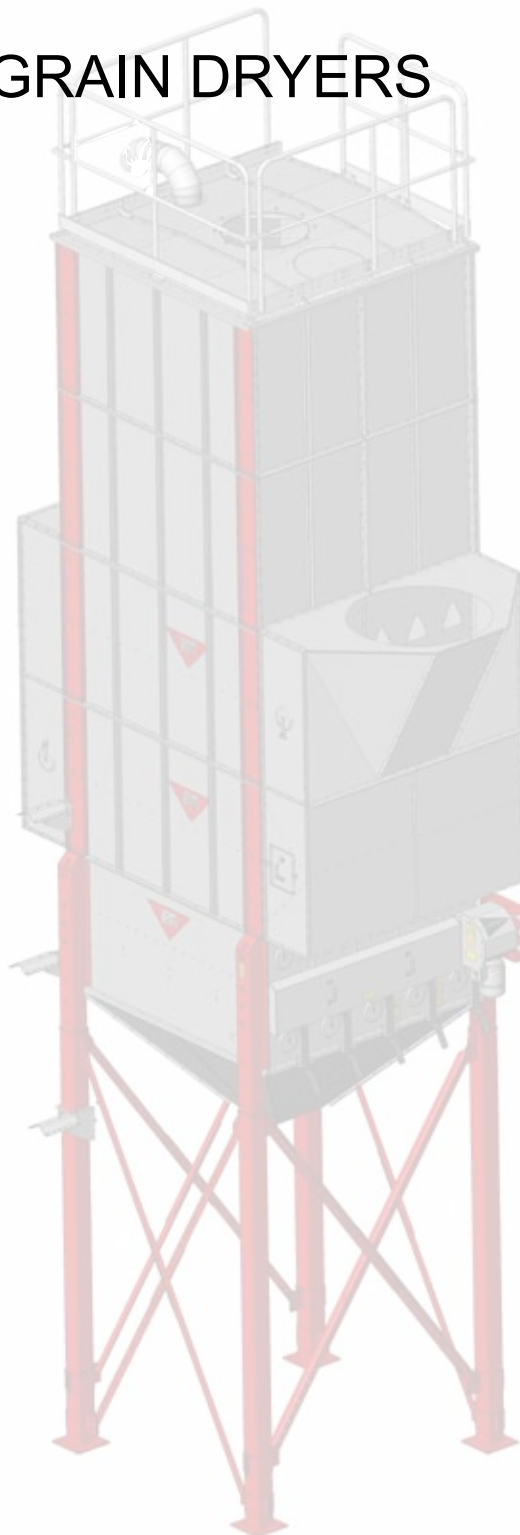


Assembly Instructions

ANTTI M06 2W GRAIN DRYERS TOP SECTION

408072 (en) 01-01-2010

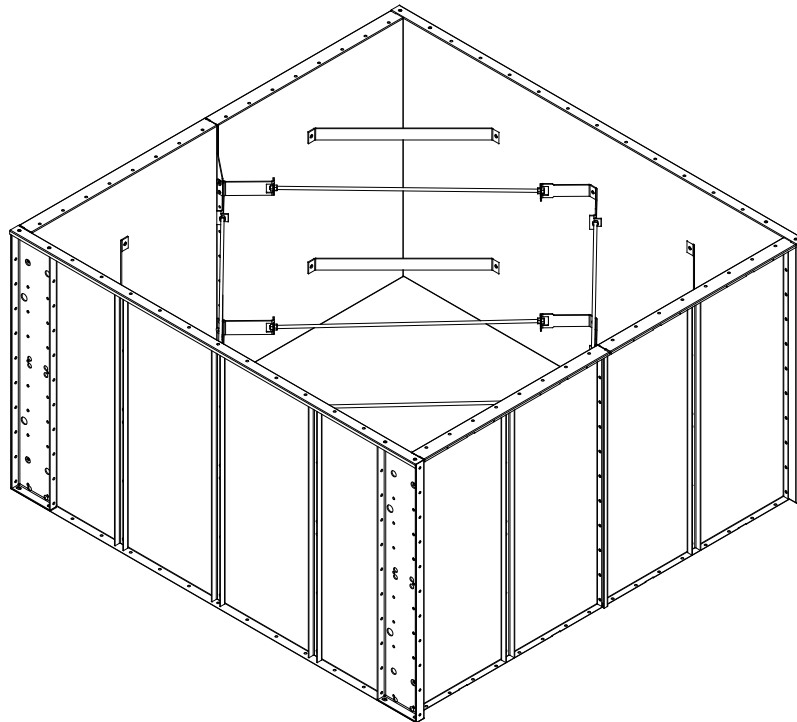


You'll see the difference



Top section 2W assembled (A70559)

