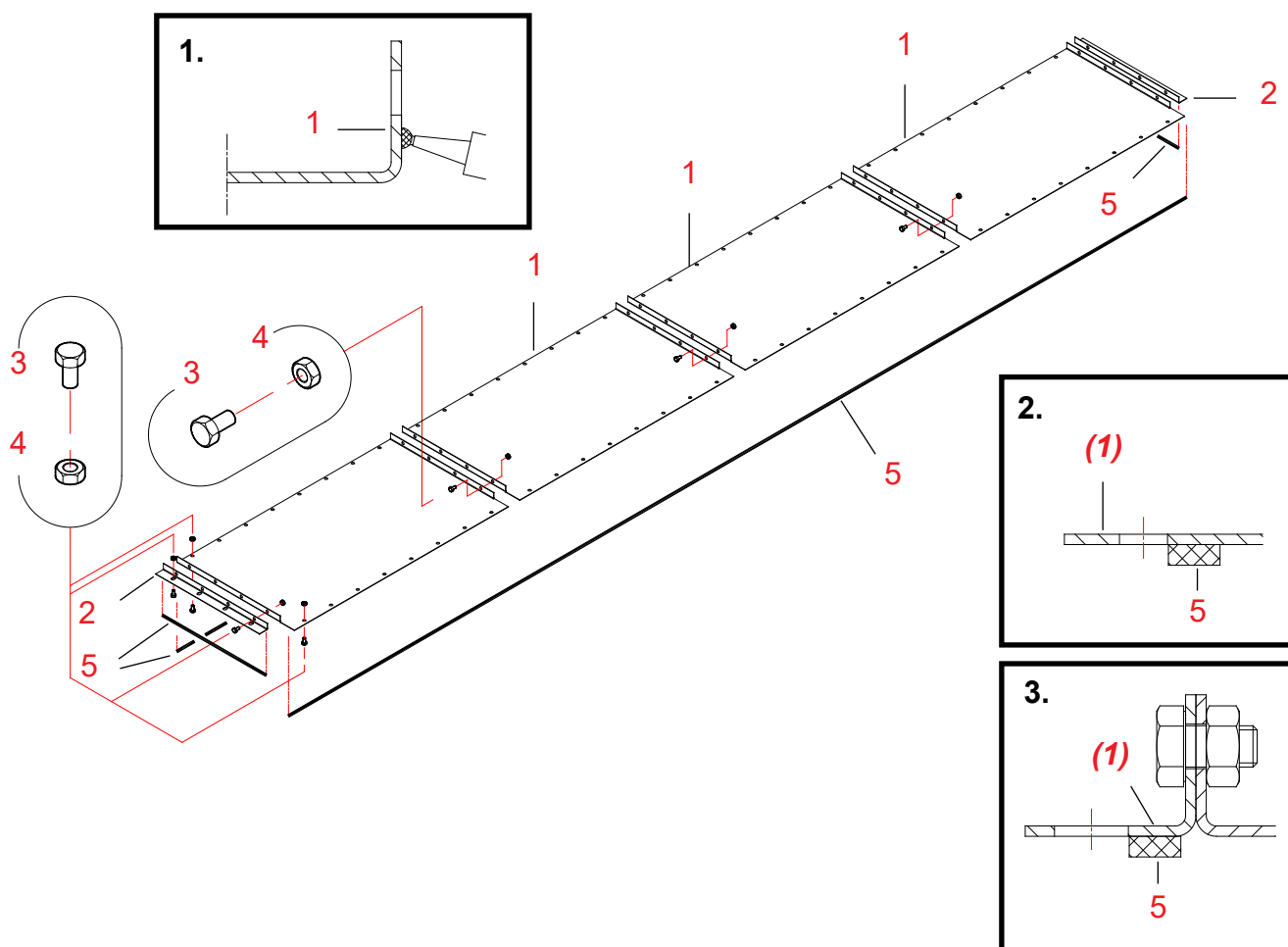
- Parts Refer to the installation drawing below for the lower shutter A70728 of the air channel end.
- (1) **Move the assembly against the flanges at the lower end of the air channel end.**
Be careful not to damage the sealing strips while installing the plate.
Check correct position for the assembly in detail drawing 4.
 - 5, 6 **Fix the shutter-plate using bolts and nuts (M 8 x 16, 72 pcs.).**
Note! Do not install the bolts on the other long side (Y) until the dryer is being assembled.





Air channel end 0,5 4W (A70731) - upper shutter B

Spare parts



20080715

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A70636	AIR CHANN END WM06 0.5	SHUTTER-PLATE	4	A70636	6.13	3000
2	A70637	AIR CHANN END WM06 0.5	CORNER-STRIP	2	A70637-A	0.31	3000
3	101810	BOLT HEX ZN 8.8	8X16 AM DIN933	92		0	2010
4	110540	NUT ZN 8 M 8	DIN934	92		0	2010
5	115570	SEALING STRIP	4X10 MAPA	7		0	2600
6	800271	MASTIC SEALING/GLUE	GREY 310 ML	1			2600

Installing the upper shutter for the air channel end A70731

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

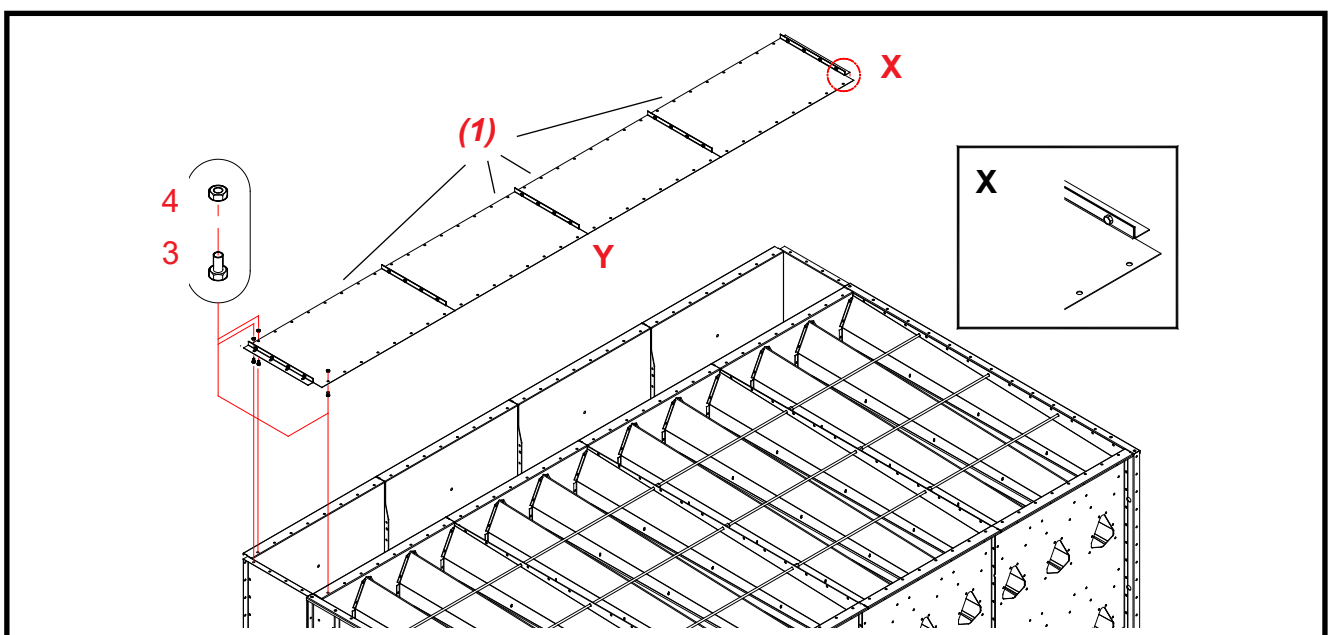
Parts The numbering of work stages refers to reference numbers in the spare parts drawing A70731 for the upper shutter of the air channel end.

- * **Apply sealing mastic on the outside of both end flanges (parts 1).**
Apply sealing mastic outside the bolthole rows in the supports (see detail drawing 1).
Try to keep the mastic strip as even and continuous as possible.
- 3, 4 **Join the shutter-plates together using bolts and nuts (M8 x 16, 4 pcs./joint).**
Be careful not to damage the sealing mastic strip while joining the plates.
- 2 **Fix the corner-strips against the flanges at the outer ends of the shutter-plate set-up.**
Be careful not to damage the sealing mastic strip while installing the corner-strips.
- 3, 4 **Fix them in place using bolts and nuts (M 8 x 16, 4 pcs./corner-strip).**
- 5 **Fix sealing strips to the lower surfaces of the shutter-plate/corner-strip assembly (assembled at stage 1).**
Fix the sealing strips inside the bolthole rows in the shutter-plates (see detail drawing 2).
Fix the sealing strips inside the bolthole rows in the corner-strips (see detail drawing 3).

2. Fixing the shutter-plate to the upper end of the air channel end

Parts Refer to the installation drawing below for the upper shutter A70731 of the air channel end.

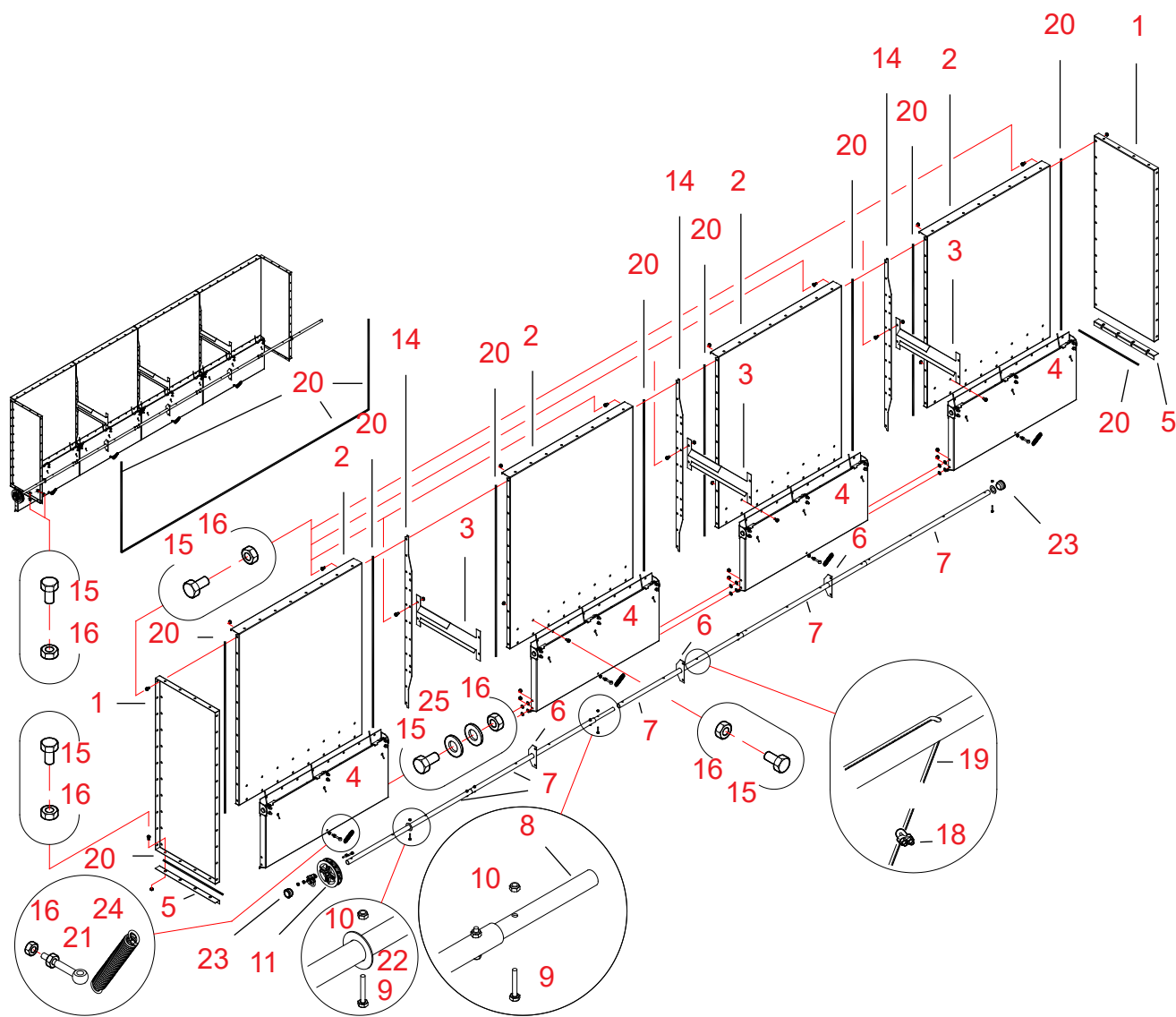
- (1) **Move the assembly against the flanges at the upper end of the air channel end.**
Be careful not to damage the sealing strips while installing the plate.
Check correct position for the assembly in detail drawing 4.
- 3, 4 **Fix the shutter-plate using bolts and nuts (M 8 x 16, 72 pcs.).**
Note! Do not install the bolts on the other long side (Y) until the dryer is being assembled.





Air channel end 0,5 4W (A70823) - channel shutter B

Spare parts



Parts 5 and their sealings are installed only if this assembly is the lowest part of the air channel end in the dryer.

As required, plug the unused shaft holes in the drying section with parts 23.



