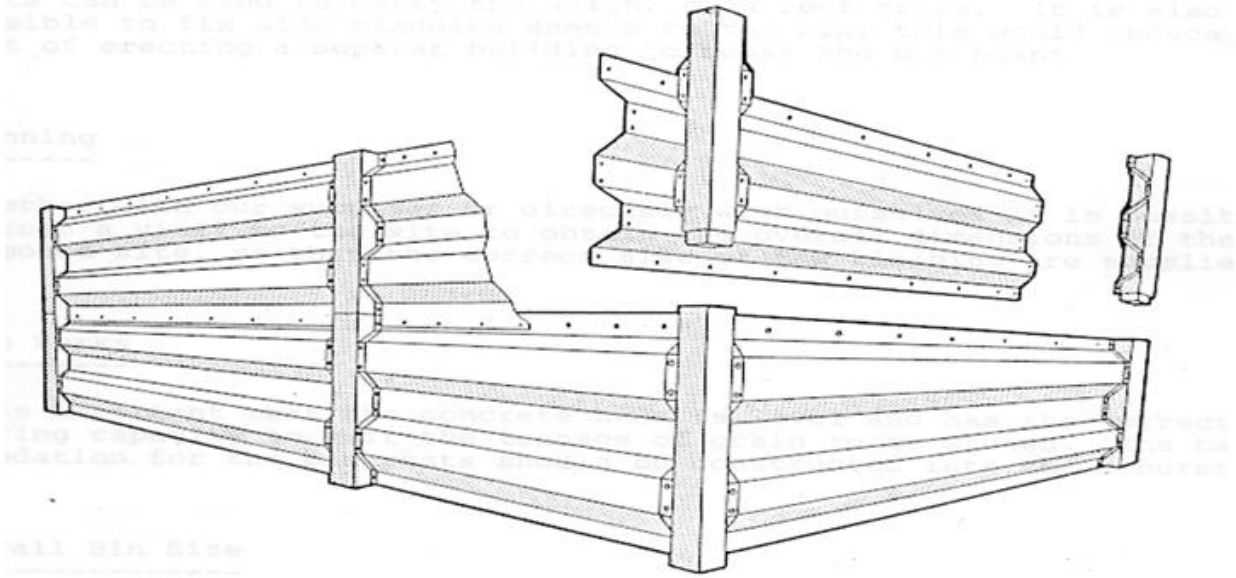
ASSEMBLY INSTRUCTIONS FOR ELEMENT SILOS



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D00268_2020_EN

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1. MATTERS TO TAKE NOTICE DURING ASSEMBLY

NOTE!

BEWARE HAZARDS RELATED TO ASSEMBLY.

USE PROPER STEPLADDERS AND WORK PLATFORMS DURING ASSEMBLY.

BE CAREFUL NOT TO FALL.

BEWARE SHARP PLATE EDGES.

BEWARE FALLING OBJECTS, WEAR PROTECTIVE HELMET.

Tools needed for assembly:
- tapering pin
- 13 mm wrenches
- a press for sealing compound
- an impact wrench + 13 mm sockets
- a pneumatic compressor

Check the delivery note to make sure that you have all parts at the assembly site.
Two people are needed to carry out the assembly.

IPE-beams and supports are not included in the delivery.

2. INTRODUCTION

Elements of the silos are made of hot-galvanized sheet steel. The standard lengths are 2, 2.5 and 3 metres. You can make efficient use of the available space by combining elements of different length. Subsequent extension of the silo system is simple, if appropriate pole types and element thickness options are selected right at the silo system's design stage.

Silos are available with the following assembly options:

1. Assembly on a conical base
2. Assembly on a flat base on a concrete foundation

COVERING THE SILO

The silo structures are designed such that the poles can be used to fasten the roof structure (see page 26).