Air channel end side

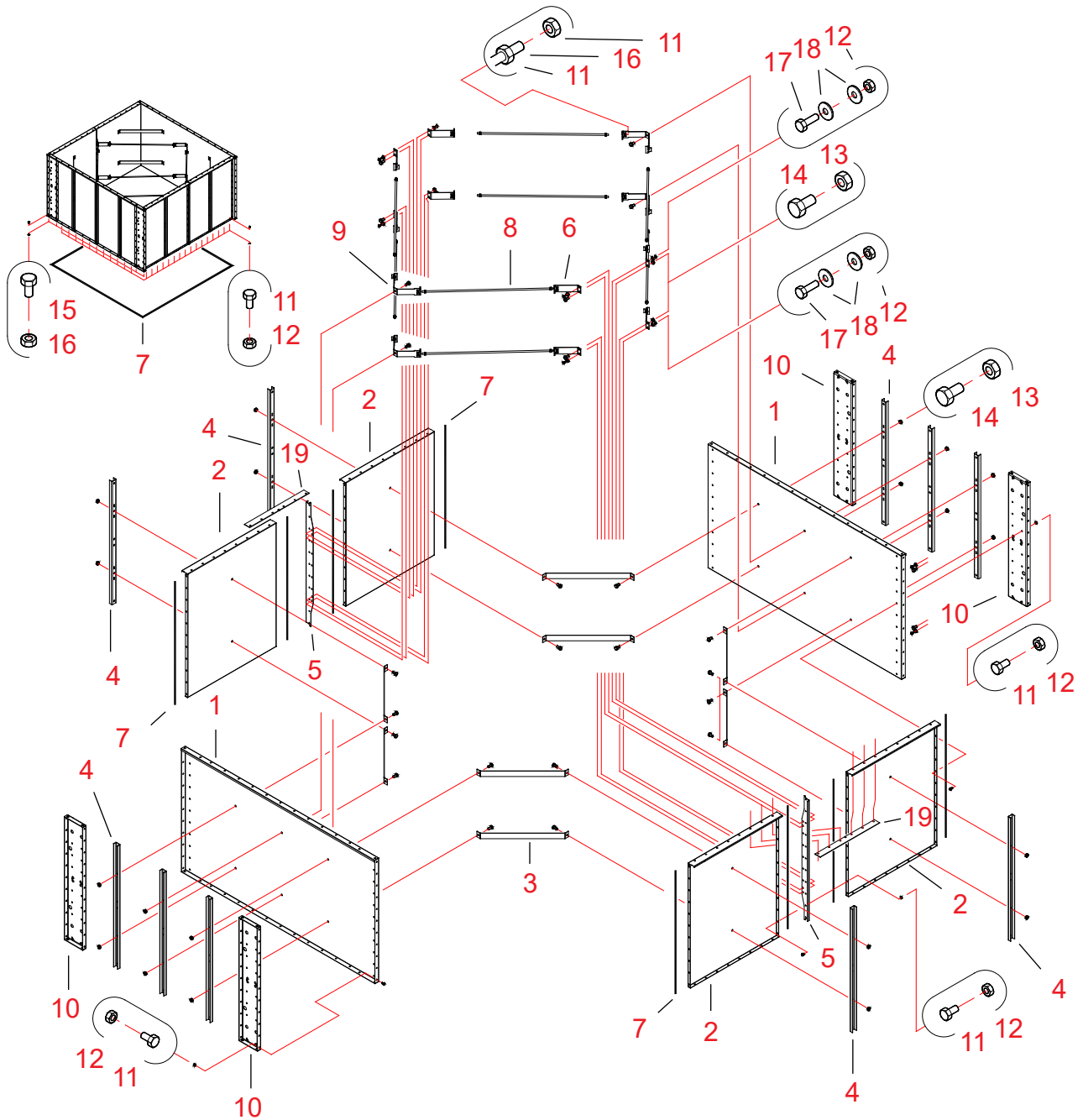


Air channel end side

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Top section 2W assembled (A70559), spare parts





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Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	A70562	TOP SECTION WM06 SIDE-PLATE	2	A70562-A	31.75	3000
2	A70563	TOP SECTION/AIR CH END END-PLATE	4	A70563-C	14.65	3000
3	A70560	TOP SECTION WM06 DRAWBAR SHORT	8	A70560	1.11	3000
4	A70565	TOP SECTION WM06 VERTICAL SUPPORT	10	A70565-D	2.45	3000
5	A70810	TOP SECTION WM06 VERTICAL SUPPORT PL 3	2	A70810-C	2.34	3000
6	A72407	TOP SECTION WM06 BRACKET DRAWBAR LONG DUAL	4	A72407-0	0.68	3000
7	115570	SEALING STRIP 4X10 MAPA	19		0.04	2600
8	119028	THREADED ROD ZN - M12x1000 MM 8.8	8		0.89	2010
9	A72408	TOP SECTION WM06 BRACKET DRAWBAR LONG SINGLE	8	A72408-0	0.41	3000
10	A70359	SECTION WM06 SUPPORT LEG S=4	4	A70359-D	9.72	3000
11	101810	BOLT 6K ZN – 8x16 AM DIN933	120		0.01	2010
12	110540	NUT ZN – M8 DIN934	120+8		0	2010
13	110570	NUT ZN - M12 DIN934	24+32		0	2010
14	102500	BOLT 6K ZN – 12x25 AM DIN933	24		0	2010
15	102210	BOLT 6K ZN – 10x25 AM DIN933	8		0	2010
16	110560	NUT ZN – M10 DIN934	8		0	2010
17	101830	BOLT 6K ZN – 8x25 AM DIN933	4		0	2010
18	111532	WASHER ZN FENDER - M8 DIN9021	8		0	2010
19	A71060	TOP SECTION WM06 BRACE FLANGE	2	A71060-0	1.11	3000



