Assembly Instructions

Envistar Flex

Size 060-1580

PRODUKT

Documentation for your unit:

1. Visit IV Produkt's order portal *docs.ivprodukt.com* or scan the QR code.
2. Enter your order number.
3. Press ENTER or click on search.
4. Select your order.

Is any documentation missing?

See information in section

"2.1 Documentation and support", page 11.

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Assembly Instructions
Envistar Flex

1 SAFETY

This section addresses important safety aspects of assembly, with the aim of raising safety awareness and avoiding personal injuries and damage to surroundings and units.

- This manual contains important instructions. Read it carefully and follow the instructions.
- Pay special attention to warning and information messages, as well as markings on the product.
- Keep the manual for future use.

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1.1 Intended use

Intended use

The product is intended to be used air handling unit as comfort ventilation in properties.

Intended users

The contents of this manual are intended for personnel assembling the unit on site.

Intended user environment

- The unit is usually placed indoors, but is also available as an outdoor version.
- When assembled indoors, the unit must be assembled in a ventilated area that maintains a temperature between +7 and +30 °C, and that maintains a moisture content of <3.5 g/kg in dry air in the winter.
- The unit can also be equipped for assembly in cold attics.

1.2 Unintended uses

Any use other than specified in Intended use is prohibited unless specifically permitted by IV Produkt. It is not permitted to use the unit in potentially explosive environments.

1.3 General safety

Failure to comply with the safety precautions may result in injury to persons or damage to air handling units. To avoid personal injuries and damage to surroundings or units:

- Follow national and local laws/regulations for safe work, e.g. fall protection when working at a height.
- Do not wear loose clothing or jewellery that may become fastened.
- Do not step or climb on the unit.
- Use appropriate tools.
- Use appropriate personal protective equipment.
- Note the unit's markings: product signs, information and warning stickers.

Personal Protective Equipment (PPE)

Personal protective equipment must always be used based on the risks present in the workplace. For example, wear protective footwear with steel toecaps, hearing protection, protective helmet, gloves, safety eyewear, fully-covering clothing, safety overalls, facial/protective mask and/or fall protection equipment where the work and work environment requires it.

1.4 Structure of warning notices

Warning notices in the instruction warn of risks when handling and assembling the product. Carefully follow the instructions published in warning notices.

The warning symbol  indicates that a risk exists.

WARNING! indicates a potential risk that, if not avoided, can cause **life-threatening or serious** situations that can lead to death or personal injury.

CAUTION! indicates a potential risk that, if not avoided, can cause **material damage** too the product or surroundings as well as impairment of product function.

"Risk of xxxxxx." Indicates the risk in a short risk title.

A description in italics provides more detailed information about what the risk entails.

- The bullet points indicate how the user avoids harm.

1.5 General warning notices

WARNING!

Risk of life-threatening or serious personal injury.

Electrical voltage can cause electric shock, burns and death. The product must not be energised during assembly.

- Electrical connection and electrical work may only be carried out by a qualified electrician.
- For initial start-up of the unit, see Operation and Maintenance of the unit on IV Produkt's Order portal.

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WARNING!

Risk of life-threatening or serious crushing or compression injury.

High unit parts, as well as unit parts with a high or offset centre of gravity, mean a greater risk of tipping.

- Follow the lifting and assembly instructions in this manual.
- Use lifting equipment where available.
- Use appropriate protective equipment.
- Exercise caution when working between unit parts.
- Exercise caution when placing unit parts on the support.
- Use the support to secure the parts against possible tipping risk.

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WARNING!

Risk of life-threatening or serious crushing or compression injury.

The unit parts are often heavy and cannot be lifted by hand. See weights indicated on the layout drawing.

- Follow the lifting and assembly instructions in this manual.
- Use lifting equipment where available.
- Use appropriate protective equipment.

00179

WARNING!
Risk of serious crushing injury.
A falling unit when lifting can cause crushing injuries.

- Follow the instructions for lifting in this manual.
- Never exceed the specified weight for the respective lifting method or lifting equipment.
- Slide stops must be fitted when lifting, if bracket is used.
- Replace used T-bolts and nuts with new ones after each lift (EMMT-12).

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WARNING!
Risk of cutting.
Sharp edges can cause cuts.

- Use appropriate personal protective equipment when the work requires it.

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1.6 Signs on the unit

Keep signs and stickers free of dirt. Replace missing, damaged or unreadable signs and stickers on the machine. Contact IV Product for replacement stickers by specifying the article number.

1.6.1 Type plate

The unit and any associated cooling unit/reversible heat pump have a type plate affixed to the front. The type plate is used, among other things, for identification of the product.

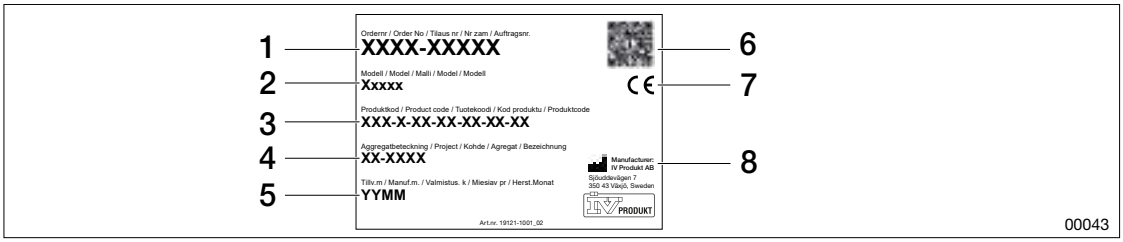

Figure: Example of a unit type plate

1. Order number
2. Product name/model
3. Product code
4. Unit designation
5. Date of manufacture
6. QR code
7. CE marking
8. Manufacturer

1.7 Accidents and incidents

Report accidents and incidents according to national and local laws/regulations.

1.8 Product liability

The unit complies with industry requirements for quiet air handling units with high-efficiency recovery systems for heating and cooling.

CE marking (EU)
The air handling unit is CE marked and meets the applicable requirements according to specified directives and standards in the Declaration of Conformity. The marking covers the unit in the configuration in which it was delivered and provided that it has been assembled and commissioned in accordance with IV Produkt's instructions. The declaration does not cover units that have been modified, retrofitted components, or other systems in which the unit may be included. The unit may not be put into service until the system in which it is included complies with the requirements for CE marking.

The Declaration of Conformity can be obtained on IV Produkt's order portal, *"2.1 Documentation and support", page 11*.

Manufacturer
The Air Handling Unit is manufactured by IV Produkt AB, Sjöuddevägen 7, S-350 43 VÄXJÖ, Sweden.

Warranty
For proper function and for the warranty to be valid, the assembly instructions must be followed.

Extended warranty
Extended warranty is a supplement to the order and to claim extended warranty (5 years), according to ABM 07 with Appendix ABM-V 07 or according to NL 17 with Appendix VU 20, a complete documented and signed IV Produkt Service and Warranty book must be presented.

Disclaimer
Continuous product development may give rise to specification changes without notice.

1.9 Lifting the units, functional section

Lifting must be done according to the lifting instructions in this document, *"5 LIFTING THE UNIT", page 16* and according to markings and signs on the unit. If there are no lifting instructions or markings, lifting must be carried out according to lifting methods prepared by the transport industry.

1.10 After the product's service life

To disassemble and decommission the unit, refer to Operation and Maintenance.

2 GENERAL INFORMATION

2.1 Documentation and support

The documentation for your unit can be found in IV Produkt's order portal. See *"2.1 Documentation and support", page 11*.

It can take up to two weeks for all documentation to be available in the IV Produkt's order portal. The text "Documentation in progress" appears until the documentation is complete. In case of missing or incorrect documentation, contact DU/Documentation. For other support, please contact the relevant department. Contact details are listed on the reverse side of the manual.

2.2 Information messages, not safety-related

Symbol together with information text highlights difficulties and also gives tips and recommendations.

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2.3 Spare parts

Spare parts list can be found atIV Produkt's order portal. Order spare parts and accessories from IV Produkt. See contact details on the last page of the manual. When contacting a department, state the order number and unit designation as shown on the type plate located on the unit.

2.4 Terms and abbreviations in the manual

Term	Explanation
Thermal wheel	Rotary heat exchanger
Unit part	Part of the unit. Can contain a function (for example, fan, media, etc.) but can also be an empty part.

2.5 Symbols on dimension drawings and in the manual

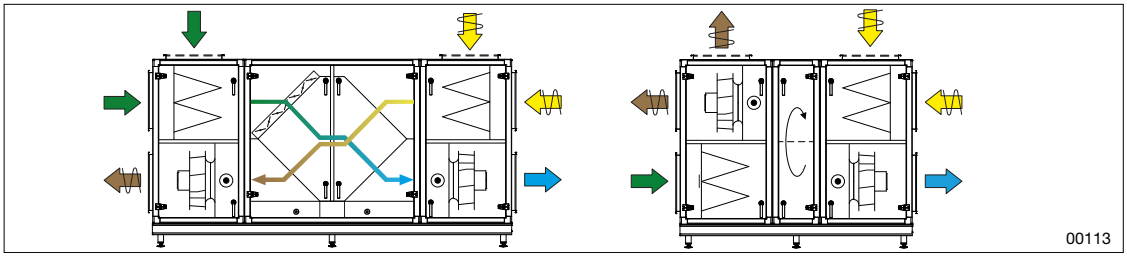

Figure: Example of a layout drawing

	Outdoor air		Extract air
	Supply air		Exhaust air
	Fan		Filter
	Shut-off damper		Trim damper
H_2O	Cooling coil water	H_2O	Heating coil water
	Heating coil electric		Noise attenuator
	Rotary heat exchanger		Plate heat exchanger
	Counterflow heat exchanger		Compressor
	Cooling unit	DX	Reversible heat pump
	Media section		Quick connector

3 DESCRIPTION OF THE UNIT

3.1 Configuration of the unit

The unit can be supplied with or without control and adjustment equipment. See *"11 ASSEMBLE CONTROL EQUIPMENT", page 54.*

The unit is supplied as a complete compact unit (unit version) or in blocks/parts (block version). Units in block version require assembly.

Indoor units are mounted on supports (aluminium profiles) with legs and feet adjustable to different heights.

The framework of the units consists of aluminium profiles:

- Sizes 060-980: 50 x 50 mm (50 profile)
- Sizes 1080-1580: 60 x 60 mm (60 profile).

Outdoor units are pre-mounted on beam frames (aluminium profiles) with a fixed height of 100 mm (for 50 profile) or 160 mm (for 60 profile) and cannot be fitted with legs or adjustable feet.

Unit parts that have pre-assembled supports have lifting lugs mounted under the cross beams of the support.

Unit parts can be delivered in sections or divisible, known as sectioned configuration, to simplify moving them in through confined spaces.

3.2 Orientation of the unit's sides/parts

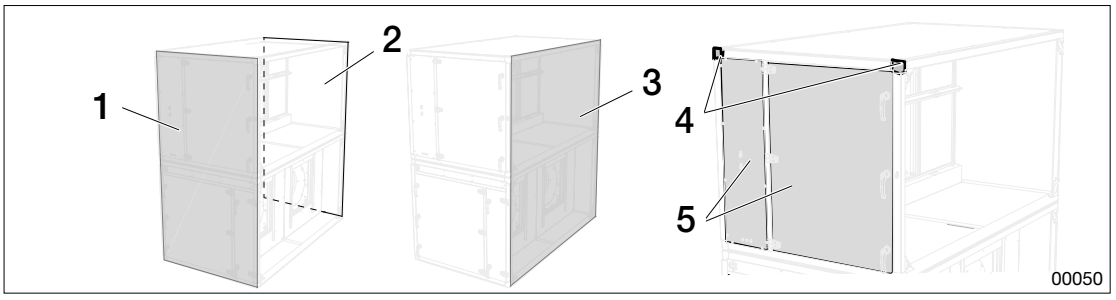

Figure: Parts of the unit

1. Access side
2. Back
3. Gable side
4. Joints
5. Covers

3.3 Signs/markings on the unit

All parts are marked with stickers that show what function the part has.


Filter


Rotary heat exchanger


Plate heat exchanger


Fan


Air cooler water


Air heater liquid


Air heater electric


Damper


Noise attenuator


Smoke by-pass


Air turner


Smoke by-pass from above


Media


Empty


Humidifier


Angle


Inspection section


Temperature sensors


Earth

4 DELIVERY RECEPTION / WAREHOUSING

4.1 Receive, unpack

Upon arrival, check the goods and their packaging. Make sure there is no damage.

4.2 Packaging and protection

The product's packaging is intended to protect the product from rain and dirt during transport and storage.

The product should be stored in its original packaging for as long as appropriate. If the packaging is removed, the product must be protected so that particles (e.g. dust and dirt) or water do not penetrate the functional sections.

If the goods are dirty on arrival, rinse the unit with water and, if necessary, clean according to the instructions for the unit's surfaces in *"14 AFTER ASSEMBLY", page 58*.

4.3 Recommended storage

Before assembly, the product must be stored on a flat surface, preferably in a dry and warm area.

If stored outdoors, the product must be protected from weather conditions such as rain, snow and direct sunlight. Ventilation inside the assembly parts must be ensured during storage. The product can be stored in both warm and cold conditions, temperature range -40 °C till +50 °C.

Small amounts of condensation water, which occurs during storage in fluctuating temperatures, will dry up when the unit is put in operation, ensure that:

- there is good air circulation between the packaging and unit as well as inside functional sections. the packaging is opened to let air in if necessary.
- the product is protected against extreme temperatures and weather conditions.
- the product is protected against water ingress so that large volumes of stagnant water do not accumulate inside the unit.

5 LIFTING THE UNIT

WARNING!
Risk of life-threatening or serious crushing or compression injury.
High unit parts, as well as unit parts with a high or offset centre of gravity, mean a greater risk of tipping.

- Follow the lifting and assembly instructions in this manual.
- Use lifting equipment where available.
- Use appropriate protective equipment.
- Exercise caution when working between unit parts.
- Exercise caution when placing unit parts on the support.
- Use the support to secure the parts against possible tipping risk.

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WARNING!
Risk of life-threatening or serious crushing or compression injury.
The unit parts are often heavy and cannot be lifted by hand. See weights indicated on the layout drawing.

- Follow the lifting and assembly instructions in this manual.
- Use lifting equipment where available.
- Use appropriate protective equipment.

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WARNING!
Risk of serious crushing injury.
A falling unit when lifting can cause crushing injuries.

- Follow the instructions for lifting in this manual.
- Never exceed the specified weight for the respective lifting method or lifting equipment.
- Slide stops must be fitted when lifting, if bracket is used.
- Replace used T-bolts and nuts with new ones after each lift (EMMT-12).

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CAUTION!
Risk of damage to the product
Chains/straps that are lying against the unit when lifting may damage the unit.

- Use spreader bars when lifting with bracket.
- Follow instructions for working with spreader bars.

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- Lifting of some thermal wheel sizes must be carried out according to separate instructions. See "5.8 Thermal wheel sizes (1250-D1, 1540-D1) - Lifting from truck", page 22 and "5.9 Thermal wheel size 1580 - Lifting with brackets", page 22.

5.1 Lifting unit parts with forklift

See also "", page 22.

When lifting with a forklift, the forks must be as long as the unit packaging or longer.

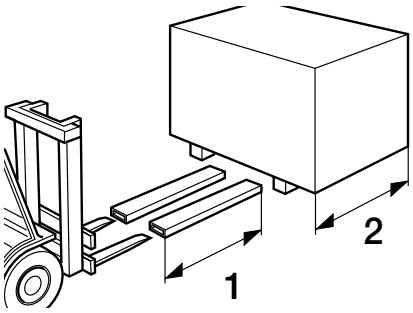

Figure: Lifting with forklift

1. Lift fork length
2. Unit packaging

5.2 Lifting brackets, pre-mounted lifting lugs, spreader bar

- The maximum permitted angle at the lift hook is 80°
- The inclination slope of unit parts when lifting is 15°. If the tilt is greater than 15°, the chains/straps must be shortened or extended until the angle is less than 15°.
- The spreader bar must be 100—400 mm wider than the unit.

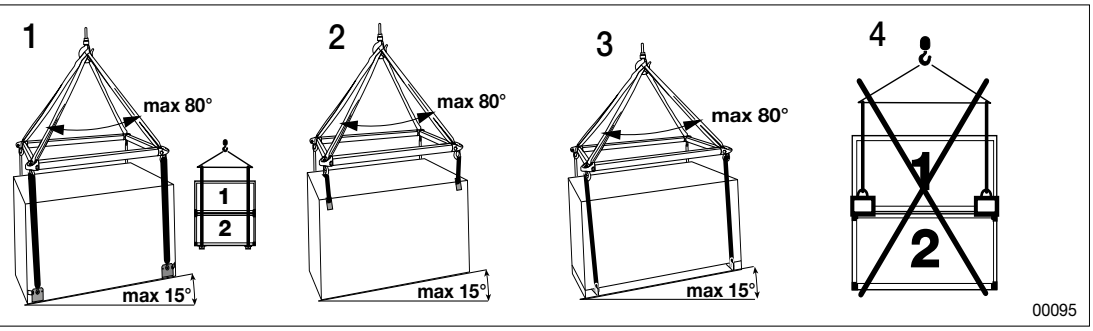

Figure: Illustration of lift with spreader bar and inclination

1. Lift with EMMT-08 with spreader bar
2. Lift with EMMT-12 with spreader bar
3. Lift in base frame with spreader bar
4. Incorrectly mounted lifting brackets in the centre profile

5.3 Lift of double stacked parts (parts on top of each other)

- Total weight ≤ 1600 kg - to be lifted with lifting brackets EMMT-12, mounted at the bottom of the lower part.
- Total weight > 1600 kg - lifted with pre-mounted lifting lugs. See "5.6 Lifting of unit pre-mounted on support", page 20.

5.4 Lift with bracket EMMT-08, for 50 profile

WARNING!
Risk of serious crushing injury.
A falling unit when lifting can cause crushing injuries.