ASSEMBLY FOUNDATION

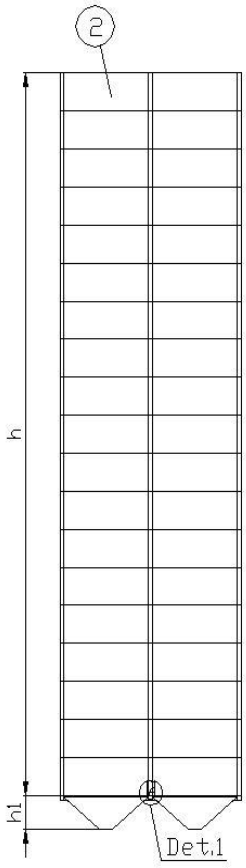
The foundation on which the silo is assembled has to be sufficiently strong and even. Uneven foundation affects the assembly of the silo. For a flat base silo make sure that moisture insulation of the foundation is adequate. For an outdoor silo install the grip plates, to which the bottom poles of the silo are welded, when concrete is cast.

ELEMENTS

Depending on the height of the silo, elements of different thickness are used such that thicker sheets are used in the lower part of the silo. Before starting the assembly, sort the elements according to their dimensions and thickness in separate piles, and then follow the assembling order provided on the next page.
Elements of the lower layer are different from the other elements, with an additional symbol "K" in part numbers.

Material thickness of Mepu Silo Elements with different elements and heights of the silo

T	Tier
h	Silo height
h1	Bottom cone height
2	Element thickness
1	Silo pole thickness



T	h [m]	2000 [mm]		2500 [mm]		3000 [mm]	
		2	1	2	1	2	1
1	0,84	1,5	3	1,5	3	1,5	3
2	1,68	1,5	3	1,5	3	1,5	3
3	2,52	1,5	3	1,5	3	1,5	3
4	3,36	1,5	3	1,5	3	2,5	3
5	4,20	1,5	3	1,5	3	2,5	3
6	5,04	1,5	3	2	3	2,5	3
7	5,88	1,5	3	2	3	2,5	3
8	6,72	1,5	3	2	3	2,5	5
9	7,56	1,5	3	2	3	3	5
10	8,40	1,5	3	2	5	3	6
11	9,24	1,5	3	2,5	5	3	6
12	10,08	1,5	5	2,5	6		
13	10,92	1,5	5	2,5	6		
14	11,76	1,5	5				
15	12,60	1,5	5				
16	13,44	1,5	5				
17	14,28	1,5	5				
18	15,12	1,5	6				
19	15,96	1,5	6				

Blade valve ø160mm or ø200mm, 120mm
Discharge trough 45° or straight
Support legs for bottom trough 2300mm, 2000mm, 1680mm, 1325mm
NB! 3x3 cone-base silo max 3 tiers on support legs.

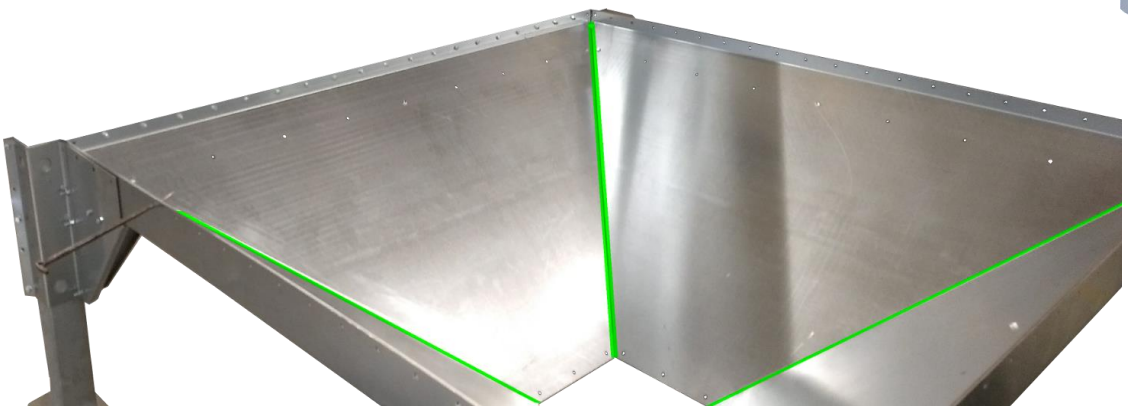
2.1 Sealing of the silo

General instructions for sealing.

Sealing must be performed carefully during assembly. It is difficult to re-seal the silo after the assembly is done.

