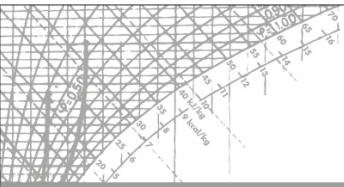


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Disassembling and reassembling of air handling units from IV Produkt.





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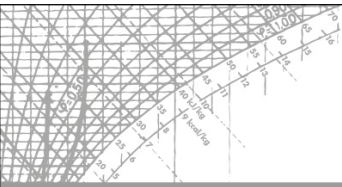
Content

Part 1: Disassembling

Part 2: Reassembling

Part 3: Detailed sealing instructions

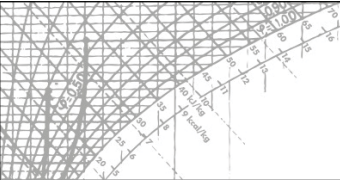




Skapad	Datum	Godkänd	Datum	Ersätter instruktion nr	Sid
PRB	160211	FW	160212		3/24
Instruktion nr	Rev.	Benämning			
IM-0021-SV	00	Demonterbart utförande			



1. Disassembling



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Step 1.1: Photo the various air handling modules



- To facilitate reassembling, you are advised to mark, number and photo the inside and the outside of all modules.

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Step 1.2: Dismounting inspection doors and vertical panels



Screw: MC6S 5x16



Screw: DK 4,2x14 PH2

- Start by dismounting the inspection doors, and thereafter dismount the vertical panels.
- To facilitate reassembling mark each panel with a name or number.

Note: When sealing profiles needs to be cut during dismounting, cut minimum 10 cm from the corner to facilitate re-sealing and avoid any leakage risk.

- Never cut a sealing profile in a corner!

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Step 1.3: Dismounting the interior details

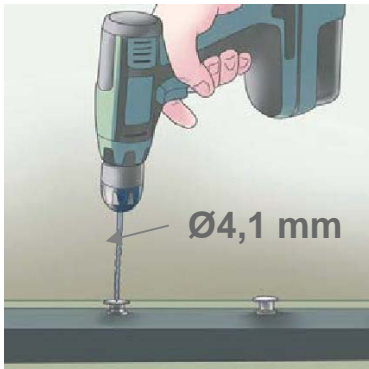


- Dismount interior details carefully not to damage sealing profiles or attachment/connection points etc.
- Sealing's must be cut lose.
- To facilitate reassembling you are strongly advised to mark, number and photo all interior details.
- **Rivet removal, please see next page**

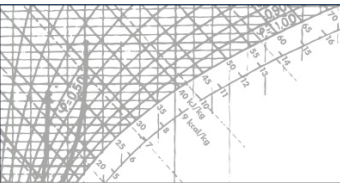
Skapad	Datum	Godkänd	Datum	Ersätter instruktion nr	Sid
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Step 1.4: Removal of rivets



1. When removing rivets, always use a new sharp drill of Ø4,1 mm.
2. Place the drill carefully at the center of the rivet.
3. Work with low revolutions, approx. 700 rpm, and wobble the drilling machine slightly while drilling.



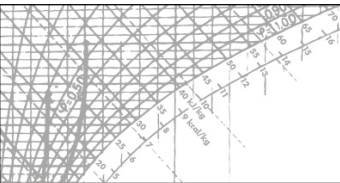
Skapad	Datum	Godkänd	Datum	Ersätter instruktion nr	Sid
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Step 1.5: Sections with roof and bottom panels



- **Note:** Before dismounting roof and bottom panels from the frame-work, always try to transport the sections in one piece to save time and efforts.



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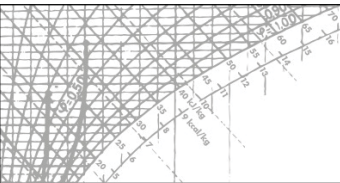


Step 1.6: Dismount roof and bottom sections



- If necessary dismount roof and bottom panels from the framework.
- Dismount the corner joints from the profile framework with a plastic hammer.





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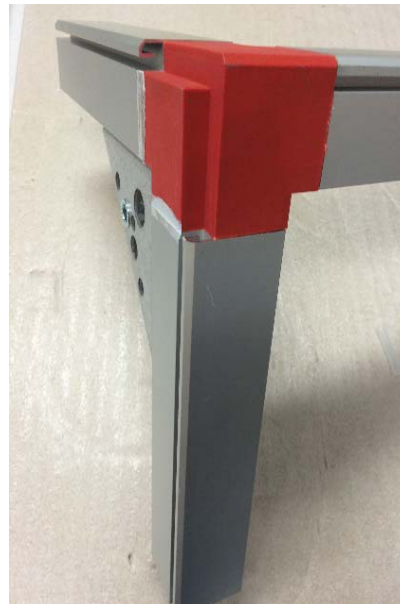
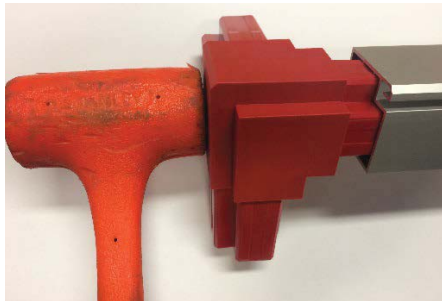


