



## Caution

Risk of injury from incorrect handling. Transport, assembly and installation work may only be performed by specialists!

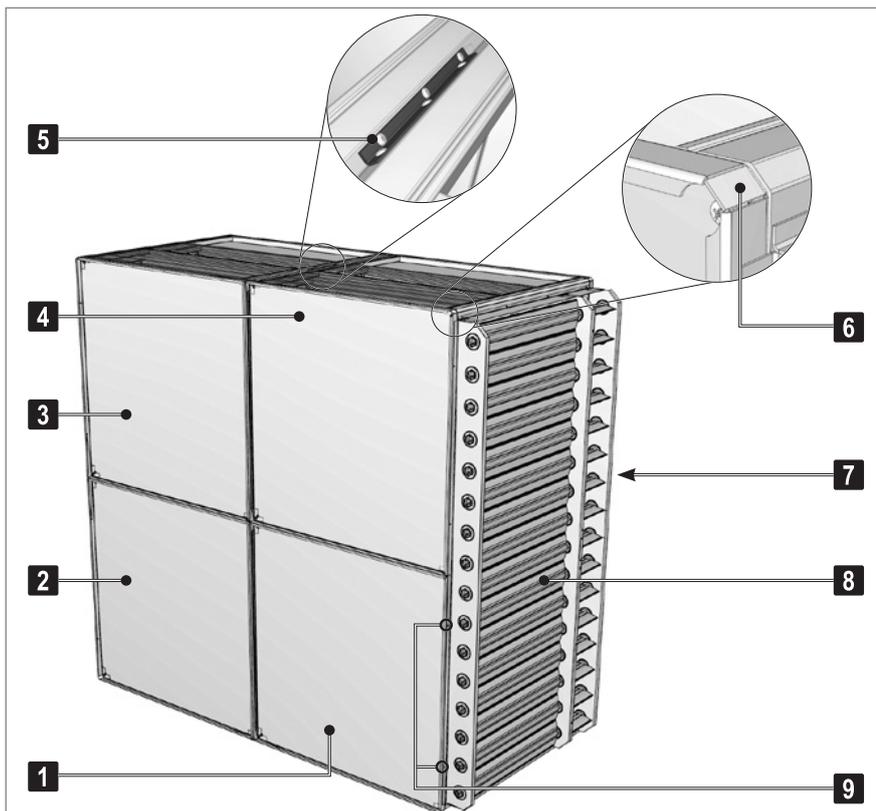
## 1 Preparation

- Check that the delivery is complete:
  - 4 exchanger blocks
  - 1 cartridge of sealing compound
  - Auxiliary materials for installation (rivets, self-cutting screws, bolt screws, washers, nuts)
  - 6 angle brackets (depending on the width of the exchanger)



**Notice:** Angle brackets are not installed in exchangers with a width of up to 1500 mm.

- Option: Control damper (one-piece for size 140/170, two-piece for size 200/240)
- Required tools:
  - Hoisting equipment to lift the components
  - Cartridge gun
  - Rivet gun
  - Drill
  - Power screwdriver
- Identify the correct position of exchanger blocks 1 to 4:
  - Each side wall has a flattened corner. These corners make up the outer edges of the exchanger once assembled.
  - For exchangers with a bypass (option): make sure that the bypass is aligned correctly.



1  
2  
3  
4

Exchanger blocks nos. 1 – 4

5

Angle bracket

6

Flattened corner of the side wall

7

Side bypass (option)

8

Control damper (option)

9

Positioning holes for the control damper (on all sides)

Bild 1: Compound plate heat exchanger (shown here with a side bypass and control damper)

## 2 Installation

### 2.1 Disassembling the exchanger blocks

The blocks are screwed together for safe transport.

- Remove the bolt screws from the flanges of the side walls.
- Separate the exchanger blocks 1 to 4.