- Follow the instructions for lifting in this manual.
- Never exceed the specified weight for the respective lifting method or lifting equipment.
- Slide stops must be fitted when lifting, if bracket is used.
- Replace used T-bolts and nuts with new ones after each lift (EMMT-12). 00180

- The bracket does not fit the 60 profile.
- Load per lifting bracket ≤ 400 kg.
- Load if all four brackets are used ≤ 1600 kg.
- A safety factor of 1.6 has been utilised in static testing of the lifting bracket.
- Use shackle with safety factor 6:1.
- Brackets must not be mounted downwards or sideways.
- Lifting brackets must not be mounted in the middle profile of double stacked parts.

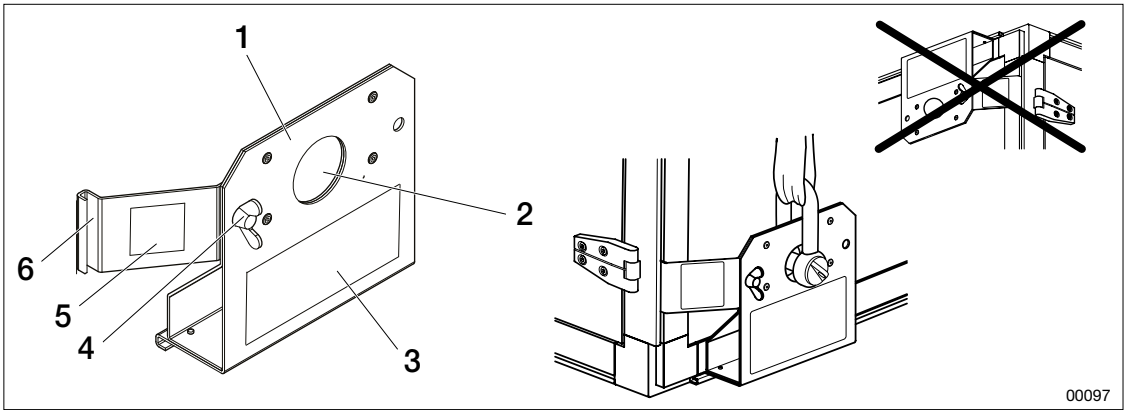

Figure: Lifting bracket EMMT-08

1. Lifting bracket EMMT-08
2. Lifting lug
3. Lift stop sticker
4. Wing nut
5. Slide stop sticker
6. Slide stop

EMMT-08 is delivered in a set of four.

1. Place the lifting brackets in the bottom four corners of the unit or unit part (on the longest sides of the part), with the lifting lug upwards.
2. Push the brackets into the horizontal track in the unit's aluminium profile.
3. Push the slide stop into the vertical track in the unit's aluminium profile.
4. Lock by tightening the wing nut.

5.5 Lift with bracket EMMT-12, for 60 profile

WARNING!
Risk of serious crushing injury.
A falling unit when lifting can cause crushing injuries.

- Follow the instructions for lifting in this manual.
- Never exceed the specified weight for the respective lifting method or lifting equipment.
- Slide stops must be fitted when lifting, if bracket is used.
- Replace used T-bolts and nuts with new ones after each lift (EMMT-12). 00180

- The bracket does not fit the 50 profile.
- Load per lifting bracket ≤ 500 kg.
- Load if all four brackets are used ≤ 2000 kg.
- A safety factor of 2.0 has been used in static testing of the lifting bracket.
- Use shackle with safety factor 6:1.
- Brackets must not be mounted downwards or sideways.
- Lifting brackets must not be mounted in the middle profile of double stacked parts.
- Lift only one part at a time.

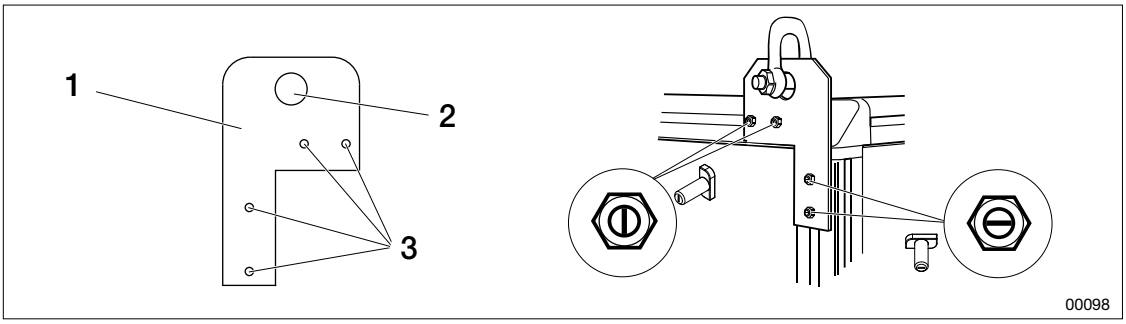

Figure: Lifting bracket EMMT-12

1. Lifting bracket EMMT-12
2. Lifting lug
3. Fixing holes

EMMT-12 is delivered in a set of four.

1. Place the lifting brackets over the top four corners of the unit (on the longest sides), with the lifting lug upwards.
2. Insert the supplied T-bolts (MB 8×19 FZB 8.8), through the bracket and into the track in the aluminium profile.
3. VTurn the T-bolts, with a tightening torque of 24 Nm, so that they are at 90° to the profile track and are firmly fixed under the edges of the track.

5.6 Lifting of unit pre-mounted on support

WARNING!
Risk of serious crushing injury.
A falling unit when lifting can cause crushing injuries.

- Follow the instructions for lifting in this manual.
- Never exceed the specified weight for the respective lifting method or lifting equipment.
- Never loosen or move the factory-fitted sliding stops.
- The lifting straps must always be pulled through the sliding stops to prevent the lifting straps from sliding underneath the unit.
- The sliding stops cannot be fitted to certain unit sizes; the person lifting the unit must therefore ensure that the straps do not slide together or apart during lifting.

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1. Pull the straps under the unit/parts. Make sure the straps go through the lugs.
2. Lift with suitable lifting equipment.

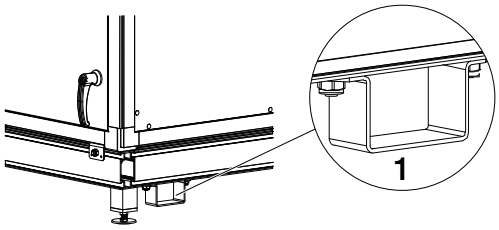

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Figure: Lifting lug on support

1. Lugs for straps (four)

5.7 Lifting of unit pre-mounted on base frame

WARNING!
Risk of serious crushing injury.
A falling unit when lifting can cause crushing injuries.

- Follow the instructions for lifting in this manual.
- Never exceed the specified weight for the respective lifting method or lifting equipment.
- Never remove or move the factory-fitted lifting lugs.
- Use shackle with safety factor 6:1.
- Lifting straps must not be pulled through the lifting lugs.

00192

Aluminium beam H=100mm:

- Maximum load=750 kg/lifting lug. Total load=3000kg (all four lifting lugs).

Aluminium beam H=160mm:

- Maximum load=1350kg/lifting lug. Total load=5400kg (all four lifting lugs).

1. Fit a shackle in each of the pre-mounted lifting lugs.
2. Pull straps through each shackle.
3. Lift with suitable lifting equipment.

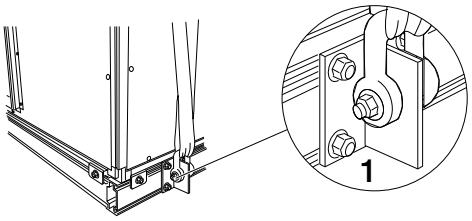

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Figure: Lifting loop pre-mounted on base frame

1. Lifting lug with shackle (four)

5.8 Thermal wheel sizes (1250-D1, 1540-D1) - Lifting from truck

Lifting brackets are placed on different points on the thermal wheel depending on the kind of lift to be done.

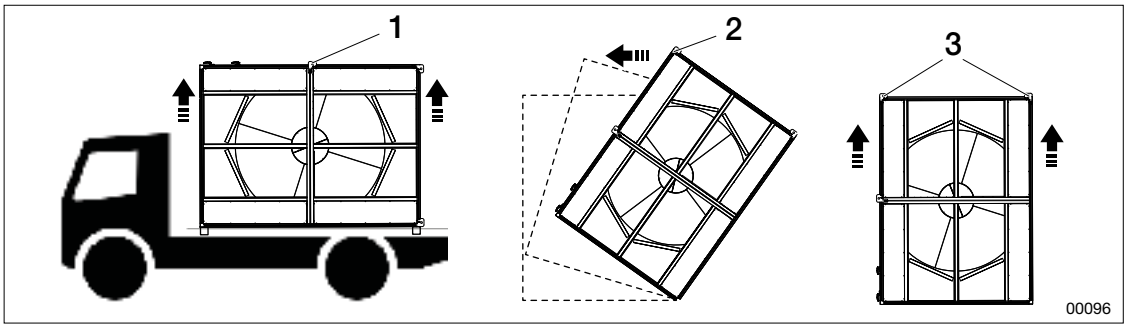


Figure: Lifting of thermal wheel from truck

1. Brackets when lifting from truck
2. Brackets to straighten the thermal wheel to standing
3. Brackets for lifting the thermal wheel to the unit

5.9 Thermal wheel size 1580 - Lifting with brackets

The thermal wheel is lifted in pre-fitted brackets. See *"5.5 Lift with bracket EMMT-12, for 60 profile", page 19*.

WARNING!

Risk of serious injury and/or material damage.

The shape and design of the thermal wheel and its high centre of mass mean it may tip over or fall if it is lifted or transported incorrectly.

- Do not lift the thermal wheel at the upper part of the casing.
- Do not use a forklift to transport the thermal wheel.
- The thermal wheel must be lifted in the pre-fitted brackets.
- The brackets must not be moved.

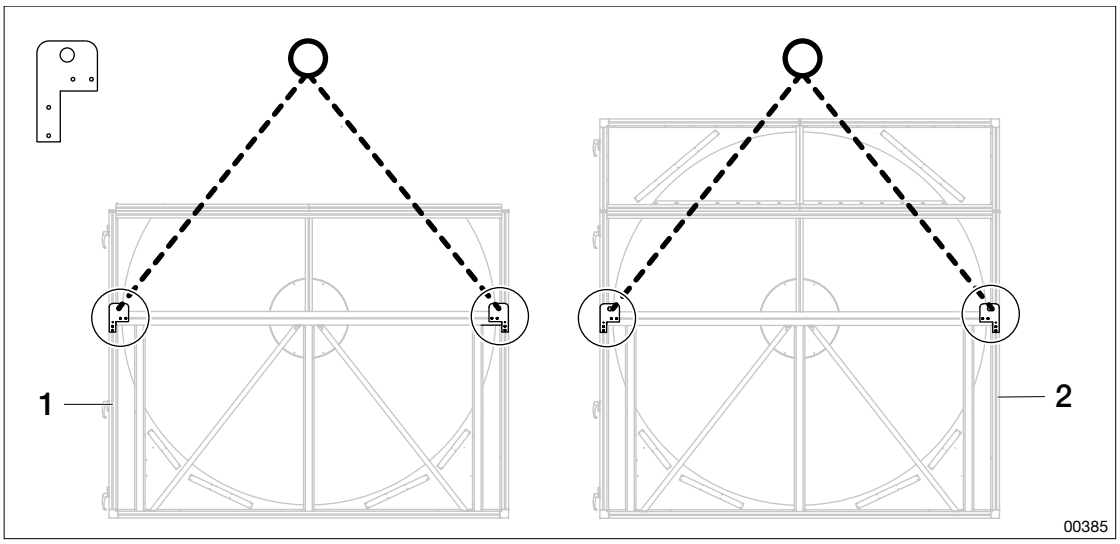


Figure: Lifting thermal wheel size 1580

1. Thermal wheel not assembled, without upper part
2. Thermal wheel assembled, with upper part

6 PREPARE ASSEMBLY

When setting up the unit, it shall be horizontal at the longitudinal leading edge, as well as slightly inclined forward (towards the inspection side) to create proper drainage of condensation water.

Inlet grilles and duct systems shall be designed and assembled so that:

- water is prevented from penetrating into the unit.
- recirculation and short-circuiting between the exhaust air and outdoor air is prevented.
- drainage cannot run backwards to the unit.

The duct system must be designed and the control system configured to prevent pressure increase through filter/air ducts, for example by soft-starting fans and opening dampers when fans are in operation. See *"13 DUCT CONNECTION, DUCT ACCESSORIES", page 57.*

Water trap is mounted as indicated. See *"12 CONNECT DRAINAGE, WATER TRAP", page 56.*

6.1 Sectioned configuration (Easy Access)

Unit parts delivered in block form must be assembled before they are put into place on the support. Follow the instructions in *"7 ASSEMBLY, GENERAL", page 26* and *"8 ASSEMBLY, SECTIONED CONFIGURATION", page 35.*

6.2 Create service area, electrical safe distance

- The service area in front of the unit should be about 1.5 x the depth of the unit so as to allow for service, replacement of parts and cleaning.
- Follow the National Electrical Safety Board's recommendations regarding the free service space to be located in front of electrical connecting equipment.

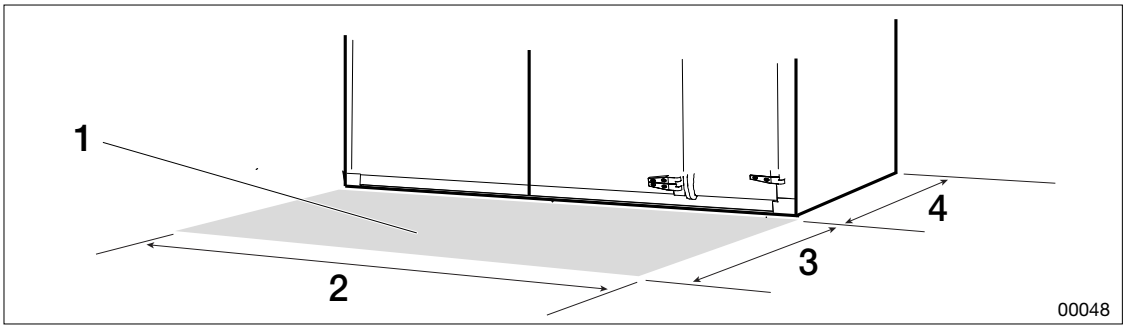


Figure: Service area on the inspection side

1. Service area
2. Service area width (width of the unit)
3. Service area depth (1.5 x depth of the unit)
4. Depth of the unit

6.3 Prepare for outdoor version

The location of outdoor units with respect to wind direction and proximity to surrounding walls may, in adverse cases, imply the recirculation of exhaust air to outdoor air intakes. In unsafe conditions, ensure sufficient distance between exhaust air and outdoor air intakes.

For outdoor units, the unit is placed on longitudinal beams on top of a waterproof roof. Water intrusion may occur between beams and unit parts.

- Underlying beams (e.g. H or U profile) and anchorage plates are not provided by IV Produkt.
- For sealing strips in outdoor version, see *"7.4.1 Sealing strip in outdoor version", page 29.*

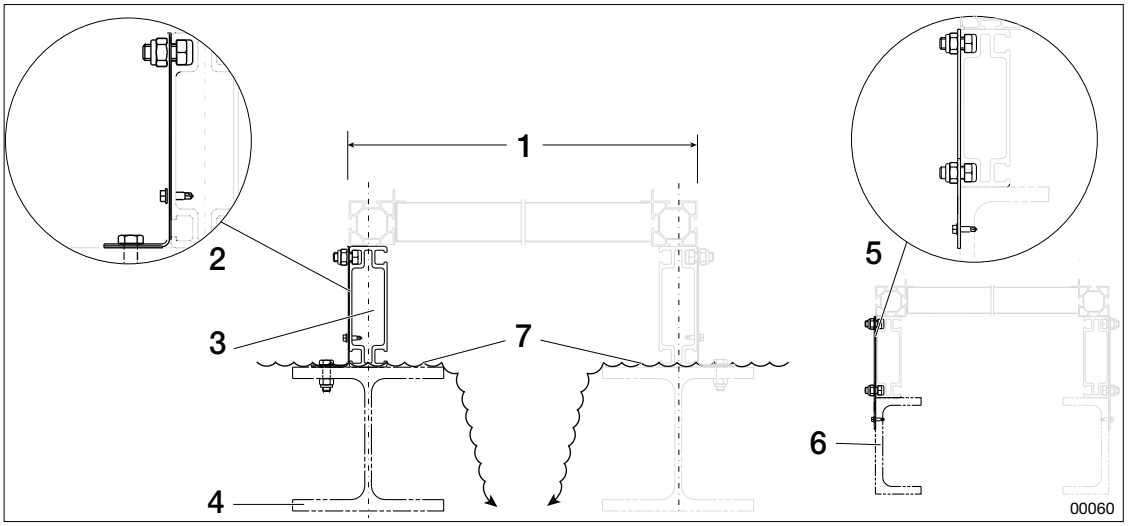


Figure: Aluminium profiles (support) and base frames in cross section as seen from the gable side

1. Unit width
2. Example, anchorage plate on H-profile (not included in delivery)
3. The unit's aluminium base frame
4. H profile (not included in delivery)
5. Example, anchorage plate on U profile (not included in delivery)
6. U profile (not included in delivery)
7. Risk of water ingress

The height of the aluminium base frame is 100 mm or 160 mm, and the width is 50 mm.

The air handling unit on the underlying base frame shall be dimensioned as distributed load.

The air handling unit on the aluminium base frame is self-supporting between inspection side and back and only needs support under the longitudinal beam on the inspection side and on the back. The framework must be placed with the extruded profile centrally over the H-beam. See the previous figure.

Anchoring of base frame in underlying beams (underlay) is carried out with anchorage plates according to the example in the previous figure. Anchorage plates are not included in the delivery and must be fitted by the customer.