2. Reassembling

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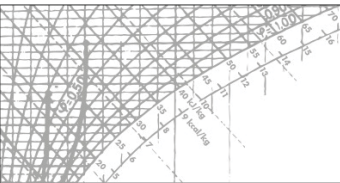
Step 2.1: Reassembling the framework



- Start the reassembling by joining profiles and corner joints with a plastic hammer.

Note: Its essential that profiles and corner-sections are mounted exactly in according to the attached pictures.

Ensure that the slot in the profile is turned in the right direction.



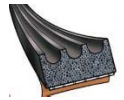
Skapad	Datum	Godkänd	Datum	Ersätter instruktion nr	Sid
PRB/MSW	160526	FW	160526		1/24
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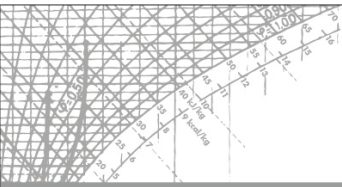
Step 2.2: Assembling of roof and bottom sections



- When reassembling the panels its critical to maintain the perpendicular format of the roof and bottom sections.
- Max deviation is 2 mm/m.
- Use self drilling screws DK 4,2 x 14 PH2 when mounting the panels.



Always replace damaged sealing profiles



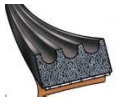
Skapad	Datum	Godkänd	Datum	Ersätter instruktion nr	Sid
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Step 2.3: Reassembling of interior details



- Check marking and photos to make sure each component is mounted in the right place!
- At reassembling be extra careful and ensure sealing's, screws and rivets etc. all are mounted in the right position.



Always replace damaged sealing profiles

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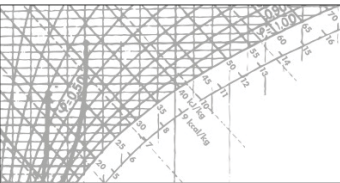
Step 2.4: Sealing (Sikaflex 515)*



- The rule is that all parts originally being sealed from the factory, always should be sealed again.
- Extra critical areas are corners between profiles and corner joints as well as joints between interior details and casing.

Note: Even if sealing still is visible in corners etc., it has broken during dismounting and must be resealed.

***For more information see Part 3 Sealing instructions**



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PRB/MSW	160526	FW	160526		1/24
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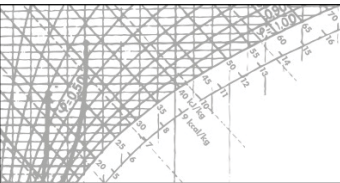
Step 2.5: Mounting of vertical panels



- When reassembling the fixed panels its critical to maintain a perpendicular format of the units framework/casing.
- Max deviation is 2 mm/m.
- Use self drilling screws DK 4,2 x 14 PH2 when mounting the panels.



Always replace damaged sealing profiles



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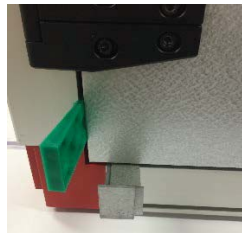


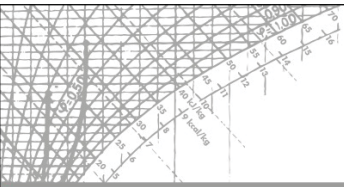
Step 2.6: Mounting of inspection doors



Always replace damaged sealing profiles

- When mounting inspection doors, make sure using spacers to center the doors.
- Allow approx. 2 mm extra distance at the handle-side to allow inspection doors to opening and close smoothly.
- Doors are easy adjustable with a 5 mm hex-key.
- Suitable spacers →





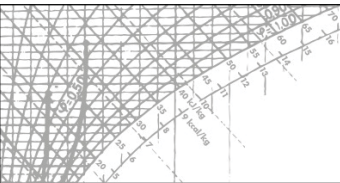
Skapad	Datum	Godkänd	Datum	Ersätter instruktion nr	Sid
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Step 2.7: Clean the air handling unit



- Clean the air handling unit carefully and make sure no metal shavings or other dirt remains in the unit.