Top section 2W, delivery package (A70829)

The top section of 2W comprises: 1 package A70829, top section 2W

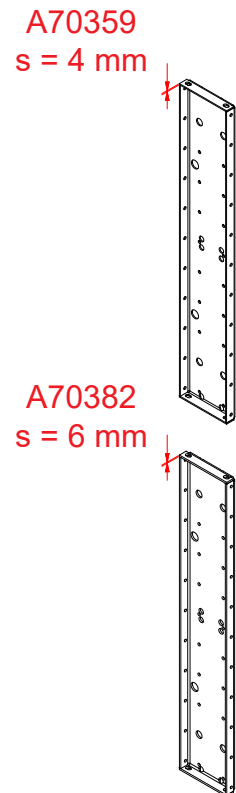
In addition, as required: (included 4 pcs. of support leg A70359, s = 4 mm. in the dryer delivery as separate items)

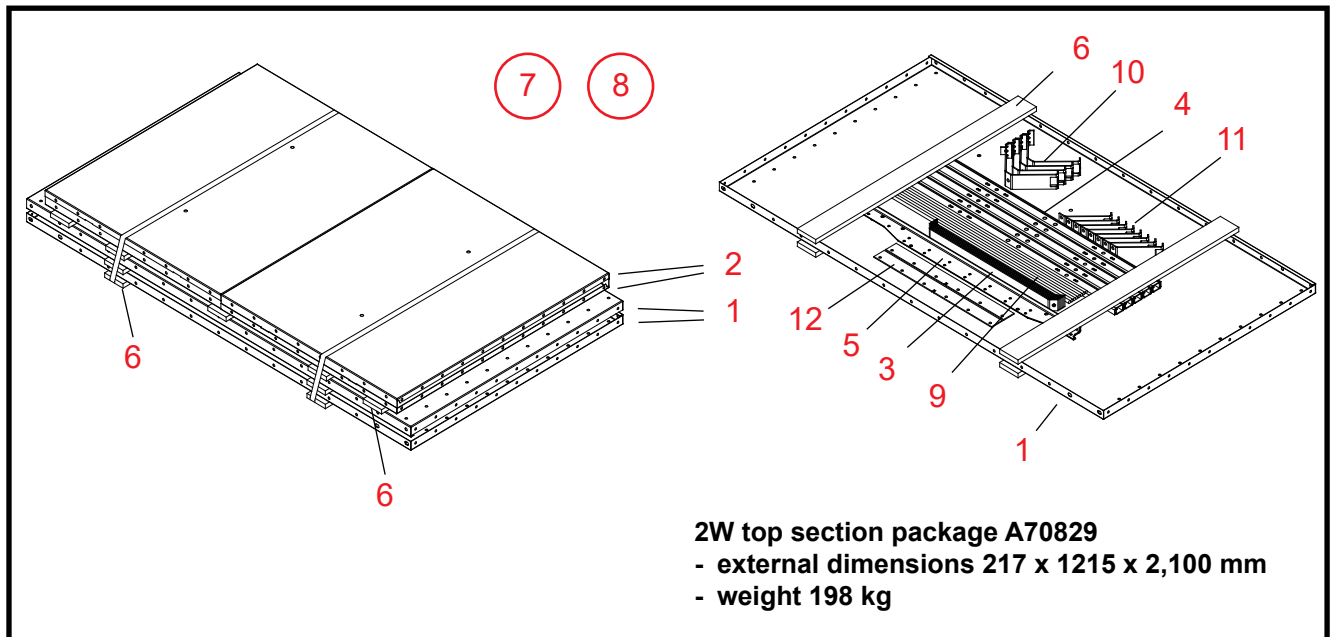
The way the legs are installed in the top section depends on location of the section in the ready-assembled dryer.

Table presenting position of the support legs in different layers of the 2W dryer

Layers are enumerated starting from top to bottom

Layer	Support leg
TOP LAYER	-
2. LAYER FROM THE TOP	-
3. LAYER FROM THE TOP	-
4. LAYER FROM THE TOP	A70359, s = 4 mm
5. LAYER FROM THE TOP	A70359, s = 4 mm
6. LAYER FROM THE TOP	A70359, s = 4 mm
7. LAYER FROM THE TOP	A70359, s = 4 mm
8. LAYER FROM THE TOP	A70359, s = 4 mm
9. LAYER FROM THE TOP	A70359, s = 4 mm
10. LAYER FROM THE TOP	A70359, s = 4 mm
11. LAYER FROM THE TOP	A70382, s = 6 mm
12. LAYER FROM THE TOP	A70382, s = 6 mm
13. LAYER FROM THE TOP	A70382, s = 6 mm