With delivery of a unit in divided outdoor version, see also the order-specific drawing for cover plate assembly, onIV Produkt's order portal.

Externally mounted damper including damper actuator must be weather protected if unit is not supplied with protective intake hood or exhaust hood.

Connected flue gas bypass ducts and flue gas bypass dampers must be weather protected and insulated in their entirety if there is a risk of condensation in the duct or on flue gas bypass dampers.

6.4 Support pillars at overhang (protruding section)

Protruding functional sections and ducts mounted in the upper section must be supported by support legs if the overhang is longer than 300 mm. The ducts can also be suspended.

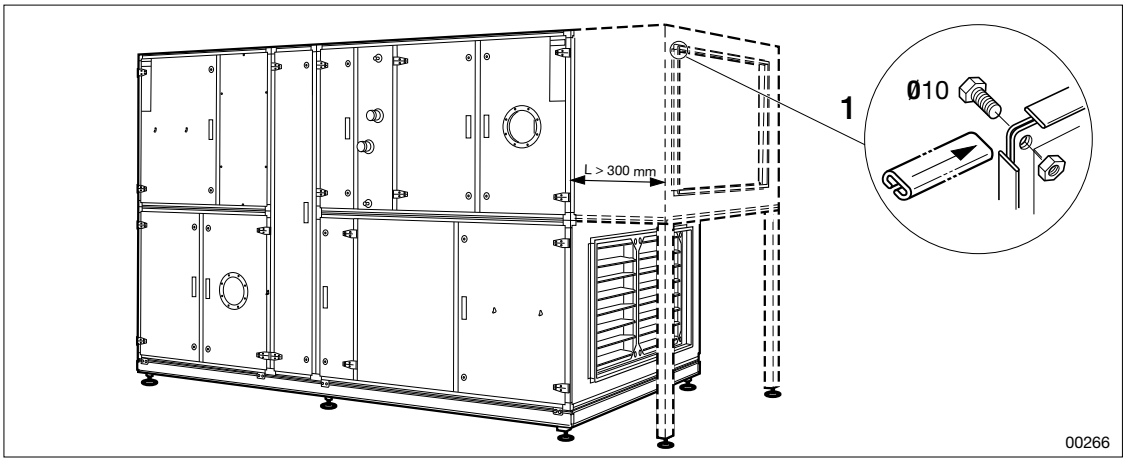


Figure: Support pillars at overhang (protruding section)

1. Connection using PG method

Ducts are connected using the PG method: gasket, guide pin and outer corner, or bolt in the corner of the connecting frame.

7 ASSEMBLY, GENERAL

Read and follow each step carefully to avoid making errors and causing personal injury or damage to surroundings or unit. See *"1 SAFETY", page 7*, *"5 LIFTING THE UNIT", page 16* and *"6 PREPARE ASSEMBLY", page 23* before beginning assembly.

For examples of layout drawings and explanations of drawing symbols, see *"2.5 Symbols on dimension drawings and in the manual", page 12.*

WARNING!
Risk of life-threatening or serious personal injury.
Electrical voltage can cause electric shock, burns and death. The product must not be energised during assembly.

- Electrical connection and electrical work may only be carried out by a qualified electrician.
- For initial start-up of the unit, see Operation and Maintenance of the unit on IV Produkt's Order portal.

00176

WARNING!
Risk of life-threatening or serious crushing or compression injury.
The unit parts are often heavy and cannot be lifted by hand. See weights indicated on the layout drawing.

- Follow the lifting and assembly instructions in this manual.
- Use lifting equipment where available.
- Use appropriate protective equipment.

00179

WARNING!
Risk of life-threatening or serious crushing or compression injury.
High unit parts, as well as unit parts with a high or offset centre of gravity, mean a greater risk of tipping.

- Follow the lifting and assembly instructions in this manual.
- Use lifting equipment where available.
- Use appropriate protective equipment.
- Exercise caution when working between unit parts.
- Exercise caution when placing unit parts on the support.
- Use the support to secure the parts against possible tipping risk.

00189

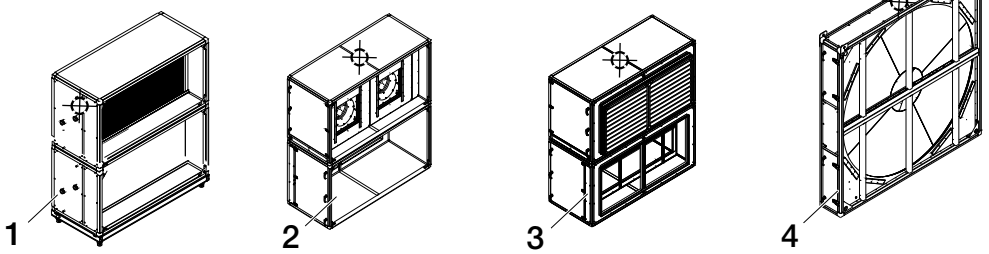


Figure: Examples of parts with a high centre of gravity or high tipping risk

1. Unit part with a high-placed coil
2. Unit part with high-placed fans
3. Unit part with high-placed damper section
4. Rotary heat exchanger

7.1 Tools required for assembly

A bag of screws, nuts, corner fittings and other items to be used for assembly is supplied with each unit. The following tools are suitable for assembly:

- Power screwdriver with 16-socket, 13-socket, 1/4-inch bit and star bit
- Screwdriver
- Spirit level
- Torch/head lamp
- Putty syringe
- Rubber mallet
- Scissors
- Polygrip pliers
- Box spanners 13, 16, 18, 19
- Wooden blocks to lay between support and road
- Pop riveter
- Lubricating grease in spray bottle
- Pipe cutter

7.2 Assembly, step by step

Unit parts in sections must also be assembled according to the instructions in the section ASSEMBLY, IN SECTIONS.

1. Refer to the layout drawing accompanying the unit or download from IV Produkt's order portal (Technical Data). See *"2.1 Documentation and support", page 11.*
2. Take out suitable tools. See *"7.1 Tools required for assembly", page 27.*
3. Assembly and adjust the support. See *"7.3 Assemble fan compartment support (EMMT-05)", page 28.*
4. Assemble unit part in sections. See *"8 ASSEMBLY, SECTIONED CONFIGURATION", page 35.*
5. Push the first unit part onto the stand.
6. Assemble the sealing strip. See *"7.4 Assemble sealing strip", page 29*.
7. Push on the next unit part and slide them together on the support.
8. Join the unit parts together. See *"7.5 Join the parts together", page 30*.
9. Repeat steps 4-7 until everything is in place and correctly assembled.
10. Connect the unit parts together with quick connectors and assemble other control equipment. See *"7.6 Quick connectors", page 31*.
11. Assemble drainage and water trap. See *"12 CONNECT DRAINAGE, WATER TRAP", page 56*.
12. Assemble cover detail. See *"7.8 Fit cover detail on join", page 34* .
13. Ensure that everything is correctly assembled. See *"14 AFTER ASSEMBLY", page 58* and if problems occur *"2.1 Documentation and support", page 11*.

7.3 Assemble fan compartment support (EMMT-05)

- The unit should tilt slightly forward (towards the inspection side) for condensation runoff and drainage. The tilt may be a maximum of 3 mm/m.
- Longitudinal beams must be level and the top of the support structure must be level.
- The support must not, at any point, be bent down more than 2 mm. If the distance between the transverse beams of the support is >1700 mm (c.t.c), extra transverse beams must be fitted to prevent bending.

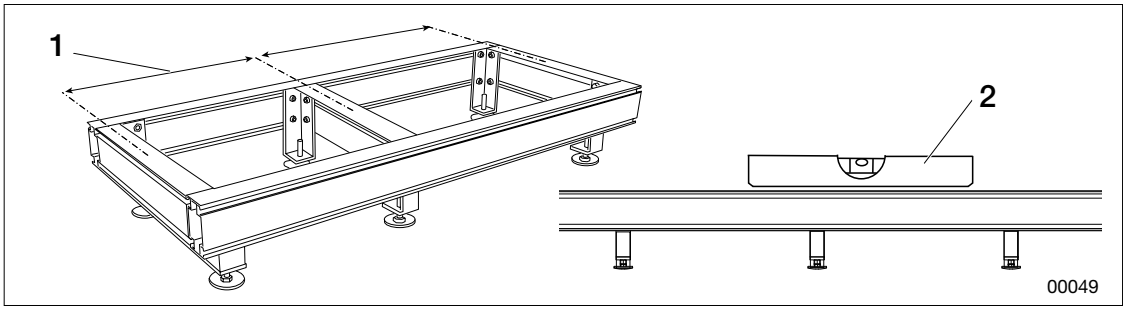
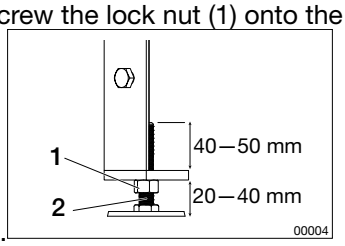


Figure: Support

1. Distance between transverse beams (c/c)
2. Longitudinal beam level

A general support drawing is included in the delivery of the support. The order-specific support drawing is available from IV Produkt's order portal (Technical Data). See *"2.1 Documentation and support", page 11.*

1. Screw the lock nut (1) onto the support foot (2) and make sure it is some of the way in.



2. Screw all feet into the threaded holes in each angle profile.
3. Push in and locate, in the track of the profile, the screws that will later be used to tighten the corner stays. Make sure you have the right number (2 per corner stay).
4. Screw the angle profiles and support legs together.
5. Use a spirit level and ensure that the longitudinal beam of the unit is level.
6. Adjust the height and inclination of the support by screwing the support feet.
7. Secure all feet with the lock nuts.

7.4 Assemble sealing strip

- The sealing strip must only be fitted on one of two opposite parts.
- The sealing strip is not fitted on the rotary heat exchanger.
- For units in sections, the sealing strip must also be fitted in the joint. Does not apply to ThermoCooler HP/EcoCooler.
- For outdoor units, the sealing strip must also be fitted on the outer edge, see "7.4.1 Sealing strip in outdoor version", page 29.
- See also "8 ASSEMBLY, SECTIONED CONFIGURATION", page 35.

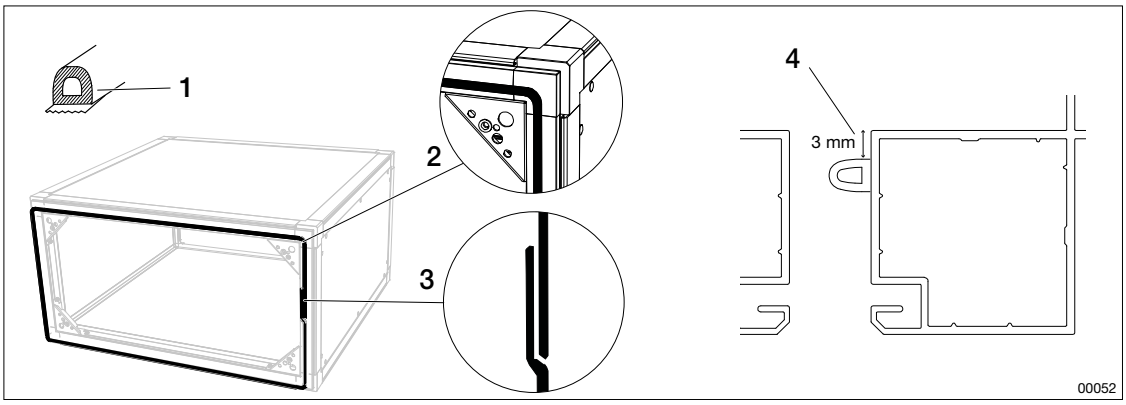


Figure: Sealing strips, location.

1. Sealing strip of type D-profile
2. Sealing strip in corner
3. Sealing strip joint
4. Profile in cross section

1. Divide the strip into two.
2. Fit the strip in the middle surfaces of the unit, about 3 mm from the inner edge. Remove the protective layer over the adhesive, after which the strip is glued on. Bend the strip in the corners and join it on vertical sides.

7.4.1 Sealing strip in outdoor version

For outdoor version units, a sealing strip must also be fitted in the outer edges.

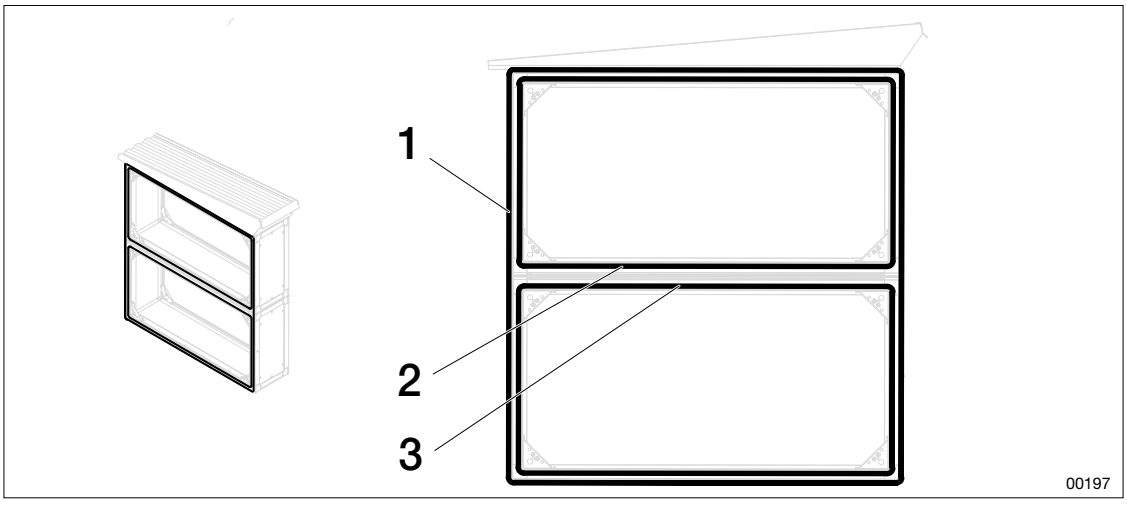


Figure: Location of sealing strips in outdoor version

1. Sealing strip in the outer edge around the entire double stack
2. Sealing strip around the top part
3. Sealing strip around the lower part

7.5 Join the parts together

50 profile (unit size 060-980):

- Usually, the unit parts are joined together with screw joints.
- Otherwise, (where there is a lack of space/ability to screw), the unit parts are joined together with guide pins.

60 profile (unit size 1080-1540):

- On larger units, the unit parts are joined together with tensioning lugs.

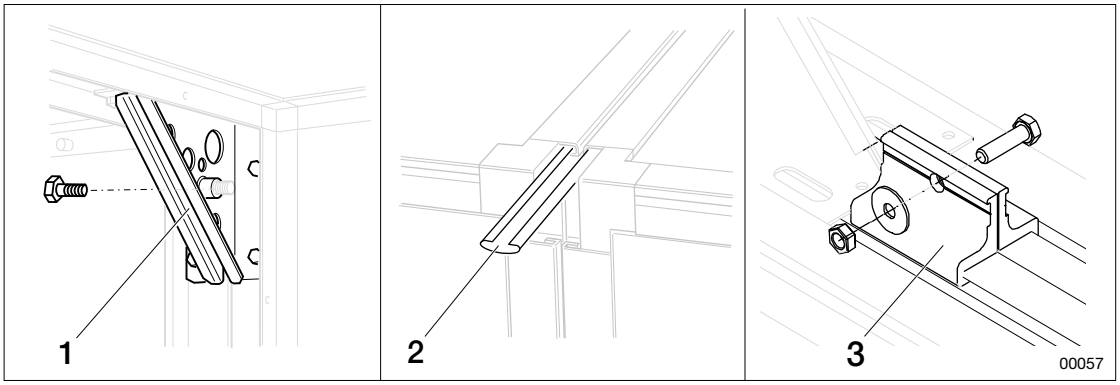


Figure: Screw joint and guide pin

1. Screw joint
2. Guide pin
3. Tensioning lug

7.5.1 Join with screw joints

1. Remove any cover plugs to access the screw joints.
2. Screw together the unit parts with bolts through each corner strut.

7.5.2 Join with tensioning lugs

For larger sizes, tensioning lugs must be used. 8 tensioning lugs must be mounted next to the screw joints.

1. Put part of the tensioning lug on each side of the profile.
2. Put in the bolt and screw together with a washer under the nut.
3. The tensioning lugs are located according to the following figure:

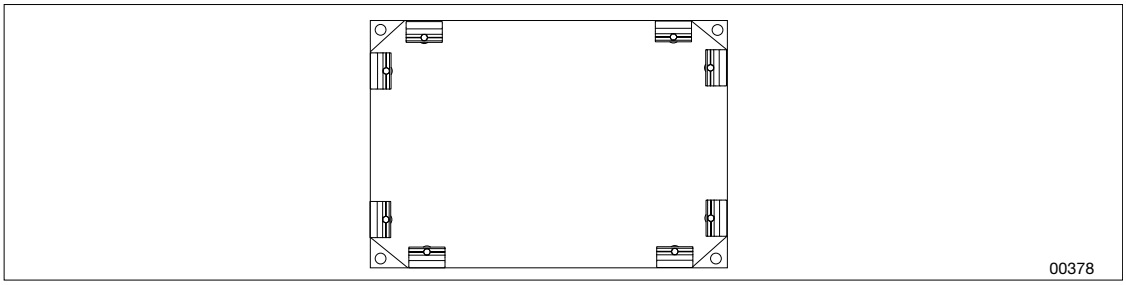


Figure: Assembly of screw joints and tensioning lugs

7.5.3 Join with guide pins

- Guide pins must always be set all the way from corner to corner on the units parts, as well as also on the opposite side.
- If two flush parts are assembled vertically with guide pins, the pins must be inserted through both parts (over the division).

Make sure the unit parts are completely pushed together.

1. Pull the parts together with tensioning straps.
2. Push the guide pin into the track of the profile, all the way to the other end of the unit.
3. Do the same on the opposite side of the unit.

