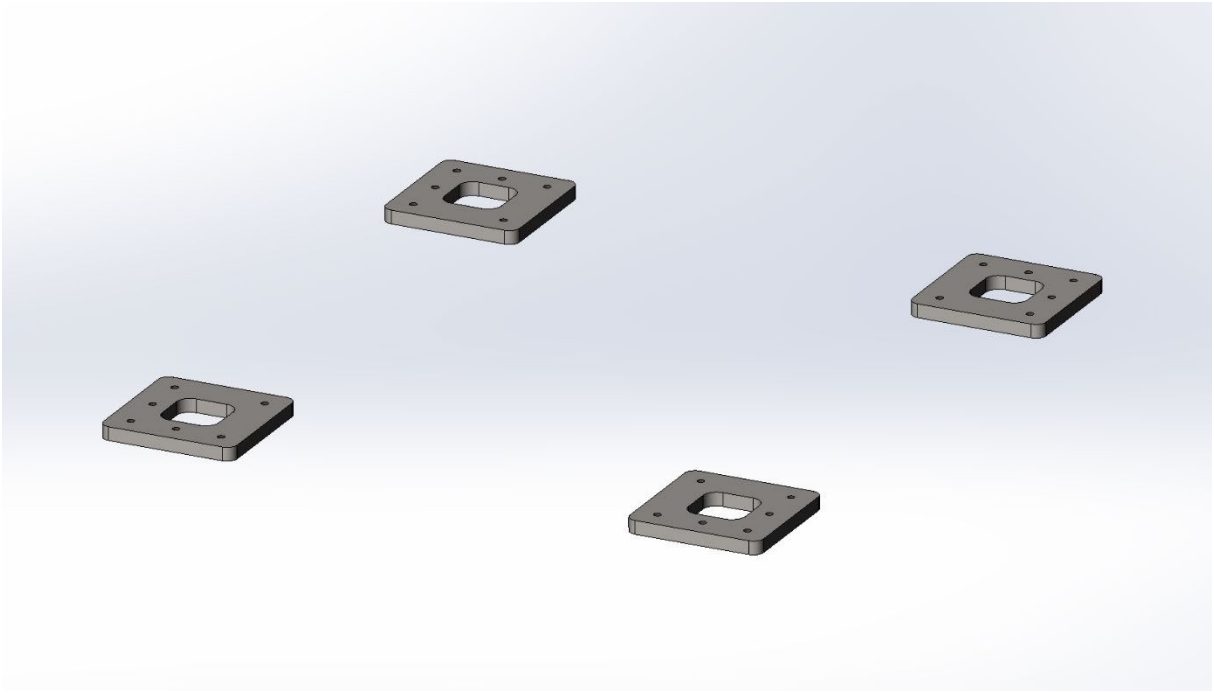
HEADQUARTER: ULICA 25. MAJA 27,
6258 PRESTRANEK, SLOVENIA, EU
REGISTRATION NUMBER: 6296351000
VAT NUMBER: SI41281152

MAIN CASING INSTALLATION PROCEDURE

1. Before the start of assembly check the dimensions of foundation plates and trenches so that you can adjust the position of the main casing on foundation plates if necessary.

2. Grind the paint off four bottom steel plates dimension 400 x 400 x 40 mm. These plates will be welded to steel plates that are part of the foundation. Plates in the foundation must also be grinded.



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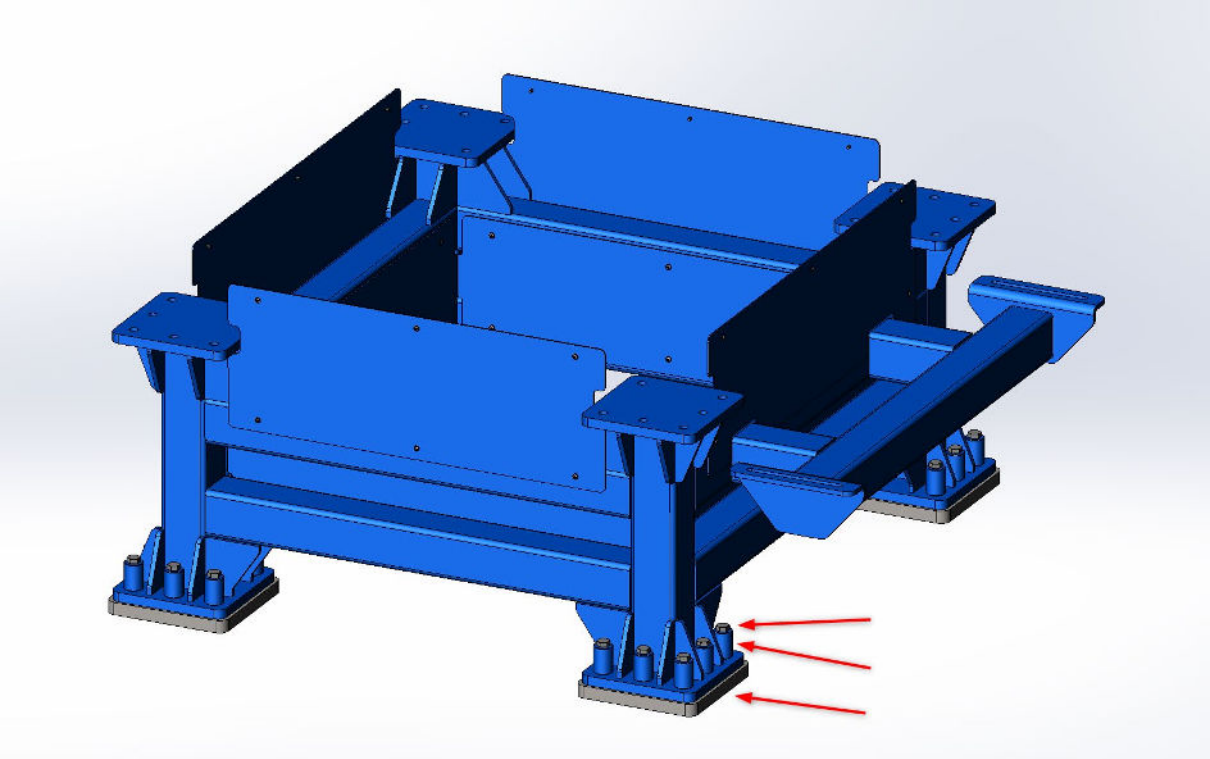
3. Bolt the steel plates to four legs of the main casing bottom structure. Each plate is bolted with 6 bolts size M24 and under each bolt is a spacer length of 85 mm.