20070419

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A70635	AIR CHANN END WM06 0.5	SIDE-PLATE	2	A70635	7.52	3000
2	A70682	AIR CHANN END WM06	END-PLATE W SHUTTER	4	A70682	14.64	3000
3	A70660	AIR CHANN END WM06 0.5	STRAIGHT SUPPORT	3	A70660-A	0.77	3000
4	A70734	AIR CHANN END WM06	TURN SHUTT PL 500 ASSY	4	A70734	12.07	3000
5	A70637	AIR CHANN END WM06 0.5	CORNER-STRIP	2	A70637-A	0.31	3000
6	A70551	SECTION WM06 SHUTTER	GUIDE-LUG	3	A70551	42.34	3000
7	A70548	SECTION WM06 SHUTTER	D25-958 PIPE	5	A70548-A	42.34	3000
8	A70733	SECTION WM06 SHUTTER	D19-300 EXTENS PIPE	4	A70733	0.25	3000
9	101520	BOLT HEX ZN 8.8	6X35 AM DIN933	10		0	2010
10	110789	NUT NYLOC ZN	M6 DIN985	10		0	2010
11	111478	CHAIN-WHEEL PLASTIC	SKANDIA PDREV	1		0	2900
14	A70810	TOP SECTION WM06	VERTICAL SUPPORT PL3	3	A70810-B	1.12	3000
15	101810	BOLT HEX ZN 8.8	8X16 AM DIN933	193		0	2010
16	110540	NUT ZN 8 M 8	DIN934	201		0	2010
18	114055	WIRE-LOCK	D 5	8		0	2900
19	114067	WIRE-ROPE	D3/D5 MM PLAST P	9		0	2900
20	115570	SEALING STRIP	4X10 MAPA	35		0	2600
21	107821	EYE-BOLT	M8X60	4		0	2010
22	400344	WASHER AISI	PL1,5 D45/25,5	2	21175,4	0	4500
23	116065	PLASTIC PLUG	DBI 42	2		0	2600
24	120014	DRAW-SPRING	3X17 140	3		0.09	
25	111540	WASHER ZN	M 8 DIN125	12		0	2010

Assembling air channel end A70823

*We recommend carrying out assembly of the air channel end on an even plane.
This ensures the ready-assembled air channel end is straight.*

1. Assembling the end-plate set-up for the air channel end

Parts The numbering of work stages refers to reference numbers in the spare parts drawing A70823 for the air channel end.

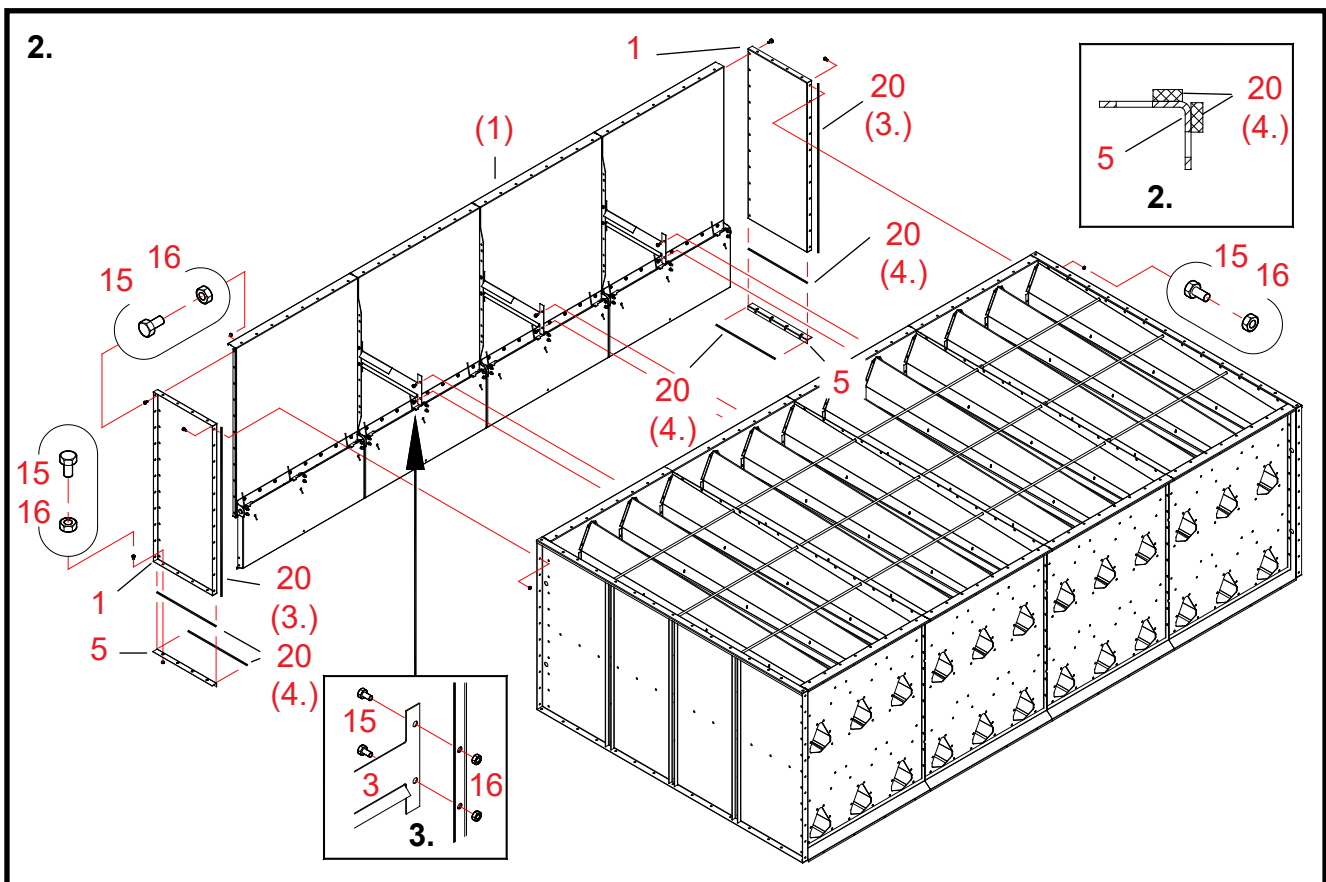
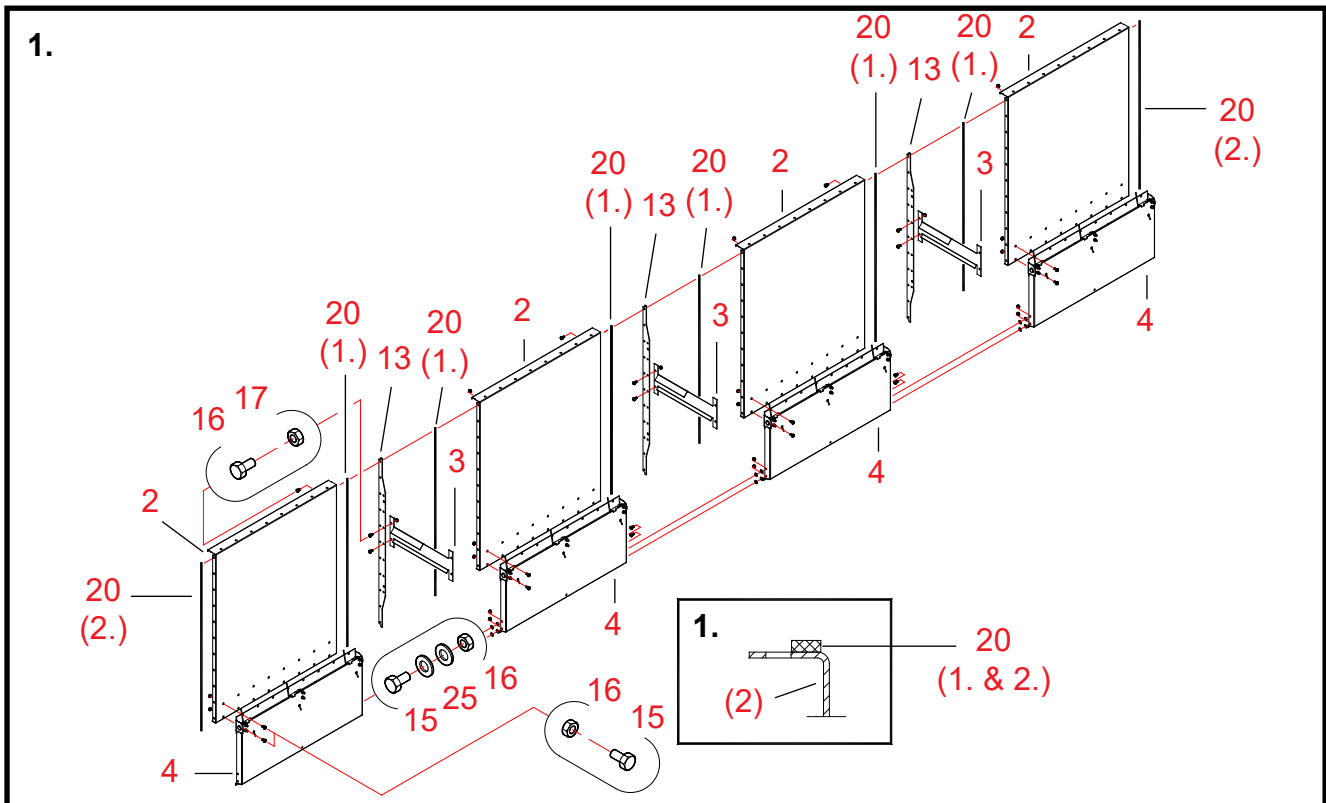
See illustration of this stage on next page.

20 (1.) **Fix sealing strips to the flanges of the four end-plates (parts 2) to be joined together.**
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).

14 **Place the vertical supports between the end-plates.**
Be careful not to damage the sealing strips while installing the vertical support.

15, 16 **Fix the end-plates and the vertical supports using bolts and nuts (M8 x 16, 11 pcs.).**
Tighten the bolts only lightly so that you can straighten the air channel end later.

>>>





- 3** **Install the straight supports for the air channel end in the vertical supports (parts 13).**
Look up correct position for the supports in the drawing.

- 15, 16** **Fix the supports using bolts and nuts (M8 x 16, 2 pcs.).**

- 4** **Attach the shutter-plate set-ups (parts 14) to the holes in the end-plate set-up.**

- 15, 16** **Fix the shutter-plates using bolts and nuts (M 8 x 16, 16 pcs. / shutter-plate).**

- 15, 16, 25** **Join the shutter-plates together using bolts, washers and nuts (M 8 x 16).**
Install two M10 washers on both bolts, between the shutter-plates.

- 20 (2.)** **Fix sealing strips to the end-flanges of the end-plate (parts 2 joined together).**
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).

2. Attaching the side-plates of the air channel end to the section

- 20 (3.)** **Fix sealing strips to the attachment flanges of the side-plates (parts 1) to be attached to the drying section.**
Fix the sealing strips inside the bolthole rows.

- 1** **Move the side-plates tight against the ends of the section.**
Be careful not to damage the sealing strips while installing the side-plates.

- 15, 16** **Fix the side-plates using bolts and nuts (M8 x 16, 11 pcs. /side-plate).**
Tighten the bolts only lightly so that you can straighten the air channel end later.

- (1)** **Move the set-up, assembled at stage 1 against the side-plates.**
Be careful not to damage the sealing strips while moving the set-ups.

- 15, 16** **Fix the set-up, assembled at stage 1, using bolts and nuts (M8 x 16, 11 + 11 pcs.).**
- 15, 16** **Fix the straight support for the air channel end to the section using bolts and nuts (M 8 x 16, 2 pcs.).**
See detail drawing 3. Tighten the bolts only lightly so that you can straighten the air channel end later.

Install the corner-strips (parts 5) only if this set-up is the lowest part of the air channel end in the dryer.

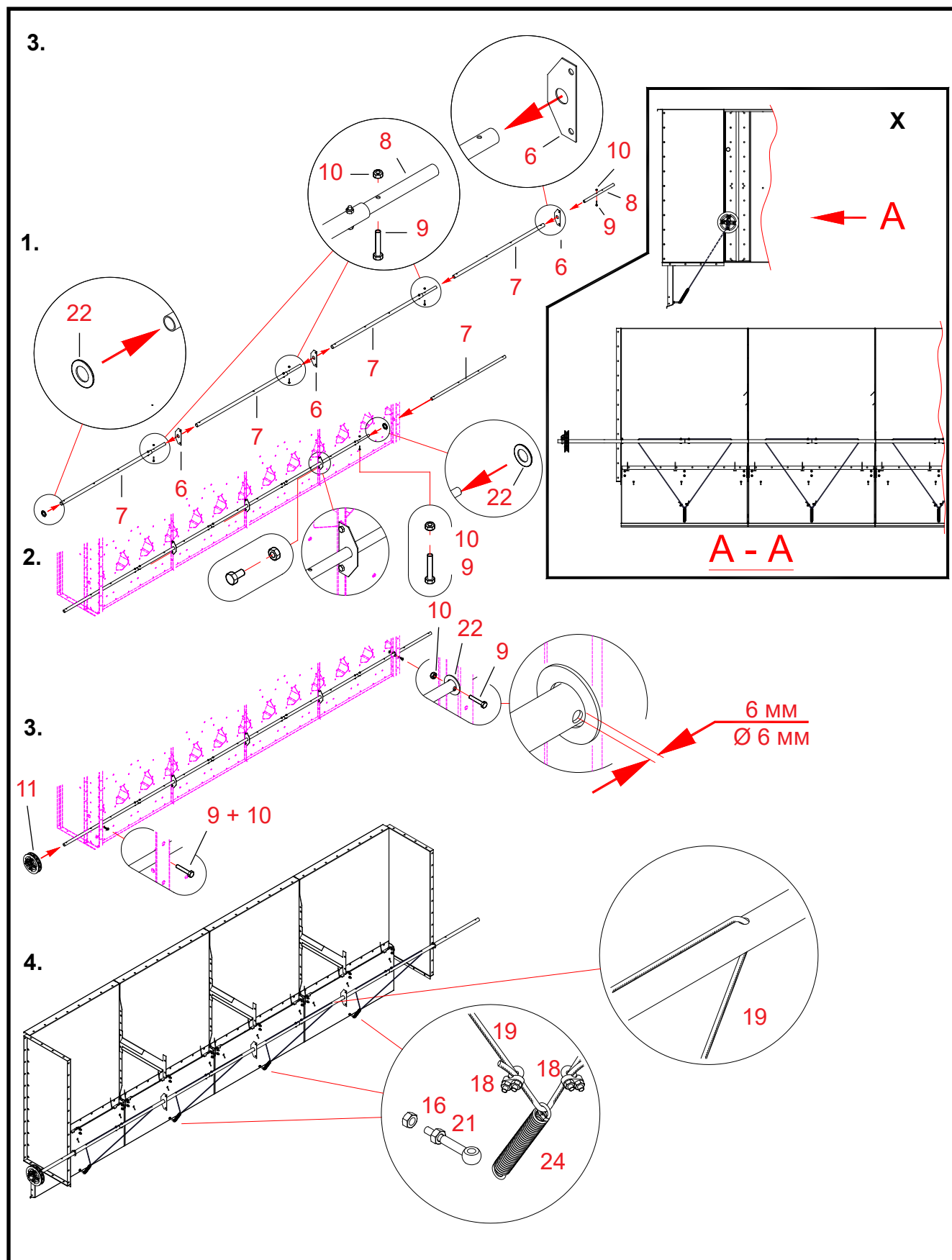
- 20 (4.)** **Fix sealing strips to the flanges of the corner-strips (parts 5).**
Fix the sealing strips inside the bolthole rows (see detail drawing 2).