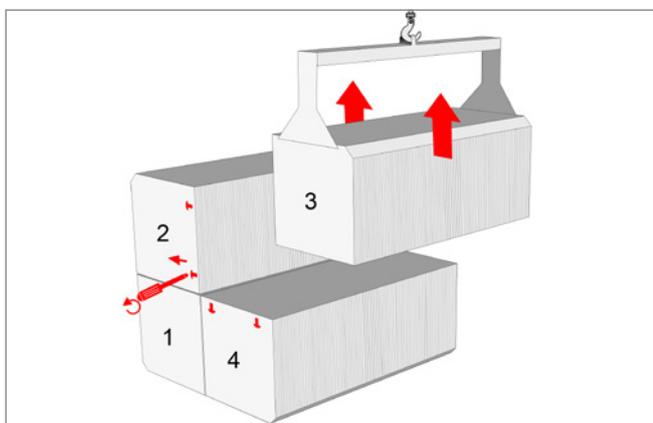


Bild 2: Remove bolt screws

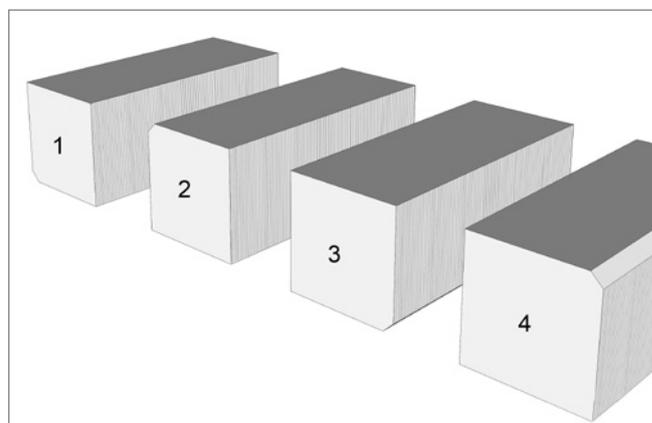


Bild 3: Separate exchanger blocks

## 2.2 Installing the exchanger blocks

- Prepare block no. 1 (flattened corner at the bottom).
- Apply the sealing compound in the sealing groove that runs around the block.
- Attach block no. 2.
- Use screws to connect the flanges of the side walls to one another (use all holes).
- Attach angle brackets 1-2 (inside and outside):
  - Place the bracket onto the corner sections in the middle of the exchanger.
  - Drill holes and insert rivets.
- Rotate blocks 1 and 2.
- Apply the sealing compound in the sealing groove that runs around block no. 2.
- Attach block no. 3.
- Use screws to connect the flanges of the side walls to one another (use all holes).
- Attach angle brackets 2-3 (inside and outside).
- Apply the sealing compound in the sealing grooves that run around blocks 1 and 3.
- Attach block no. 4.
- Use screws to connect the flanges of the side walls to one another (use all holes).
- Use rivets to connect angle brackets 3-4 and 4-1 to the corner sections.

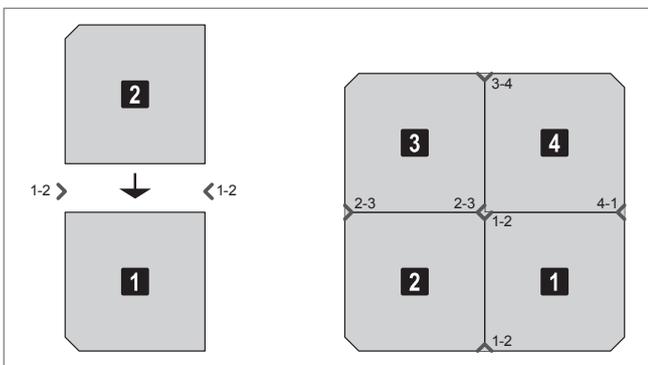


Bild 4: Installation sequence and position of the angle brackets



Bild 6: Screw the side wall flanges to one another



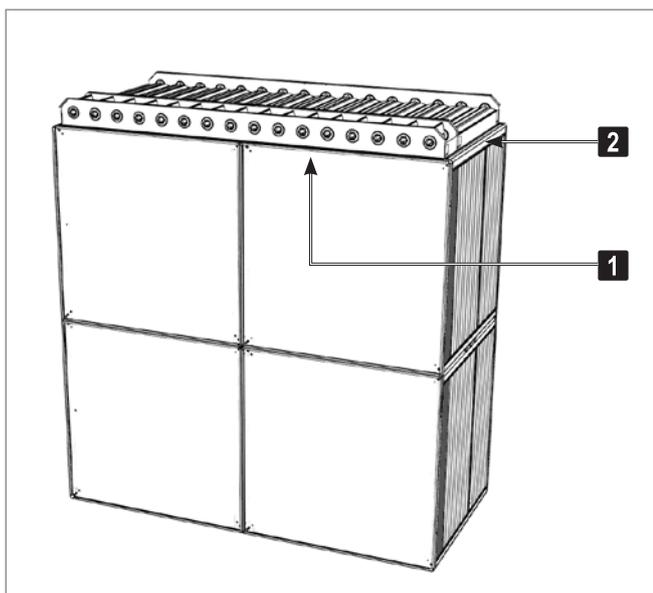
Bild 5: Apply sealing compound



Bild 7: Rivet on the angle brackets

## 2.3 Installing the control damper (option)

- Identify the correct position for the damper:
  - Place it on the open side of the bypass.
  - For exchangers with a side bypass: pay attention to the installation position of the exchanger.
- Rotate the exchanger so that it is positioned correctly (damper at the top).
- Attach the damper to the exchanger.
- Rivet the damper in the positioning holes of the side wall flange on both sides.
- Attach the damper to the corner sections of the exchanger using self-cutting screws.



**1** Side wall flange with positioning holes

**2** Corner section of the exchanger

Bild 8: Installation of the control damper

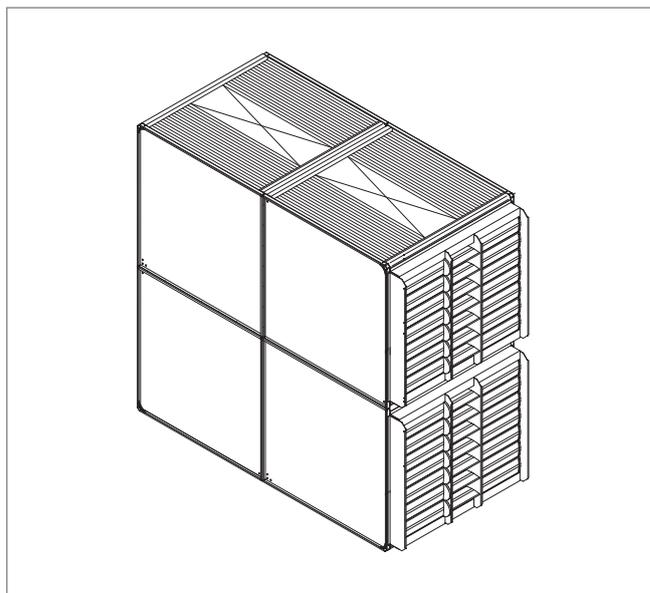


Bild 9: For plate heat exchangers in size 200/240, the control damper is in two pieces (shown here with a bypass in the middle)