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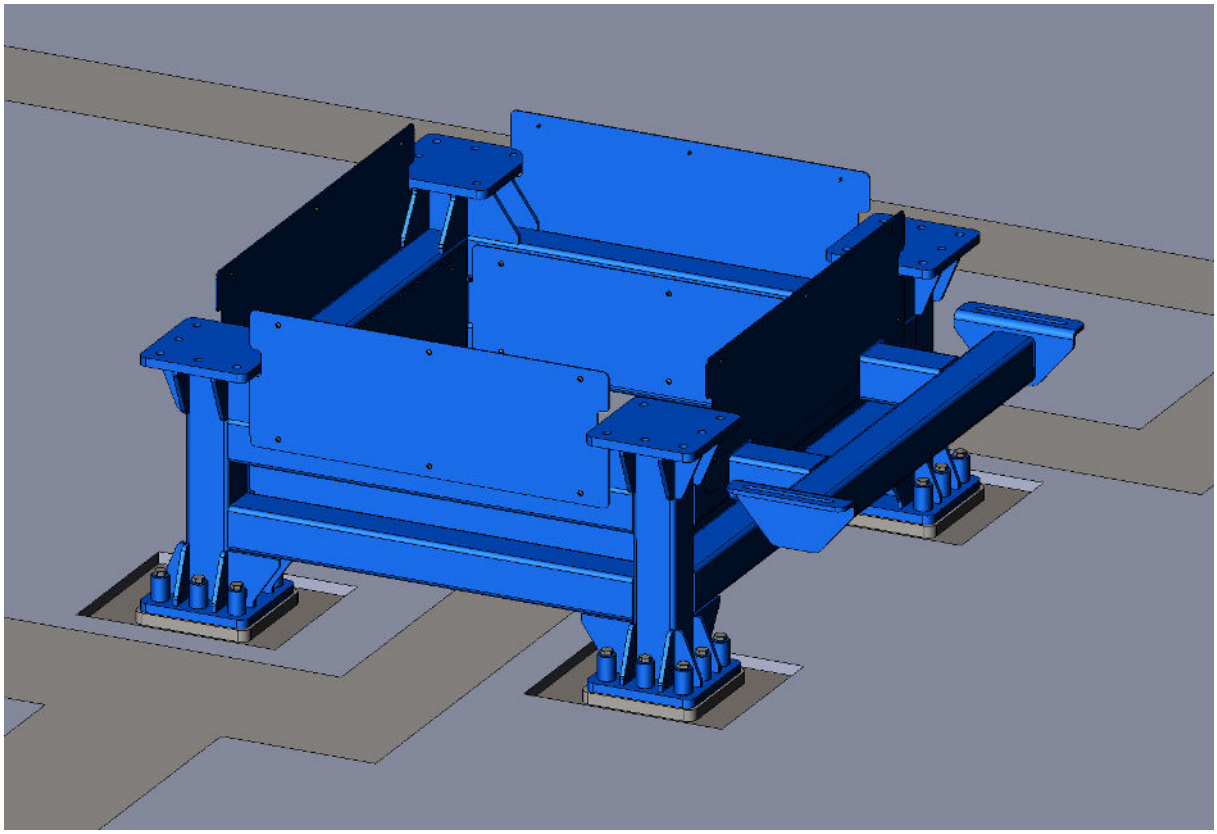
4. Center the bottom main casing structure on foundation steel plates and align it with the axis of the production line. Also, check the level of the bottom main casing structure and level it before welding, if necessary. For leveling, add shims under plates that must be welded to steel foundation plates.
   IMPORTANT: It is absolutely necessary that the main casing structure is not tilted down in the direction of production.