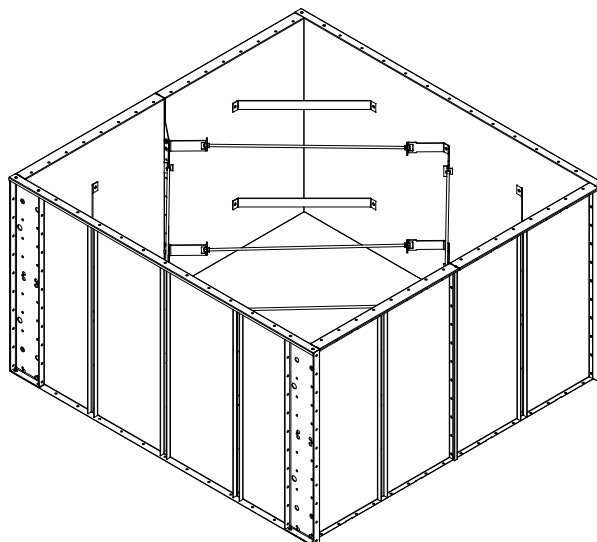




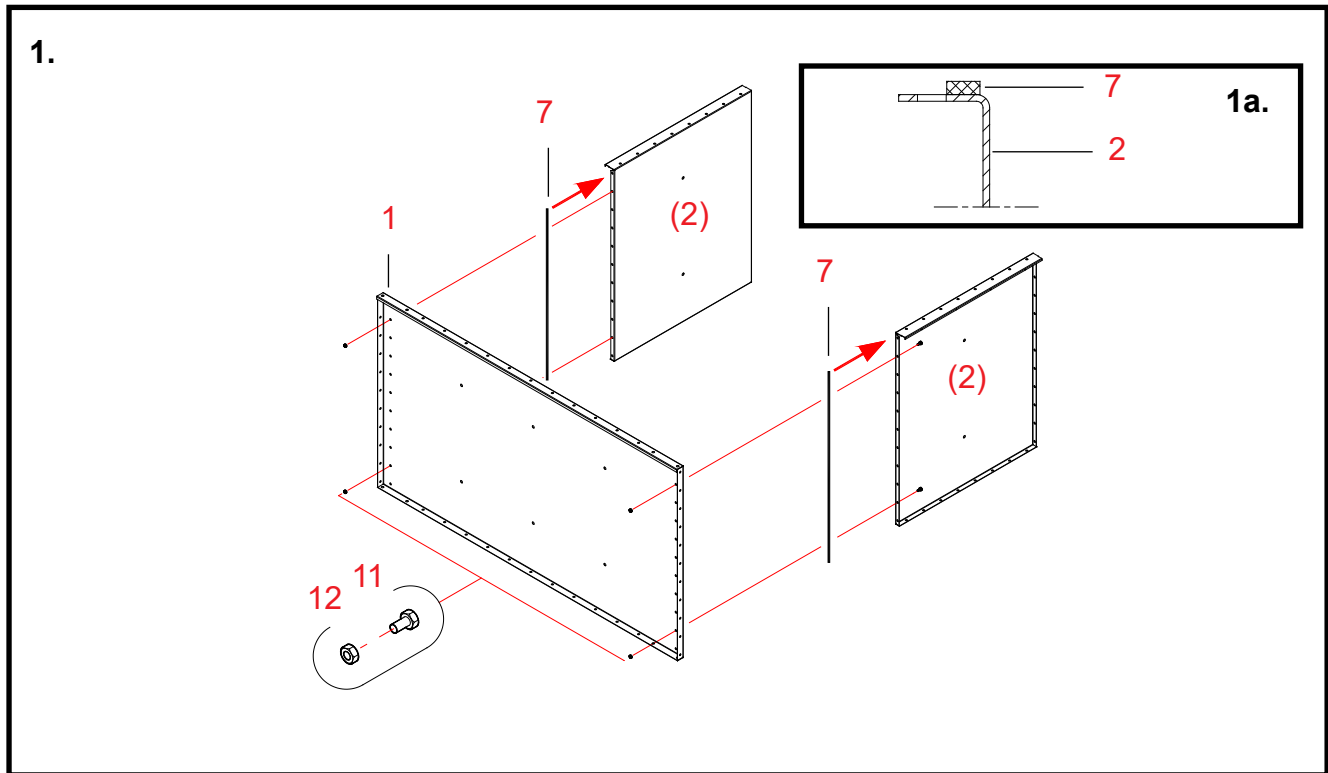
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Ref.	Part no.	Denomination 1 and 2	Pcs.	Drawing No.	Weight	Group
1	A70562	TOP SECTION WM06 SIDE-PLATE	2	A70562-A	31.74	3000
2	A70563	TOP SECTION/AIR CH END END-PLATE	4	A70563-C	14.65	3000
3	A70560	TOP SECTION WM06 DRAWBAR SHORT	8	A70560-0	1.11	3000
4	A70565	TOP SECTION WM06 VERTICAL SUPPORT	10	A70565-D	2.45	3000
5	A70810	TOP SECTION WM06 VERTICAL SUPPORT PL 3	2	A70810-C	2.34	3000
6	315418	BOARD L=1200 22x100	9		1.44	2800
7	A70831	TOP SECTION WM06 2W BOLT PACK 9994200044	1	A70831-B	4.25	2010
8	115570	SEALING STRIP 4X10 MAPA	19		0.04	2600
9	119028	THREADED ROD ZN - M12x1000 MM 8.8	8		0.89	2010
10	A72407	TOP SECTION WM06 BRACKET DRAWBAR LONG DUAL	4	A72407-0	0.68	3000
11	A72408	TOP SECTION WM06 BRACKET DRAWBAR LONG SINGLE	8	A72408-0	0.41	3000
12	A71060	TOP SECTION WM06 BRACE FLANGE	2	A71060-0	1.11	3000