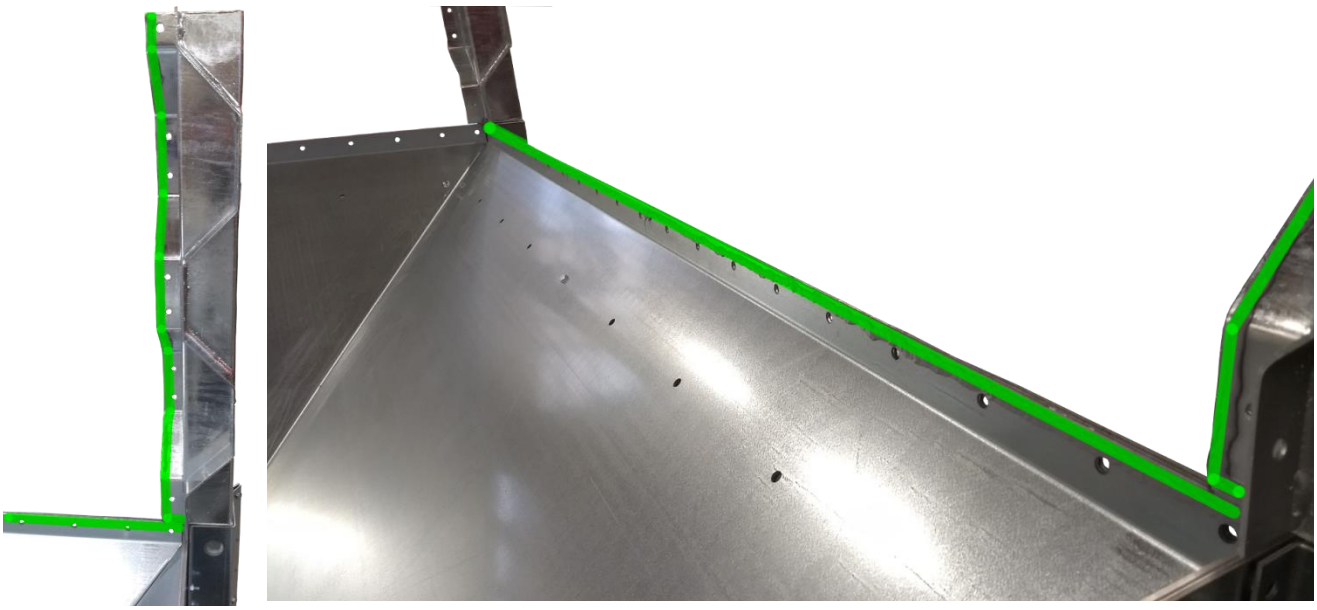
Recommended sealant for the silo is Würth polymer glue and sealant (Würth product code 8093 225 42). Properly clean the surfaces before applying the sealant. This product fares well under ambient UV- radiation.

Sealing of the cones



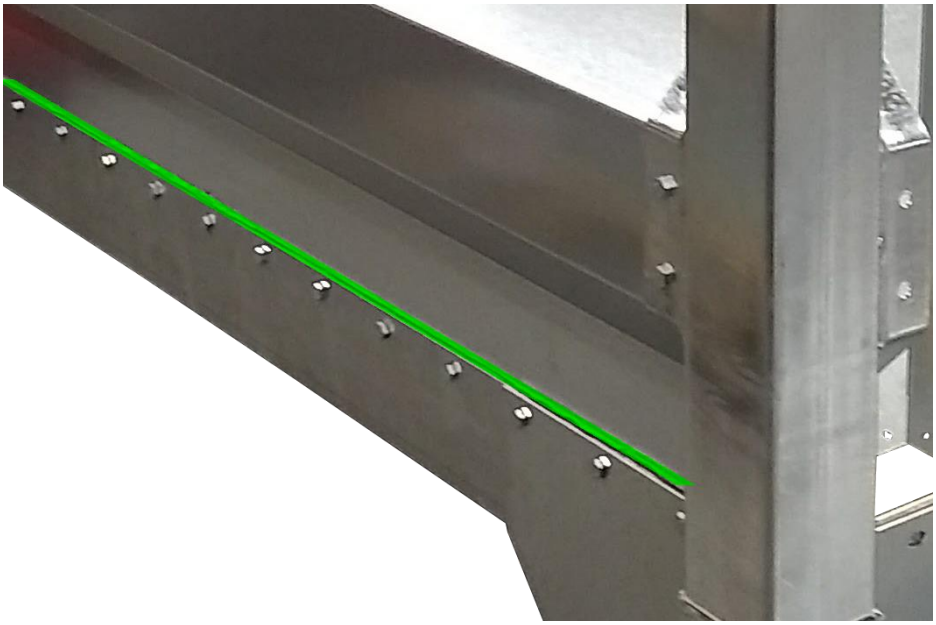
Add sealant to the seams prior to tightening of the bolts.