- 5** **Fix corner-strips to the lower flanges of both side-plates.**

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

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

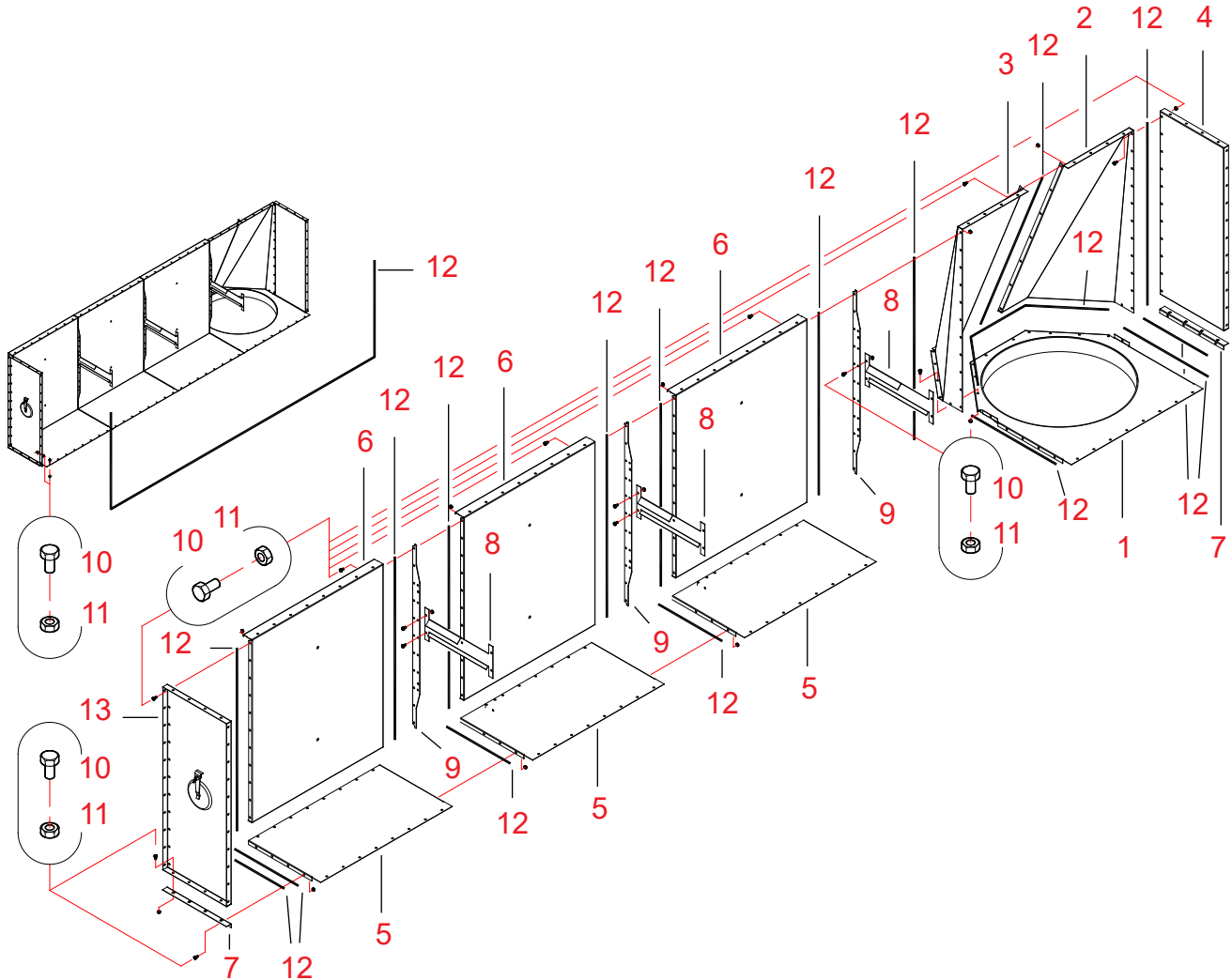
>>>





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

- Parts The numbering of work stages refers to reference numbers in the spare parts drawing A70737 for the air channel end.
- Fig. 1.
- 8 **Join together the four shaft-pipes (parts 7) using the extension pipes.**
- 9, 10 **Fix the joints using two bolts and Nyloc-nuts (M 6 x 35).**
- 6 **Push two guide-lugs for the shaft on the pipes before installing bolts in the joints.**
- 8 **Attach the extension pipe to the same end of the shaft-pipe, on which you threaded the last guide-lug.**
- 9, 10 **Fix the extension pipe using bolt and Nyloc-nuts (M 6 x 35).**
- 22 **Thread washer (D45/25,5) onto the pipe from the opposite end of the pipe.**
- Fig. 2.
- (1) **Insert the shaft, assembled in accordance with drawing 1, in the lower Ø 25,5 mm holes in the section's side-plates.**
Remove two bolts from the centre-seam of the section's end-plates at the guide-lugs.
Place the guide-lug against the flanges of the end-plate and insert the bolts back in place.
- 22 **Thread another washer (D45/25,5) onto the shaft-pipe.**
- 7 **Push the fourth shaft-pipe through the side-plate and the leg of the section onto the extension pipe of the ready-assembled shaft.**
- 9, 10 **Fix the shaft-pipe joint using bolt and Nyloc-nut (M 6 x 35).**
- Fig. 3.
- * **Centre the shaft-pipe with respect to the side-flanges of the section.**
- * **Shift washers (parts 22) against the side-flanges of the section.**
- * **Drill a Ø 6 mm hole through the shaft-pipe, at a distance of 6 mm from the face of each washer.**
- 9, 10 **Insert bolts in the drilled holes and fix them using Nyloc-nuts (M 6 x 35).**
- 11 **Place the chain-wheel unit onto the actuator-shaft for the shutter-plates.**
Tighten the nuts of the U-bolt ties only lightly at this stage.
- * **Install the air channel end in the section in accordance with point "Attaching the assembled air channel end to the drying section".**
- Fig. 4.
- 16, 21 **Provide both shutter-plates with an eye-bolt. Fix them using two nuts (M8).**
- 24 **Thread in a draw-spring through both eye-bolts.**
- 19 **Install the actuator wires for the shutter-plates.**
Thread the wire through the two holes in the shaft and the draw-spring eye to make a triangle-shaped loop. (Picture X)
- 18 **Place wire-locks on both sides of the draw-spring eye.**
- * **Cut off the wire at a distance of about 30 mm from the wire-lock.**

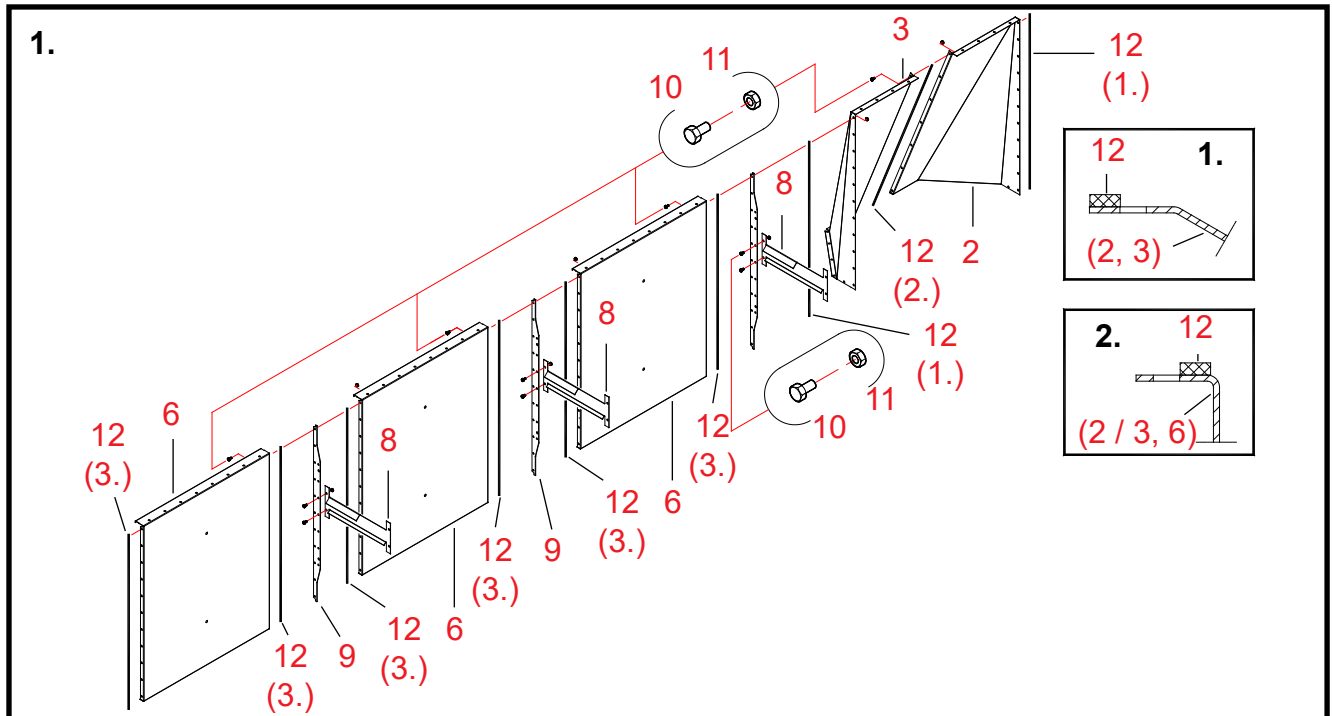
**Air channel end 0,5 4W (A70963) - lower part / upper part L, Ø 800 mm**
Spare parts

20061106

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A70630	AIR PIPE WM06 0,5	V SINGLE D800	1	A70630	5.33	3000
2	A70609	AIR CHANN END WM06 0.5	V SINGL D800 L	1	A70609	9.75	3000
3	A70610	AIR CHANN END WM06 0.5	V SINGL D800 R	1	A70610	9.75	3000
4	A70635	AIR CHANN END WM06 0.5	SIDE-PLATE	1	A70635	7.52	3000
5	A70636	AIR CHANN END WM06 0.5	SHUTTER-PLATE	3	A70636	6.13	3000
6	A70563	TOP SECTION/AIR CH END	END-PLATE	3	A70563-A	14.65	3000
7	A70637	AIR CHANN END WM06 0.5	CORNER-STRIP	2	A70637-A	0.31	3000
8	A70660	AIR CHANN END WM06 0.5	STRAIGHT SUPPORT	3	A70660-A	0.77	3000
9	A70810	TOP SECTION WM06	VERTICAL SUPPORT PL3	3	A70810-B	1.12	3000
10	101810	BOLT HEX ZN 8.8	8X16 AM DIN933	188		0	2010
11	110540	NUT ZN 8 M 8	DIN934	188		0	2010
12	115570	SEALING STRIP	4X10 MAPA	43		0	2600
13	A71401	AIR PIPE WM06 0.5	SIDE-PL CLEAN HATCH	1	A71401	7.89	3000

Assembling air channel end A70963

*We recommend carrying out assembly of the air channel end on an even plane.
This ensures the ready-assembled air channel end is straight.*



1. Assembling the end-plate set-up for the air channel end

Parts The numbering of work stages refers to reference numbers in the spare parts drawing A70963 for the air channel end.

- 12 (1.)** **Fix sealing strips to the end-flanges of the two diagonal end-plates (parts 3 and 4).**
Fix the sealing strips outside the bolthole rows in the flanges (see detail drawing 1).
- 12 (2.)** **Fix a sealing strip also to one of the slanting surfaces of the flange on the diagonal end-plates (parts 2 and 3).**
Fix the sealing strip inside the screw hole row in the flange (see detail drawing 2).
- 12 (3.)** **Fix sealing strips to the end-flanges of the end-plate (parts 6).**
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 2).
- 10, 11** **Join the diagonal end-plates (2 and 3) together using bolts and nuts (M8 x 16, 7 pcs.).**
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 9** **Place vertical supports between the end-plates and the diagonal end-plate on the right-hand side.**
Be careful not to damage the sealing strips while installing the vertical support.
- 10, 11** **Fix the end-plates and the vertical supports to the diagonal end using bolts and nuts (M8 x 16, 11 pcs.).**
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 8** **Install the straight supports for the air channel end in the vertical supports (parts 9).**
Look up correct position for the support in the drawing.
- 10, 11** **Fix the supports using bolts and nuts (M8 x 16, 2 pcs./support).**

>>>



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

- 12 (4.) **Fix sealing strips to the upper surface of the shutter-plate with round opening (part 1) at the diagonal end.**
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 3).
Extend the sealing strips to inside the vertical flanges of the shutter-plate (see detail drawing 4).
- 12 (5.) **Fix sealing strips to the flanges of the corner-strips (parts 7).**
Fix the sealing strips inside the bolthole rows (see detail drawing 5).
- 12 (6.) **Fix sealing strips to the other end-flanges of the shutter-plates (parts 5).**
Fix the sealing strips inside the bolthole rows. (see detail drawing 6).
- 5 **Install the shutter-plates (parts 5) with their centre-flanges face to face.**
- 5 **Place the shutter-plates (parts 5) against one of the end-flanges of the large shutter-plate (part 1).**
- 10, 11 **Fix the plates using bolts and nuts (M8 x 16, 4 pcs/joint).**
- 12 (7.) **Fix a sealing strip to the upper surface of the shutter-plates (part 5).**
Fix the sealing strips inside the bolthole rows. (see detail drawing 7).
- 7 **Install the corner-strips on both end-flanges of the shutter-plate set-ups.**
- 10, 11 **Fix the corner-strips using bolts and nuts (M8 x 16, 4 + 4 pcs.).**