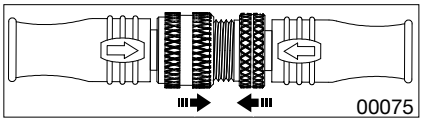
7.6 Quick connectors

See *"11 ASSEMBLE CONTROL EQUIPMENT", page 54* and order-specific documentation (Control Diagram) on IV Produkt's order portal.

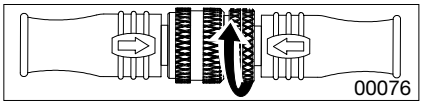
Quick connectors to be joined are marked with the same designation.

7.6.1 Quick connector, signal feed

1. Press together quick connectors according to marking (arrows or other).

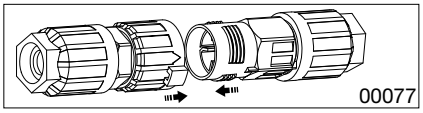


2. Screw together as hard as possible by hand.

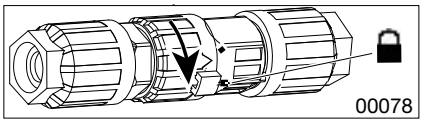


7.6.2 Quick connector, power supply

1. Press together quick connectors according to marking (arrows, dashes or similar).



2. Turn the arrow on the white cuff to the mark for closed (padlock).



7.7 Disassemble/Reassemble/Refit Fan

For better access to the inner corner struts when joining adjacent unit parts, the fan can be disassembled.

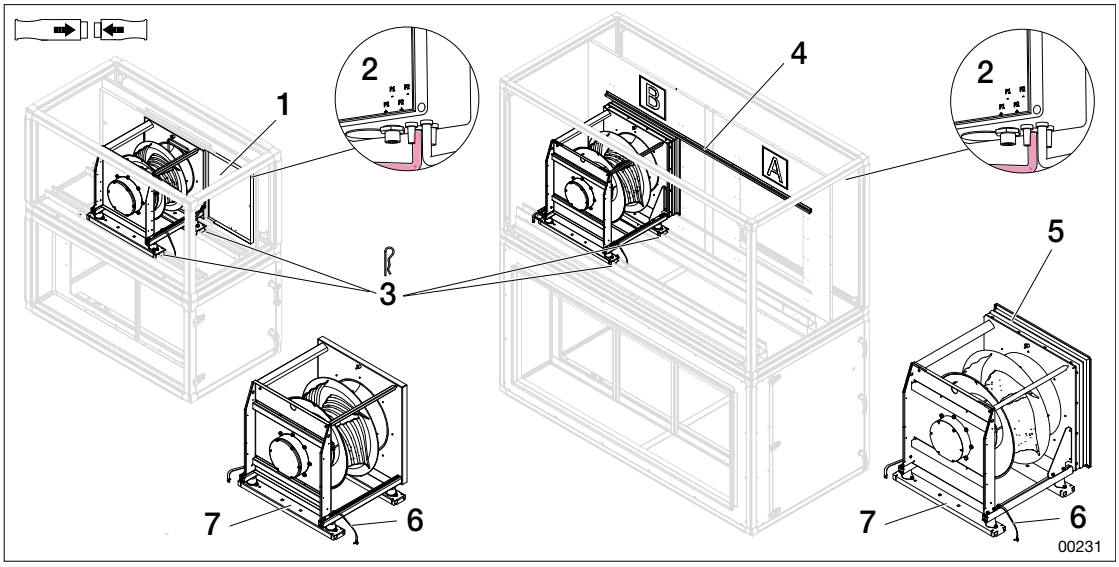


Figure: Remove the fan and reassemble

1. Cover plate
2. Pressure sensor module
3. Pins/screws
4. Sleeve rail
5. Sleeve
6. Earthing braid
7. Top sliding rail

7.7.1 Removing the fan

1. Unscrew the pressure sensor module, but make sure to not loosen hoses or cables attached to the module.
2. Fan without sleeve: Unscrew the cover plate and lift it out (including the screws).
3. Unscrew the earthing braid from the rail on the unit part.
4. Loosen the temperature sensor and remove it through the hole on the fan frame.
5. Unscrew the quick connectors between the fan and the unit part. See *"7.6 Quick connectors", page 31*.
6. Disconnect the pressure sensor hoses between the fan and pressure sensor module.
7. Pull the pins/screws out of the rails (two per fan) and pull the fan out.
8. Screw the corner struts together against the adjacent unit parts. See *"7.5 Join the parts together", page 30*.

7.7.2 Reassemble/Refit fan

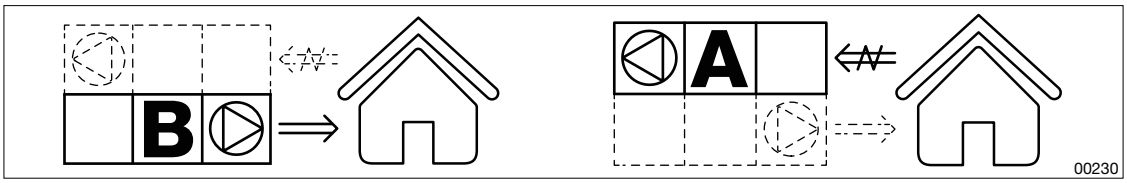


Figure: Fan label – the arrow direction indicates whether the fan is for supply air or extract air. For multi-fan installations, A/B/C, etc. indicates the fan position in the unit, as seen from the inspection door.

- Before inserting the fan, make sure that the pressure sensor module is not in the way. If necessary, disassemble it according to the instructions in "7.7.1 Removing the fan", page 32.
- Make sure that each fan is fitted in the correct place (supply air/extract air, and placement order). See fan label (pictured above).
- When connecting pressure sensor hoses, make sure that each hose is correctly connected to the pressure sensor module. The red (pink) hose must be connected to the red connector and the white (translucent) hose to the white connector.
- Ensure that hoses hang freely (not pinched).
- Ensure that hoses cannot be sucked into the fan.

1. Lift the fan onto the unit's rails and slide it to the far end of the unit part. Make sure the fan is turned correctly so that hoses and cables from the pressure sensor module can be connected. If the fan has a sleeve, this must also be inserted into the sleeve rail.
2. Fan without sleeve: Screw on the cover plate.
3. Screw the earthing braid to the unit's rail. If the fan is refitted, use the supplied self-tapping screw.
4. Insert the pins or self-tapping screw through the holes in the rails.
5. Firmly press the temperature sensor into the hole on the fan frame.
6. Screw the quick connectors together. See "7.6 Quick connectors", page 31.
7. Shorten the pressure sensor hoses to the correct length and connect the hoses between the fan and the pressure sensor module. See info box above.
8. Gather the cables together and use cable ties to fasten them to the inner wall of the unit. Ensure that they are not pinched when the inspection door closes.
9. Gather the hoses together and use cable ties to fasten them to the cables. Make sure that they are not pressed together or pinched.
10. Screw on the pressure sensor module with the front facing outwards.

7.7.3 Connect hoses for air flow control

- The image shows the location of the hoses for standard assembly. For custom installation, see the unit's dimension drawings.

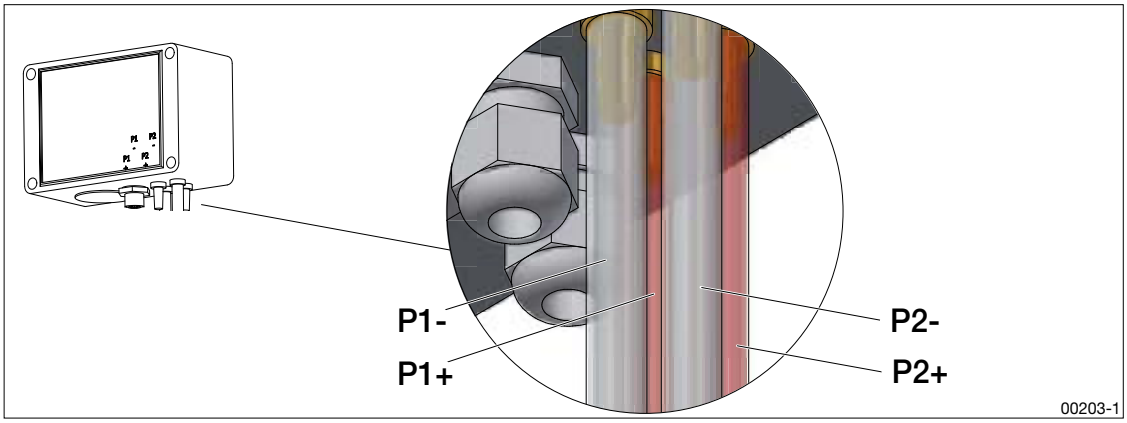


Figure: Hoses for air flow control

P1- Fan cone - Transparent hose

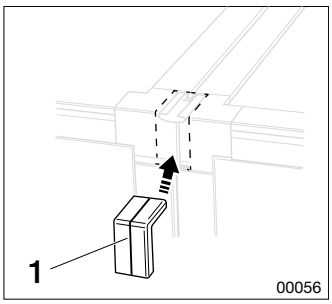
P1+ Fan suction side - Red hose

P2- Filter to fan - Transparent hose

P2+ Filter at intake - Red hose

7.8 Fit cover detail on join

1. When the unit parts are joined together, put the cover detail (1) over the join.



2. Make sure it is properly secured.

8 ASSEMBLY, SECTIONED CONFIGURATION

This section's instructions are complementary to the general instructions in *"7 ASSEMBLY, GENERAL", page 26.* Follow the instructions in both sections.

For parts to be drained, see *"12 CONNECT DRAINAGE, WATER TRAP", page 56*.

For parts that have an electrical connection, see *"11 ASSEMBLE CONTROL EQUIPMENT", page 54*.

WARNING!

Risk of life-threatening or serious crushing or compression injury.

High unit parts, as well as unit parts with a high or offset centre of gravity, mean a greater risk of tipping.

- Follow the lifting and assembly instructions in this manual.
- Use lifting equipment where available.
- Use appropriate protective equipment.
- Exercise caution when working between unit parts.
- Exercise caution when placing unit parts on the support.
- Use the support to secure the parts against possible tipping risk.

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8.1 Assemble control cabinet

CAUTION!

Risk of damage to the product.

The disassembled control cabinet can be damaged if it falls. The main switch, under the control cabinet, can be damaged if the control cabinet is placed on a high edge.

- Make sure that the cabinet is held up when the pins are removed. Once the pins are pulled out, the cabinet is completely detached and may fall.
- Always place the disassembled control cabinet with its back down on a flat surface.

00196

In sectioned configuration, the control cabinet is fixed to the unit on a hanging bracket. The control cabinet can be disassembled from the unit.

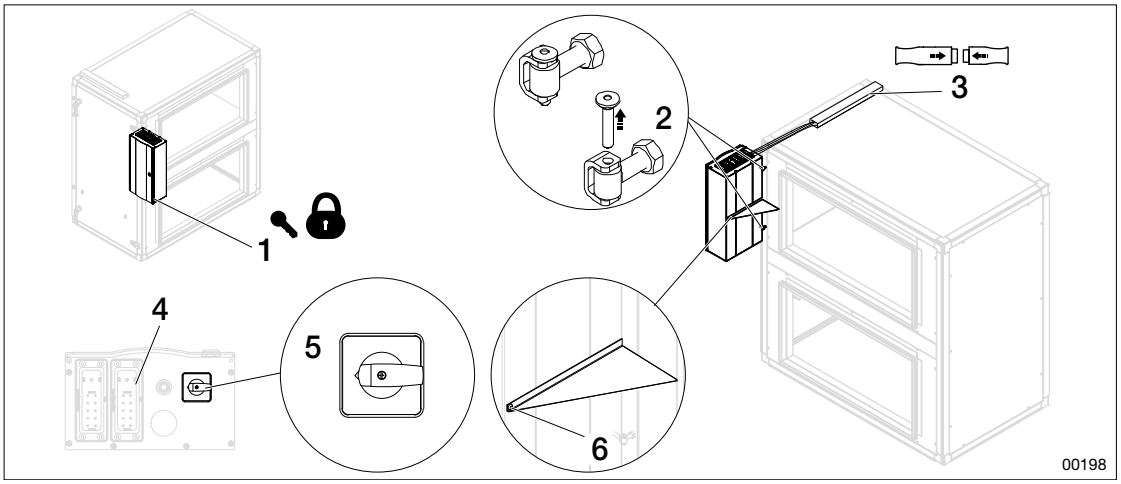


Figure: Control cabinet in sectioned configuration

1. The location of the control cabinet on delivery
2. Hinge
3. Cable strip
4. Control cabinet seen from below
5. Main switch
6. Hanging bracket with bolt in control cabinet

Remove the control cabinet from the unit

1. Lock the control cabinet with keys included.
2. Remove the cover of the cable strip on top of the unit and disconnect all the quick connectors between the control cabinet and the unit part.
3. Unscrew and lift off the bolt on the hanging bracket.
4. From below, with a rubber mallet: knock the pins in the two hinges upwards and pick out the pins. Make sure to support the control cabinet during the process.
5. Lift the control cabinet straight out from the hinges.
6. Place the control cabinet with its back down on a flat surface. Be careful with the loose hoses and cables hanging out from the control cabinet.

Reassemble the control cabinet

Follow the instruction for removal in reverse order. Be sure not to squeeze any cables or knock out hoses when handling.

8.2 Assemble fan and filter (ENF)

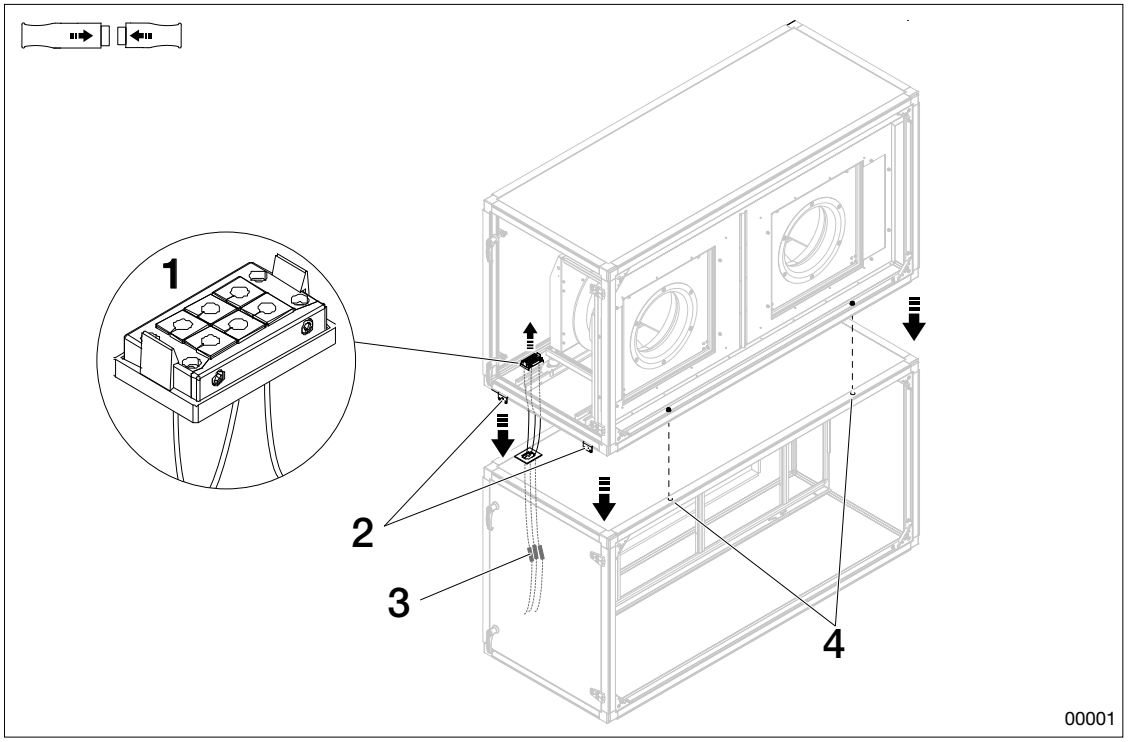


Figure: Fan and filter part (ENF)

1. Cable entry fan part
2. Fixing in middle profile
3. Quick connectors
4. Screws in middle profile

Take apart the assembled fan and filter part

1. Loosen fixings and screws from the middle profiles.
2. Divide cables at the quick connectors in the bottom part. See *"7.6 Quick connectors", page 31.*
3. Loosen the cable entry at the snap lock and pull it out completely, upwards, without disconnecting the cables from the cable entry.
4. Lift off the top part without damaging the sealing strip around the cable entry.

Fit the fan and filter part together

1. Lift up the lower part onto the support.
2. Lift up the top part onto the lower part without damaging the sealing strip.
3. Tighten fasteners and screws in the middle profiles.
4. Run the cables through the hole between the parts and snap the cable entry in place with the snap lock.
5. Connect the quick connectors. See *"7.6 Quick connectors", page 31.*

8.3 Assemble counter-flow heat exchanger (EXM)

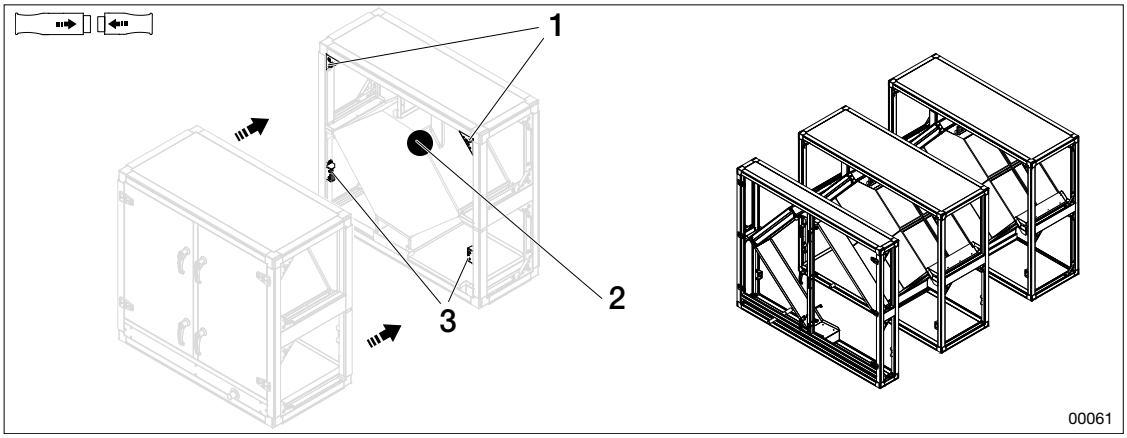


Figure: Counter-flow heat exchanger, sectioned configuration

1. Corner strut
2. Approximate location of quick connector
3. Joint fixings

Disassemble counter-flow exchanger

1. Separate quick connectors for damper motors (one on the two-part version and two on the three-part version). See *"7.6 Quick connectors", page 31.*
2. Loosen hoses.
3. Loosen and remove bolts and screws in corner struts and joint fixings.
4. For the three-part version: Cut away the putty in the joints that is affected by the dismantling.
5. Pull the parts apart without damaging the sealing strip between the parts.