**Top section 2W
assembled**



Assembling the top section

**1. Installing the end-plates in the side-plate of the section**

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

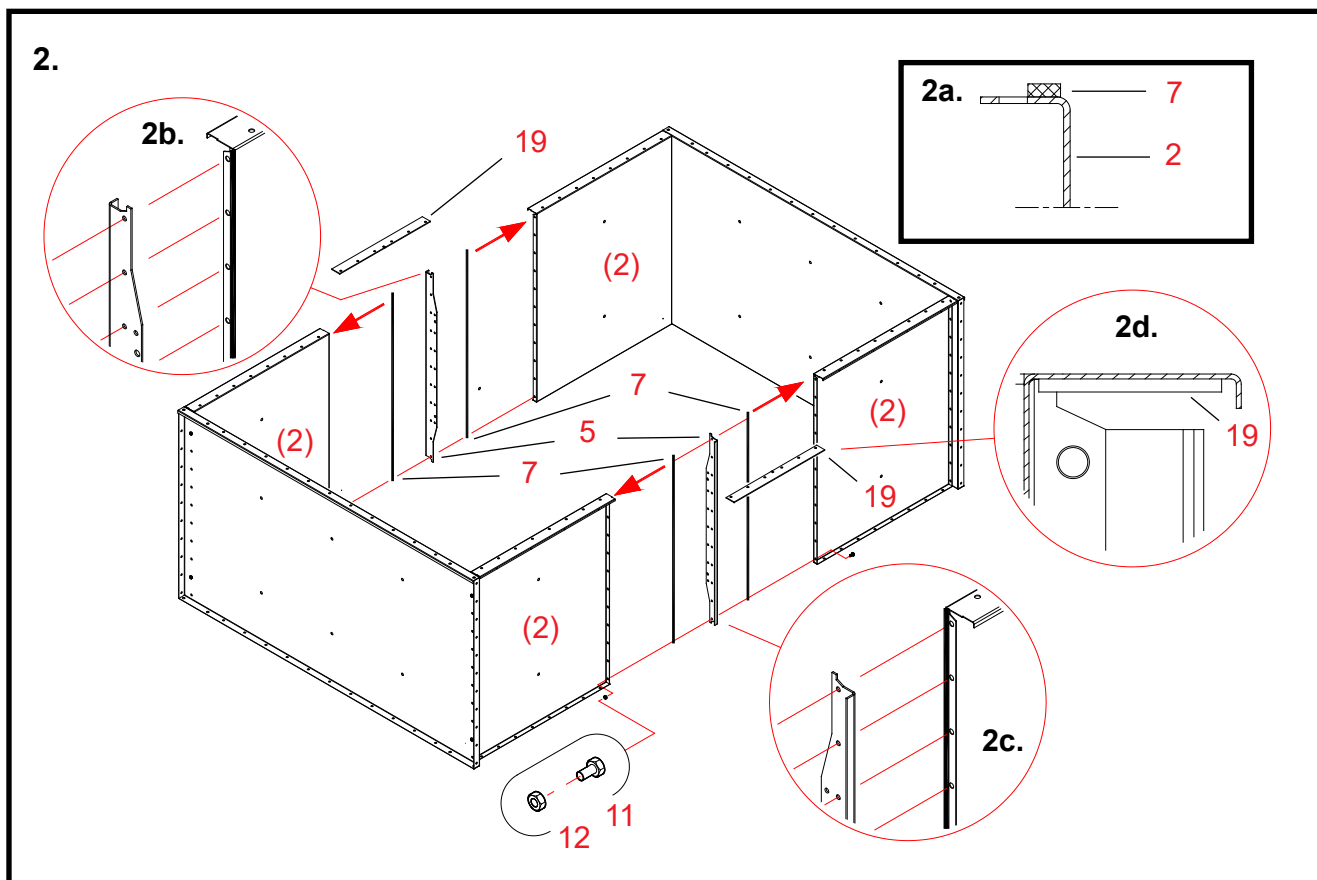
***We recommend carrying out assembly of the top section on an even plane.
This ensures the ready-assembled top section is straight.***

7 **Fix sealing strips to one end-flange of the two end-plates (parts 2).**
Fix the sealing strips inside the bolthole rows in the flange (see Fig. 1a).

1 **Place the side-plate against the flanges of the end-plates**
Be careful not to damage the sealing strips when installing the side-plate.

