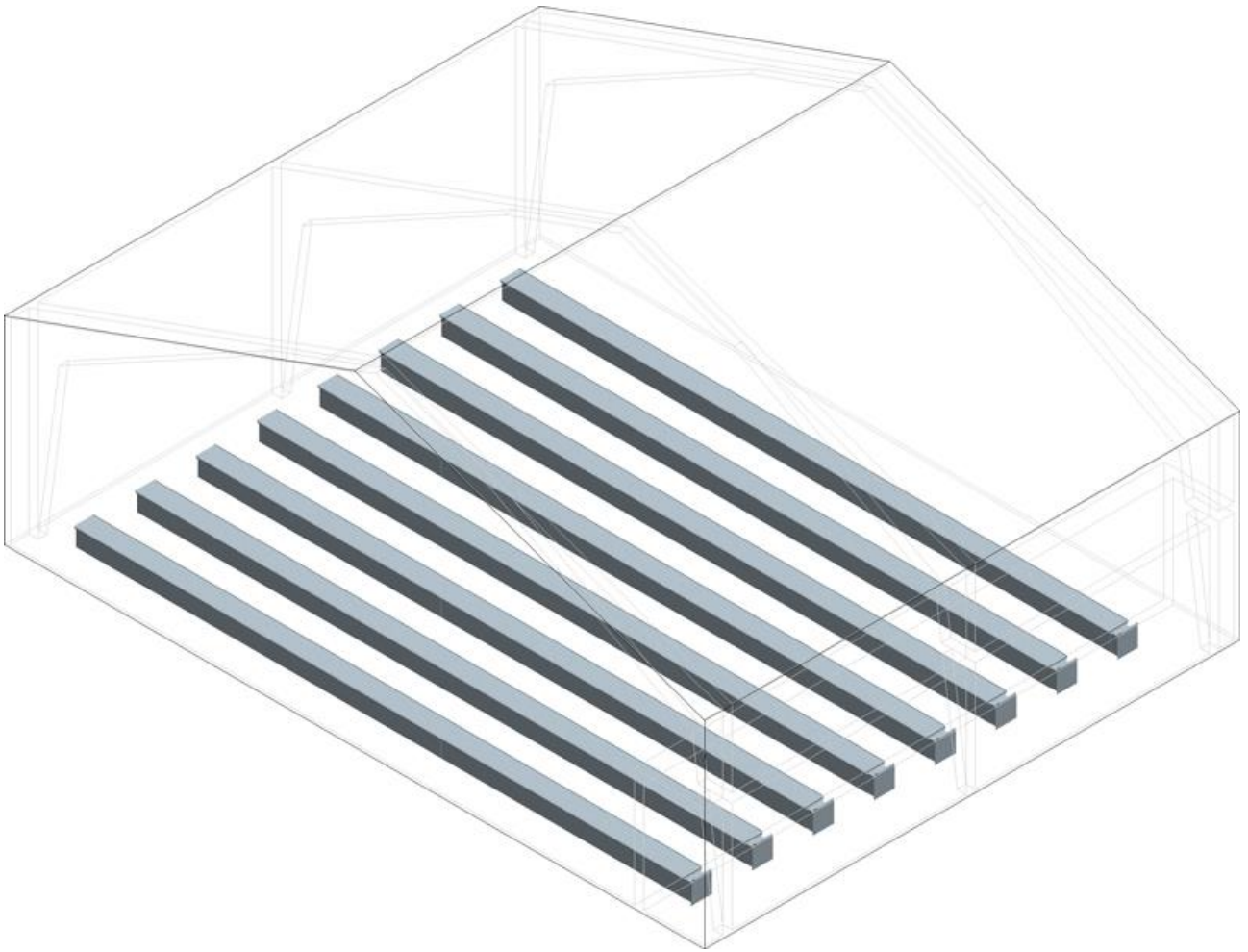


Instructions

Concrete Formwork Boxes



Procedure for Casting

The concrete formwork boxes are placed onto a firm surface with a center distance between the formwork boxes (see table). The main channel can for example be constructed from Funda-blocks, in which one can place a number of brick-in-nozzles that suit into the formwork boxes. The formwork boxes are to be placed onto the existing floor and are to be screwed firmly to the floor; or they are to be put into minimum 10 cm base concrete, quality 15 MN/m². (See sketch 1, page 3)