Assemble counter-flow exchanger.

1. Slide the parts together without damaging the sealing strip.
2. Screw the parts together on the corner struts and joint fixings.
3. For the three-part version: Add new putty in those joints where the putty was cut away when dismantling.
4. Refit the hoses.
5. Put together quick connectors for damper motors. See *"7.6 Quick connectors", page 31.*
6. Connect drainage.

8.4 Assemble rotary heat exchanger (EXR)

WARNING!
Risk of cuts and crushing injuries
Sharp edges on the thermal wheel casing can cause hand injuries.

- Wear appropriate protective equipment, such as gloves.
- Be careful when handling the thermal wheel casing and make sure that no hands or fingers get stuck between the parts.
- Lift and hold by the framework, not any other parts.

00207

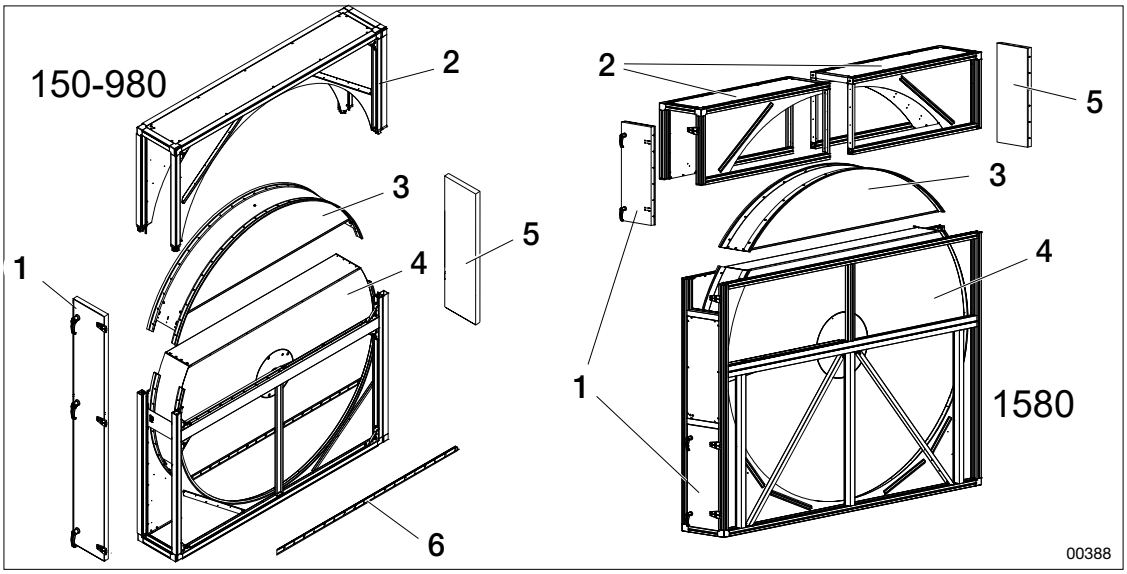


Figure: The parts of the thermal wheel

1. Inspection door
2. Upper part of casing Size 1580 is in 2 pieces.
3. Upper part of thermal wheel
4. Lower part of thermal wheel
5. Cover hatch back
6. Jointing strip

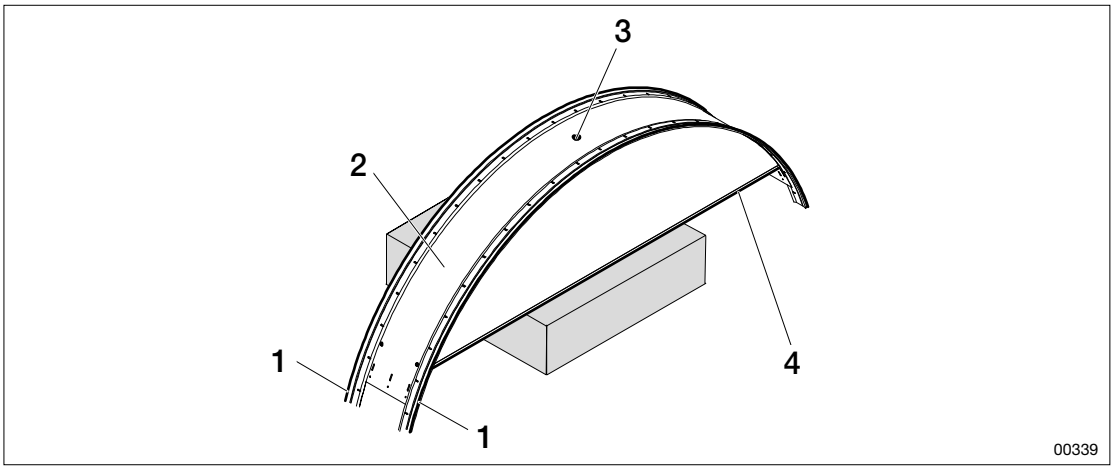


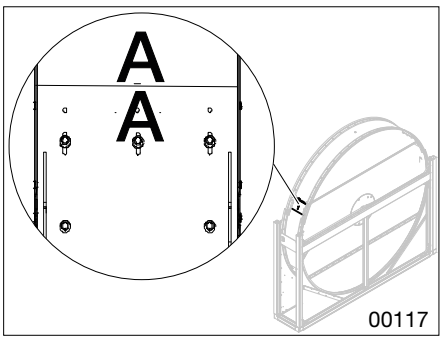
Figure: Upper part of thermal wheel

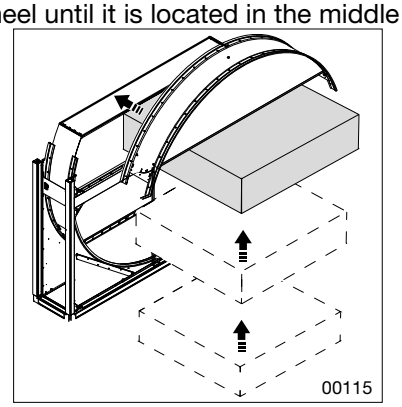
1. Brush strip
2. Shell
3. Hole for mounting lifting lug
4. Straight sheet underneath

- The top of the thermal wheel must not be lifted into or put onto the shell.
- Remove the lifting lug immediately after use.
- Use attached self-tapping screws when joining.
- The rotary heat exchanger must be fully assembled before being placed on the support.
- See also *"7 ASSEMBLY, GENERAL", page 26.*

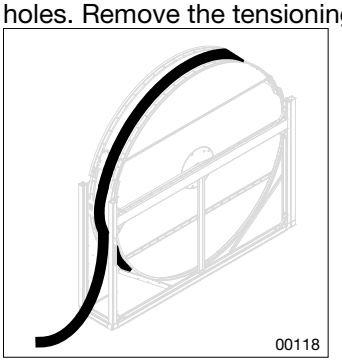
8.4.1 Thermal wheel sizes 150-980

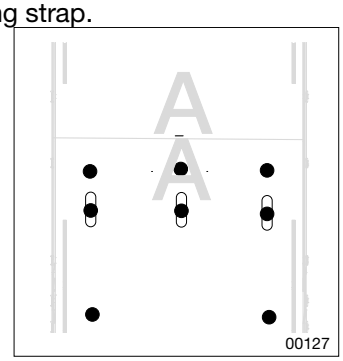
1. Place the upper part of the thermal wheel on the pallet, so that it rests on the lower, straight sheet. Before lifting, make sure the A mark is in the same direction as the A mark on the lower part of the thermal wheel. Lift with forklift truck under the straight plate or use mounted lifting lug. Lift up the upper part of the thermal wheel level with the flat surface on top of the lower part of the thermal wheel and push the upper part of the thermal wheel onto the lower part of the thermal wheel until it is located in the middle of it.



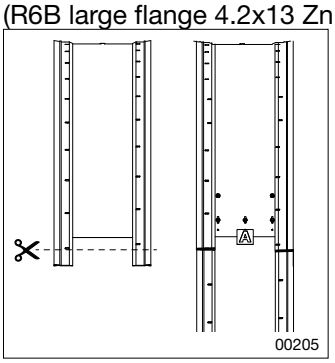


2. Place a tensioning strap around the thermal wheel and tighten. Assemble the shell at the joints (letter markings) with self-tapping screws (JT2 5.5x35) in both oval holes and round holes. Remove the tensioning strap.

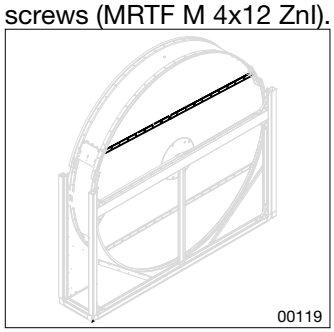




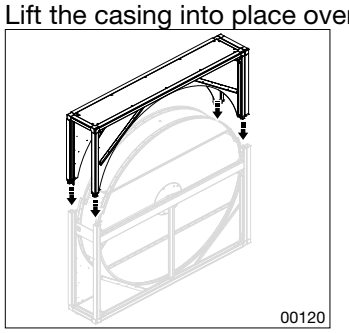
3. Cut off the bristle strip on the top of the thermal wheel so that the edges are tight against the edge of the lower part. Screw on the bristle strip at the joint using self-tapping screw (R6B large flange 4.2x13 ZnNi).



4. Place the motor belt around the thermal wheel.
5. Screw on the jointing strips, one on each side of the thermal wheel, with self-tapping screws (MRTF M 4x12 Znl). When reassembling, all screw holes must be used.

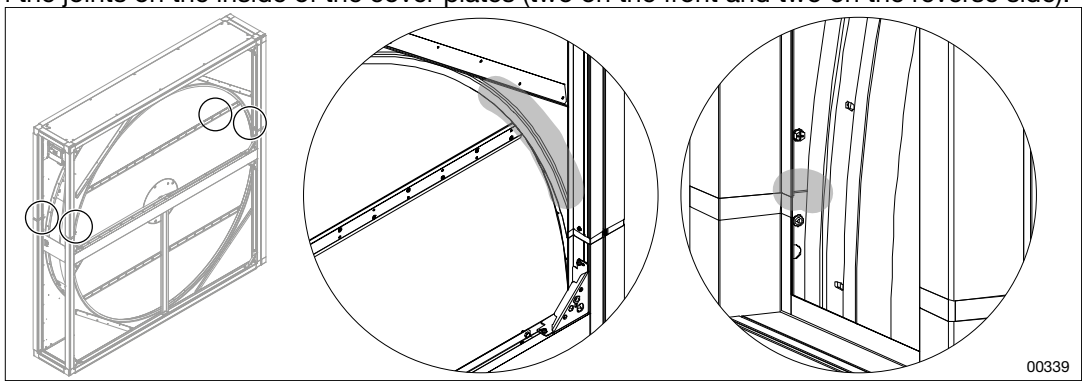


6. Lift the casing into place over the thermal wheel and down into the bottom frame.



7. On the inspection side, cut off the sealing strip on the upper part of the thermal wheel so that the cut edge meets the edge of the sealing strip of the lower part. Attach the strip.
8. Apply sealant:

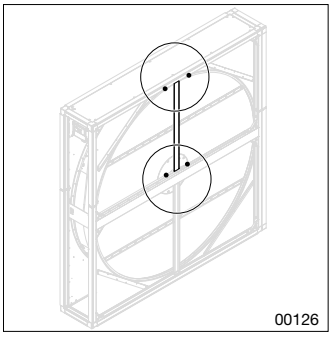
- in the joint on the inside of the thermal wheel, between the bristle strip and the thermal wheel (two at the front and two on the reverse side).
- in the joints on the inside of the cover plates (two on the front and two on the reverse side).



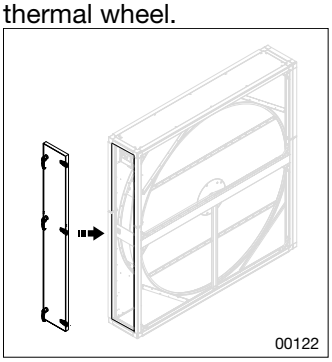
9. Unscrew both transport safety devices, marked with yellow stickers.

10. Screw the cover hatch onto the reverse side of the thermal wheel using self-tapping screws (DK 4.2x14 PH2 Znl).
11. **Sizes 740-980:** Also mount a cover hatch to the inspection side of the thermal wheel.
12. Fit cover plugs over the screw holes.

13. **Sizes 740-980:** Assemble a centre post in the upper part of the thermal wheel, on both sides of the thermal wheel. Screw the centre post into in the pre-drilled holes using self-tapping screws (DK 4.2x14 PH2 ZnI).



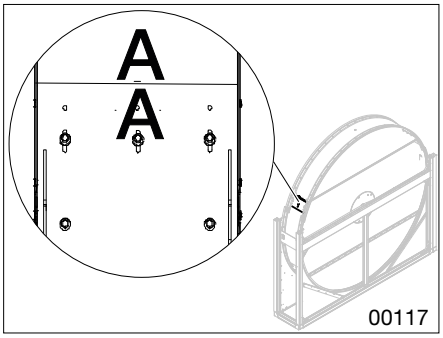
14. **Sizes 150-600:** Screw the inspection door onto the hinges, on the inspection side of the thermal wheel.

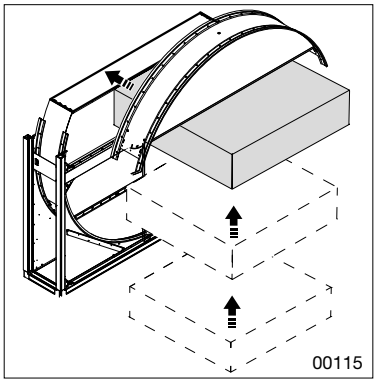


15. Slide the thermal wheel onto the support and slide together with the connecting part.

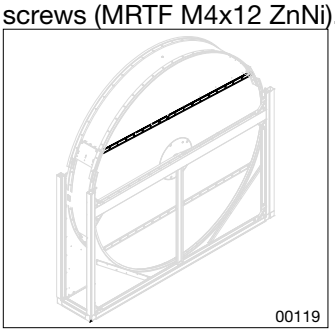
8.4.2 Thermal wheel size 1580

1. Place the upper part of the thermal wheel on the pallet, so that it rests on the lower, straight sheet. Before lifting, make sure the A mark is in the same direction as the A mark on the lower part of the thermal wheel. Lift with forklift truck under the straight plate or use mounted lifting lug. Lift up the upper part of the thermal wheel level with the flat surface on top of the lower part of the thermal wheel and push the upper part of the thermal wheel onto the lower part of the thermal wheel until it is located in the middle of it.



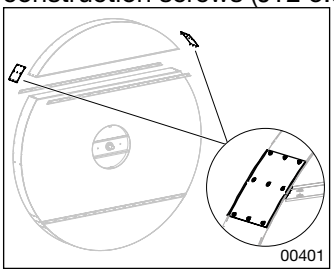


2. Screw on the jointing strips, one on each side of the thermal wheel, with self-tapping screws (MRTF M4x12 ZnNi).

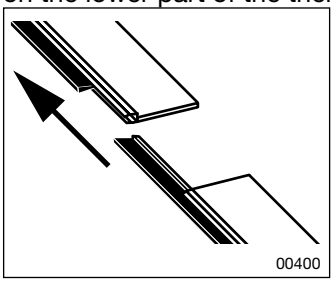


3. Unscrew both transport safety devices, marked with yellow stickers.

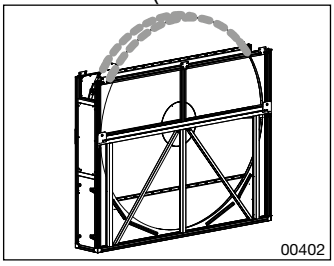
4. Screw the joint plates on the thermal wheel into the joint between the thermal wheel sections. Turn the plate so that it is centred over the joint, fastened with self-tapping construction screws (JT2 5.5x35).



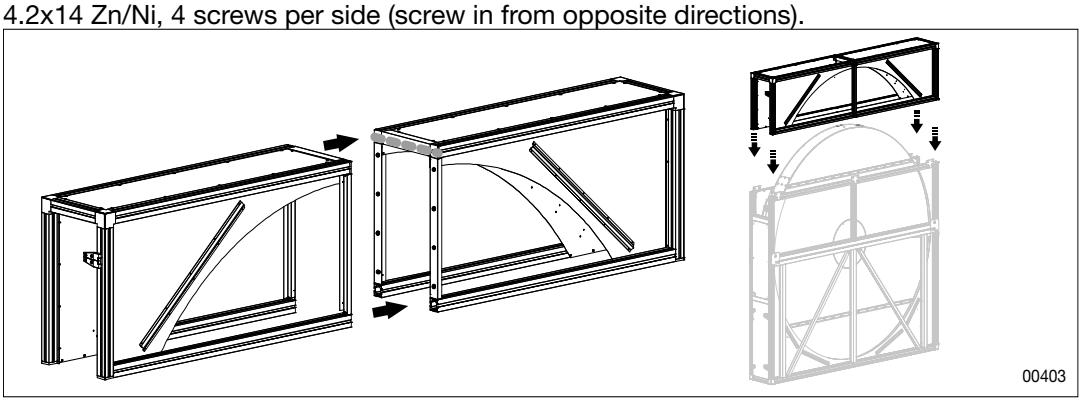
5. Fit the packaged brush strip to the upper part of the thermal wheel using R6B large flange screws (4.2x13 ZnNi). Adjust the brush in the brush strip holder so that it overlaps approximately 150 mm into the next brush strip holder and into the pre-fitted brush strip holders on the lower part of the thermal wheel.