5. Weld the steel plates on foundation steel plates so that their position cannot move. This is not final welding.

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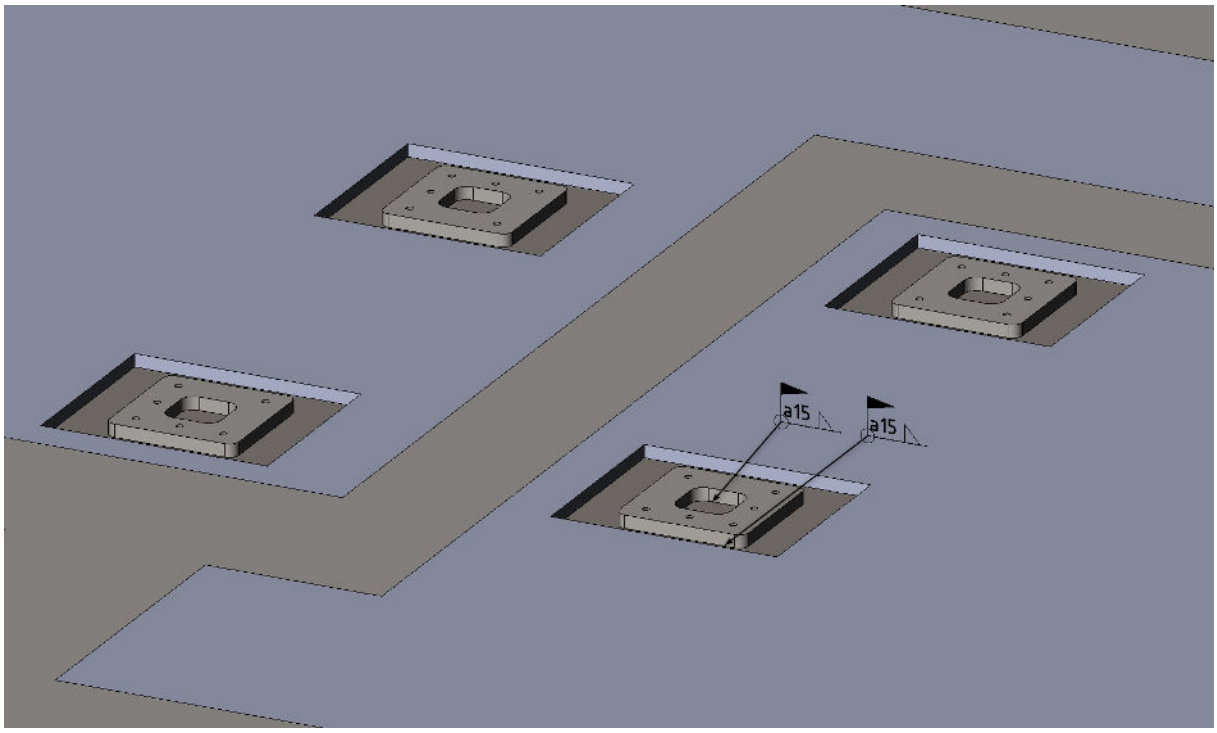
6. After welding for the position, remove the bottom main casing structure and weld all four plates with fillet welds size a15 on the outer and inner edge. Take care so that the weld heat input is well distributed.



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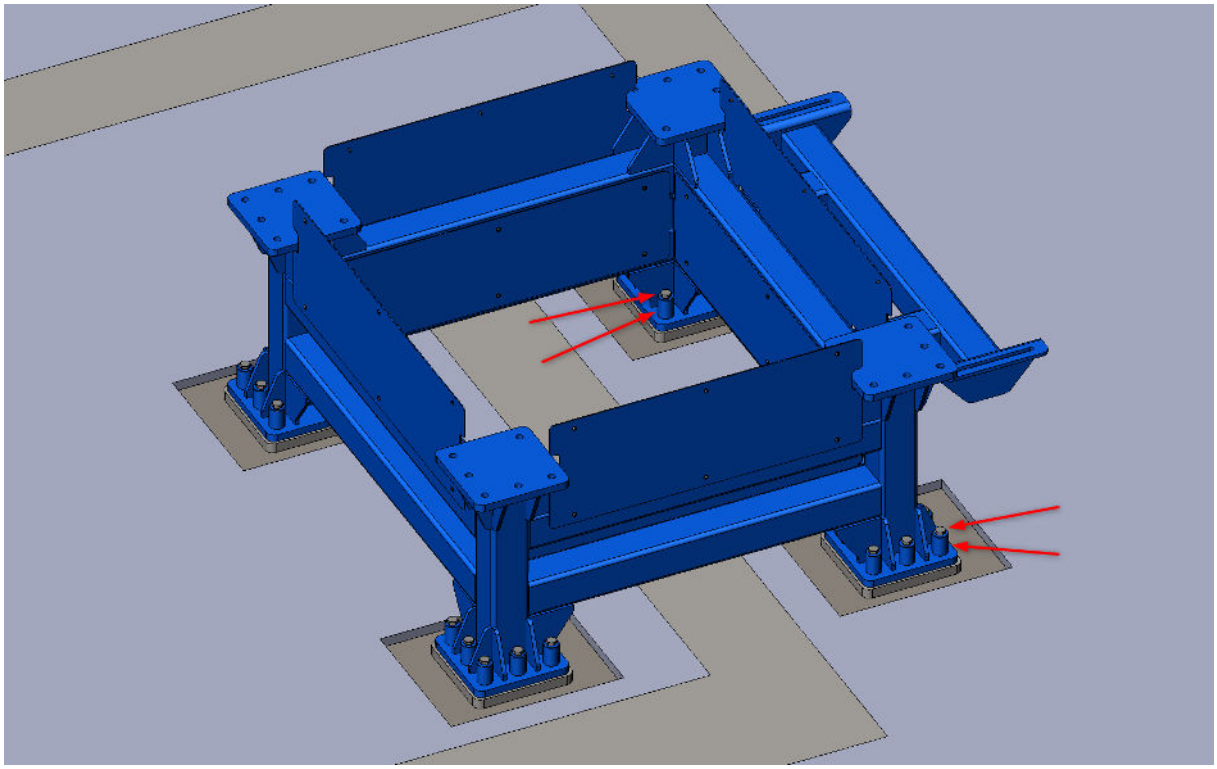
7. After welding, paint the steel plates with the same color as the bottom main casing structure is painted.

8. Bolt the bottom main casing structure to the welded steel plates. Each plate has 6 bolts size M24x150 8.8 and 6 spacers length 85 mm. One bolt on each plate is on the inner side of the structure. **Tightening torque is T = 500 Nm**. When tightening use the criss-cross tightening technique. First tight one bolt on the first plate and then another on the next plate. Repeat the procedure for all 24 bolts.