	Center Distance between the Formwork Boxes Figure 1 Position A	Type of Grate
Drying of Seeds	Approximately 60 – 65 cm	300x1000 Ø1,5mm Perforation
Drying of Grain	Approximately 70 – 100 cm	300x1000 Ø2mm Perforation
Aeration	Approximately 150-300 cm	300x1000 Slit, smooth Surface or Ø1,5-Ø2- Perforation

Base concrete is subsequently submerged in quantity 15 MN/m² between the boxes and up to 8 cm under the top level of the box.

When the base concrete has cured for 24 hours, is submerged topping of passive concrete quality 25 MN/m² for the last 8 cm and up to the top level of the box.

In order to secure a strong concrete and in order to eliminate airlocks, the topping has to be vibrated (flumed) properly.

In order to facilitate the submerging of the wear surface in particular, it would be advantageous to put down for example a wooden plate, measuring 1 mm wider than the width of the grate. Thus reduces the risk of concrete residues remaining in the formwork boxes. The plate is to be brought forward, as the wear surface will be casted.

Sketch 1

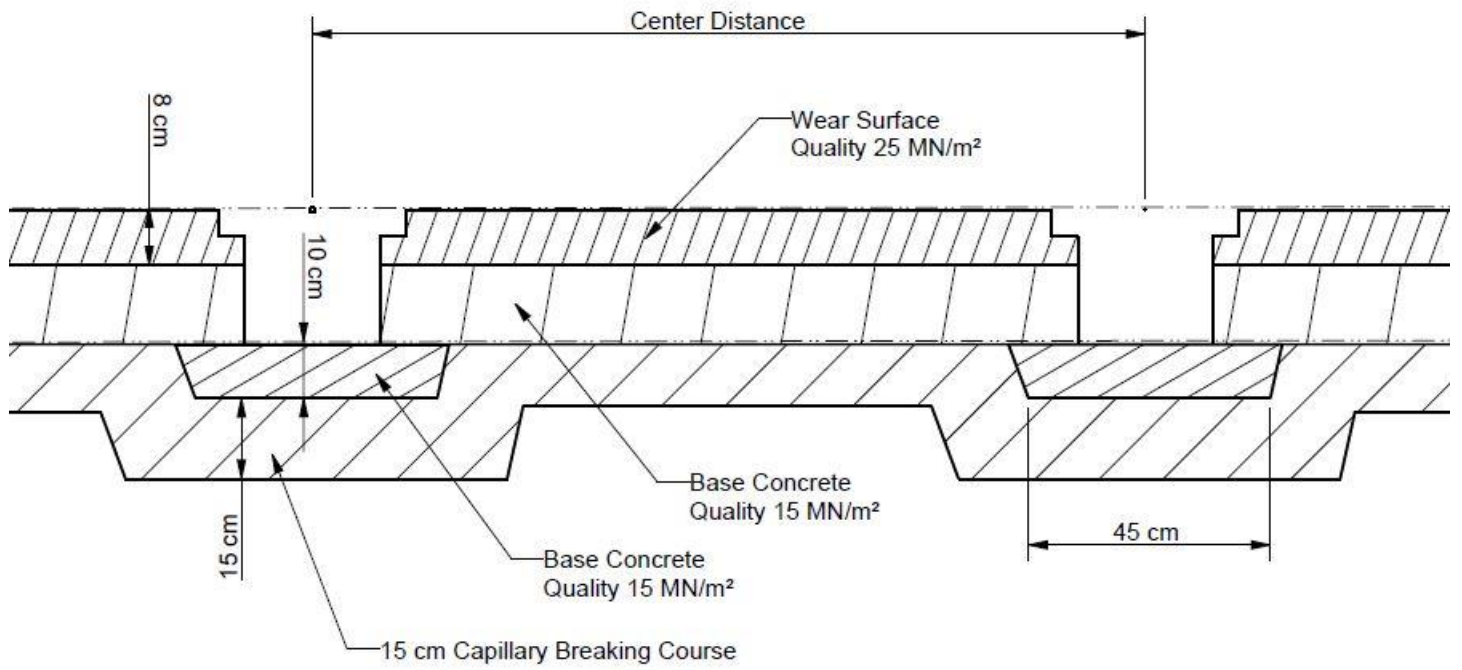


Figure 1

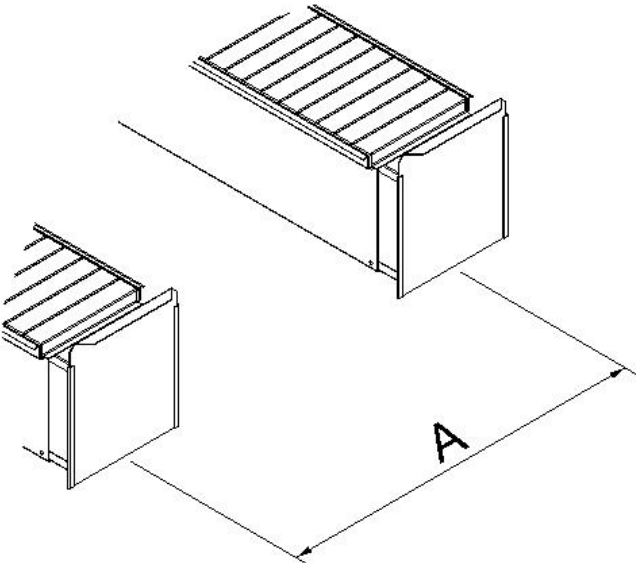
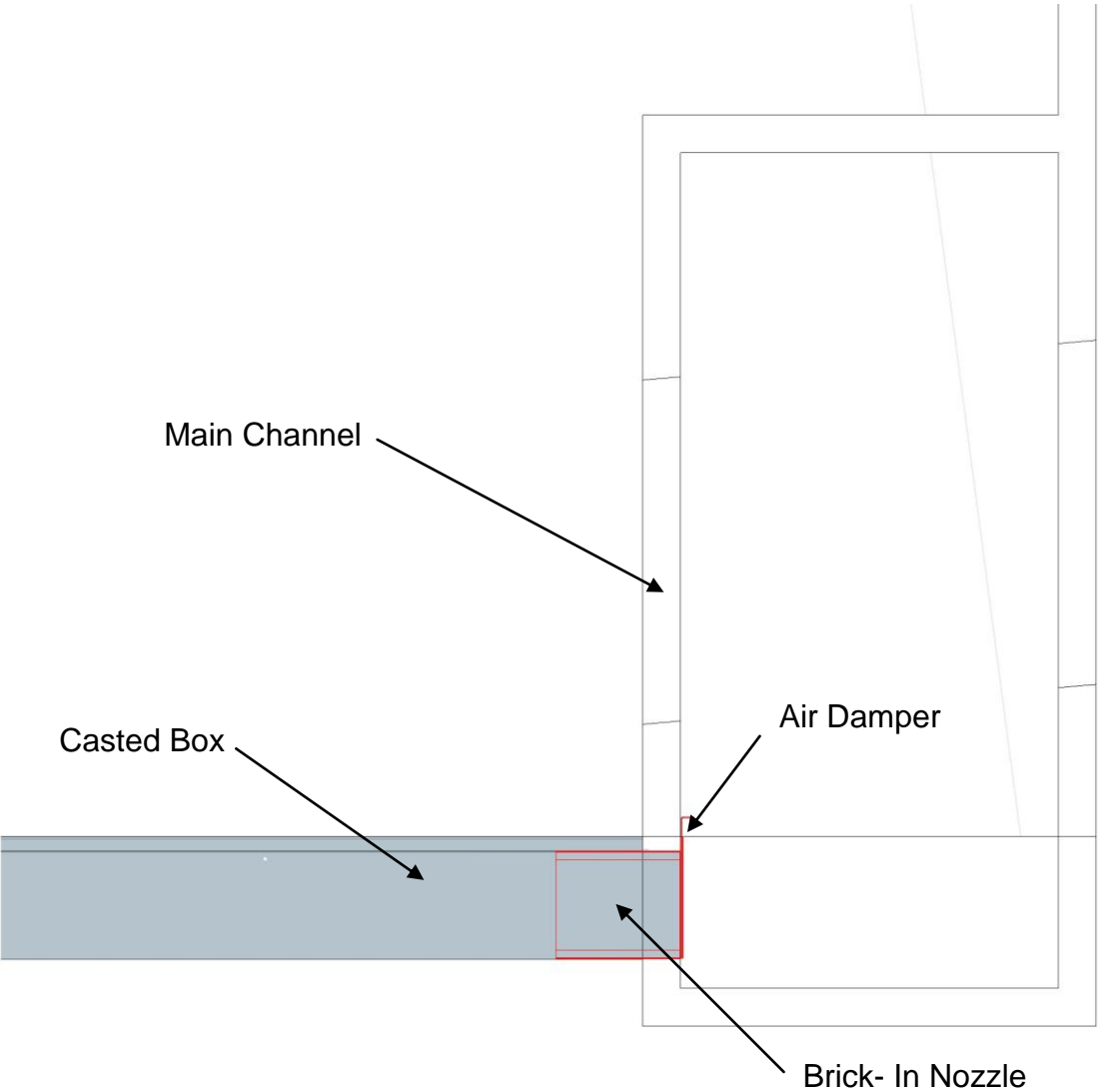
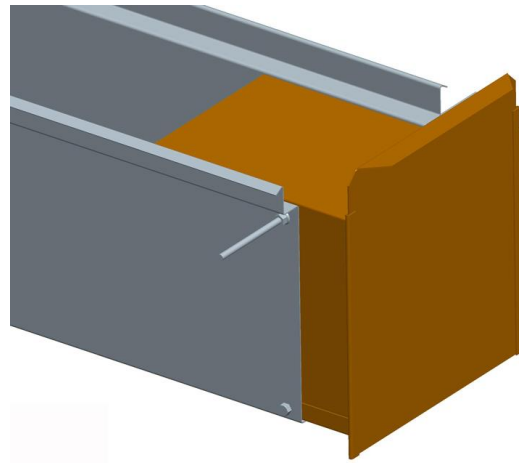