Sealing of the corner of the cone and the poles



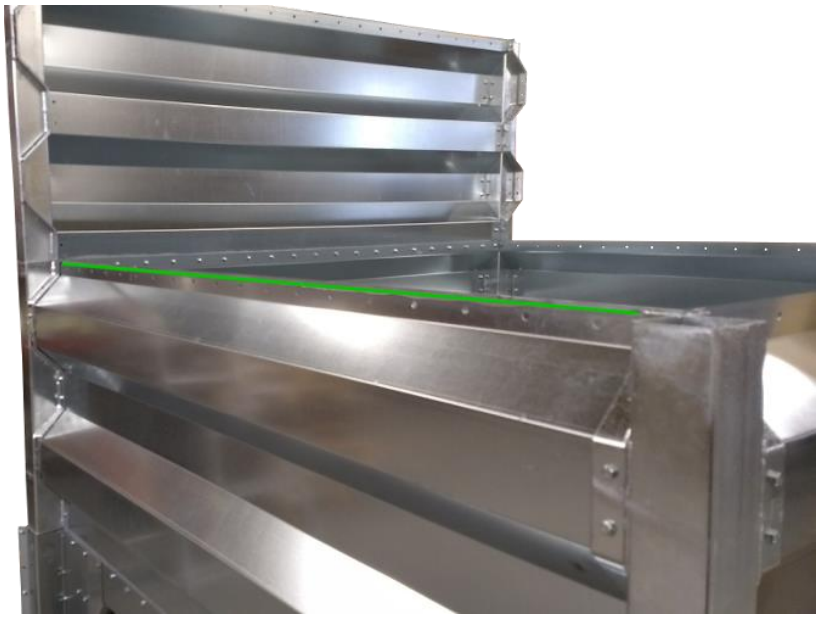
Observe the positioning of the application of the sealant.

Sealing the first element and the cone



Apply the sealant in the top edge of the cone before installing the silo element. Make sure the sealant is pushing out of the gap between the element and the cone.

Sealing of the upper layers



Apply the sealing agent for the poles inside the silo. Horizontal seams between the silo elements are applied from the outside. Observe the application of the sealant in the lower corner of the pole (image on the left).

Enough sealant has been applied when the seams are overflowing a little bit.

3. ASSEMBLY ON A CONICAL BASE

1. Before mounting the base check the height of the grip plates, e.g. with a builder's level.

2. Assemble the cone base according to the instructions provided below

    1) Assemble the side plates (Figure 1) No. 1 (4 pcs)
    (with M8x16 screws). **Note!** In 2x2.5, 2.5x2.5 and 3x3 cones the side plate consists of two parts – No. 1 and No.2, with a reinforcement seam between them.
    Assemble all the parts of the side plates; do not tighten the screws yet.
    a) Make sure that the cones are rectangular and straight and that the seams are tight.
    b) Tighten the screws.

    2) Fasten the edge reinforcements No. 3 (4 pcs) to the cone (with M8x16 screws). Check that the fastening holes of the silo elements are aligned.

    3) Silos on support legs
    4) Fasten the cone legs No. 4 to the corners of the cone (with M8x25 screws).
    See support legs on the next page.
    a) These screws need to be loosened when the first silo element is installed.
    b) NOTE! Only loosen the screws required to assemble one silo element at a time, and attach the pole/ silo element/ leg

    5) Assemble the discharge connector No. 5 to the cone (with M8x16 screws + washers).
    6) Backup welds are made as double welds through the holes in the band plate. (Page 5)
    7) Install the cross supports (depending on the type) as shown in the picture (drawing 300341).