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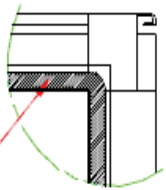


3. Detailed sealing instructions

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3.1 Sealing of fixed panels



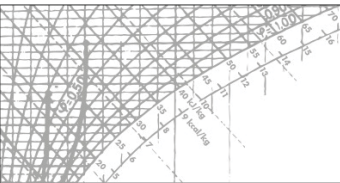
Corner cutting



- Use sealing profile Kron 4x15 black
- Joints between sealing profiles, must not be done in corners, but on a straight side, minimum 10 cm from a corner.
- Sealing profiles should be cut with 50% of its width to fit well in the corners



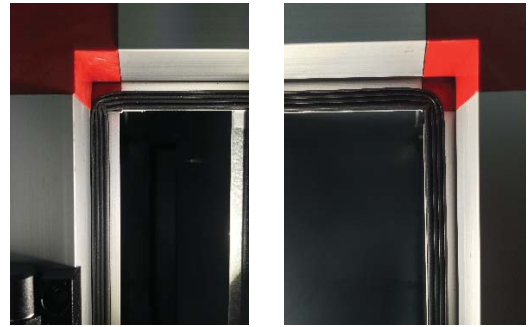
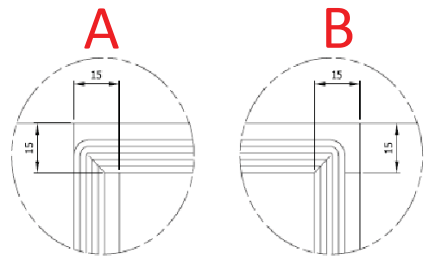
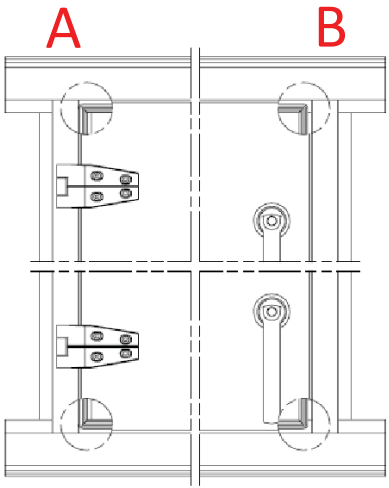
Always replace damaged sealing profiles



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Instruktion nr IM-0021-Eng	Rev. 00	Benämning Disassembling and reassembling			



3.2 Sealing of inspection panels



- Use sealing profile Cellolist 10x6 black
- A. To avoid damages when opening the doors, sealing profiles on the hinge side must be mounted on the inner corner of the profile.
- B. To avoid leakage, sealing profiles on the handle side must be mounted close to the edge of the profile.

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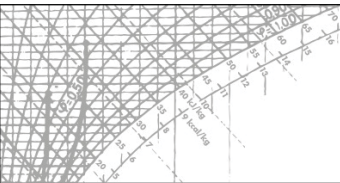


3.3 Sealing of interior corners



- Use Sikaflex - 515
- Make sure to seal all corners properly, both on the inspection side and on the back side.

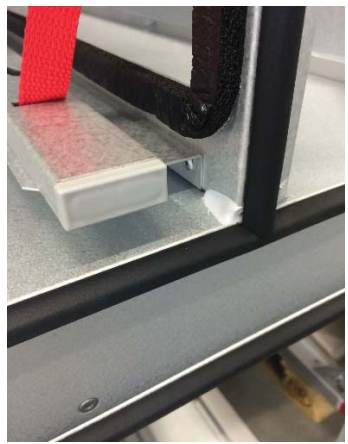
Note: Even if sealing still is visible in the interior corners, it has broken during dismounting and must be resealed.



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3.4 Sealing between interior details and casing

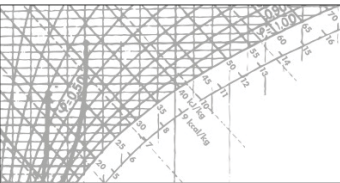


- All joints between interior details and the casing are to be sealed in the corners with Sikaflex 515 as in pictures.

Note: Even if sealing still is visible at the joints between interior details and casing, it has broken during the dismantling and must be resealed.



Always replace damaged sealing profiles



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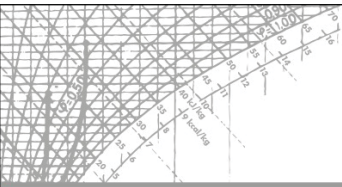
3.5 Sealing of connection profile



Red color = Sealing

- Make sure the profile slots are fully filled with sealant, so no leakage of air is possible.

Note: Even if sealing still is visible on the profile and in the slots, it has broken during the dismounting and must be resealed.



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Ändringshistorik/revidering

<i>Datum</i>	<i>Rev.</i>	<i>Revidering</i>	<i>Utförd av</i>
2016-02-11	00	Första utgåvan	PRB
2016-05-26	00	Engelskspråkig version	MSW/PRB