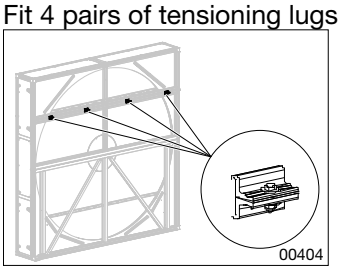
6. Seal between the thermal wheel sides and along the attached brush strip, around the entire frame (both sides of the thermal wheel).



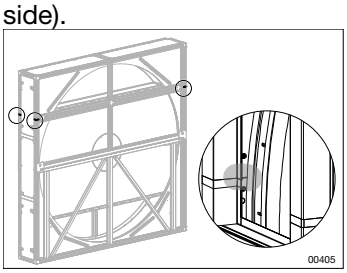
7. Lift up and insert the upper parts of the cover. Seal between the horizontal profiles before joining the parts. Screw the parts together via the vertical plate profiles. Use screw DK 4.2x14 Zn/Ni, 4 screws per side (screw in from opposite directions).



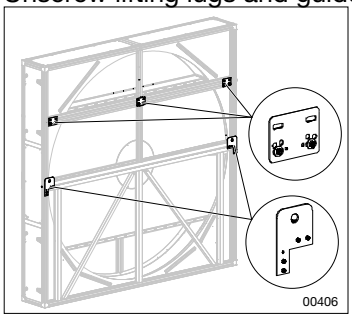
8. Fit 4 pairs of tensioning lugs per side. See "7.5.2 Join with tensioning lugs", page 30



9. Seal in the joints on the inside of the cover plates (two on the front and two on the reverse side).



10. Unscrew lifting lugs and guide plates.



11. Fit the cover hatch on the reverse side, use screw DK 4.2x14 Zn/Ni.
12. Fit cover plugs over the screw holes.
13. On the inspection side, cut off the sealing strip on the upper part of the thermal wheel so that the cut edge meets the edge of the sealing strip of the lower part. Attach the strip. See "7.4 Assemble sealing strip", page 29.
14. Assemble the inspection door.
15. Fit motor belt (v-belt). Refer to Operation and Maintenance of the unit.

8.5 Assemble cooling unit EcoCooler (ECO/ECX), ThermoCooler HP

For general instructions, also refer to "7 ASSEMBLY, GENERAL", page 26.

- On the part towards the rotary heat exchanger, sealing strips should also be fitted on the upper edge of the profile to ensure tightness.

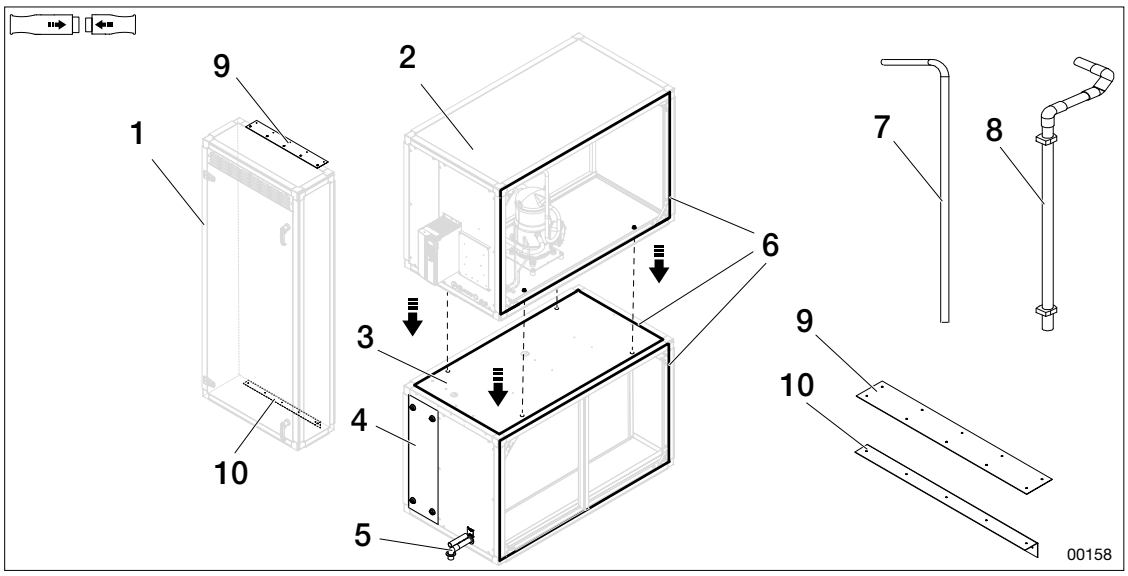
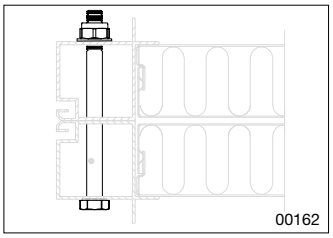


Figure: Cooling unit parts

1. Media section
2. Unit part - compressor/coil
3. Unit part - coil
4. Coil hatch
5. Drainage pipe
6. Sealing strip
7. Joint pipe
8. Drainage pipe
9. Sheet metal strip upper part
10. Sheet metal strip lower part

1. Fit sealing strip on the outer side of the upper and lower unit parts, as well as in the middle level. See "7.4 Assemble sealing strip", page 29.
2. Push the lower part up onto the support.
3. Lift and place the upper part on top of the lower part.
4. Join the upper and lower parts using the included screws M6S 10x120 FZB, washers SRB 11x22x2 FZ and lock nuts M10 FZ.



5. Slide the parts together with the rotary heat exchanger.
6. Join the unit parts together with screw joints or guide pins. See "7.5 Join the parts together", page 30. If screw joints are used, the trim heater (coil) must be lifted out to make room to screw inside. See "8.5.2 Disassemble trim heater/coil", page 46.

7. Unscrew the transport safety devices from the compressor part (marked with stickers).

8. Screw the media cabinet sheet metal strips onto the unit parts with the self-tapping screws in the connecting profile. If the strips are not pre-assembled, see *"8.5.1 Assemble the media cabinet sheet metal strips", page 46.*

8.5.1 Assemble the media cabinet sheet metal strips

1. Mount the upper sheet metal strip on the upper side of the media cabinet, using self-tapping screws.
2. Mount the lower sheet metal strip on the lower side of the media cabinet, using self-tapping screws.

8.5.2 Disassemble trim heater/coil

1. Open the hatch in front of the coil with the four levers on the hatch.
2. Disconnect the two quick connectors under the coil (inside the unit part), without disconnecting any cables from the coil. See *"7.6 Quick connectors", page 31.*
3. Pull away the two pins on the rails that the coil hangs in.
4. Carefully pull out the coil without letting it fall at the end of the rails. This is easier to do with two people.

8.5.3 Reassemble trim heater/coil

1. Open the hatch in front of the coil with the four levers on the hatch.
2. Hang up the battery on the rails and push it back into the unit part.
3. Reinsert the pins.
4. Connect the quick connectors. See *"7.6 Quick connectors", page 31.*
5. Close the hatch.

8.6 Assemble mixing section (EEC), media section (EMR)

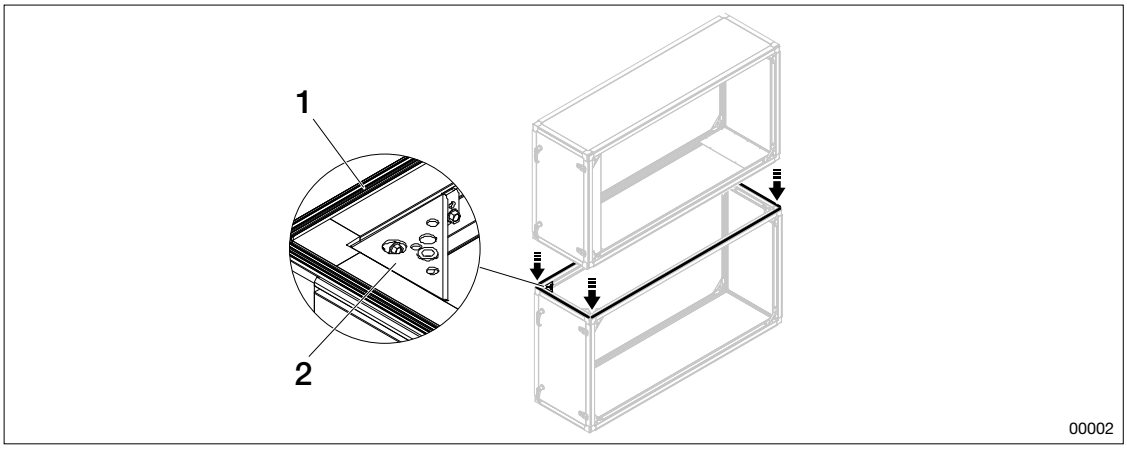


Figure: Mixing section, sectioned configuration

1. Sealing strip
2. Corner strut

1. Assemble sealing strip on the lower part.
2. Screw the upper section to the lower section in all corner struts.

8.7 Assemble smoke gas connection (EKR)

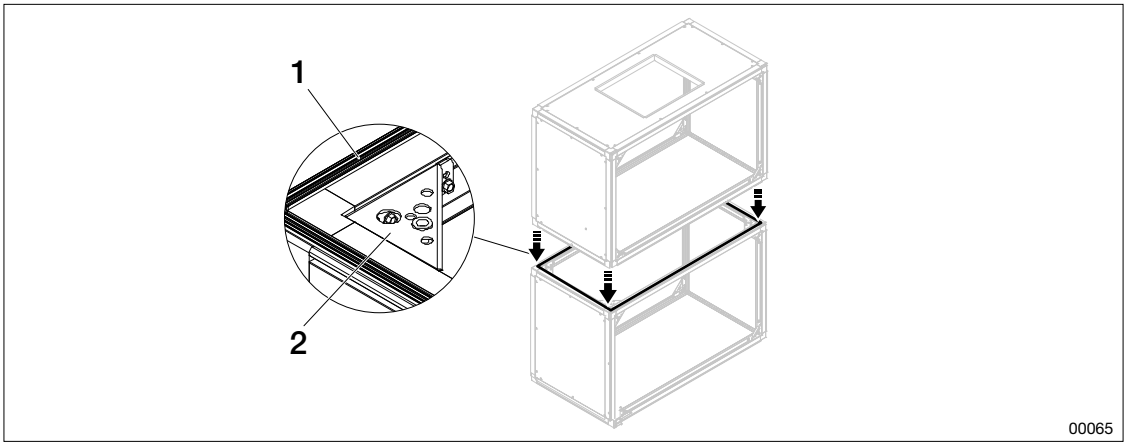


Figure: Smoke gas connection, sectioned configuration

1. Sealing strip
2. Corner strut

1. Assemble sealing strip on the lower part.
2. Screw the upper section to the lower section from below in all corner struts. Use bolts up into the intermediate level plate, which is equipped with built-in fixing nuts.

8.8 Assemble cross-flow section (ERX/EKX)

For general instructions, also refer to *"7 ASSEMBLY, GENERAL", page 26.*

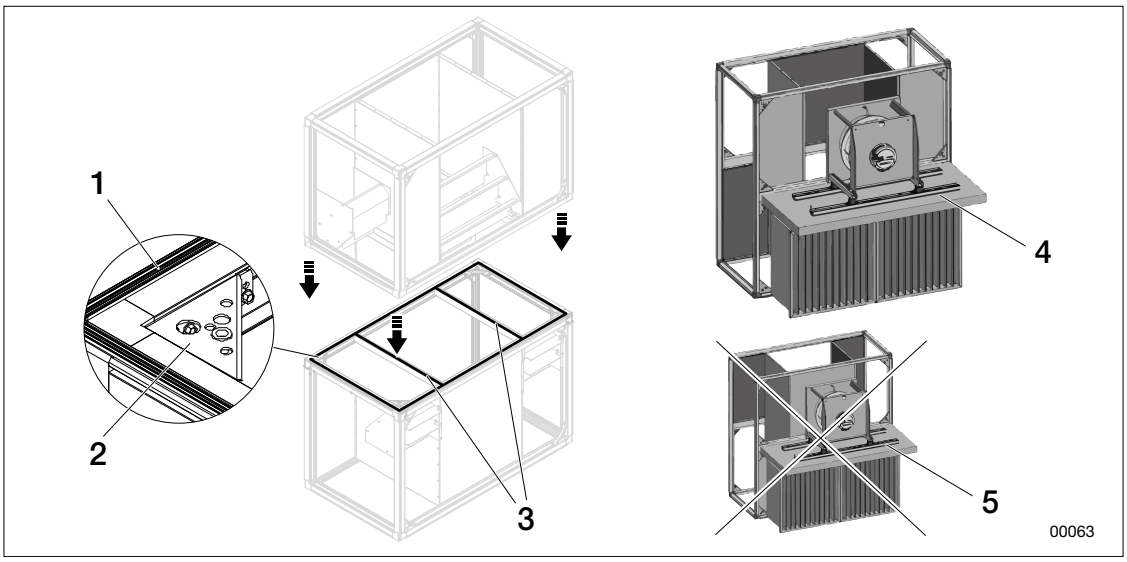


Figure: Cross-flow section, sectioned configuration

1. Sealing strip
2. Corner strut
3. Sealing strips on cross brace
4. Cross-flow section, correctly positioned towards the fan and filter section.
5. Cross-flow section, incorrectly positioned towards the fan and filter section

1. Assemble sealing strip on the lower part, at the outer edges and on the cross braces.
2. Screw the upper section to the lower section in all corner struts.

8.9 Assemble coil recovery (EXL)

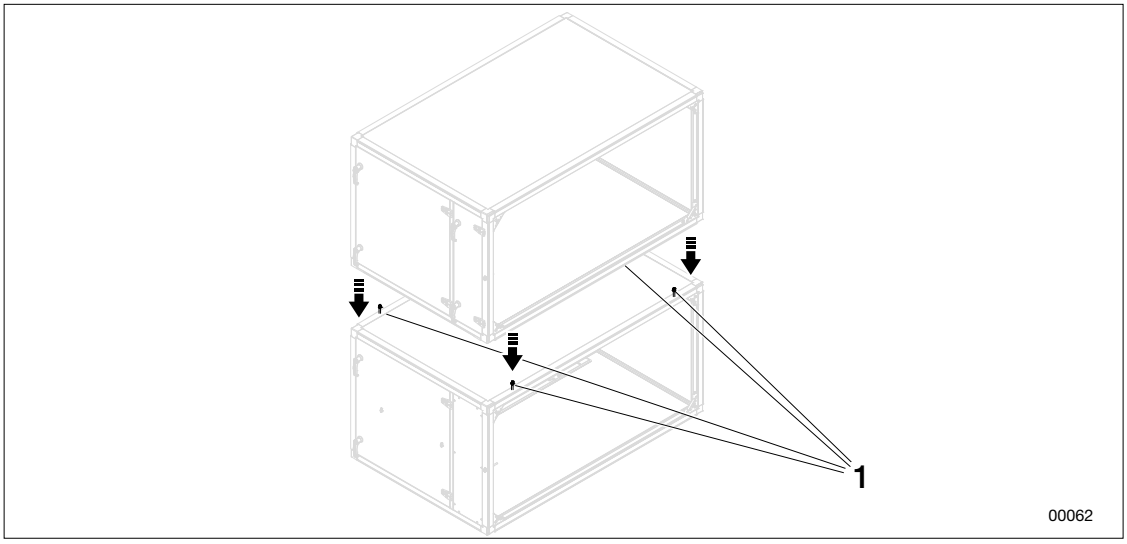


Figure: Coil recovery, sectioned configuration

1. Screws

1. Put the lower part onto the support.
2. Lift up the upper part on top of the lower.
3. Screw the parts together with the screws on the long side.

9 CONNECT COIL, WATER

9.1 Connect coil to pipelines

- In order not to damage the coil, always use a counterhold when connecting.
- Ensure that connecting pipes (including insulation) do not block inspection hatches.

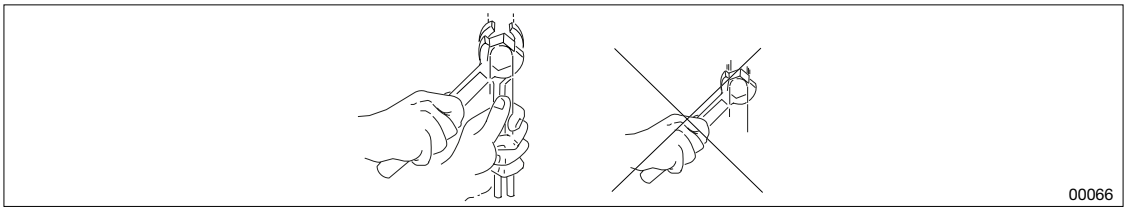


Figure: Pipe connection counterhold

9.2 Connect heating coil

1. Connect coil to pipeline.
2. Connect frost protection on heating coil.
3. Connect pipes for exhaust air and drainage.

9.2.1 Heating coil (ELEV) in unit, (EMT) in duct

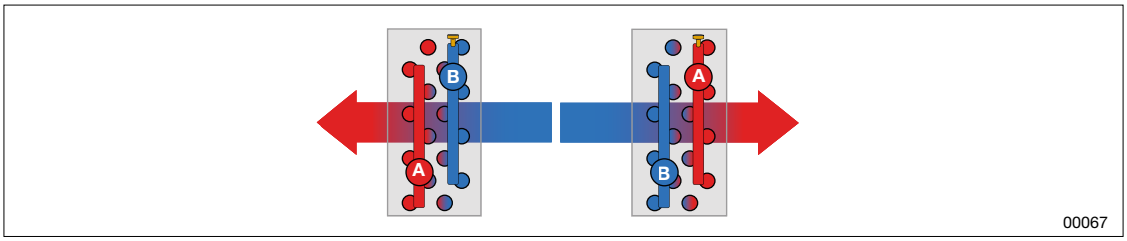


Figure: Connection pipe, heating coil (ELEV, EMT-VV)

A. Fluid in
B. Fluid out

The heating coil must be fitted with frost protection of the clamp on or immersion sensor type.