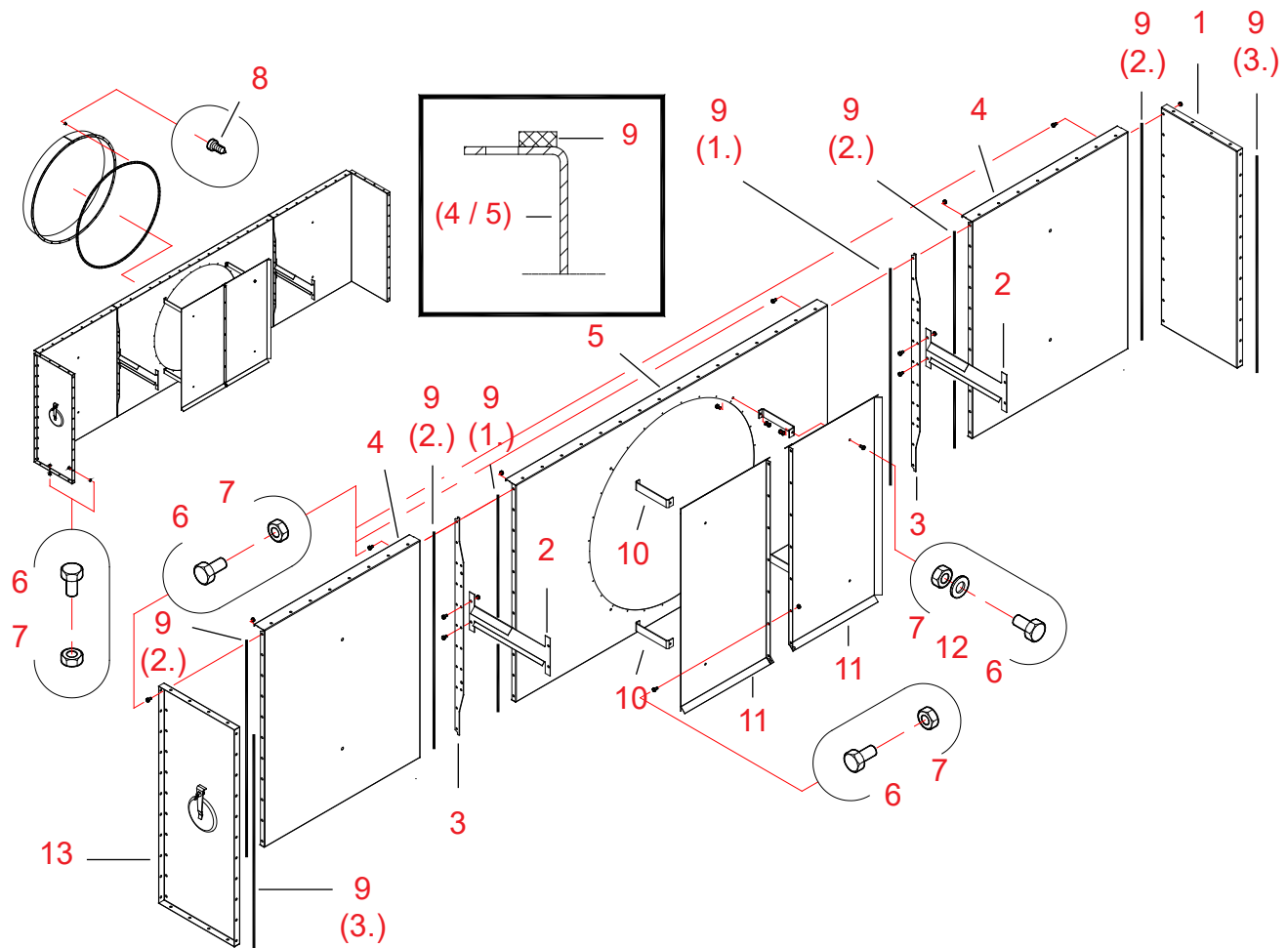
3. Assembling the air channel end

- 12 (7.) **Fix sealing strips to the flanges of the side-plates (parts 4 and 13).**
Fix the sealing strips inside the bolthole rows.
- 4, 13 **Move the side-plates tight against the ends of the section.**
Be careful not to damage the sealing strips while installing the side-plates.
- 10, 11 **Fix the side-plates using bolts and nuts (M8 x 16, 11 pcs. /side-plate).**
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 12 (8.) **Fix a sealing strip to the long edge of the set-up, assembled at stage 2.**
Fix the sealing strips inside the screw hole row.
- (2) **Move the set-up, assembled at stage 2, under the edge of the section. Align the boltholes.**
Be careful not to damage the sealing strips while moving the set-ups.
- 10, 11 **Fix the part to the section and to the side-plates using bolts and nuts (M8 x 16, 32 + 4 + 4 pcs.).**
Tighten the bolts only lightly so that you can straighten the air channel end later.
- (1) **Move the set-up, assembled at stage 1, on top of the set-up, assembled at stage 2, and against the side-plates.**
Be careful not to damage the sealing strips while moving the set-ups.
- 10, 11 **Fix the set-up, assembled at stage 1, using bolts and nuts (M8 x 16, 44 + 11 + 11 pcs.).**
- 10, 11 **Fix the straight supports for the air channel end to the section using bolts and nuts (M 8 x 16, 2 pcs.).**
See detail drawing 8. Tighten the bolts only lightly so that you can straighten the air channel end later.
- * **Check the joints and rectangular shape of the air channel end. Tighten all bolts.**



Air channel end 0,5 4W (A71213) - centre-part S, Ø 1000 mm

Spare parts



20061106

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A70635	AIR CHANN END WM06 0.5	SIDE-PLATE	1	A70635	7.52	3000
2	A70660	AIR CHANN END WM06 0.5	STRAIGHT SUPPORT	2	A70660-A	0.77	3000
3	A70810	TOP SECTION WM06	VERTICAL SUPPORT PL3	2	A70810-B	1.12	3000
4	A70563	TOP SECTION/AIR CH END	END-PLATE	2	A70563-A	14.65	3000
5	A71207	AIR CHANN END WM06	END D1000 SCREW ATT	1	A71207-B	19.34	3000
6	101810	BOLT HEX ZN 8.8	8X16 AM DIN933	131		0	2010
7	110540	NUT ZN 8 M 8	DIN934	131		0	2010
8	107720	SELF-TAP HEX SCREW	4,8X13 ZN	28		0	2010
9	115570	SEALING STRIP	4X10 MAPA	18		0	2600
10	A71231	AIR CHANN END WM06	DIFFUSER PL ATTACH	4	A71231	0.3	3000
11	A71337	AIR CHANN END WM06	DIFFUSER PLATE 1/2	2	A71337	7.65	3000
12	111540	WASHER ZN	M 8 DIN125	8		0	2010
13	A71401	AIR PIPE WM06 0,5	SIDE-PL CLEAN HATCH	1	A71401	7.89	3000



Assembling air channel end A71213

1. Assembling the end-plate set-up for the air channel end

Parts The numbering of work stages refers to reference numbers in the spare parts drawing A71213 for the air channel end.

*We recommend carrying out assembly of the air channel end on an even plane.
This ensures the ready-assembled air channel end is straight.*

- 10, 11 **Attach the dispersion plate brackets to the bolt holes in the end-plate and the dispersion plates to the brackets.**
- 6, 7, 12 **Fix the dispersion plates and the brackets using bolts and nuts (M8 x 16, 4 + 4 pcs).**
- 6, 7 **Join the dispersion plates together using bolts and nuts (M8 x 16, 7 pcs.).**
- 9 (1.) **Fix sealing strips to the end flanges of the ready-assembled end-plate.**
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing).
- 9 (2.) **Fix sealing strips to the end-flanges of the end-plate (parts 4).**
- 3 **Place the vertical supports between the end-plates.**
Be careful not to damage the sealing strips while installing the vertical support.
- 6, 7 **Fix the end-plates and the vertical supports using bolts and nuts (M8 x 16, 11 pcs.).**
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 2 **Install the straight supports for the air channel end in the vertical supports (parts 3).**
- 6, 7 **Fix the supports using bolts and nuts (M8 x 16, 2 pcs./support).**

2. Assembling the air channel end

- 9 (3.) **Fix sealing strips to the end-flanges of the side-plates (parts 1 and 13).**
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing).
- 1, 13 **Move the side-plates tight against the ends of the section.**
Be careful not to damage the sealing strips while installing the side-plates.
- 6, 7 **Fix the side-plates using bolts and nuts (M8 x 16, 11 pcs. /side-plate).**
Tighten the bolts only lightly so that you can straighten the air channel end later.
- (1) **Move the set-up, assembled at stage 1 against the side-plates.**
Be careful not to damage the sealing strips while moving the set-ups.
- 6, 7 **Fix the set-up, assembled at stage 1, using bolts and nuts (M8 x 16, 11 + 11 pcs.).**
Tighten the bolts only lightly so that you can straighten the air channel end later.

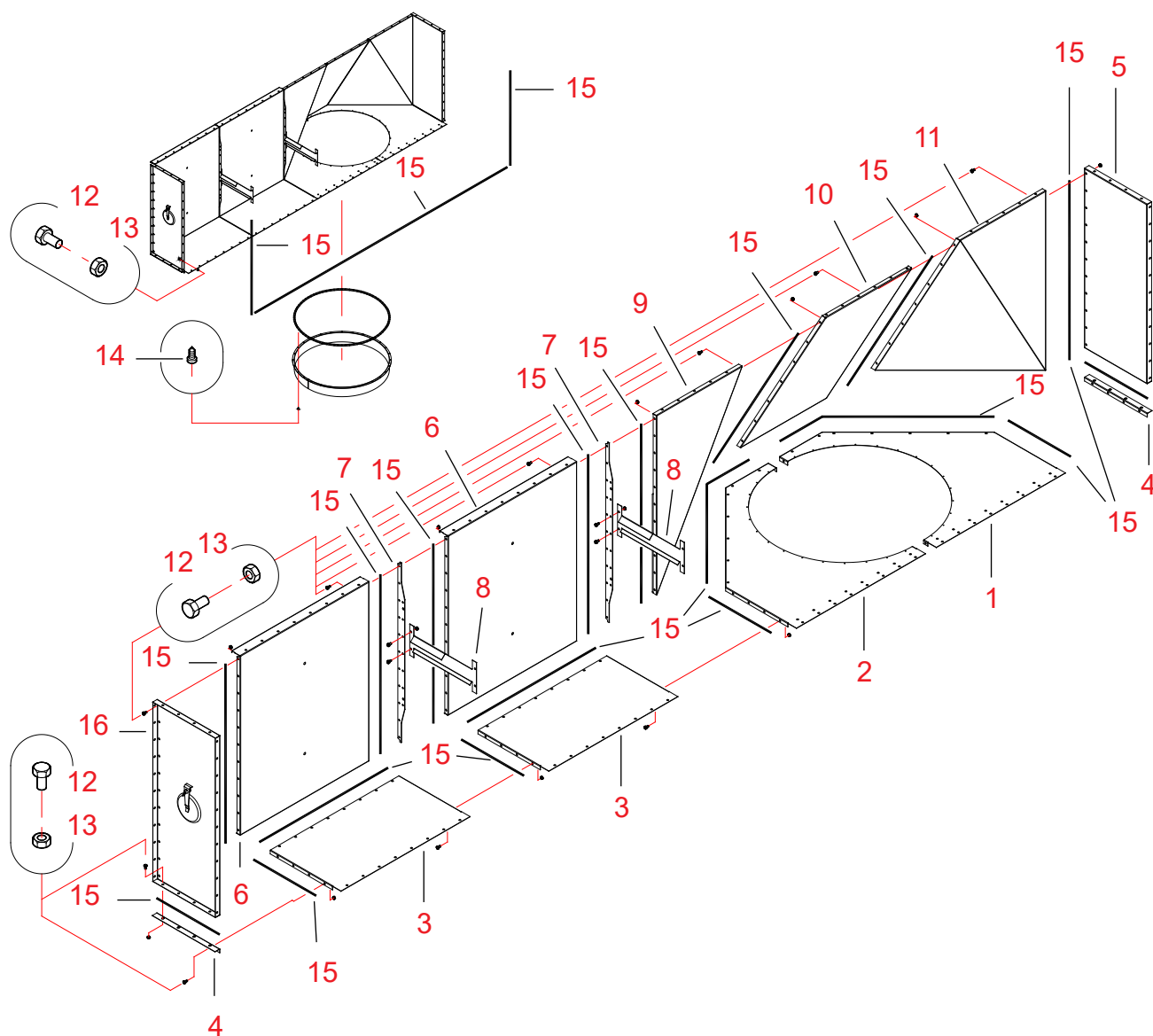
3. Installing the air pipe connector (pipe sleeve Ø 1000 mm, conversion part 1000/800 mm or 1000/630 mm)

- * **See point "Installing the air pipe connector in the air channel end"**
- 8 **Fix the connector to the air channel end using self-tapping screws (4,8 x 13, 28 pcs.).**
- * **Check the joints and rectangular shape of the air channel end. Tighten all bolts.**



Air channel end 0,5 4W (A71269) - lower part / upper part L, Ø 1000 mm

Spare parts





20061106

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A71218	AIR CHANN L WM06 0.5	SHUTTER-PL D1000 L	1	A71218-A	6.23	3000
2	A71217	AIR CHANN L WM06 0.5	SHUTTER-PL D1000 R	1	A71217-A	6.23	3000
3	A70636	AIR CHANN END WM06 0.5	SHUTTER-PLATE	2	A70636	6.13	3000
4	A70637	AIR CHANN END WM06 0.5	CORNER-STRIP	2	A70637-A	0.31	3000
5	A70635	AIR CHANN END WM06 0.5	SIDE-PLATE	1	A70635	7.52	3000
6	A70563	TOP SECTION/AIR CH END	END-PLATE	2	A70563-B	14.65	3000
7	A70810	TOP SECTION WM06	VERTICAL SUPPORT PL3	2	A70810-B	1.12	3000
8	A70660	AIR CHANN END WM06 0.5	STRAIGHT SUPPORT	2	A70660-A	0.77	3000
9	A71265	AIR CHANN L WM06 0.5	DIAGON D1000 RIGHT	1	A71265	11.93	3000
10	A71267	AIR CHANN L WM06 0.5	DIAGON D1000 CENTRE	1	A71267	10.92	3000
11	A71266	AIR CHANN L WM06 0.5	DIAGON D1000 LEFT	1	A71266	11.93	3000
12	101810	BOLT HEX ZN 8.8	8X16 AM DIN933	212		0	2010
13	110540	NUT ZN 8 M 8	DIN934	212		0	2010
14	107720	SELF-TAP HEX SCREW	4,8X13 ZN	28		0	2010
15	115570	SEALING STRIP	4X10 MAPA	43		0	2600
16	A71401	AIR PIPE WM06 0,5	SIDE-PL CLEAN HATCH	1	A71401	7.89	3000

Assembling air channel end A71269

*We recommend carrying out assembly of the air channel end on an even plane.
This ensures the ready-assembled air channel end is straight.*

1. Assembling the end-plate set-up for the air channel end

Parts The numbering of work stages refers to reference numbers in the spare parts drawing A71269 for the air channel end.