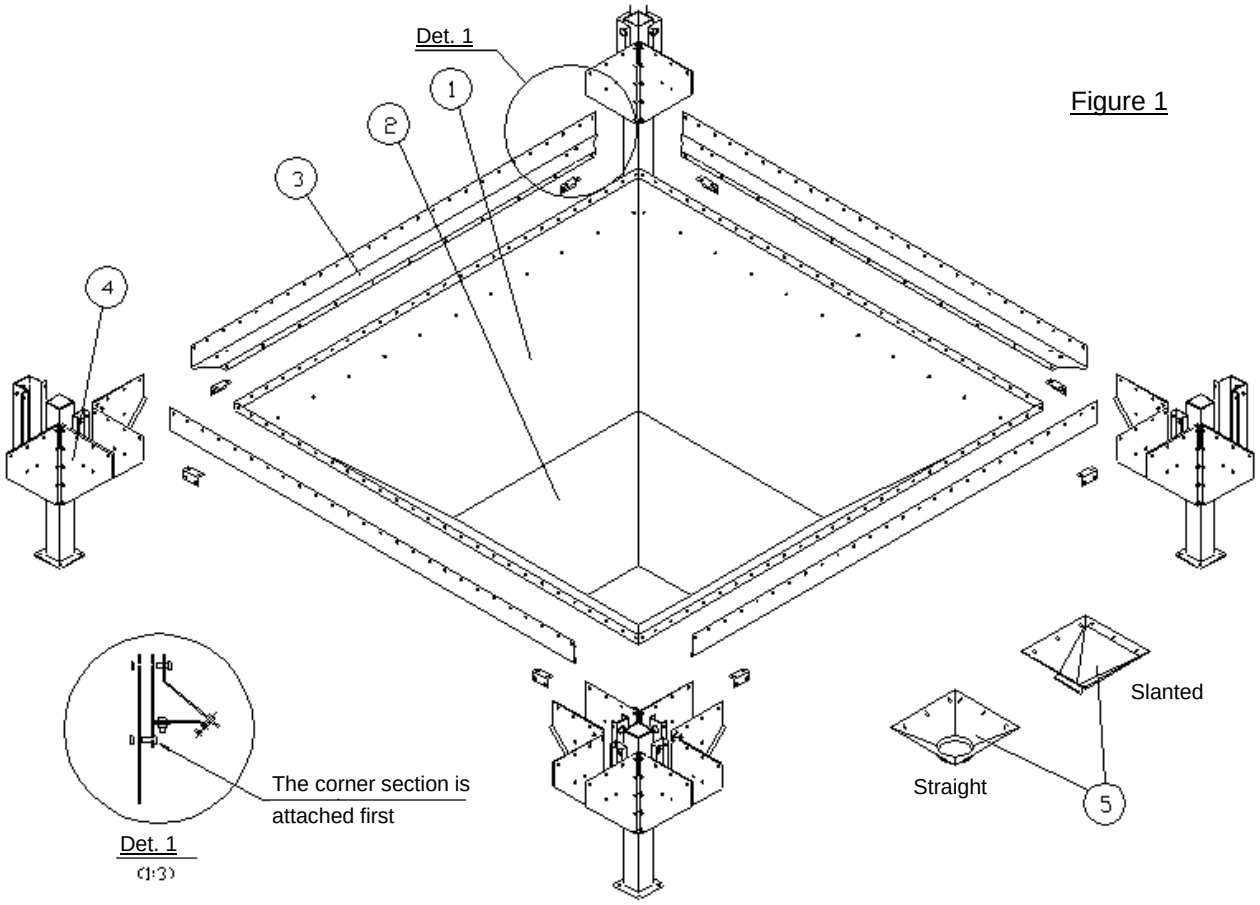
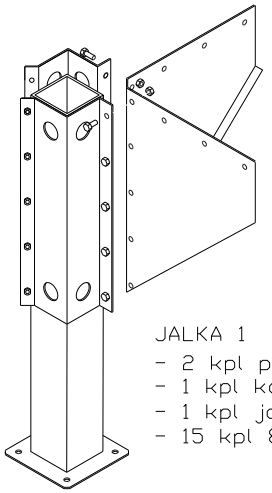
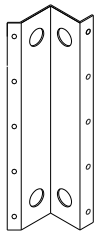