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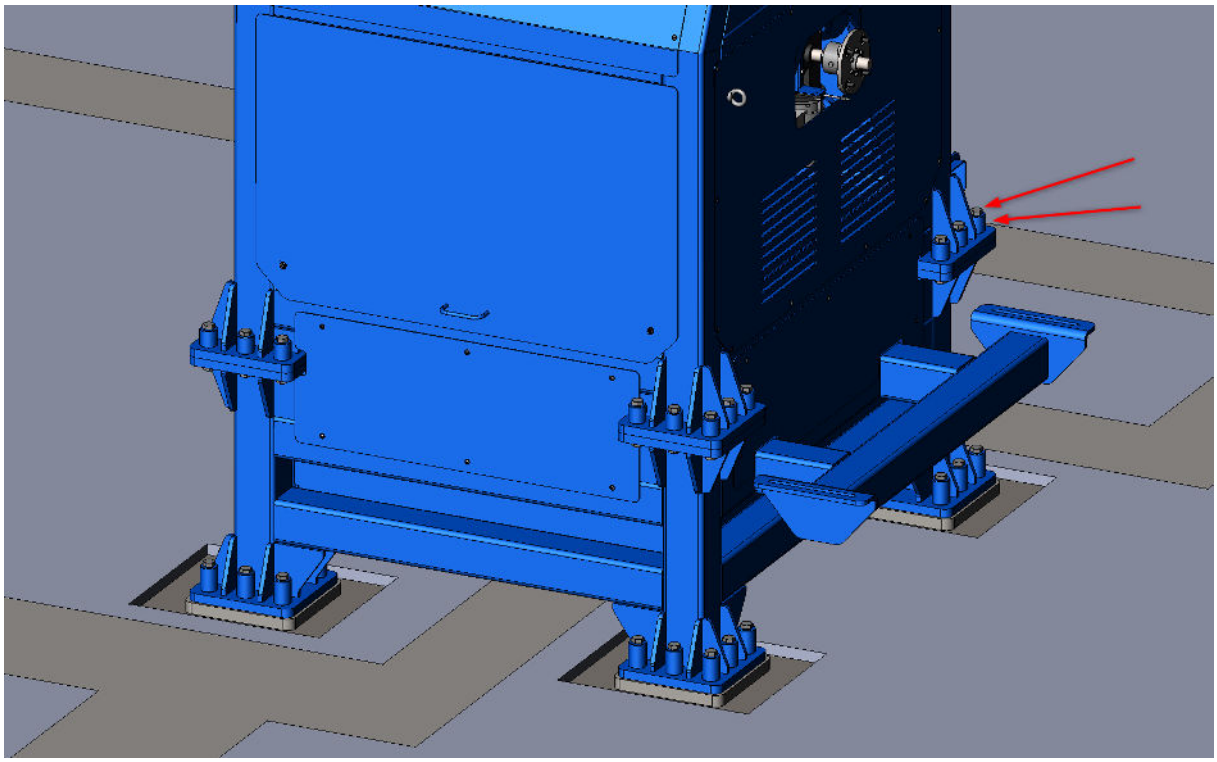
9. Install the top main casing structure and bolt it to the bottom structure. Each plate has 6 bolts size M24x150 8.8, 6 spacers length 60 mm, and 6 washers and nuts size M24 8. One bolt on each plate is on the inner side of the structure. **Tightening torque is T = 500 Nm**. When tightening use the criss-cross tightening technique. First tight one bolt on the first plate and then another on the next plate. Repeat the procedure for all 24 bolts.



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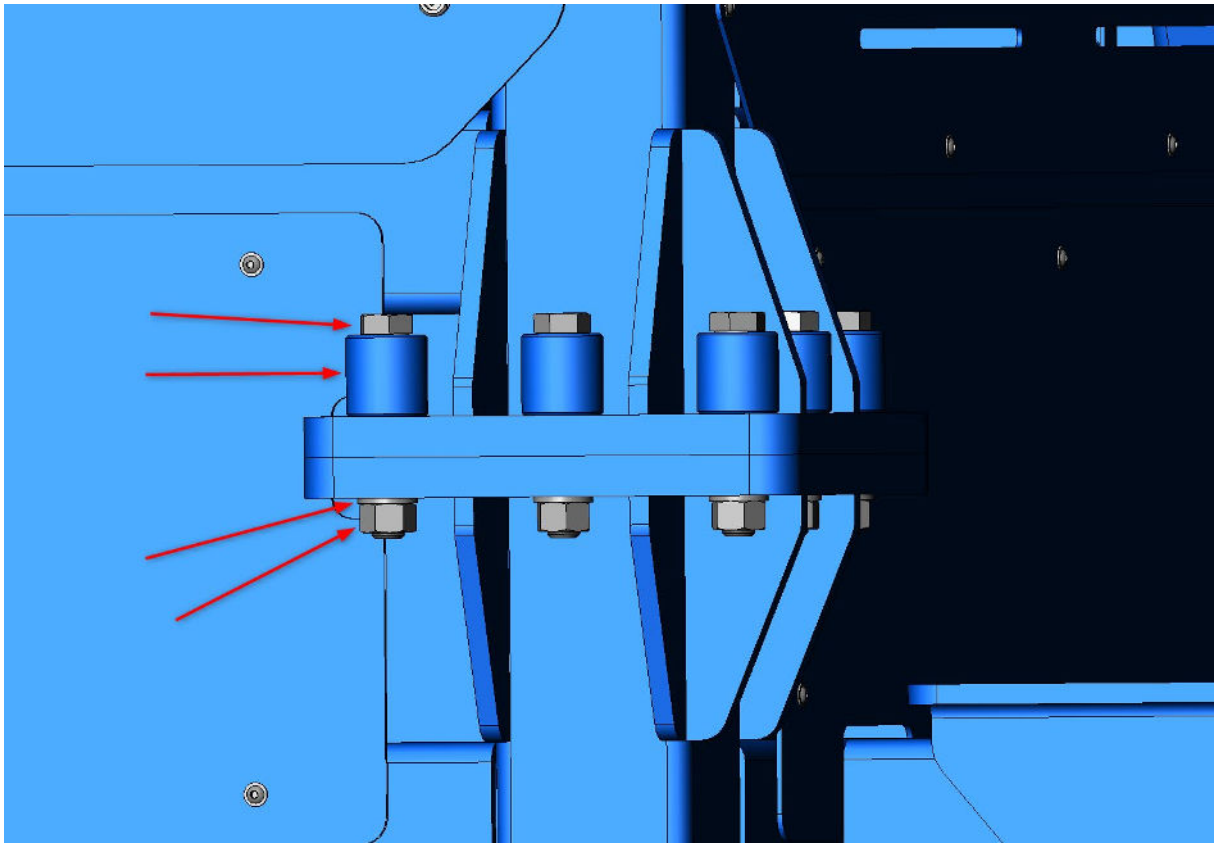