See illustration of this stage on next page.

- 15 (1.)** **Fix sealing strips to both end-flanges of the diagonal end's centre-part (part 10).**
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).
- 9, 10, 11** **Join together the centre-part and the left and right side-parts of the diagonal end.**
Be careful not to damage the sealing strips while joining the parts.
- 12, 13** **Fix the diagonal end joints (2 pcs.) using bolts and nuts (M8 x 16, 7 + 7 pcs.).**
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 15 (2.)** **Fix sealing strips to the end-flanges of the end-plate set-up, joined at stage 1.**
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).

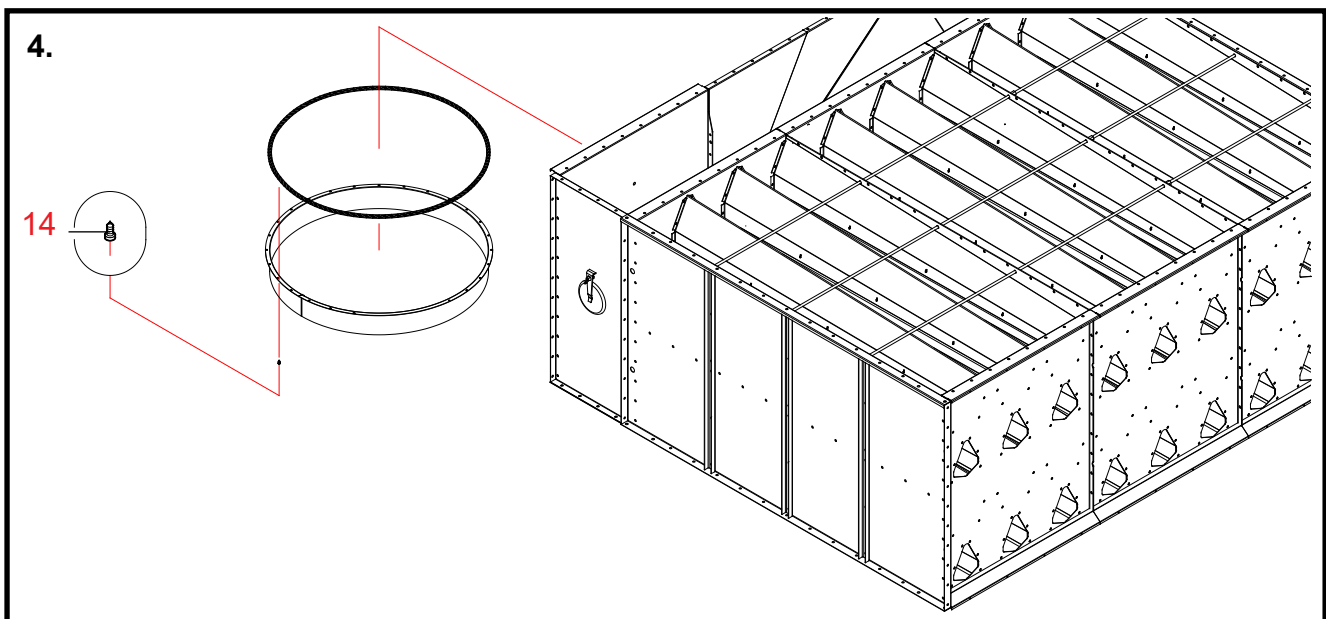
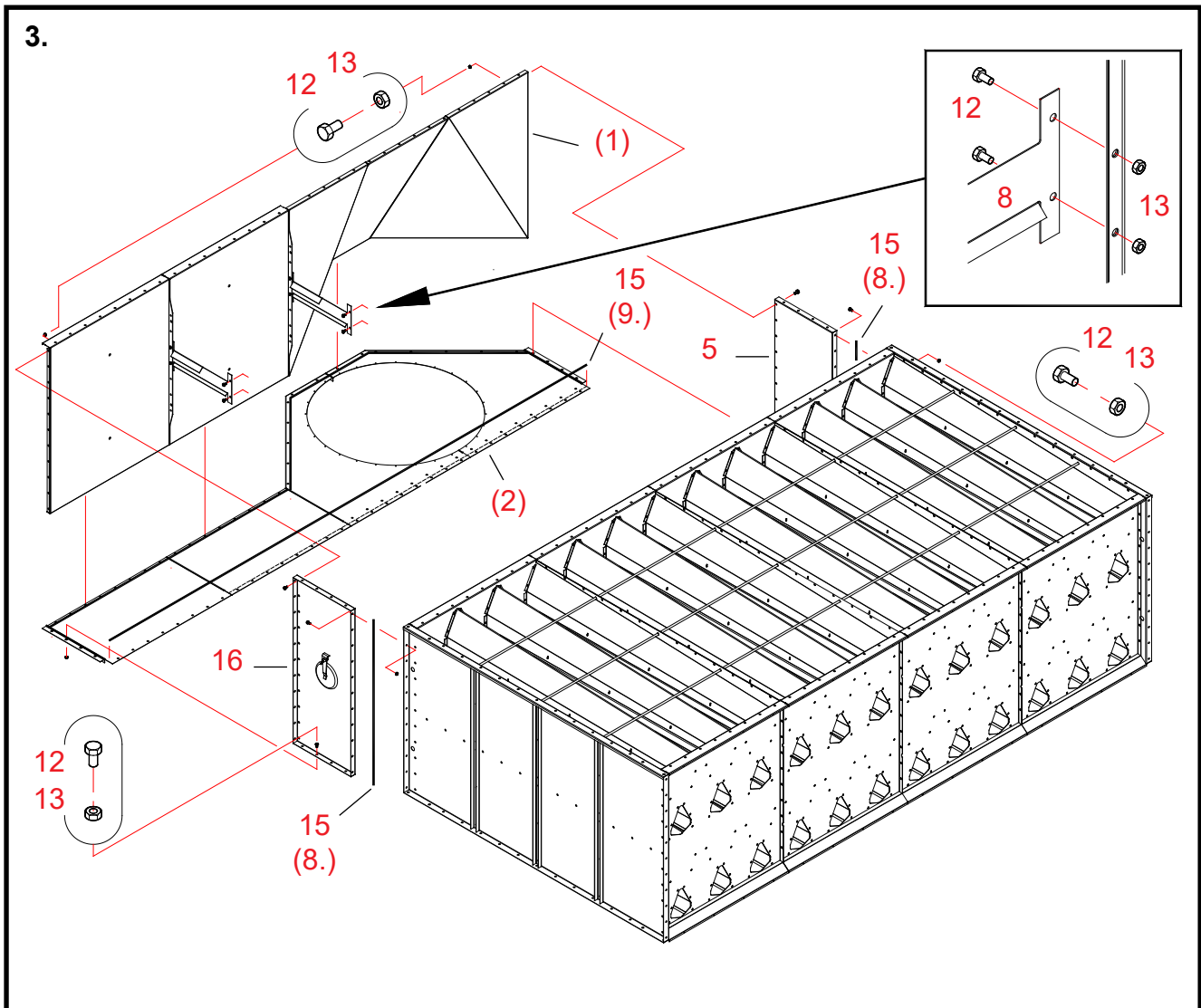
>>>



- 15 (3.) **Fix sealing strips to the end-flanges of the end-plate (parts 6).**
- 7 **Place a vertical support between the diagonal end and the end-plates.**
Be careful not to damage the sealing strips while installing the vertical support.
- 12, 13 **Fix the diagonal end, the end-plates and the vertical supports using bolts and nuts (M8 x 16, 11 + 11 pcs.).**
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 8 **Install the straight supports for the air channel end in the vertical supports (parts 7).**
- 12, 13 **Fix the supports using bolts and nuts (M8 x 16, 2 pcs./support).**

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

- 1, 2 **Join together the shutter-plate halves.**
- 12, 13 **Fix the joints (2 pcs.) of the shutter-plates using bolt and nut (M 8 x 16, 1 + 1 pcs.).**
- 15 (4.) **Fix sealing strips to the upper surface of the shutter-plate at the centre-part and the side-parts of the diagonal end.**
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 2).
- 15 (5.) **Fix sealing strips to the flanges of the corner-strips (parts 4).**
Fix the sealing strips inside the bolthole rows (see detail drawing 3).
- 15 (6.) **Fix a sealing strip to the other end-flange of both shutter-plates (part 3).**
Fix the sealing strips inside the bolthole rows. (see detail drawing 4).
- 3 **Install the shutter-plates (parts 3) with their centre-flanges face to face.**
- 12, 13 **Fix the plates using bolts and nuts (M8 x 16, 4 pcs.).**
- 15 (7.) **Fix a sealing strip to the upper surface of the shutter-plates (part 3).**
Fix the sealing strips inside the screw hole row. (see detail drawing 5).
- 3 **Place the shutter-plates (parts 3) against the end-flange of the large shutter-plate (parts 1 and 2).**
- 12, 13 **Fix the plate using bolts and nuts (M8 x 16, 4 pcs.).**
- 4 **Attach corner-strips to the end-flanges of the shutter-plate.**
- 12, 13 **Fix the corner-strips (2 pcs.) using bolts and nuts (M8 x 16, 4 + 4 pcs.).**





3. Assembling the air channel end

- 15 (8.) **Fix sealing strips to the flanges of the side-plates (parts 5 and 16).**
Fix the sealing strips inside the bolthole rows.
- 5, 16 **Move the side-plates tight against the end of the section.**
Be careful not to damage the sealing strips while installing the side-plates.
- 12, 13 **Fix the side-plates to the section using bolts and nuts (M8 x 16, 11 pcs. /side-plate).**
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 15 (9.) **Fix a sealing strip to the long edge of the set-up, assembled at stage 2.**
Fix the sealing strip inside the outer screw hole row.
- (2) **Move the set-up, assembled at stage 2, under the edge of the section.**
Align the holes in the outer screw hole row with the holes in the section.
Be careful not to damage the sealing strips while moving the set-ups.
- 12, 13 **Fix the part to the section and to the side-plates using bolts and nuts (M8 x 16, 32 + 4 + 4 pcs.).**
Tighten the bolts only lightly so that you can straighten the air channel end later.
- (1) **Move the set-up, assembled at stage 1, on top of the set-up, assembled at stage 2, and against the side-plates.**
Be careful not to damage the sealing strips while moving the set-ups.
- 12, 13 **Fix the set-up, assembled at stage 1, using bolts and nuts (M8 x 16, 30 + 11 + 11 pcs.).**
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 12, 13 **Fix the straight support for the air channel end to the section using bolts and nuts (M 8 x 16, 2 pcs.).**

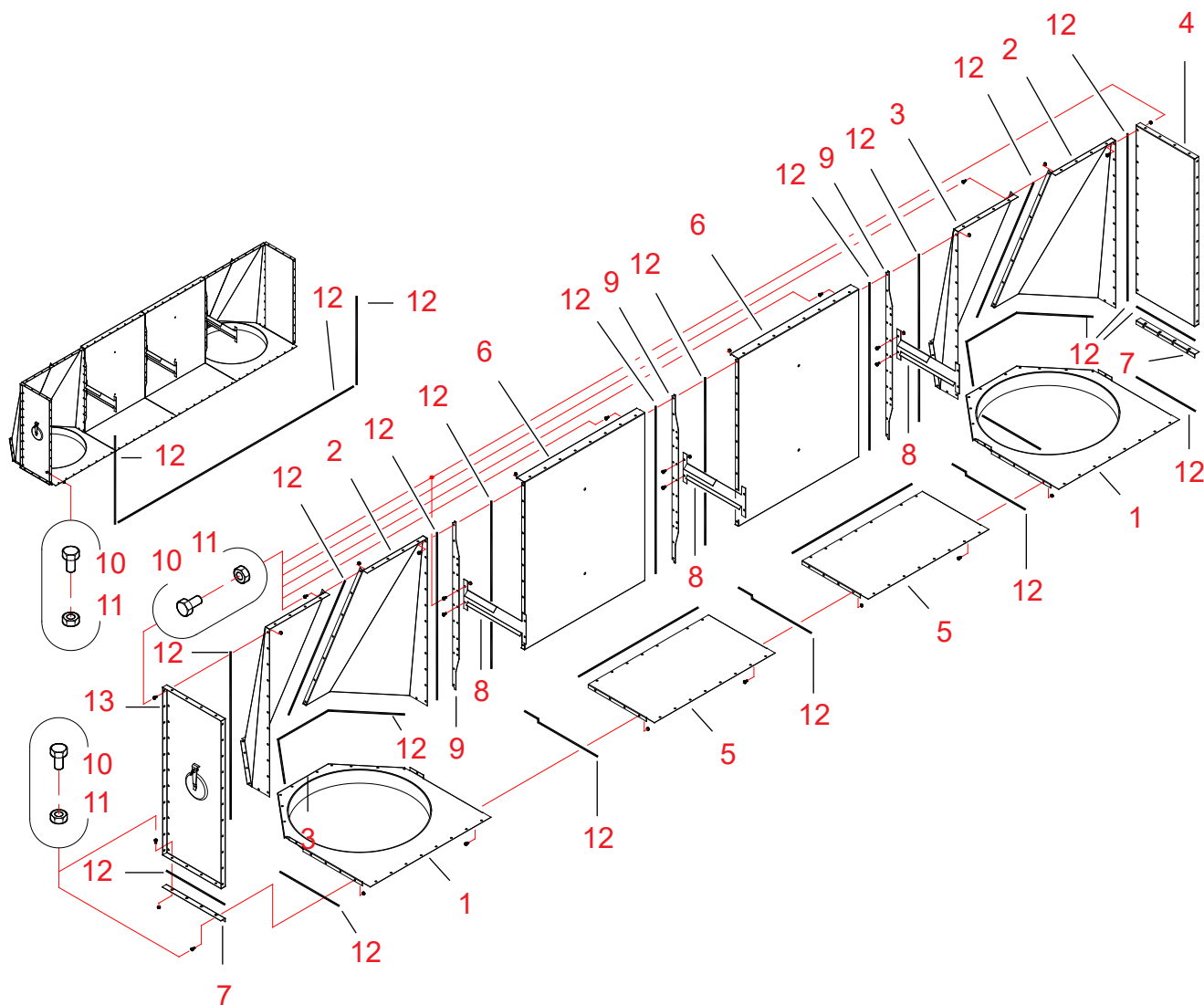
4. Installing the air pipe connector (pipe sleeve Ø 1000 mm, conversion part 1000/800 mm or 1000/630 mm)