Det. 1
1
2
3
4
5
Slanted
Straight
The corner section is
attached first
Det. 1
(1:3)

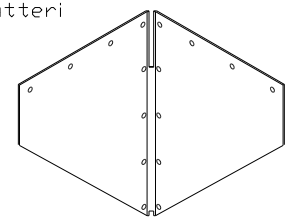
Figure 1



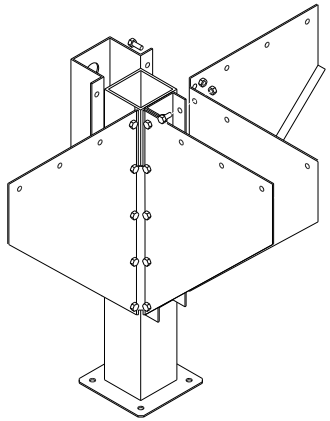
JALKA 1
- 2 kpl pantalevyt 4
- 1 kpl kolmiolevy
- 1 kpl jalan laippa
- 15 kpl 8x25 kuusioruuvi + -mutteri



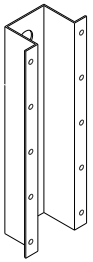
4. PANTALEVY



KOLMIOLEVY



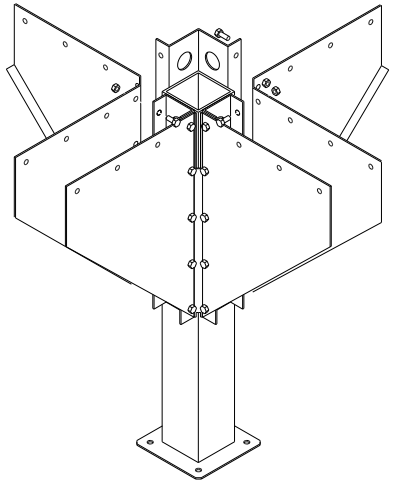
JALKA 2
- 1 kpl pantalevy 1
- 1 kpl pantalevy 2
- 2 kpl kolmiolevyjä
- 1 kpl jalan laippa
- 20 kpl 8x25 kuusioruuvit + -mutterit



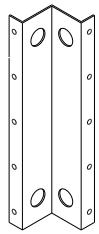
2. PANTALEVY

JALAN LAIPPA

1. PANTALEVY

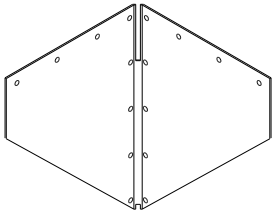


JALKA 3
- 2 kpl pantalevy 1
- 1 kpl pantalevy 3
- 3 kpl kolmiolevyjä
- 1 kpl jalan laippa
- 30 kpl 8x25 kuusioruuvi + -mutteri



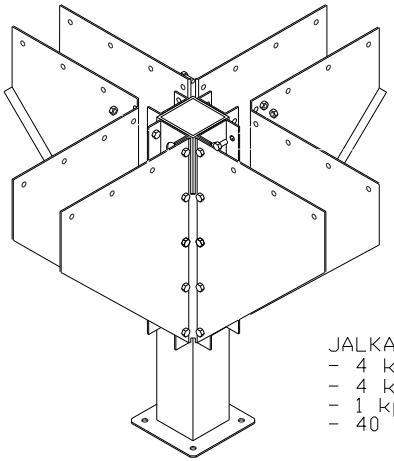
3. PANTALEVY

1. PANTALEVY



KOLMIOLEVY

JALAN LAIPPA



1. PANTALEVY

JALKA 4
- 4 kpl 1 pantalevyjä
- 4 kpl kolmiolevyjä
- 1 kpl jalan laippa
- 40 kpl 8x25 kuusioruuvi + -mutteri