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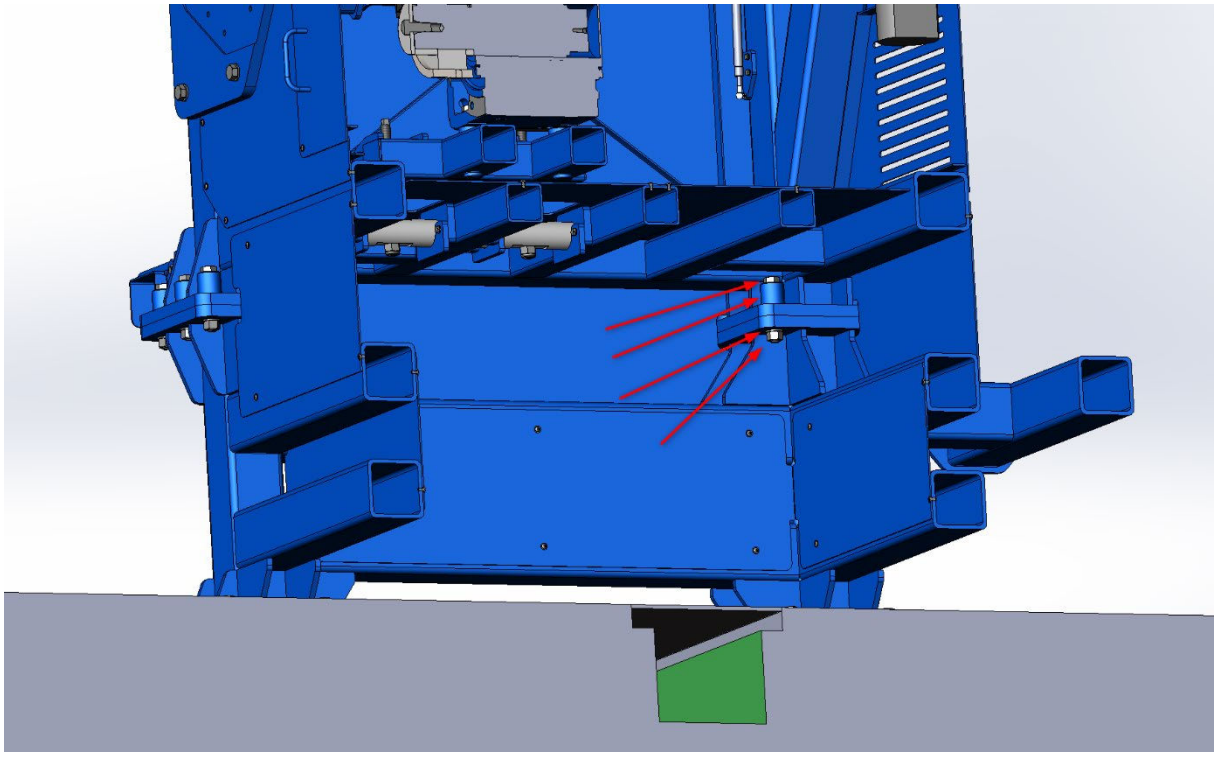

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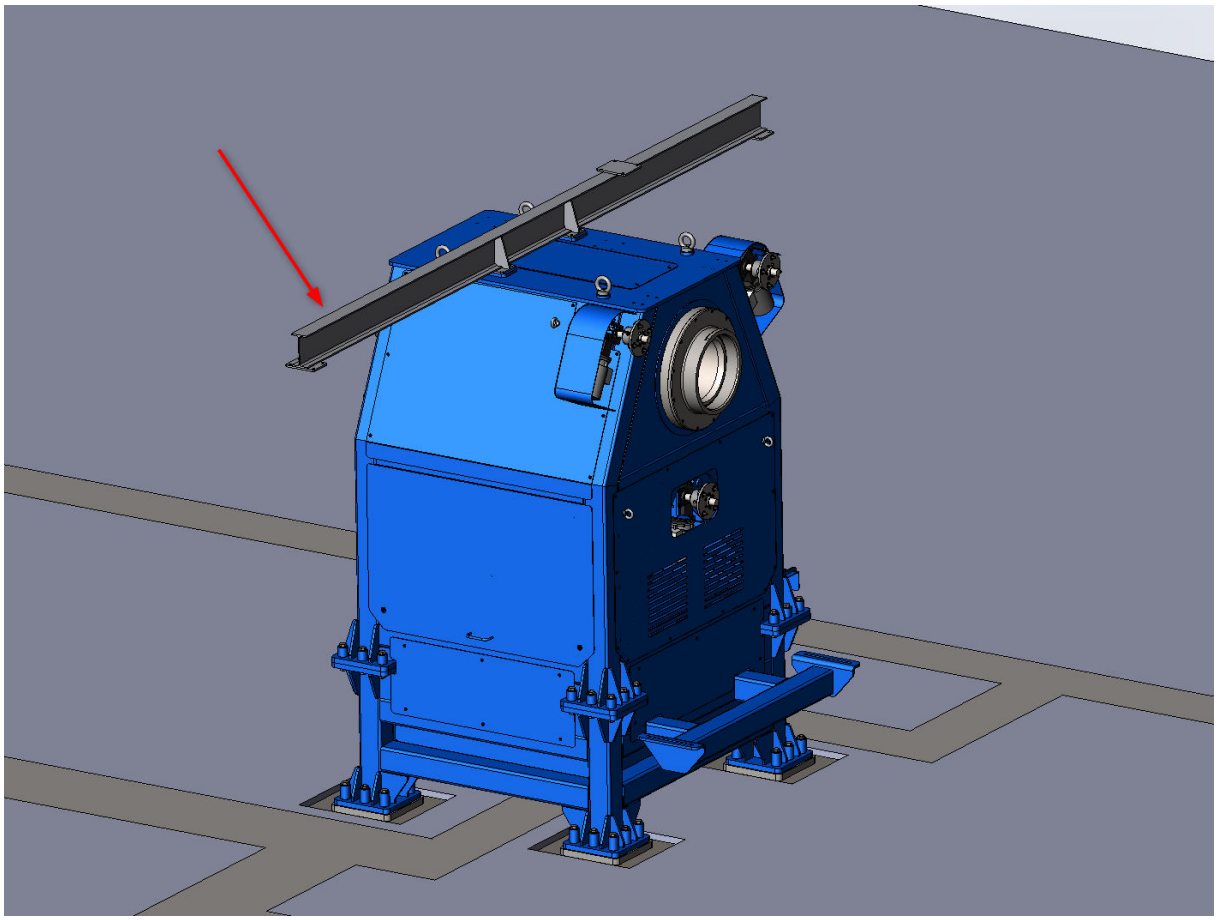
10. Install main casing top beam for elevator connection.