- * **See point "Installing the air pipe connector in the air channel end"**
- 14 **Fix the connector to the air channel end using self-tapping screws (4,8 x 13, 28 pcs.).**
- * **Check the joints and rectangular shape of the air channel end. Tighten all bolts.**



Air channel end 0,5 4W (A71412) - lower part / upper part L, 2 x Ø 800 mm

Spare parts





20061106

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
1	A70630	AIR PIPE WM06 0,5	V SINGLE D800	2	A70630	5.33	3000
2	A70609	AIR CHANN L WM06 0.5	SINGLE D800 LEFT	2	A70609	9.75	3000
3	A70610	AIR CHANN L WM06 0.5	SINGLE D800 RIGHT	2	A70610	9.75	3000
4	A70635	AIR CHANN END WM06 0.5	SIDE-PLATE	1	A70635	7.52	3000
5	A70636	AIR CHANN END WM06 0.5	SHUTTER-PLATE	1	A70636	6.13	3000
6	A70563	TOP SECTION/AIR CH END	END-PLATE	1	A70563-B	14.65	3000
7	A70637	AIR CHANN END WM06 0.5	CORNER-STRIP	2	A70637-A	0.31	3000
8	A70660	AIR CHANN END WM06 0.5	STRAIGHT SUPPORT	2	A70660-A	0.77	3000
9	A70810	TOP SECTION WM06	VERTICAL SUPPORT PL3	2	A70810-B	1.12	3000
10	101810	BOLT HEX ZN 8.8	8X16 AM DIN933	181		0	2010
11	110540	NUT ZN 8 M 8	DIN934	181		0	2010
12	115570	SEALING STRIP	4X10 MAPA	35		0	2600
13	A71401	AIR PIPE WM06 0,5	SIDE-PL CLEAN HATCH	1	A71401	7.89	3000

Assembling air channel end A71412

*We recommend carrying out assembly of the air channel end on an even plane.
This ensures the ready-assembled air channel end is straight.*

1. Assembling the end-plate set-up for the air channel end

Parts The numbering of work stages refers to reference numbers in the spare parts drawing A71412 for the air channel end.

See illustration of this stage on next page.

12 (1.) **Fix sealing strips to the centre-flange of the diagonal end's (part 3) left halves.**
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).

2, 3 **Assemble two similar diagonal end set-ups (of parts 2 and 3).**
Be careful not to damage the sealing strips while joining the parts.

10, 11 **Fix the centre-joints of the diagonal end set-ups using bolts and nuts (M8 x 16, 7 + 7 pcs.).**
Tighten the bolts only lightly so that you can straighten the air channel end later.

12 (2.) **Fix sealing strips to both side-flanges of the diagonal end set-ups (parts 2 + 3).**
Fix the sealing strips outside the bolthole rows in the flanges (see detail drawing 2).

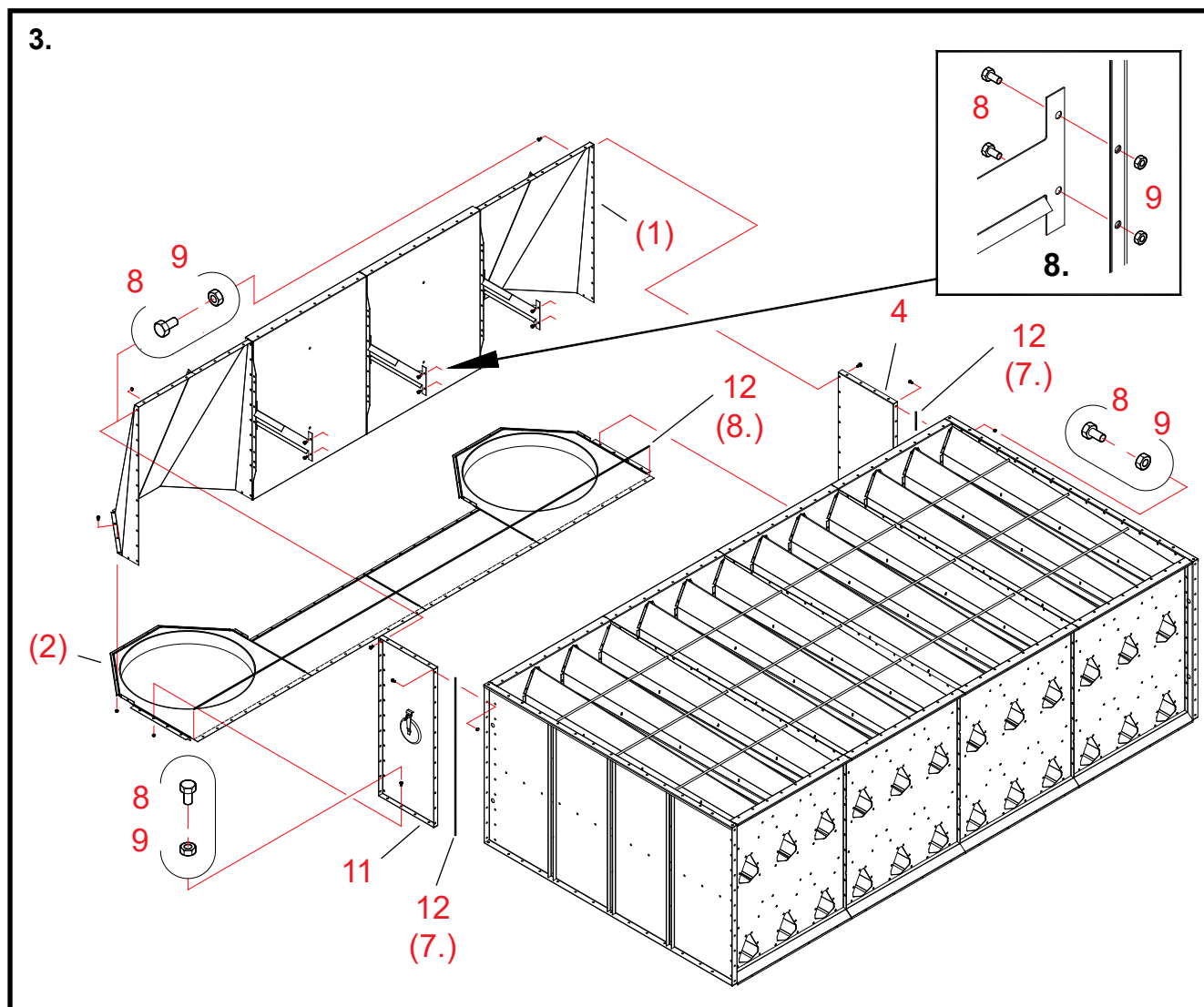
>>>



- 12 (3.)** **Fix sealing strips to the end-flanges of the end-plate (parts 6).**
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1).
- 6** **Place the end-plates (parts 6) between the diagonal end set-ups (parts 2 + 3).**
- 9** **Place the vertical supports on both sides between the end-plates, against the diagonal end set-ups.**
Be careful not to damage the sealing strips while installing the vertical support.
- 10, 11** **Fix the diagonal ends, the end-plates and the vertical supports using bolts and nuts (M8 x 16, 3 x 11 pcs.).**
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 8** **Install the straight supports for the air channel end in the vertical supports (parts 9).**
Look up correct position for the support in the drawing.
- 10, 11** **Fix the supports using bolts and nuts (M8 x 16, 2 + 2 + 2 pcs.).**

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

- 12 (3.)** **Fix sealing strips to the upper surface of the shutter-plates (parts 1) at the diagonal end.**
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 3).
Extend the sealing strips to inside the vertical flanges of the shutter-plate (see detail drawing 4).
- 12 (4.)** **Fix sealing strips to the end-flanges of the shutter-plates (parts 5).**
Observe, that the other plate shall be provided only with one sealing strip.
Fix the sealing strip inside the bolthole rows in the flange (see detail drawing 5).
- 1+1 + 5+5** **Install the end-flanges of the shutter-plates (parts 1 and parts 5) face to face.**
- 10, 11** **Join the shutter-plates together using bolts and nuts (M8 x 16, 4 + 4 + 4 pcs.).**
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 12 (5.)** **Fix a sealing strip to the upper surface of the shutter-plates (part 5).**
Fix the sealing strips inside the screw hole rows (see detail drawing 7).
- 12 (6.)** **Fix sealing strips to the flanges of the corner-strips (parts 7).**
Fix the sealing strips inside the bolthole rows (see detail drawing 6).
- 7** **Attach corner-strips to the end-flanges of the shutter-plate.**
- 10, 11** **Fix the corner-strips (2 pcs.) using bolts and nuts (M8 x 16, 4 + 4 pcs.).**





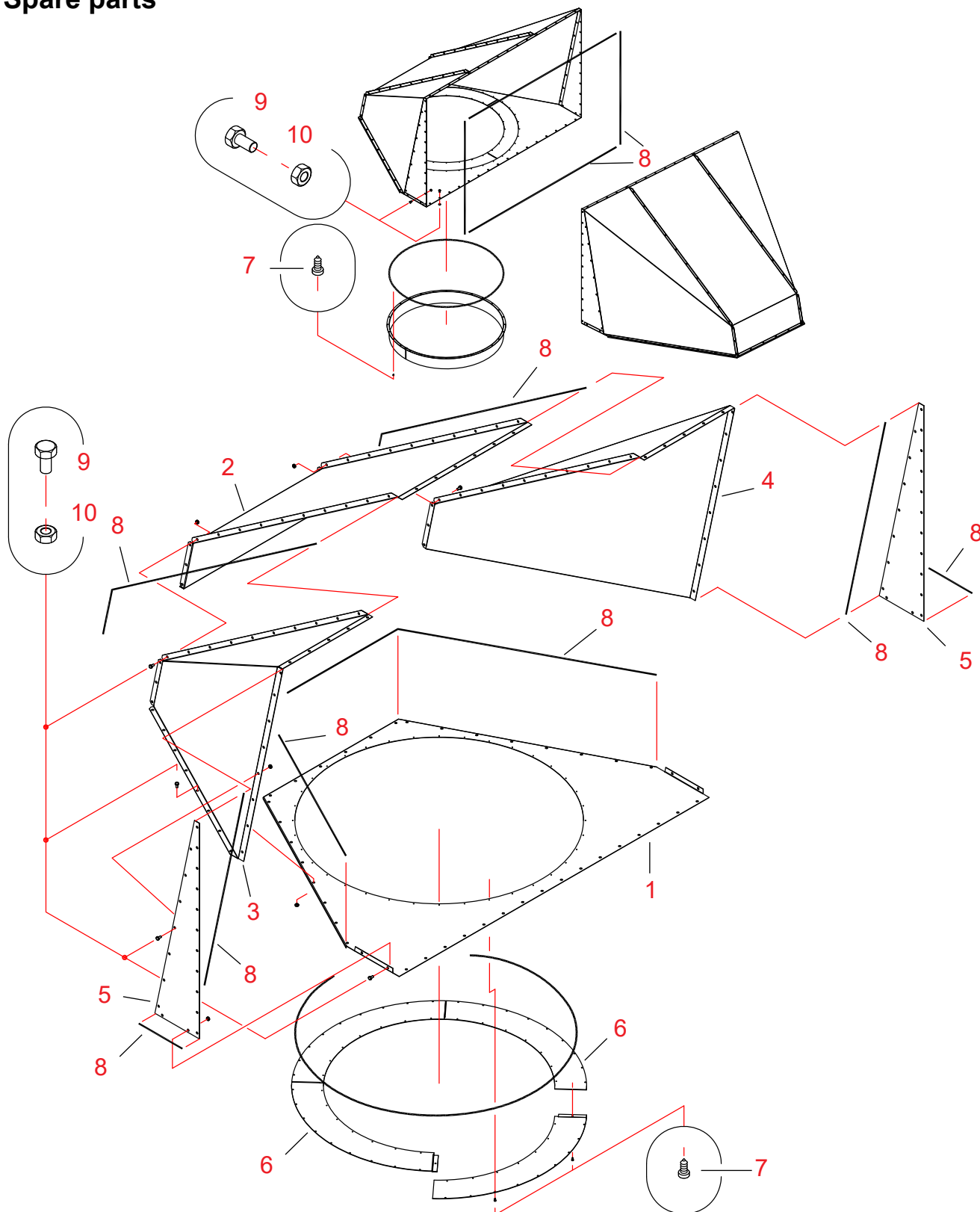
3. Assembling the air channel end

- 12 (7.) **Fix sealing strips to the flanges of the side-plates (parts 4 and 13).**
Fix the sealing strips inside the bolthole rows.
- 4, 13 **Move the side-plates tight against the end of the section.**
Be careful not to damage the sealing strips while installing the side-plates.
- 10, 11 **Fix the side-plates to the section using bolts and nuts (M8 x 16, 11 pcs. /side-plate).**
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 12 (8.) **Fix a sealing strip to the long edge of the set-up, assembled at stage 2.**
Fix the sealing strips inside the screw hole row.
- (2) **Move the set-up, assembled at stage 2, under the edge of the section.**
Align the holes in the screw hole row with the holes in the section.
Be careful not to damage the sealing strips while moving the set-ups.
- 10, 11 **Fix the part to the section and to the side-plates using bolts and nuts (M8 x 16, 32 + 4 + 4 pcs.).**
Tighten the bolts only lightly so that you can straighten the air channel end later.
- (1) **Move the set-up, assembled at stage 1, on top of the set-up, assembled at stage 2, and against the side-plates.**
Be careful not to damage the sealing strips while moving the set-ups.
- 10, 11 **Fix the set-up, assembled at stage 1, by its lower edge using bolts and nuts (M8 x 16, 39 pcs.).**
- 10, 11 **Fix the set-up, assembled at stage 1, by its ends using bolts and nuts (M8 x 16, 11 + 11 pcs.).**
- 10, 11 **Fix the straight supports for the air channel end using bolts and nuts (M 8 x 16, 2 pcs./support).**
See detail drawing 8. Tighten the bolts only lightly so that you can straighten the air channel end later.
- * **Check the joints and rectangular shape of the air channel end. Tighten all bolts.**