3. Lift the base cones to their places with e.g. an agricultural loader. Lifting is easier if you use a lifting lever inserted between the edge reinforcements (Figure 3). (The lifting lever is not included in the delivery).
   If the working range of the loader/ hoist is insufficient, lift the cone from the discharge trough side as far as possible, and pull it to its place along the base and the support beam. (Figure 4, Photo E)

Figure 3
lifting lever

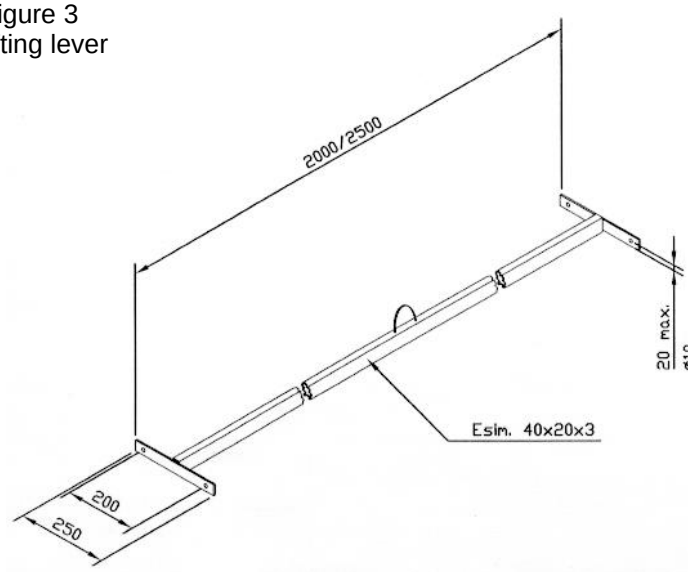
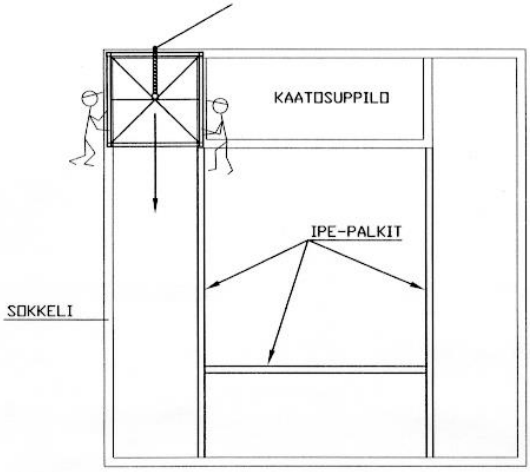
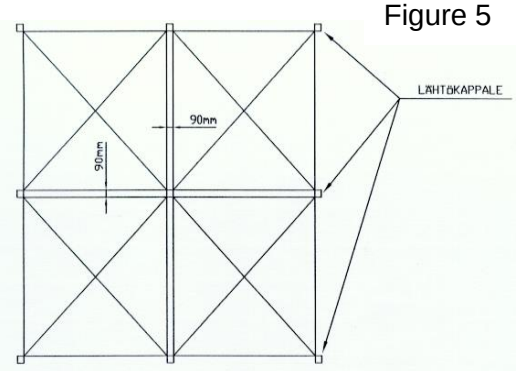


Figure 4



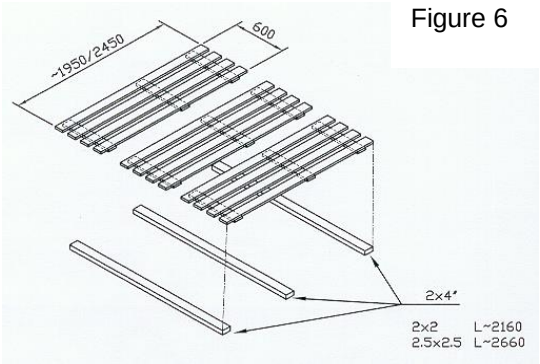
4. After the bases are all mostly positioned in their designated spots, attach the starting pieces 90x90x3 L=120 to the location shown in the drawing (Figure 5). The starting pieces are positioned in the corners of the cone, not between them. After all the starting pieces are installed,
   check the starting heights and the cross-dimension (Figures 15 and 16, Photos H and E).