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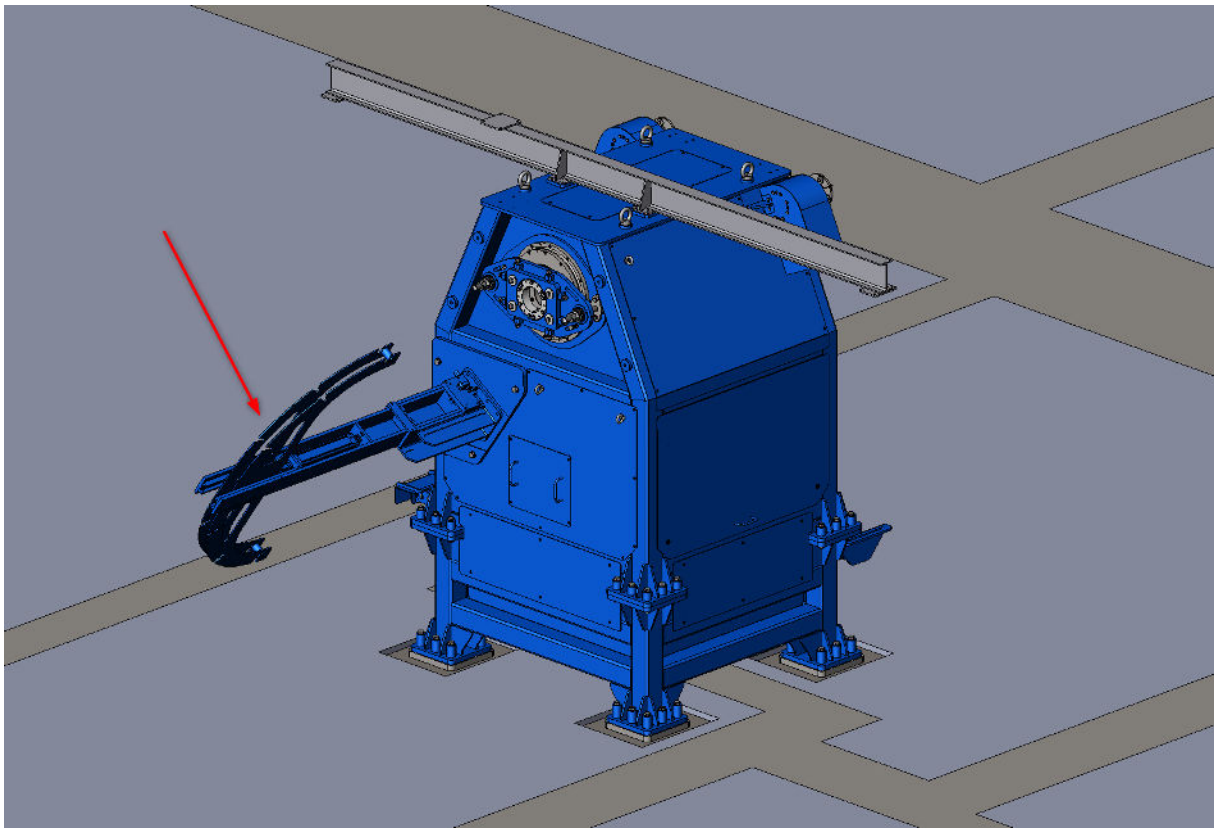
11. Install back steel band tensioner.