Air channel end 2W / 3W / 4W (A71090) - centre-part L, ø 1250 / 1000 mm

Spare parts

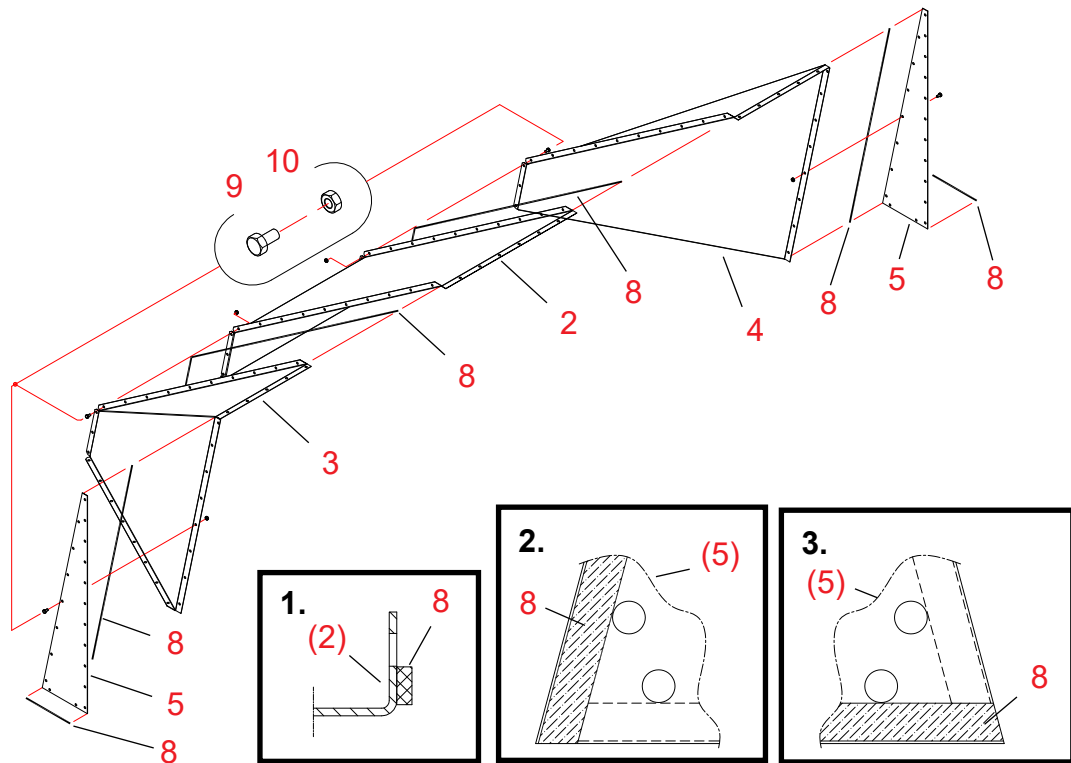




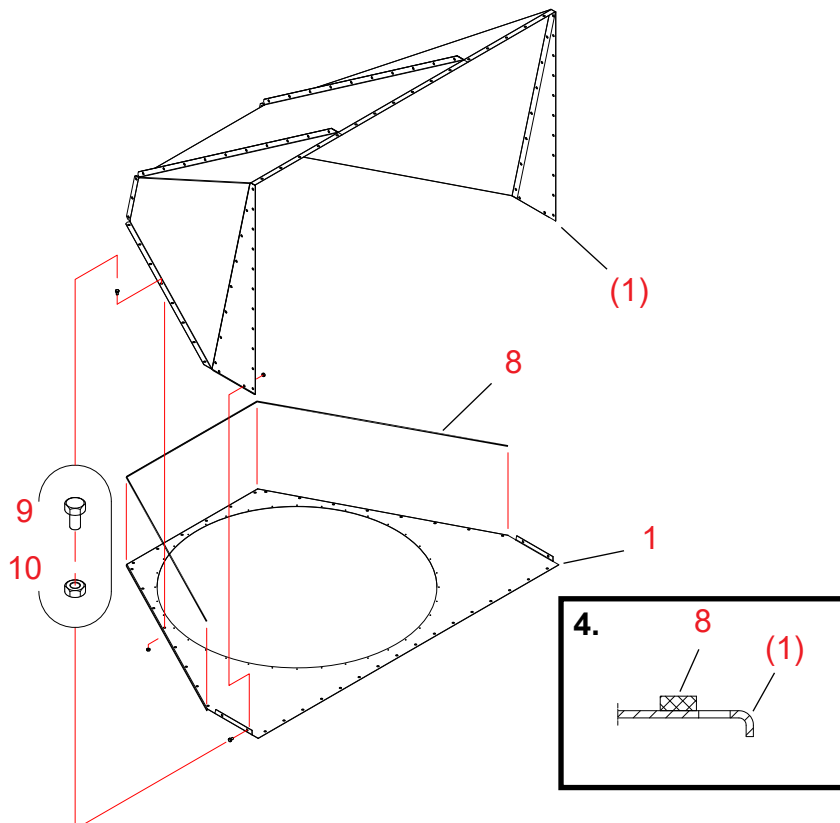
Ref.	Part no.	Denomination 1	Pcs.	Drawing No.	Weight	Group
1	A71084	AIR CHANN END SHUTTER-PL SINGLE D1250 WM06 L	1	A71084	10,1	3000
2	A71086	AIR CHANN END SINGLE D1250 WM06 L CENTRE	1	A71086	18,6	3000
3	A71087	AIR CHANN END SINGLE RIGHT D1250 WM06 L	1	A71087	16,6	3000
4	A71088	AIR CHANN END SINGLE LEFT D1250 WM06 L	1	A71088	16,6	3000
5	A71089	AIR CHANN END TRIANGLE D1250 WM06 L	2	A71089	2,1	3000
6	A71254	AIR CHANN END 1/4 CIRCLE D1250/1000 WM06	4	A71254	2,0	3000
7	107720	SELF-TAP HEX SCREW 4,8X13 ZN	72			2010
8	115570	SEALING STRIP 4X8 EKO-40	24			2600
9	101810	BOLT HEX ZN 8.8 8X16 AM DIN933	126			2010
10	110540	NUT M8 ZN 8 DIN934	126			2010



1.



2.





Assembling air channel end A71090

*We recommend carrying out assembly of the air channel end on an even plane.
This ensures the ready-assembled air channel end is straight.*

1. Assembling the end-plate set-up for the air channel end

(See drawing on the previous page)

- Parts The numbering of work stages refers to reference numbers in the spare parts drawing A71090 for the air channel end.
- 8** **Fix sealing strips to both end-flanges of the diagonal end's centre-part (part 2).**
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 1 on the previous page).
- 2, 3, 4** **Join together the centre-part and the left and right side-parts of the diagonal end.**
Be careful not to damage the sealing strips while joining the parts.
- 9, 10** **Fix the joints of the diagonal end (2, 3 and 4) using bolts and nuts (M8 x 16, 11 + 11 pcs.).**
Tighten the bolts only lightly so that you can straighten the air channel end later.
- 8** **Fix the long sealing strips to the sides with 7 holes of the triangular plates (parts 5).**
Fix the sealing strips to the edge of the plate, outside the screw hole rows (see detail drawing 2 on the previous page).
Observe, that you should make one right-handed and one left-handed plate, i.e place the sealings on opposite sides of the plate.
The triangular plate to be attached to the left side of the diagonal end is shown in the detail drawing 2.
- 8** **Fix the short sealing strips to the sides with 2 holes of the triangular plates (parts 5).**
Fix the sealing strips to the edge of the plate, outside the screw hole rows (see detail drawing 3 on the previous page).
Observe, that the short sealings are fixed on different side of the plate than the long ones.
The triangular plate to be attached to the left side of the diagonal end is shown in the detail drawing 3.
- 4** **Move the triangular plates tight against the ends of the diagonal end set-up.**
Be careful not to damage the sealing strips while installing the side-plates.
- 9, 10** **Fix the triangular plates using bolts and nuts (M 8 x 16, 7 pcs./triangular plate).**
Tighten the bolts only lightly so that you can straighten the air channel end later.

2. Assembling the air channel end

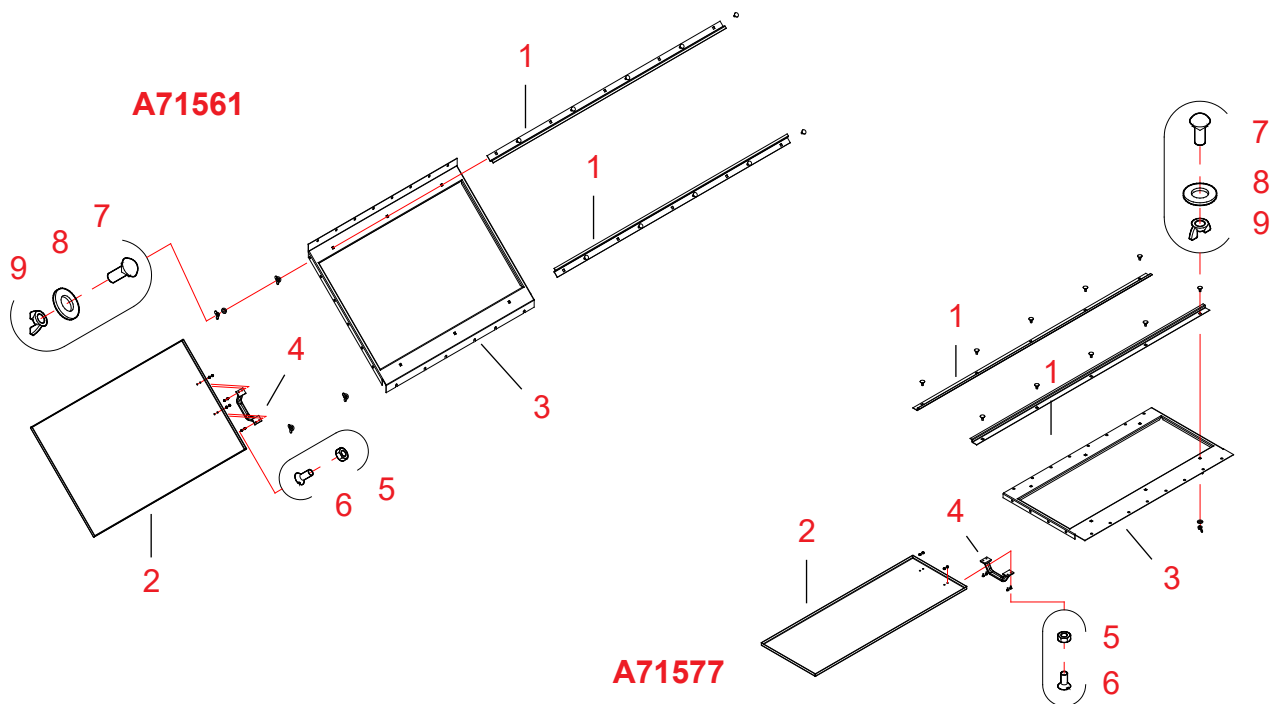
- 8** **Fix sealing strips to the upper surface of the shutter-plate at the centre-part and the side-parts of the diagonal end.**
Fix the sealing strips inside the bolthole rows in the flanges (see detail drawing 4).
- 1** **Attach the shutter-plate to the lower surface of the diagonal end, assembled at stage 1.**
Place the lower ends of the triangular plates inside the vertical flanges.
Be careful not to damage the sealing strips while joining the parts.
- 9, 10** **Fix the shutter-plate to the diagonal end and the triangular plates using bolts and nuts (M 8 x 16, 22 pcs.).**
- *** **See point "Installing the air pipe connector in the air channel end"**
Pipe sleeve Ø 1250 mm, pipe sleeve Ø 1000 mm, conversion part 1000/800 mm or 1000/630 mm.
- 7** **Fix the adapter (parts 6) to the air channel end using self-tapping screws (4,8 x 13, 28 pcs.).**
- *** **Check the joints and rectangular shape of the air channel end. Tighten all bolts.**