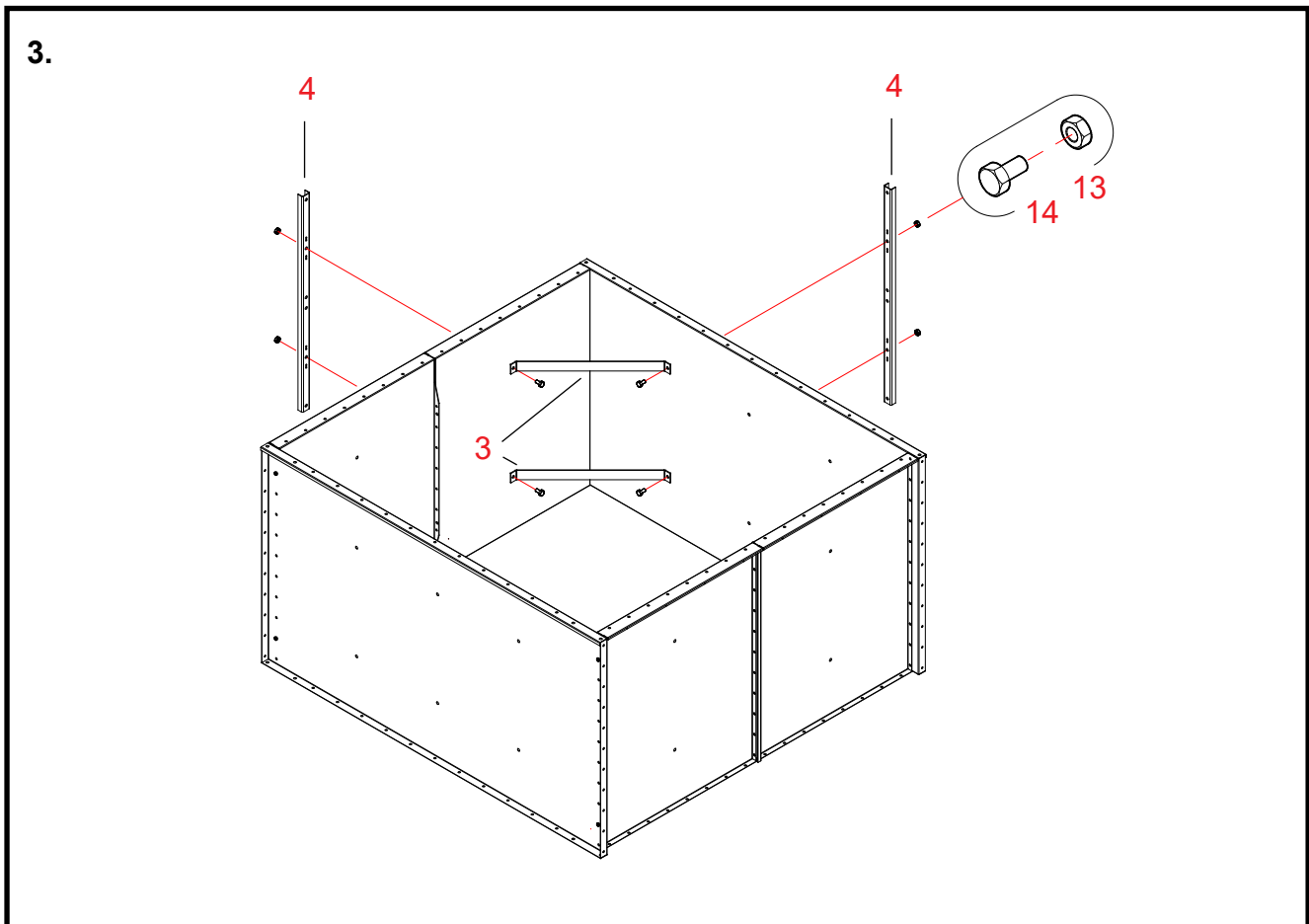
11, 12 **Fix the side-plate and the end-plates using bolts and nuts (M8 x 16, 2 pcs./side).**
Install only the uppermost bolt and the second bolt from the bottom in both screw hole rows.
The rest of the bolts will be installed in connection with final assembly of the top section.
The need for support legs and their type is decided during the final assembly (see last page of these instructions).
Tighten the bolts only lightly so that you can straighten the section later.

***** **Assemble another similar section module.**



2. Connecting the top section modules

- Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the top section.
- 7** **Fix sealing strips to end-plate flanges (parts 2) of both modules.**
Fix the sealing strips inside the bolthole rows in the flange (see Fig. 2a).
- *** **Move the section modules close to each other.**
Be careful not to damage the sealing strips while installing.
- 5** **Place the vertical supports for the top section between the section modules.**
Look up correct direction for the vertical supports in the detail drawings 2b and 2c.
Install the flanges of the vertical supports that remain outside the top section in the position presented in the drawings.
The flanges must be in the position presented in the drawings 2b and 2c when the rain roof for the air channel ends is in use.
Align the holes in the end-plates with the holes in the vertical supports.
- 11, 12** **Fix the top section modules and their vertical supports using bolts and nuts (M8 x 16, 11 pcs./joint).**
Tighten the bolts only lightly so that you can straighten the section later.
- *** **Check that the section is rectangular. Tighten the bolts in the vertical joints of the section.**
- 19** **Do not put the brace flanges in place until the top section is installed in the dryer (detail drawing 2d).**