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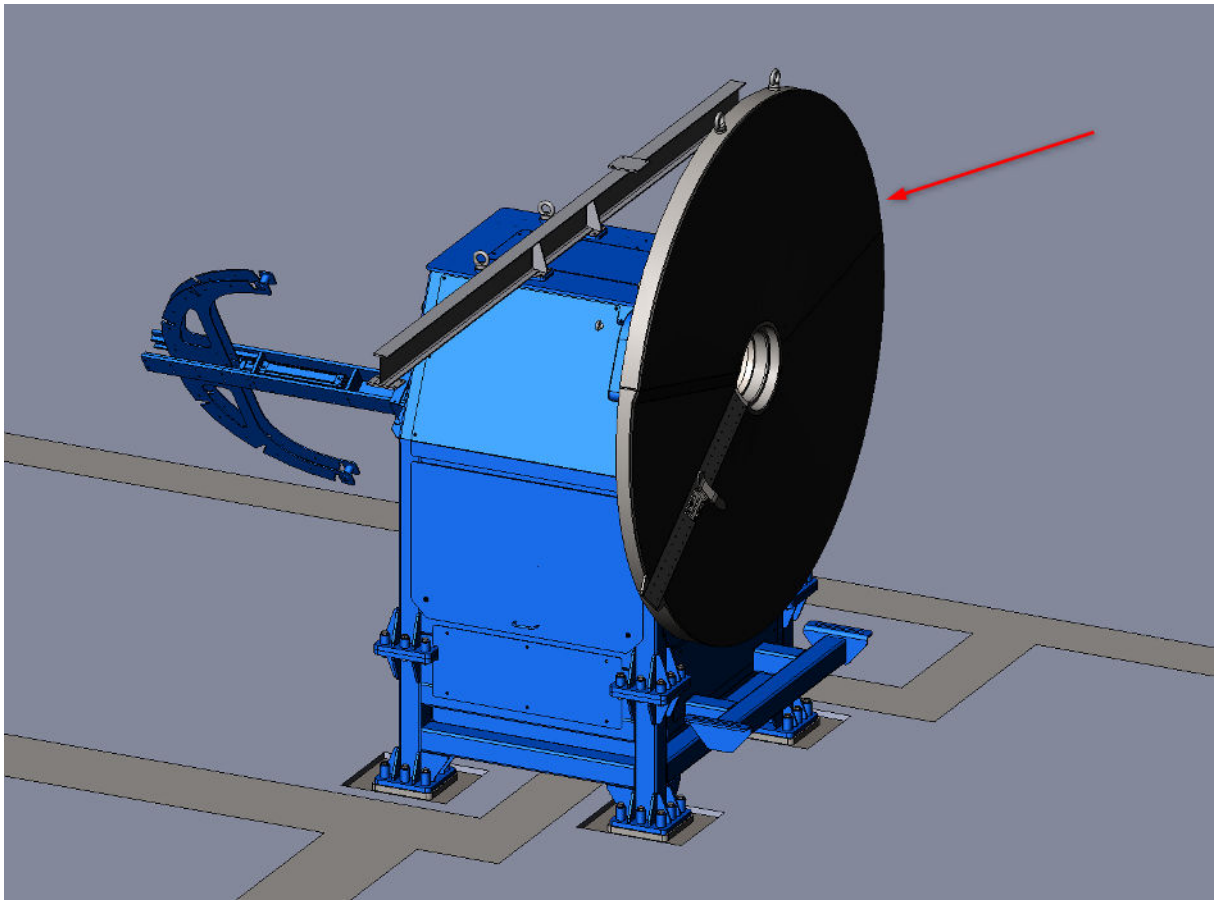
12. Install cam plate and bolt it to 3 flanges of screw jacks for tilt setting. Each flange has 4 bolts size M12x50 8.8 and 4 bushings for the flange.



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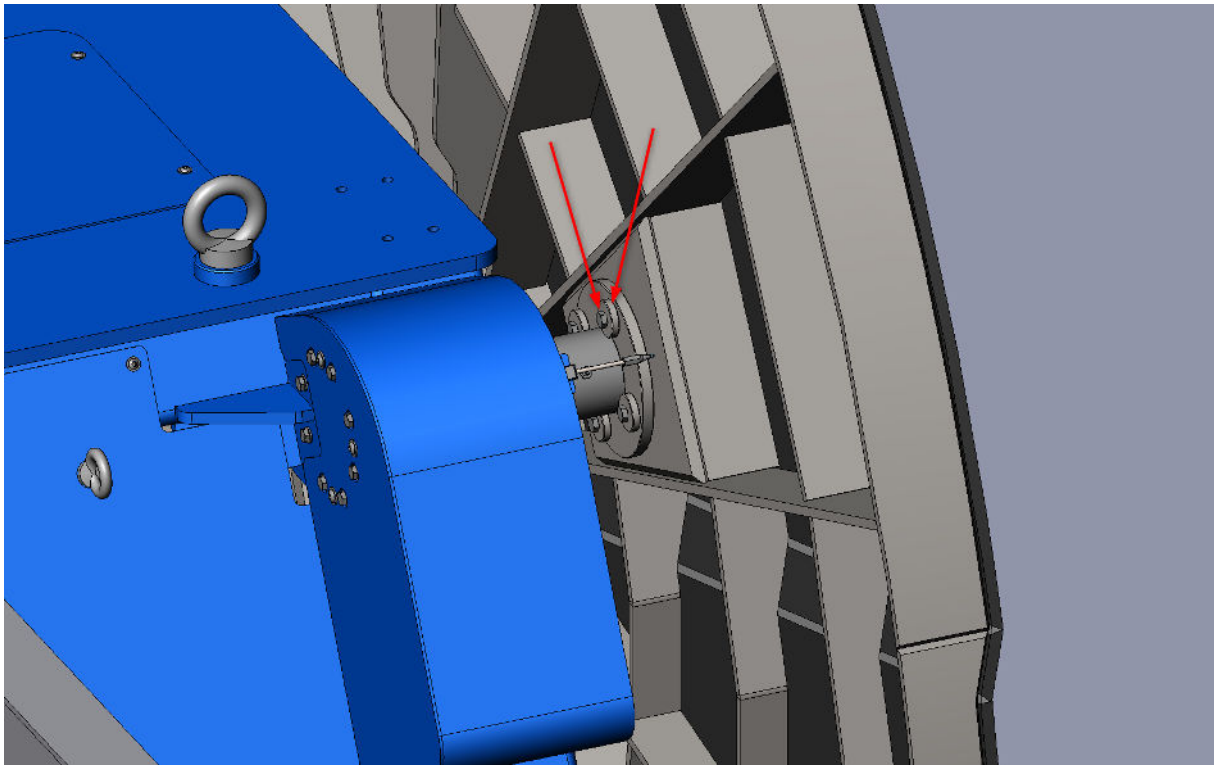