Air channel end 0,5 (A71561) - replacement air opening in the return bottom

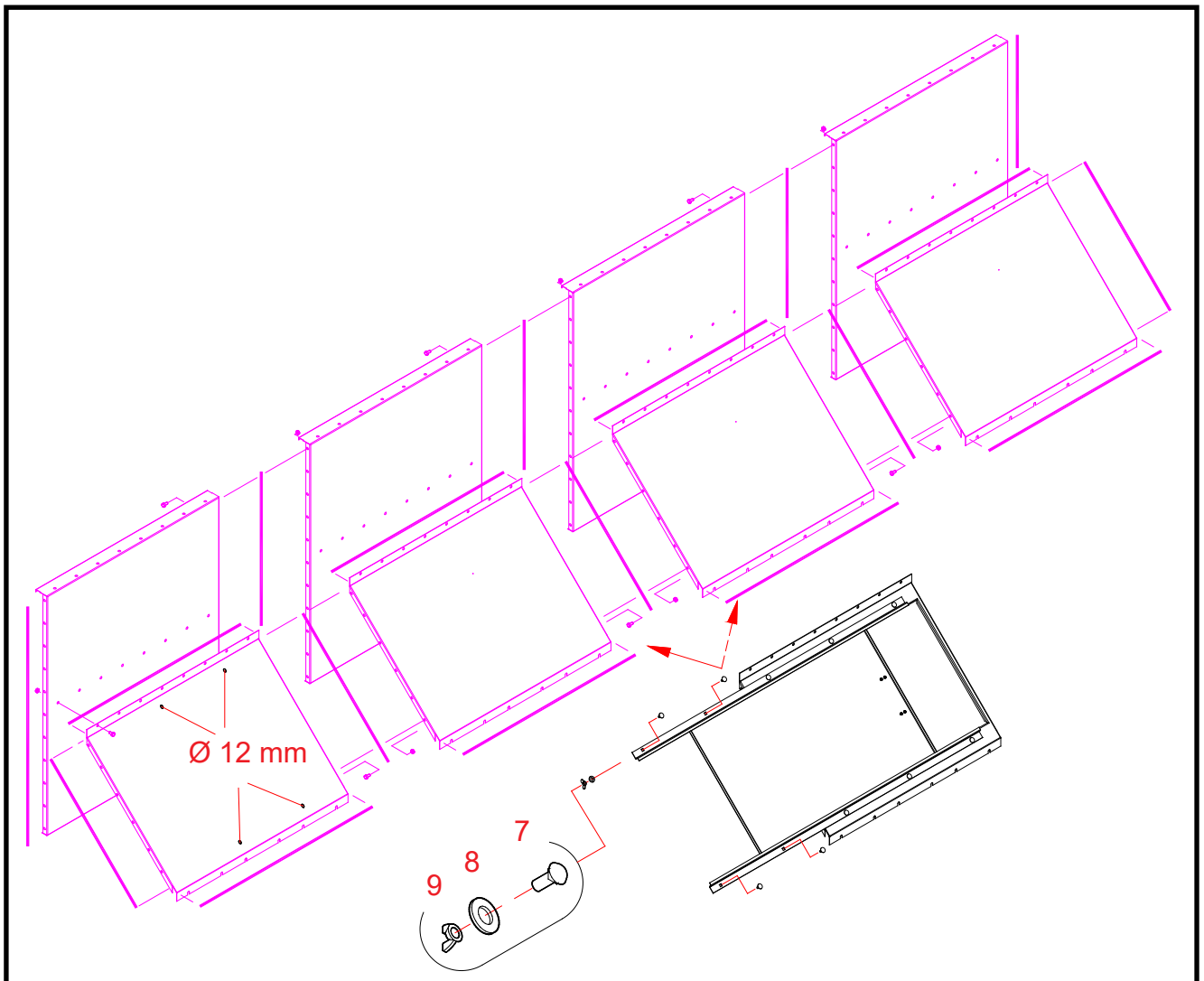
Air channel end 0,5 (A71577) - replacement air opening in the shutter-plate

Spare parts



20070322

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
A71561							
1	A71555	AIR CHANN END WM06	REPLAC AIR GUIDE	2	A71555-0	0,95	
2	A71556	AIR CHANN END WM06	REPLAC AIR PLATE	1	A71556-0	9,44	
3	A71558	AIR CHANN END WM06	0.5 RET BOTT WITH OPEN	1	A71558-0	4,65	
4	119034	PLAST HANDLE	LGT GREY PISLA 805	1	119034-	0,59	
5	110520	NUT ZN 8 M 5	DIN934	4		0	
6	103691	BOLT CTRSUNK SLOT	5X12XAM	4		0	
7	107913	LOCK SCREW ZN	M8X20 DIN603 8.8	10		0,02	
8	111560	WASHER ZN	M12 ZN DIN 125	10		0	
9	111020	NUT WING ZN	M 8 DIN315	10		0,01	
A71577							
1	A71555	AIR CHANN END WM06	REPLAC AIR GUIDE	2	A71555-0	0,95	
2	A71579	AIR CHANN END WM06	REPLAC AIR PLATE	1	A71579-0	5,86	
3	A71578	AIR CHANN END WM06	0.5 SHUTT-PL WITH OPEN	1	A71559-0	7,97	
4	119034	PLAST HANDLE	LGT GREY PISLA 805	1	119034-	0,59	
5	110520	NUT ZN 8 M 5	DIN934	4		0	
6	103691	BOLT CTRSUNK SLOT	5X12XAM	4		0	
7	107913	LOCK SCREW ZN	M8X20 DIN603 8.8	10		0,02	
8	111560	WASHER ZN	M12 ZN DIN 125	10		0	
9	111020	NUT WING ZN	M 8 DIN315	10		0,01	



Installing the replacement air opening A71561

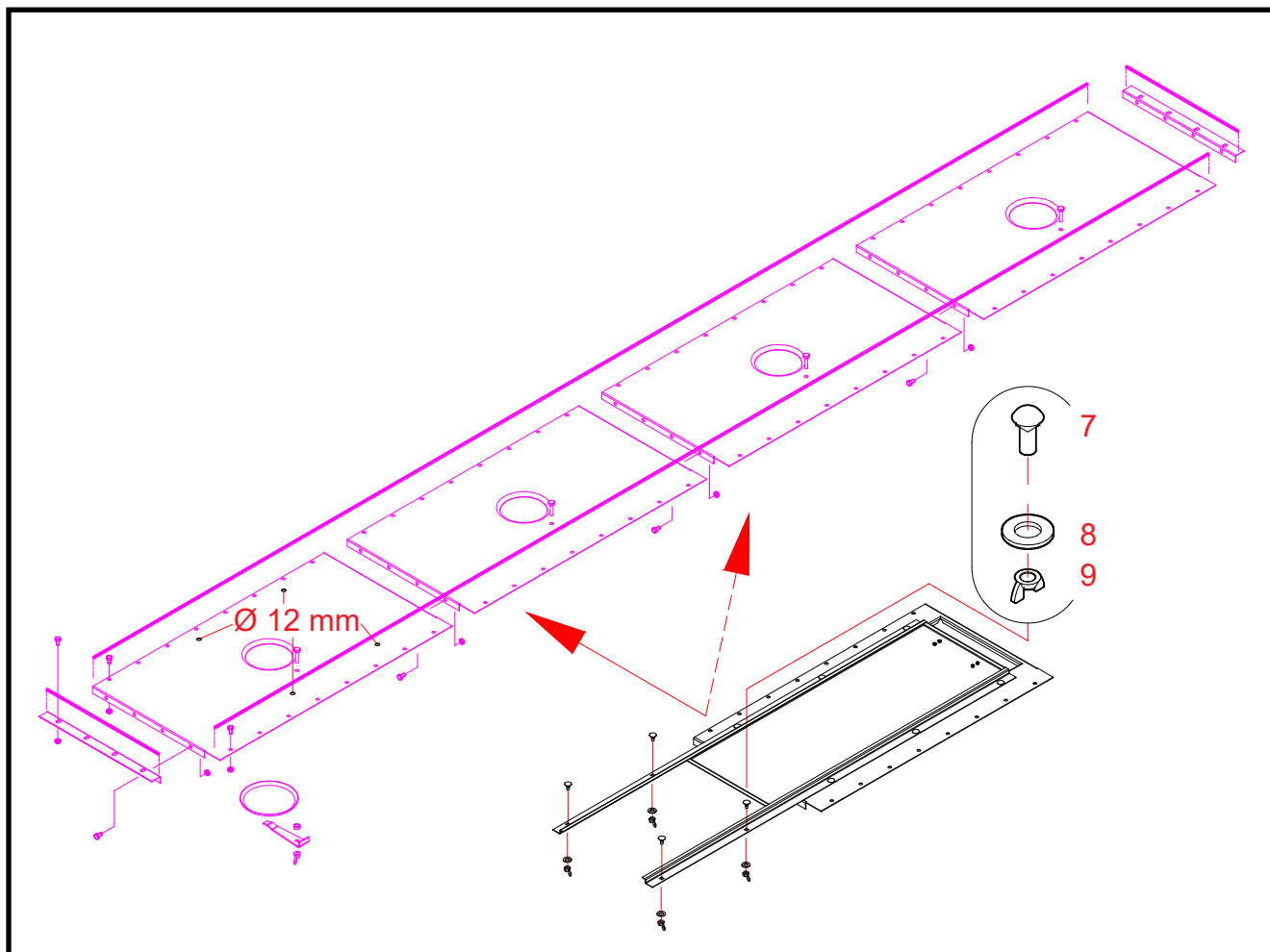
The replacement air opening (A70664) can be installed in place of the other return bottom plate. If possible, install the replacement air opening in one of the midmost modules of the air channel end.

Installing the replacement air plate

Parts The numbering of parts refers to reference numbers in the spare parts drawing A71561 for the air channel end.

Please refer to the assembly instructions for the return end A70664.

1. The replacement air plate shall be installed in the same way as the return bottom, indicated by the arrow.
2. Drill four Ø 12 mm holes in the next return bottom, in the drawing on the left-hand side. Mark the places for the holes in accordance with the square holes in the guide strips.
3. Attach the guide strips to the left return bottom.
Lock screws (parts 7), washers (parts 8) and wing nuts (parts 9) (M 8 x 20, 4 pcs.).



Installing the replacement air opening A71577

The replacement air opening (A70728) can be installed in place of one of the shutter-plates
If possible, install the replacement air opening in one of the midmost modules of the air channel end.

Installing the replacement air plate

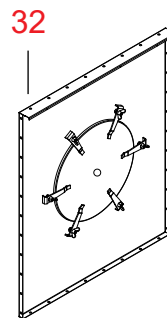
Parts The numbering of parts refers to reference numbers in the spare parts drawing A71577 for the air channel end.

Please refer to the assembly instructions for the lower shutter-plate A70728.

1. The replacement air plate shall be installed in the same way as the return bottom, indicated by the arrow.
2. Drill four Ø 12 mm holes in the next shutter-plate, in the drawing on the left-hand side.
Mark the places for the holes in accordance with the square holes in the guide strips.
3. Attach the guide strips to the left shutter-plate.
Lock screws (parts 7), washers (parts 8) and wing nuts (parts 9) (M 8 x 20, 4 pcs.).



Air channel end (A71406), manhole hatch - end-plate

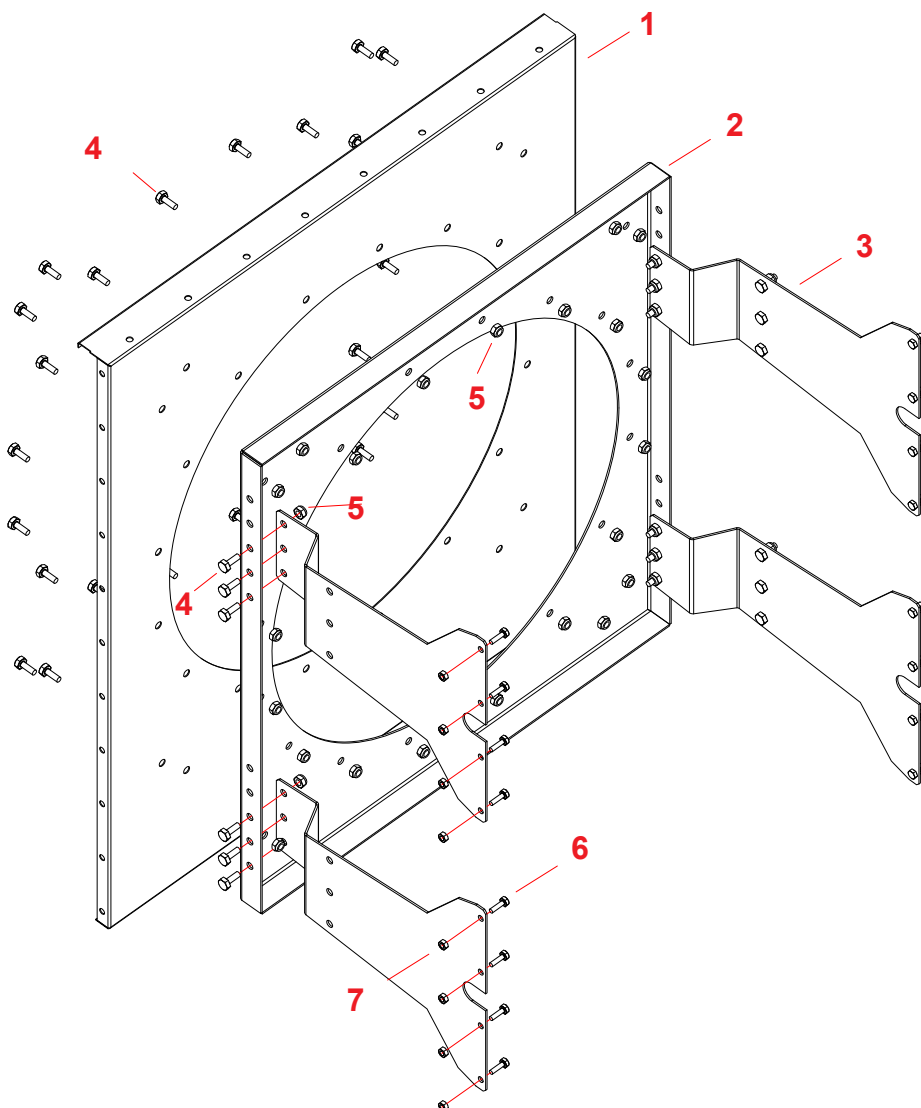


20080715

Ref.	Part no.	Denomination 1	Denomination 2	Pcs.	Drawing No.	Weight	Group
32	A71406	AIR PIPE WM06	END-PLATE MANHOLE HATCH	1	A71406-A	16.65	3000

Air channel end 0,5 (A76263) - fan mounting parts

Spare parts



Ref.	Part no.	Denomination	Pcs.	Drawing No.	Weight
1	A76255	AIR CHANN END AXIAL D710 FAN END WM06	1	A76255	9.97
2	A76256	AIR CHANN END AXIAL D710 RESPONSE PLATE WM06	1	A76256	12
3	A76257	AIR CHANN END AXIAL D710 BRACKET WM06 0.5	4	A76257	2.42
4	102210	BOLT HEX ZN 8.8 10X25 AM DIN933	42		
5	110800	NUT NYLOC M10 ZN DIN985	42		
6	101830	BOLT HEX ZN 8.8 8X25 AM DIN933	16		
7	110540	NUT M8 ZN 8 DIN934	16		



Installing axial fan mounting parts (A76263)

