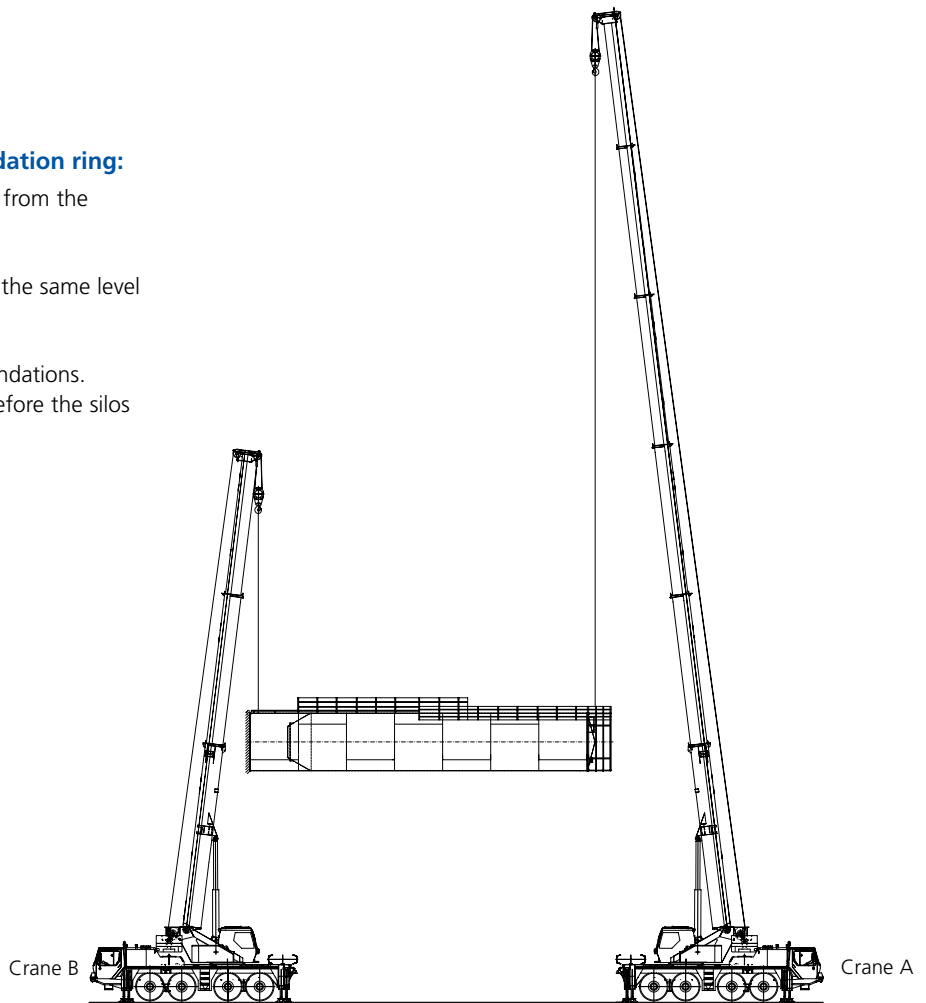


# SILO MONTAGE INSTALLATION INSTRUCTIONS

## Preparation at the foundation / foundation ring:

1. The clamping nuts must be turned away from the anchor bolts.
2. The foundation ring must be brought to the same level at 4 points by adjusting the lock nuts.
3. Exact axes have to be marked at the foundations. Ideally this work should be carried out before the silos or the cranes arrive.



## Assembling the silos:

1. Unloading or reloading the silos can be carried out with a crane. To do this, a rope with suitable lifting capacity must be wrapped around the gravity centre of the silo. To prevent scratches on the silo, we recommend using a coated wire rope or taking other precautions.
2. Ladders, filling pipes and other parts should be mounted on the shell when the silo is still lying on the ground.
3. Crane A (the main crane) is to be attached by the lifting eyes to the upper edge of the rope. The hoisting ropes are to be attached with shackles. The shackles have to be twisted over the lifting eyes. 2 lifting eyes must lie as horizontally as possible. Crane B (guide crane) or the fork lift is to be attached to the lower section of the silo. While crane A erects the silo, crane B or fork lift must guide it without any ground contact. For smaller silos, crane B or fork lift are unnecessary.
4. When installing the silos on the foundation, the axis position is to be observed. With groups of silos, an exact axis position is particularly important because of the walkways and railing joints.
5. When fixing the silo, it must be ensured that at least 80% of the silo standing ring is mounted evenly on the foundation ring. This is achieved by turning the locknuts upwards so that the foundation ring is pressed against the silo standing ring. Only then are the pressure pieces to be tightened evenly.
6. Before filling the silo, the space between the foundation and the foundation ring must be filled with concrete.
7. For single anchors without a foundation ring, lining plates must be placed under the space between the concrete and the stand ring stand so that the entire stand ring can be grouted with a concrete layer (3 to 5 cm high) that is able to sustain a load.
8. The connecting walkways are to be bolted together so that they are stress free. One side, designed as a moveable bearing, must be secured with locknuts.



**Description**

**Article no.**

**Silo assembly**

We carry out the complete assembly of the silos. If desired, we will also make sure that a supervisor or qualified staff is available.

**Our services include:**

1. Unloading the silos with mobile cranes provided on site.
2. Mounting the silo accessory parts such as ladders, filling pipes etc.
3. Levelling the foundation ring, preparing the surface
4. Raising the silo and placing it on the foundation, steel construction or concrete floor
5. Anchoring the silo on the foundation ring, steel construction or concrete floor
6. Mounting the railings and the connecting walkways.

For practical reasons, the crane and the construction site trucks should be arranged by the customer. We will supply you with the necessary ordering information. Up to 6 silos can be erected and mounted by 2 men (40 working hours) during a well-organised assembly of silos on foundation rings.

**The following are the charges for the assembly work:**

1. Travel time and working time domestically and abroad  
Supervisor  
Expert fitters  
Overtime bonuses of 25%, 50% or 100% in addition to the hourly rates according to the collective wage agreement of the Metal Industry in Südwürttemberg-Hohenzollern (Germany)
2. Accommodation allowance according to the currently valid collective wage agreement. The accommodation allowance is reduced if the travel to the job site or the return is not at the beginning of the day.
3. Travel costs and transport of tools upon verification

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