The heating coil is reversible to suit air from the right or left. Ensure that the coil is turned so that there is a counter-flow direction between air and liquid flow.

Thermoguard coils:

- marked with inlet and outlet on the fluid side, as well as air direction.
- delivered, as standard, for vertical assembly (horizontal air stream).
- must always have the possibility of pressure relief via the coil return line out to the expansion vessel, regardless of whether the control valve is open or closed. This applies to all kinds of control valves, shunt couplings and the like.

9.3 Connect cooling coil

1. Connect coil to pipeline.
2. Connect drainage. See *"12 CONNECT DRAINAGE, WATER TRAP", page 56.*
3. Connect pipes for exhaust air and drainage.

9.3.1 Cooling coil (ELBC) in unit, (ESET-VK) in duct

Cooling coil must be connected for horizontal air stream. For duct assembly, see *"13 DUCT CONNECTION, DUCT ACCESSORIES", page 57.*

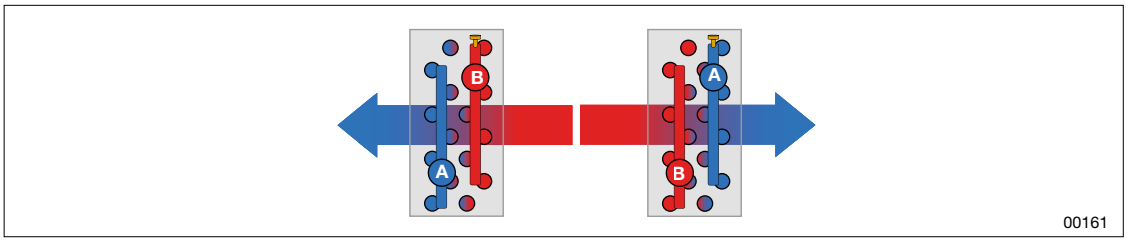


Figure: Connection pipe, cooling coil (ELBC, ESET-VK)

A. Fluid in
B. Fluid out

9.4 Connect frost protection sensor

The frost protection sensor is placed at the coldest point of the coil, i.e. on the outgoing fluid assembly tubes.

The frost protection sensor must be connected to prevent ice from forming in the coil pipe lines.

The coil should be turned so that the immersion sensor socket/contact sensor for frost protection ends up on the outgoing fluid side.

9.4.1 Connect immersion sensor

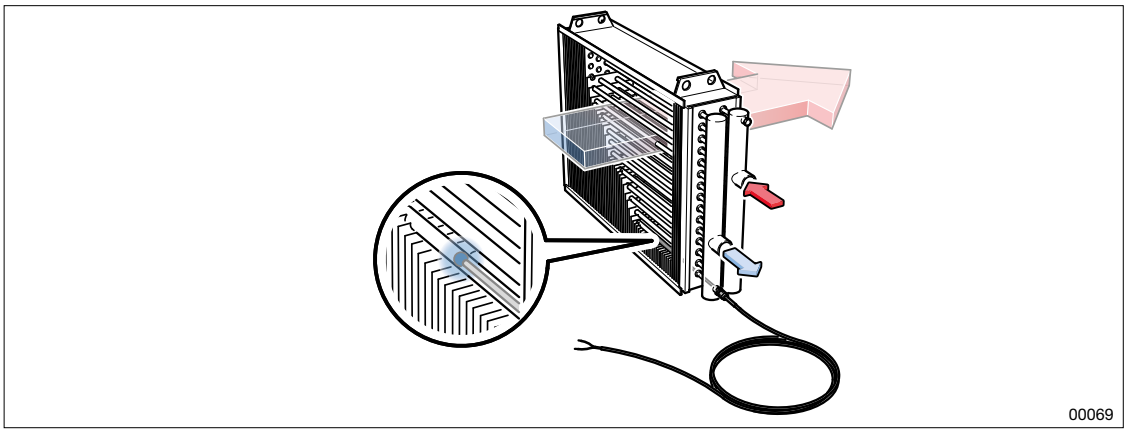


Figure: Coil with header for outgoing fluid with immersion sensor fitted in drainage/bleeding nipple.

Immersion sensor dimensions: diameter 4 mm, insert length maximum 240 mm.

The immersion sensor is placed in the venting nipple (T-pipe can be used to keep the opportunity of venting) or in the drainage/bleeding nipple.

9.4.2 Connect contact sensor

The frost protection sensor is placed at the coldest point of the coil, i.e. on the outgoing fluid assembly tubes.

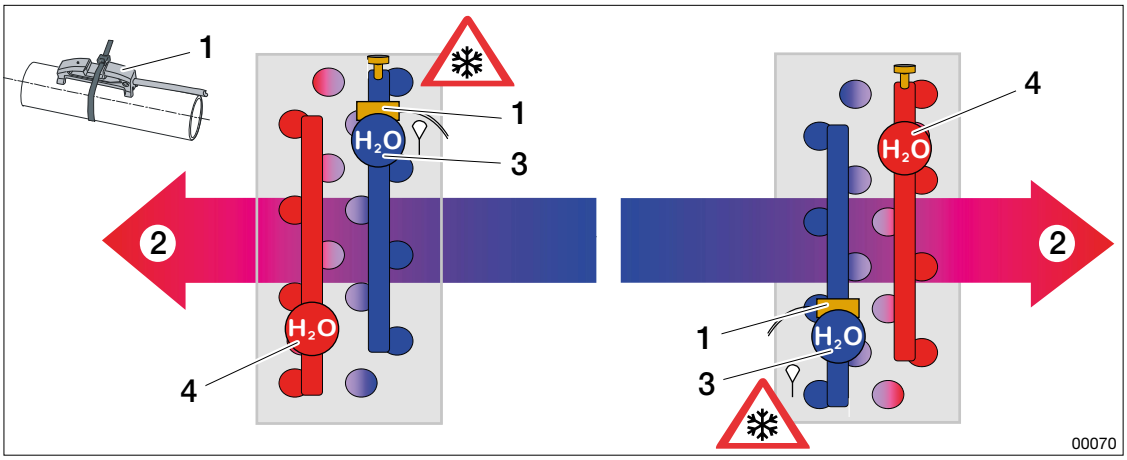


Figure: Clamp on detector

1. Clamp on detector
2. Air direction
3. Incoming fluid
4. Outgoing fluid

9.5 Connect pipes for exhaust air and drainage

The connection pipe must be equipped with exhaust air at the highest point and drainage at the lowest point.

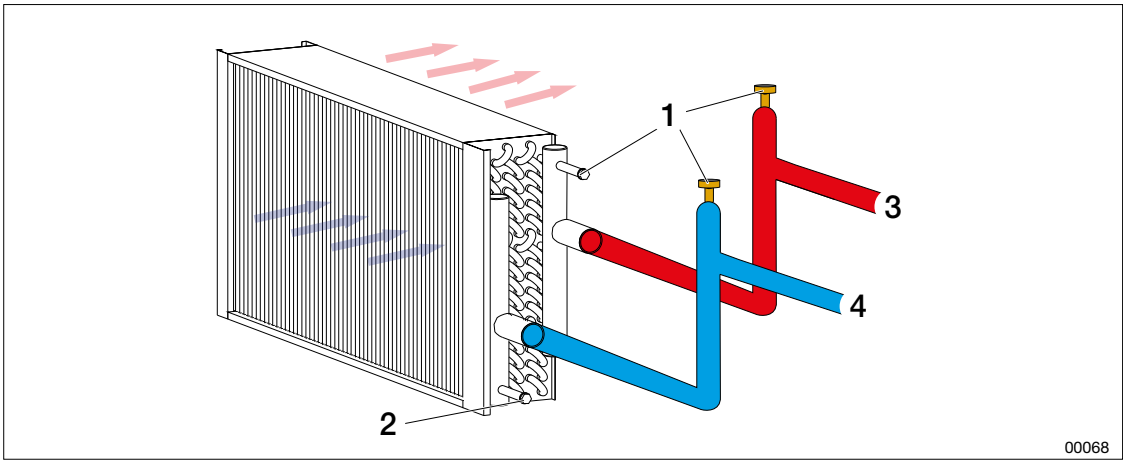


Figure: Bleeding and drainage

1. Nipple for bleeding
2. Nipple for drainage
3. Connected pipe
4. Connected pipe

9.6 Assemble valve actuator

Assembly must be carried out according to the accompanying instructions from IV Produkt's supplier. See order-specific documentation onIV Produkt's order portal.

The control valve (shunt valve), which regulates water temperature to heating or cooling systems is operated by a valve actuator attached to a control unit. The valve may be of two- or three-way type depending on the connected heating source.

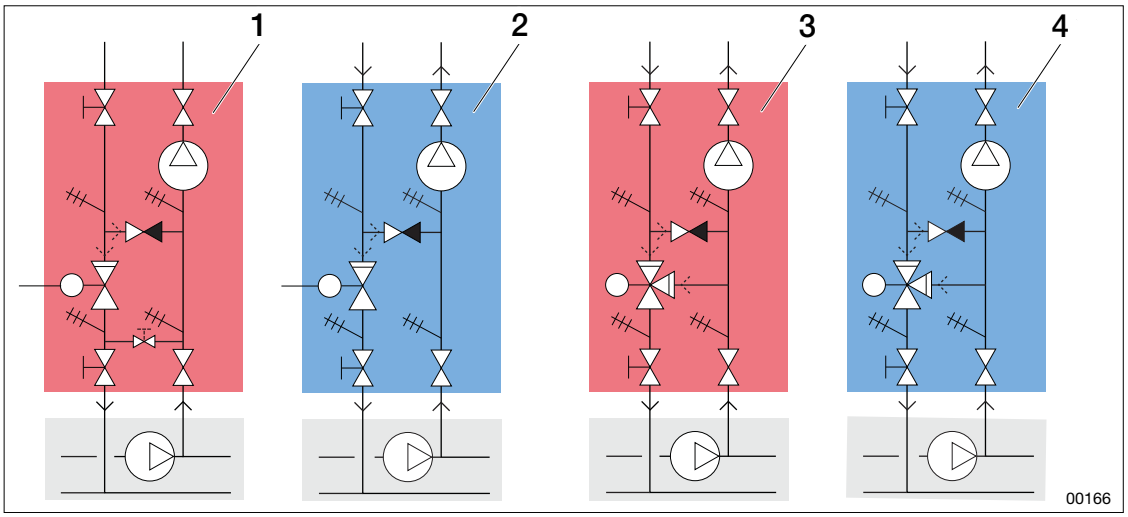


Figure: Control valve in different configurations

1. District heating - two-way valve
2. District cooling - two-way valve
3. Own heating source - three-way valve
4. Own cooling plant - three-way valve

9.7 Assemble pump, pipework package

The pump is only included in the IV Produkt accessory: Pipework package. For information and installation, see separate product sheet on IV Produkt's order portal. Other pumps are provided by the customer, the installation of which is the customer's responsibility.

10 ASSEMBLE COIL, ELECTRIC

10.1 Assemble air heater electric (ESET-EV), (ELEE), trim heater (ECXT-EV), (TCHT-EV)

WARNING!
Risk of life-threatening or serious personal injury.
Electrical voltage can cause electric shock, burns and death. The product must not be energised during assembly.

- Electrical connection and electrical work may only be carried out by a qualified electrician.
- For initial start-up of the unit, see Operation and Maintenance of the unit on IV Produkt's Order portal.

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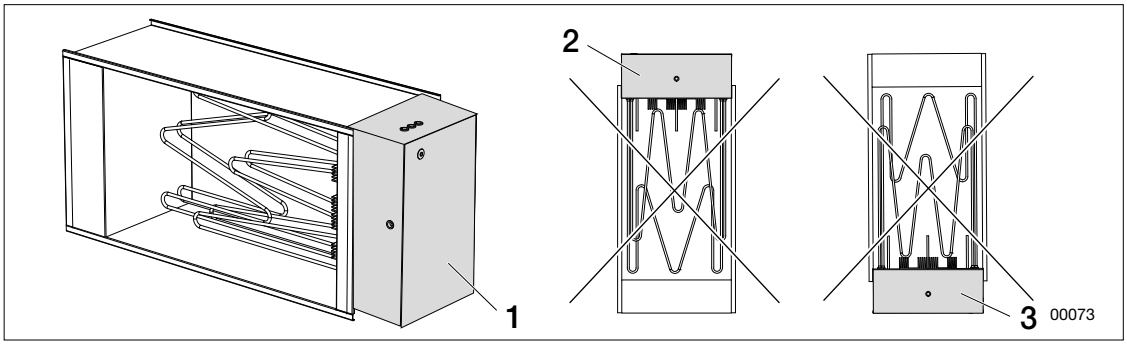

Figure: Air heater electric

1. Cover for connection box
2. Connection box - not to be mounted upwards
3. Connection box - not to be mounted downwards

The distance from the sheet metal casing of the air heater to wood or other combustible material must be 100 mm or more.

10.1.1 Heating coil, electric (ESET-VK) in duct

The air heater is adapted for assembly in duct systems and requires separate connection. The air flow direction through the air heater must correspond with the direction arrow on the air heater.

The heater can be assembled in horizontal or vertical ducts with the connection box to the side.

The distance from the air heater to duct elbows, dampers, filters or the like, should be at least the distance corresponding to the diagonal measurement of the heater (from corner to corner in the heater's duct section). If the distance is smaller, the air stream through the heater can become uneven and the overheat protection can be tripped.

The air heater is insulated according to the applicable rules for ventilation ducts/ventilation units and with non-combustible insulating material. The type plate and warning plate must be fully visible and it must be possible to open the cover. The air heater must be accessible for replacement and servicing.

10.1.2 Trim heater, EcoCooler (ECXT-EV), Thermocooler HP (TCHT-EV)

The trim heater is integrated in EcoCooler andThermoCooler HP and is normally already assembled upon delivery. It can be lifted out to facilitate cleaning and maintenance. See instructions in *"8.5.2 Disassemble trim heater/coil", page 46* .

11 ASSEMBLE CONTROL EQUIPMENT

WARNING!
Risk of life-threatening or serious personal injury.
Electrical voltage can cause electric shock, burns and death. The product must not be energised during assembly.

- Electrical connection and electrical work may only be carried out by a qualified electrician.
- For initial start-up of the unit, see Operation and Maintenance of the unit on IV Produkt's Order portal.

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If the unit is supplied with control equipment, obtain order-specific drawings from IV Produkt's order portal. Connection of control equipment (power supply, fuse protection other components, fans etc.) not specified in this section is done by a competent technician as instructed in Operation and Maintenance for the unit.

11.1 Connect quick connectors between unit parts

Interconnect all quick connectors between unit parts. See *"7.6 Quick connectors", page 31*, *"7 ASSEMBLY, GENERAL", page 26* and *"8 ASSEMBLY, SECTIONED CONFIGURATION", page 35*.

11.2 Connect hoses for pressure control

- Location of measuring sockets for pressure control should be at least 1 m from duct connections, so as to avoid disruptive turbulence.
- The image shows the location of the hoses for standard assembly. For custom installation, see the unit's dimension drawings.

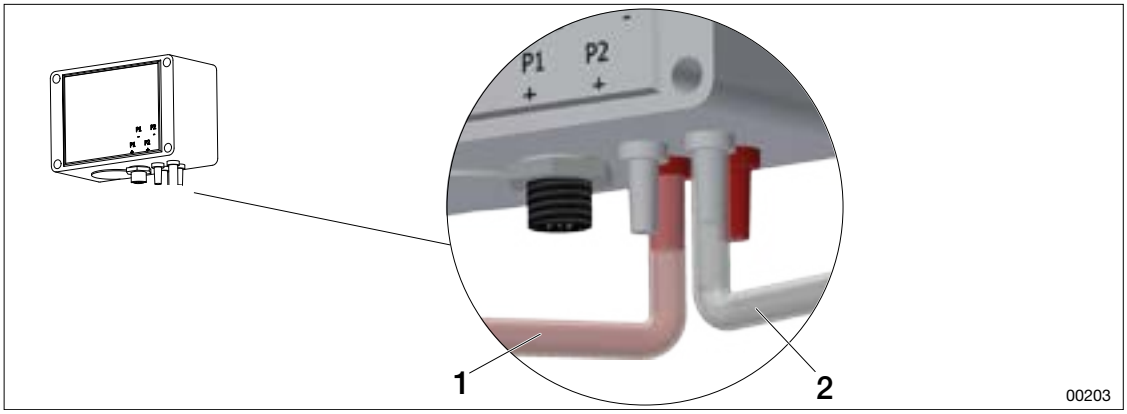


Figure: Hoses for pressure control connected to pressure sensors

- Connect the red hose (1) from the pressure sensor to the supply air duct (red connector).
- Connect the transparent hose (2) from the pressure sensor to the extract air duct (white

connector).

11.3 Connect the supply air temperature sensor

- The supply air temperature sensor must always be placed after any duct coils (heating/cooling).
- The supply air temperature sensor must not be placed in a sound attenuator.

The sensor is connected to the control cabinet before delivery and hangs twisted under the cabinet.