3. Installing short drawbars

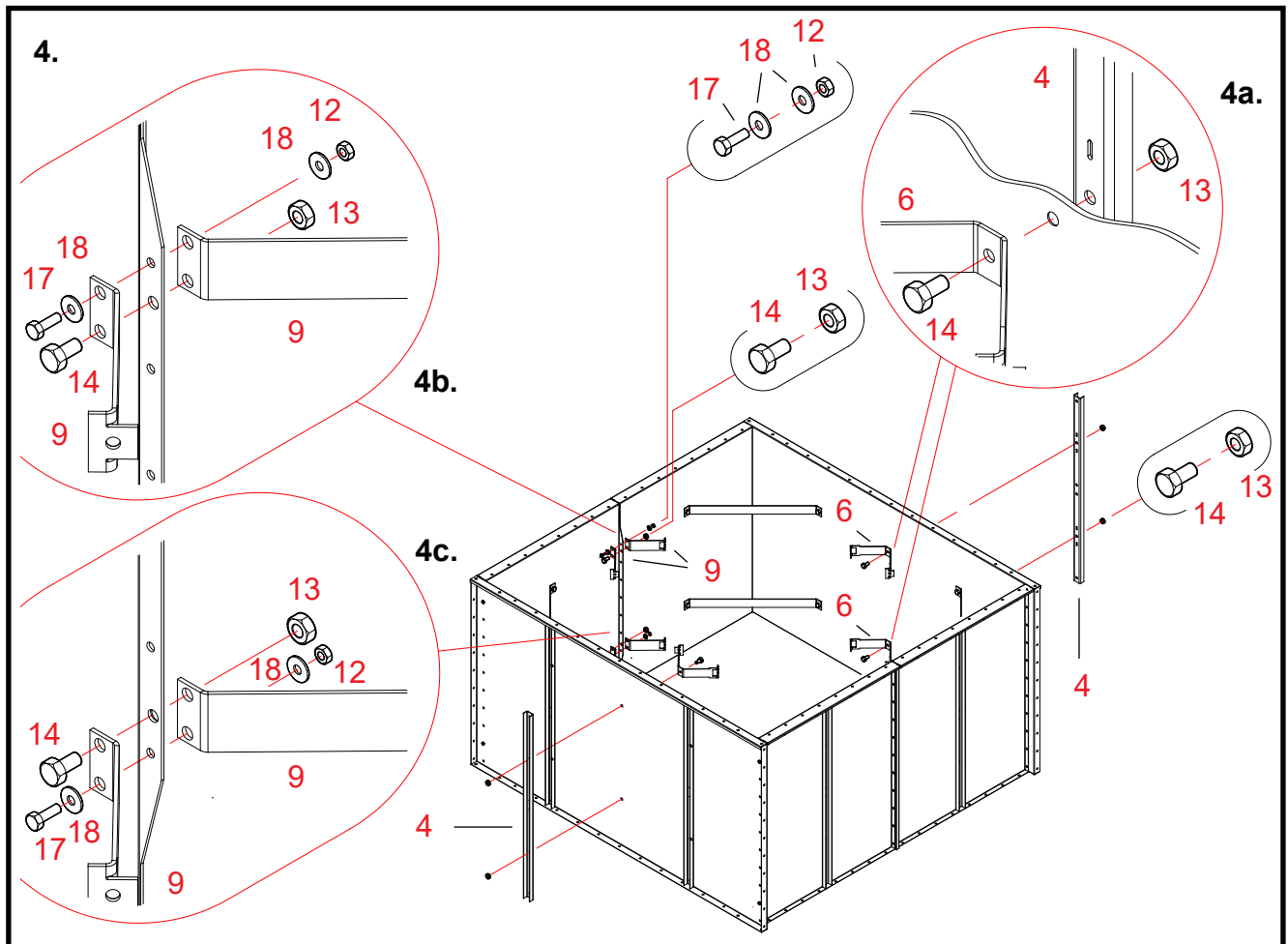
Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the top section.

3 **Install two short drawbars in the corner of the section.**

4 **Install two U-shaped vertical supports on the outside of the section, at the ends of the drawbars.**
Align the holes in the drawbars, in the side and end-plates and in the vertical support.