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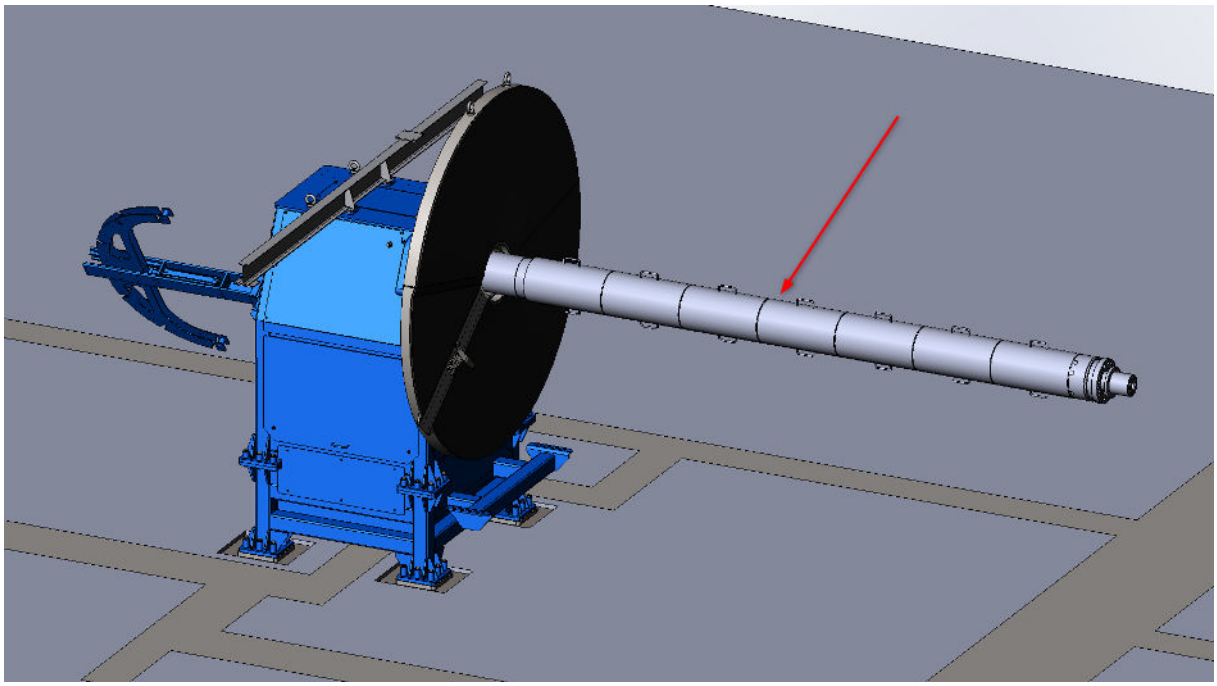
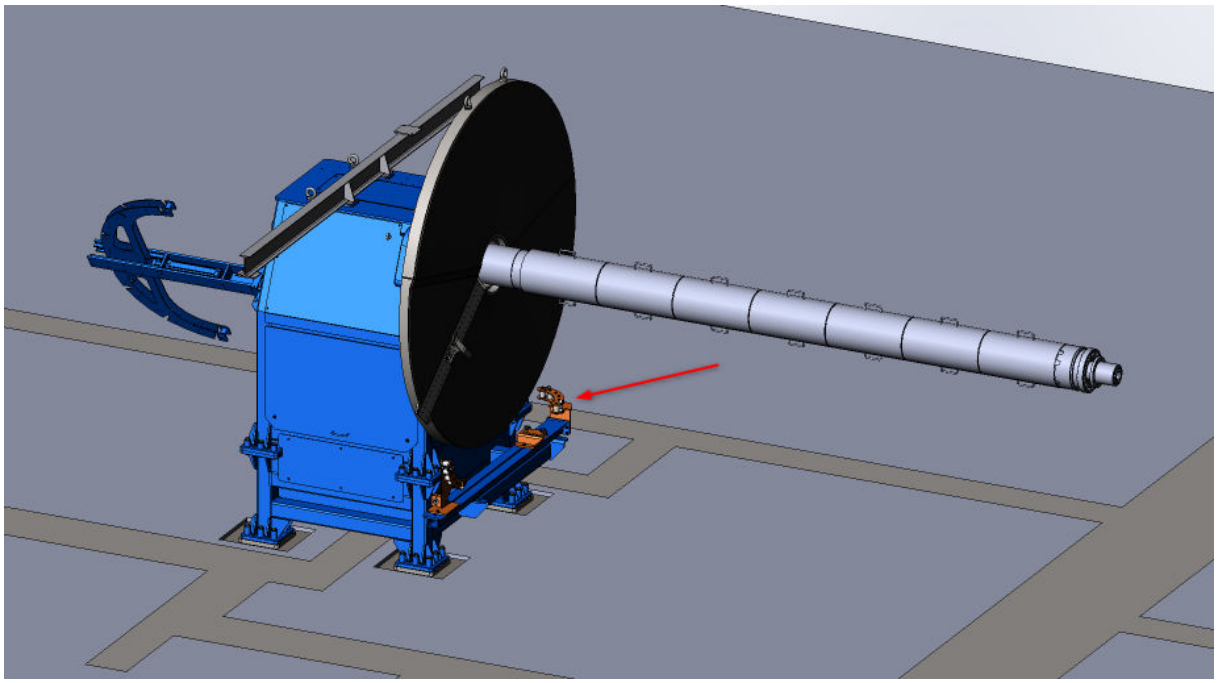
13. Install the shaft for the mandrel.



14. Install front steel band tensioner.



15. Pour the self-leveling concrete around the 40 mm steel plates that were welded to steel plates of foundation.