1. After the unit is fitted together: pull the sensor to an appropriate point in the supply air duct.
2. Screw the holder to the sensor, in the duct.
3. Assemble the sensor in the holder.

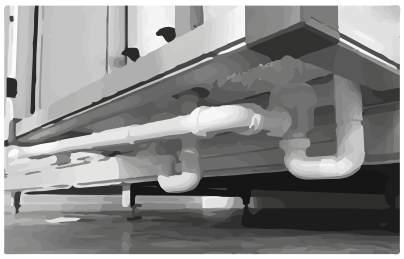
12 CONNECT DRAINAGE, WATER TRAP

- All drainages must be connected to separate water traps, which after these can be connected to a common drain.
- Use separate drainage and water traps for negative pressure and positive pressure.

For instructional videos, see IV Produkt's order portal:

Water trap site-built assembly

Water trap prefabricated MIET-CL-04 assembly.



For Thermocooler HP and EcoCooler size 100-1280:

- On ThermoCooler HP, two individual water traps are assembled.
- On ThermoCooler HP and EcoCooler, drainage connects underneath.

12.1 Connect water trap MIET-CL-04 (accessories)

MIET-CL-04 must not be used with outdoor version, in case of under-pressure. Heating cable pulled through drainage lines and water trap causes the ball not to seal.

Negative pressure (P-) **Overpressure (P+)**

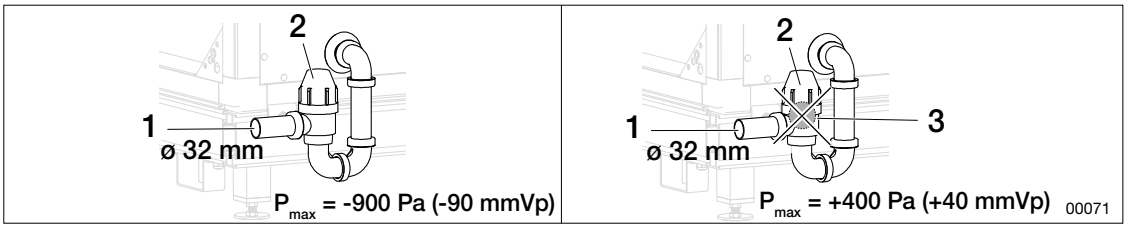


Figure: Water trap (accessory)

1. Outlet (connected to drain)
2. Cup (always mounted upwards)
3. Ball (inside pipe) is removed with overpressure

12.2 Connect water trap (site built)

- Fill the water trap with water before starting the unit.
- For each additional 100 Pa (over 1,000 Pa), H_1 och H_2 must be increased by 10 mm.

Negative pressure (P-) **Overpressure (P+)**

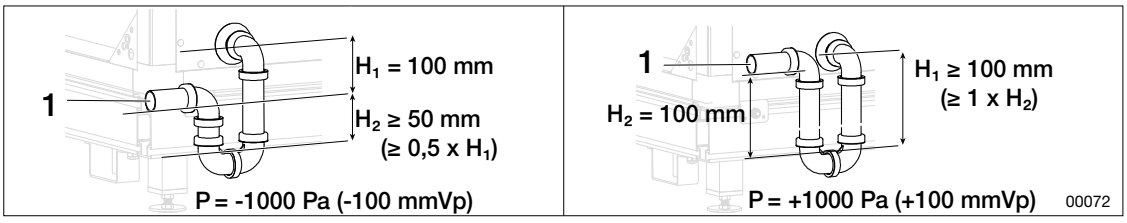


Figure: Water trap (site-built)

1. Outlet (connected to drain)

13 DUCT CONNECTION, DUCT ACCESSORIES

Duct accessories must be placed according to layout drawing. Order-specific dimension drawings can be downloaded from IV Produkt's order portal (Technical Data). See *"2.1 Documentation and support", page 11* and *"2.5 Symbols on dimension drawings and in the manual", page 12.*

13.1 Connect to ducts

The unit is supplied with rectangular connection sleeves.

13.1.1 Connect to rectangular duct

Connection sleeves on rectangular duct connections must be supplemented with sealing strips and connected with guide strips.

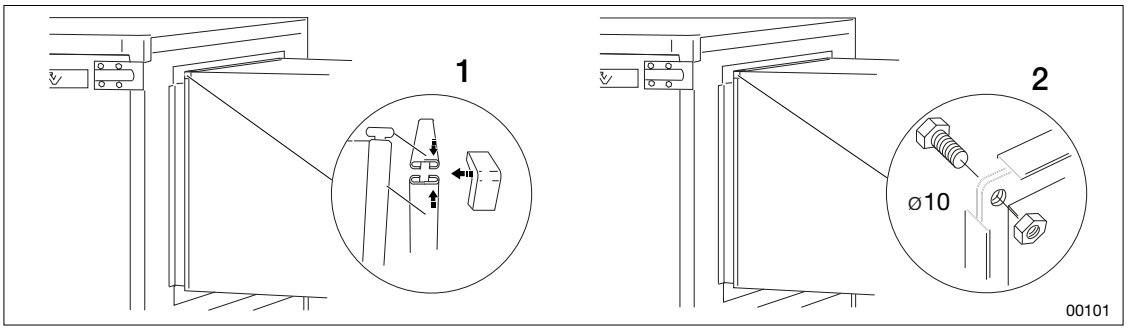


Figure: Rectangular connection sleeve

1. Option 1: The ducts are connected with a gasket, guide pin and outer corner.
2. Option 2: The ducts are connected with screws in the corners of the frame.

13.1.2 Connect to circular duct

Sleeve couplings on circular duct connections are equipped with rubber ring sealing.

13.1.3 Connect sleeve (accessories)

If the duct sleeves are connected for dampening vibrations, the duct insulation must be fitted over the entire connection.

13.2 Assemble duct coils

The distance after a duct elbow, damper, or similar must be at least three times the duct dimensions to obtain even air distribution. See *"9 CONNECT COIL, WATER", page 49* and *"10 ASSEMBLE COIL, ELECTRIC", page 53*.

The coils have a rectangular connector for the guide system.

13.3 Fit sound attenuator (EMT-02)

The unit is supplied with either a rectangular or circular sound attenuator depending on the chosen size of unit and duct connections.

13.4 Fit shut-off damper (EMT-01), trim damper (ESET-TR)

The damper can be mounted for horizontal or vertical air streams.

14 AFTER ASSEMBLY

14.1 Subsequent inspection and maintenance

EXERCISE CAUTION!

Risk of damage to the product.

Swarf from drilling left behind after assembly can lead to corrosion and rust on the surface layer of the unit.

- Make sure that the surfaces of the unit are clean of swarf.

00195

CAUTION!

Risk of damage to the product.

Corrosive substances and strong cleaning agents can damage the surface layer.

- Never use strong cleaning agents or corrosive substances when cleaning the unit.

00183

Area	Inspection	Notes
Covers	Make sure all covers/hatches are in place.	All sides must have covers/hatches.
Covers	Ensure that inspection hatches do not jam when opening.	Adjust the hinges of the hatch. If that is not enough, adjust with the support feet. After adjusting with support feet, make sure that the unit does not tilt backwards.
The internal surfaces of the unit	Make sure the unit is clean and free of dirt and debris.	Vacuum or brush if necessary. Use a cloth moistened with water.
The internal surfaces of the unit	Make sure the unit has no remaining swarf from drilling.	Vacuum or brush after assembly.
Thermal wheel	Check that the thermal wheel is balanced and correctly positioned on the shaft.	See "*14.2 Check thermal wheel", page 59*.

14.2 Check thermal wheel

EXERCISE CAUTION!

Risk of damage to the product.

Touch and contact may damage the surface layer of the rotary heat exchanger.

- Make sure that the surface does not come in contact with tools or any part of the body.
- When working with the rotary heat exchanger, wear protective gloves. 00270

The thermal wheel is factory adjusted, but may move out of position when handling and assembling the unit. After assembling the unit, check that the thermal wheel is level and correctly positioned inside the frame.

- Thermal wheels in unit sizes less than 400 do not need to be checked.

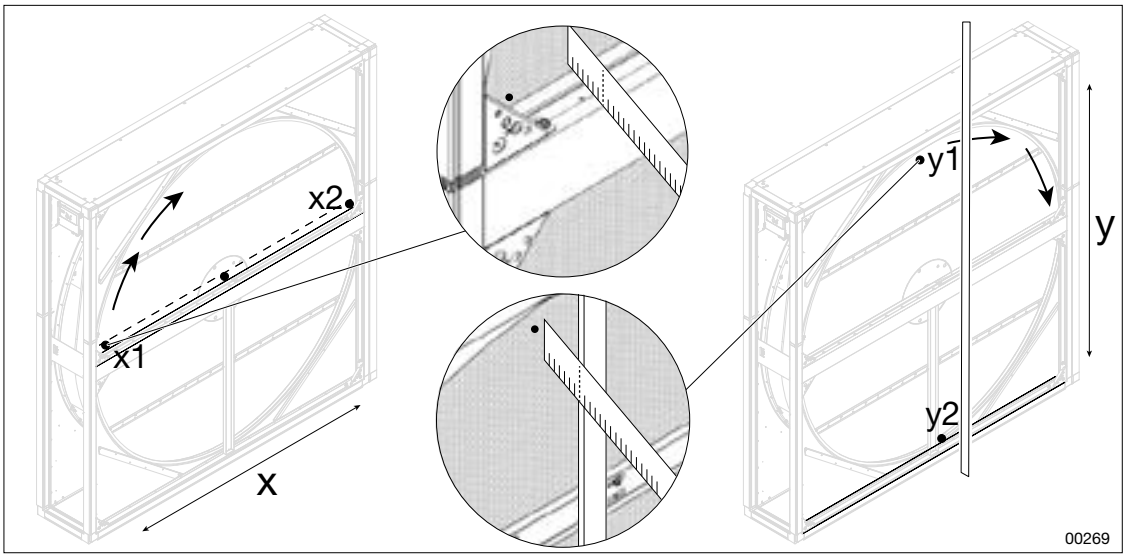


Figure: Checking the thermal wheel's horizontal and vertical positions

14.2.1 Check that the thermal wheel is straight in frame

Horizontal (x)

1. At **x1,** make a light pencil marking on the surface of the thermal wheel.
2. Measure with the mark at **x1**, from the outer edge of the strip to the thermal wheel surface.
3. Spin the thermal wheel and stop when the marking is at **x2**, then measure.
4. Compare the two measured values. They must be the same +/- 1 mm. If the distances are different; adjust the thermal wheel (refer to *"14.3 Adjusting the thermal wheel", page 61*.

Vertical (y)

1. At **y1**, make a light pencil marking on the surface of the thermal wheel.
2. Measure with the mark at **y1**, from the outer edge of the strip to the thermal wheel surface.
3. Spin around the thermal wheel and stop when the marking is at x2, then measure.
4. Compare the two measured values. They must be the same +/- 1 mm. If the distances are different; adjust the thermal wheel.

14.2.2 Check that the thermal wheel is centred in frame.

1. Open the thermal wheel door and visually check that the brush strip is equally vertical on both sides of the thermal wheel. If the thermal wheel is offset to one side, the brush strip will be folded against the thermal wheel surface.
2. On the front and reverse side of the thermal wheel, in the middle of the thermal wheel, measure and compare the measurement to the thermal wheel surface. The values must be the same +/- 1 mm. If the distances are different, adjust the thermal wheel. The nominal measurement from the inside of the centre profile to the thermal wheel surface is 35 mm for all sizes except size 1580, where the measurement must be 65 mm.

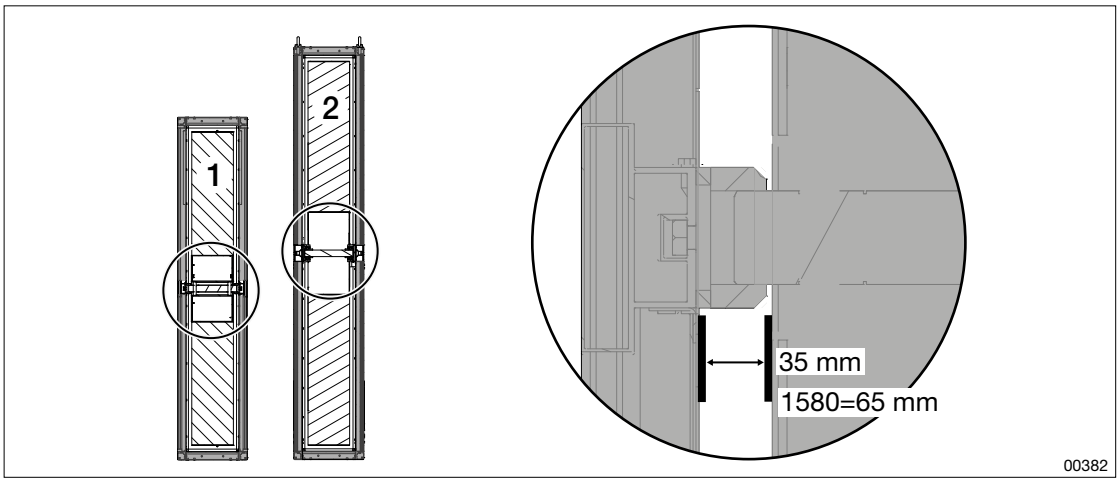


Figure: Thermal wheel in cross section

1. Thermal wheel sizes 060-600
2. Thermal wheel sizes 740-980

14.3 Adjusting the thermal wheel

WARNING!

Risk of serious crushing or compression injury.

If the bearing bolts become fully unscrewed during thermal wheel adjustment, the thermal wheel may detach from its brackets and fall down.

- Thermal wheel adjustment must be performed by technicians with the relevant expertise.
- The adjustment screws must never be fully unscrewed during adjustment.

00376

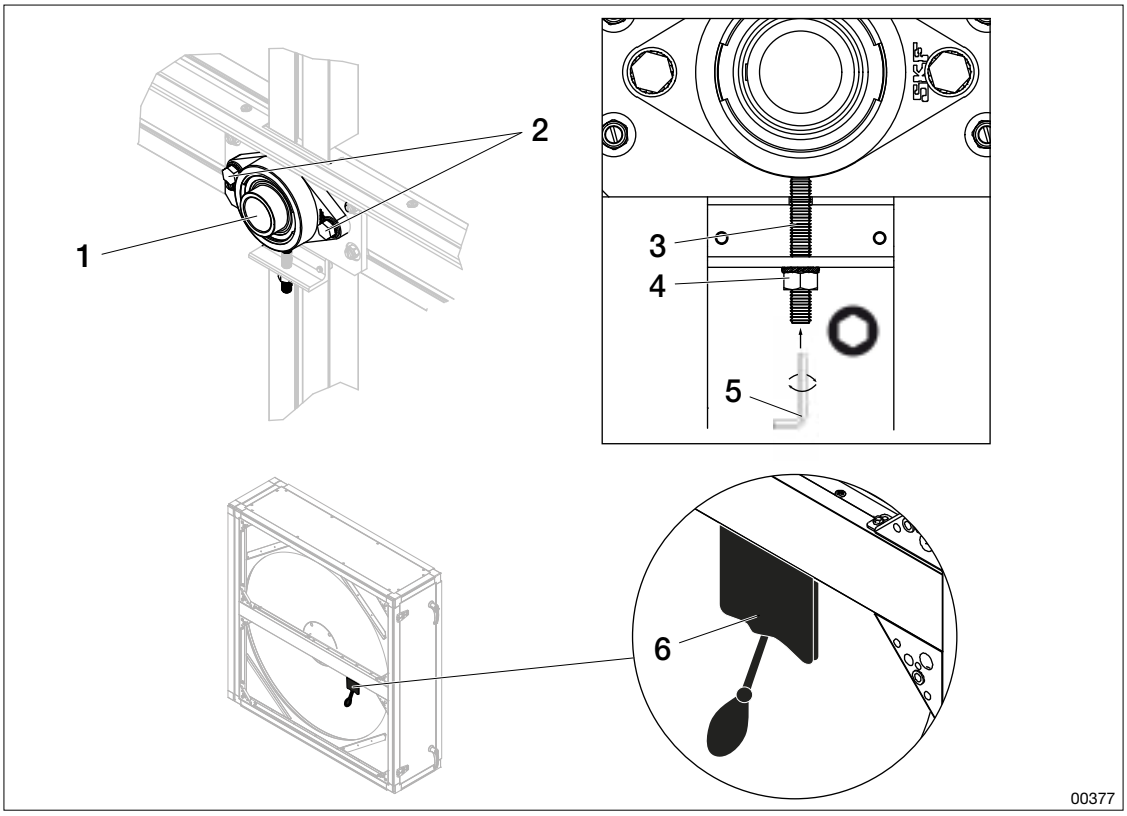


Figure: Shaft retainers on the thermal wheel

1. Shaft retainers
2. Bearing bolts
3. Adjustment screw (for Allen key)
4. Locknut
5. Allen key
6. Inflatable cushion

Horizontal (x)

1. Loosen the bearing bolts on the shaft retainers on both sides of the thermal wheel. Bearing bolts are located behind the brush strip. Screw approximately 0.5-1 turns to loosen. Do not screw out fully.
2. To adjust, manually press the thermal wheel surface at the intermediate plane. Note that the thermal wheel surface is fragile, therefore do not use tools against the thermal wheel surface. Inflatable cushions/frame pads can be used to push the thermal wheel into the correct position. See previous figure *Shaft retainer on thermal wheel*.

Vertical (y)

1. Loosen the bearing bolts on the shaft retainers on both sides of the thermal wheel. Bearing bolts are located behind the strip. Screw approximately 0.5-1 turns to loosen. Do not screw out fully.
2. Move the locknut up or down by using the Allen key to turn the adjustment screw from below. Small adjustments are usually sufficient.
3. Measure to check.
4. When the wheel is correctly positioned, tighten all the bearing bolts on the shaft retainers. Size < 600 — torque 40 Nm, Size ≥ 740 — torque 50 Nm

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