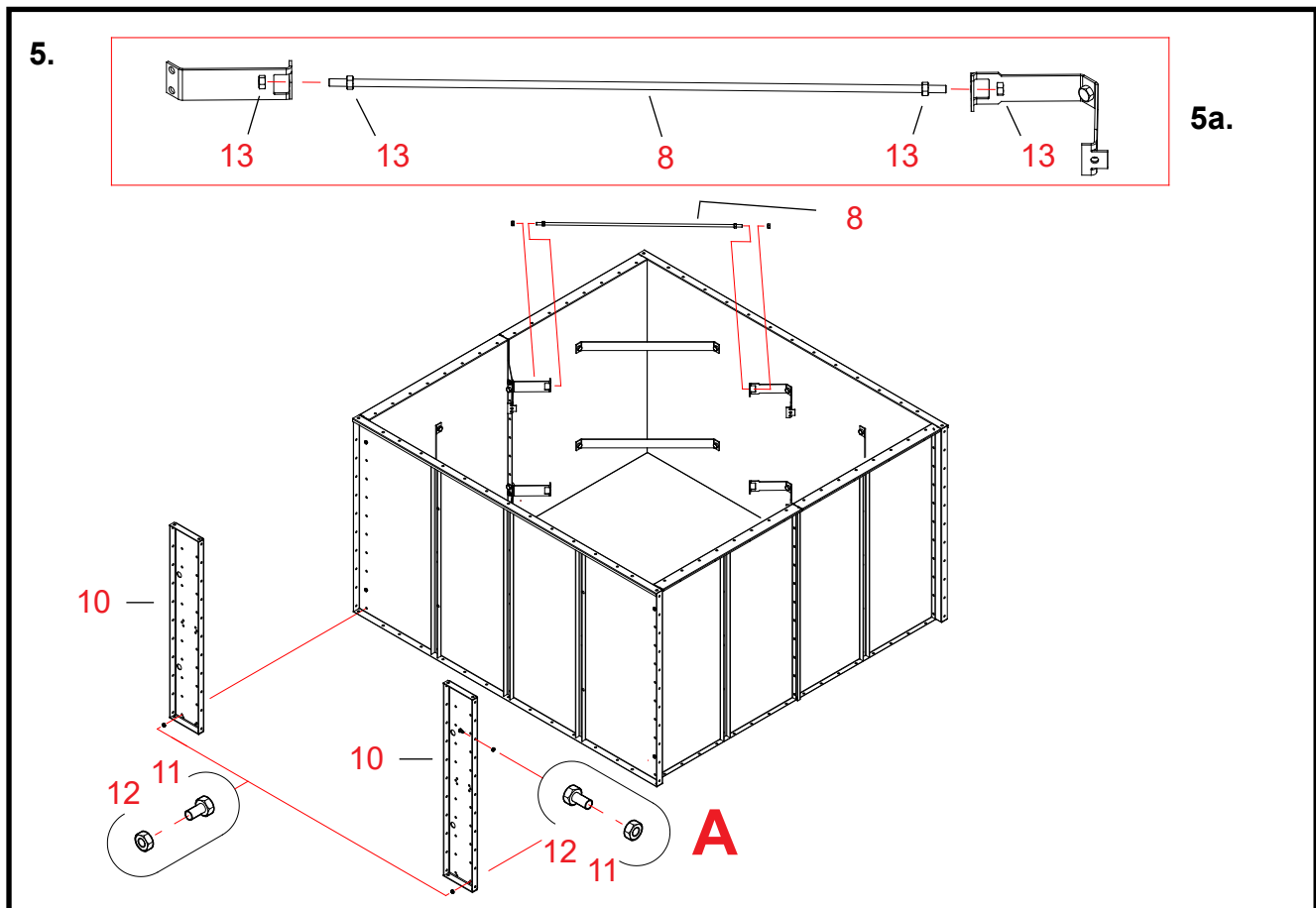
13, 14 **Fix the drawbars to the vertical supports inside the section walls using bolts and nuts (M12 x 25).**
Place the bolt heads on the grain space side.

* **Install the short drawbars in the other corners of the section in the same manner.**



4. Installing brackets for the long drawbars

- Parts The numbering of work stages refers to reference numbers in the spare parts drawing for the top section.
- 6** **Install four bifurcated brackets (dual) for the long drawbars in the Ø13 holes in the side-plates of the section.**
Check the position of the brackets in the main drawing and in the detail drawing 4a.
- 4** **Install the U-shaped vertical supports on the outside of the section at the brackets for the drawbars.**
- 13, 14** **Fix the bifurcated brackets and the vertical supports using a bolt and a nut (M12x25).**
Place the bolt head on the grain space side. See dwg. 4a.
- 9** **Install the eight smaller brackets (single) for the drawbar in the vertical supports for the end-plates.**
Check the position of the brackets in the main drawing and in the detail drawings 4b and 4c.
- 13, 14** **Fix the smaller brackets to the bigger holes in the vertical supports using bolts and nuts (M12x25).**
See pictures 4b and 4c.
- 12, 17, 18** **Fix the brackets to the smaller holes in the vertical supports using bolts, fender washers and nuts (M8x25).**
Place a fender washer against both brackets. See pictures 4b and 4c.



5. Fixing the long drawbars inside the section and attaching the support legs, if any

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

- 13** **Twist the nuts (M12) onto both ends of the threaded rods (parts 8).**
Turn the nuts so deep on the rods that you will be able to insert the ends of the threaded rod in the drawbar brackets (picture 5a).
- 8, 13** **Insert the threaded rods in the brackets, turn another nuts on them and tighten them against the brackets.**
- 10** **As required, attach support legs to both ends of the top section.**
Refer to beginning of point "Delivery packages of top sections (A70929) for 2W" for instructions on how to select the support leg.
Align the holes in the end-flange, in the side-plate and in the support leg.
- 11, 12** **Fix the side-plate, the end-plates and the support legs in place using nuts and bolts (M8x16, 9 pcs./side).**
Two of the bolts were put in place during assembly of the top section.
Tighten the bolts only lightly so that you can straighten the section later.
- 11, 12** **Fix the support legs to the side-plate flanges using nuts and bolts (M8 x 16, 11 pcs./side).**
If the dryer will be equipped with air channels extending all the way up, do not put bolts A (in the drawing) in place yet.
- *** **Check the joints and rectangular shape of the top section. Tighten all bolts.**