Figure 2



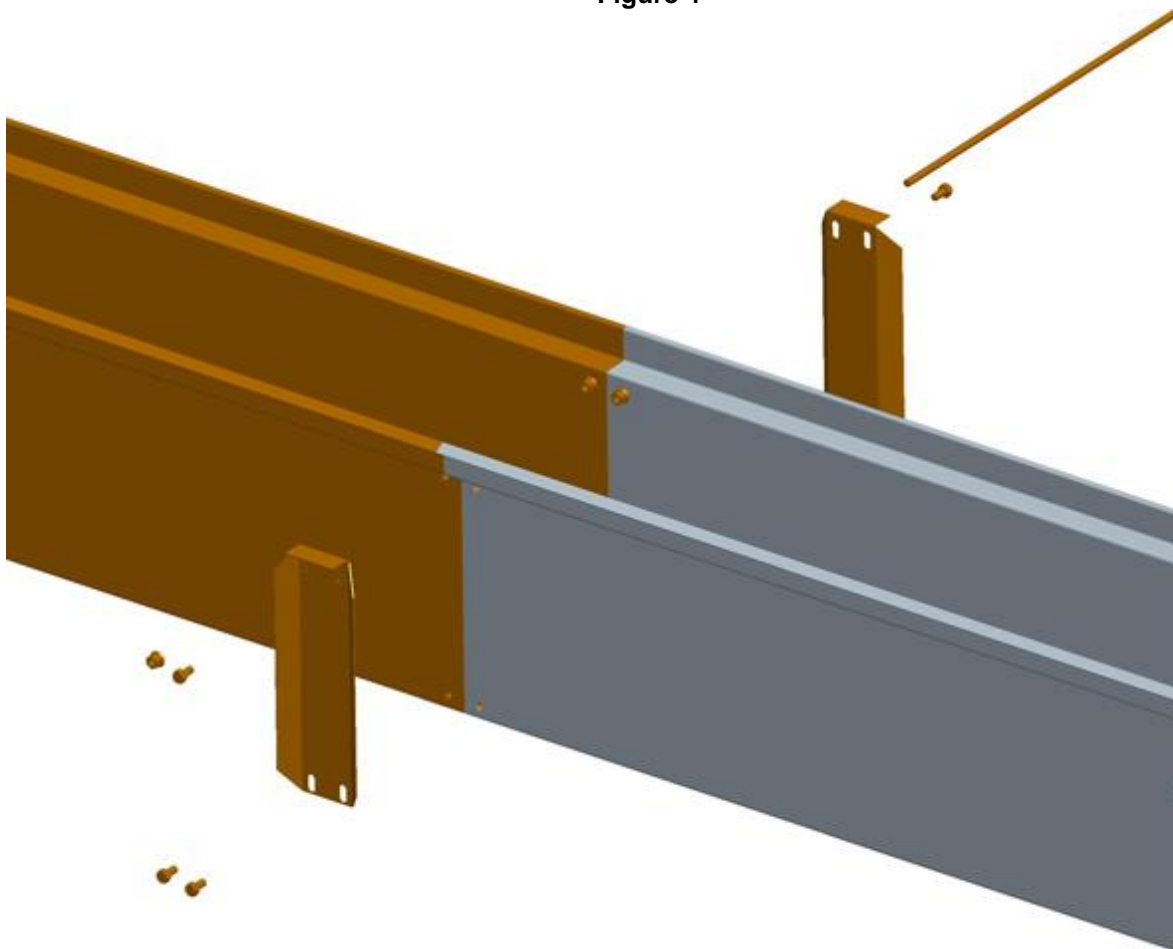
Nozzle for the main channel is to be bricked-in into the main channel w/ the throttle turned in into the main channel and the square pipe turned in into the casted box/formwork

Figure 3



Assembly of the concrete formwork is carried out by mounting bracket and spacer bars as shown in figure 4, so that there is 304mm between the surfaces onto which the grates should be placed. See drawing figure 6

Figure 4



End plate is to be mounted as shown in figure 5

Figure 5

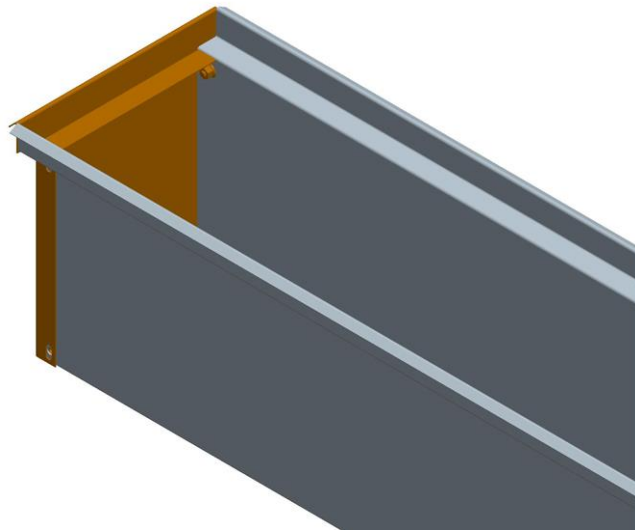


Figure 6