Figure 5



5. Before assembling the first element tier
   it is advisable to prepare work platforms to facilitate the work and to ensure work safety.
   Timber required: Work platforms made of 3-4 pcs 2 meter planks (50x100mm) per silo, and 4" boards. 2”x4” planks are subsequently used for framing the silo lids.
   You will need 3 platforms per silo (Figure 6, photo E).

Figure 6



3.1. FASTENING OF SUPPORT LEGS TO CONES

A photo of the fastening of a corner leg from outside, do not insert bolts into the topmost row.

A photo of the fastening of a corner leg from inside.
The corner leg is fastened to the supports of the cone, tightened to finger-tightness.

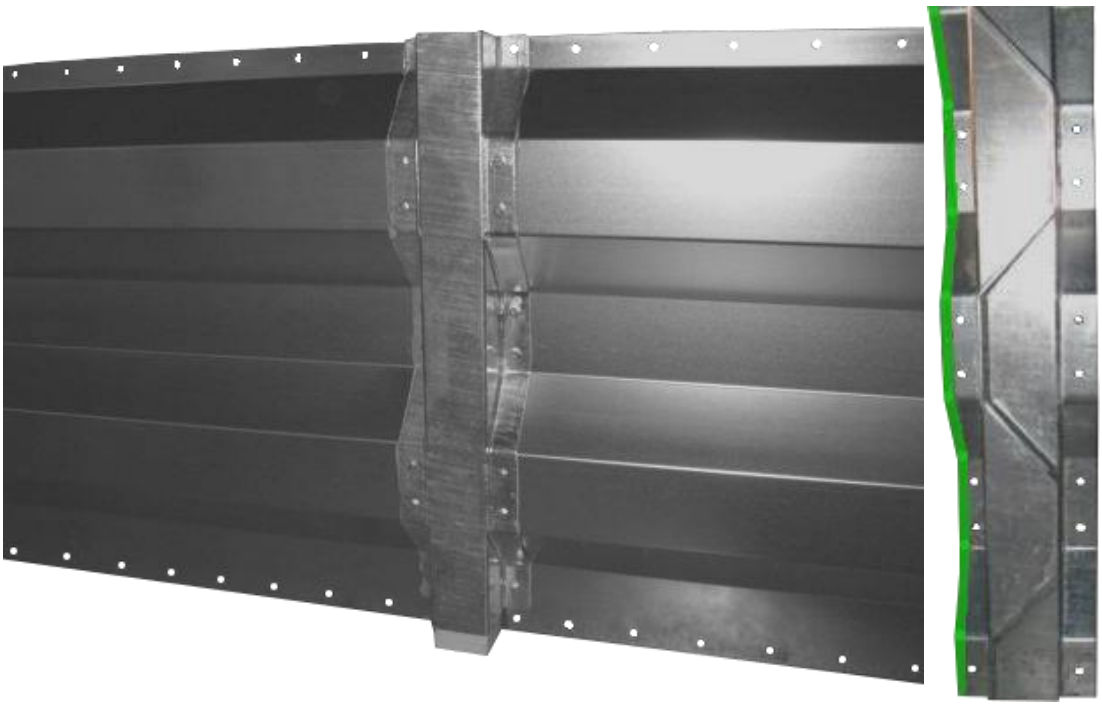
A photo showing the fastening of the central leg to the cone. The arrows point to the topmost row of perforation without bolts inserted.

3.2 Assembly of the first element tier

Sort poles of different types (2A, 3O, 3V, 4) by groups (Figures 7 and 8). After that install the poles of the first tier to their respective places according to the assembly diagram (Figures 9 and 10). Next, spread some sealing compound along the pole and the lower edge of the element. After that install the elements of the bottom tier. Elements of the lower layer are different from the other elements, with the entry "K" at the end of the element name. The elements are always positioned against the flange of the pole such that the element is inside, towards the non-welded side of the flange. Flange of the pole always goes outside. Thereafter install the bottom (thickest) elements to their places and attach with bolts to the poles and the base (tighten to finger-tightness).

USE WEATHER-RESISTANT SEALING COMPOUND IN THE JOINTS OF THE OUTER PERIMETER. (MS POLYMER SEALING COMPOUND) (Wurth prod. nbr: 8093 225 42 or equivalent)

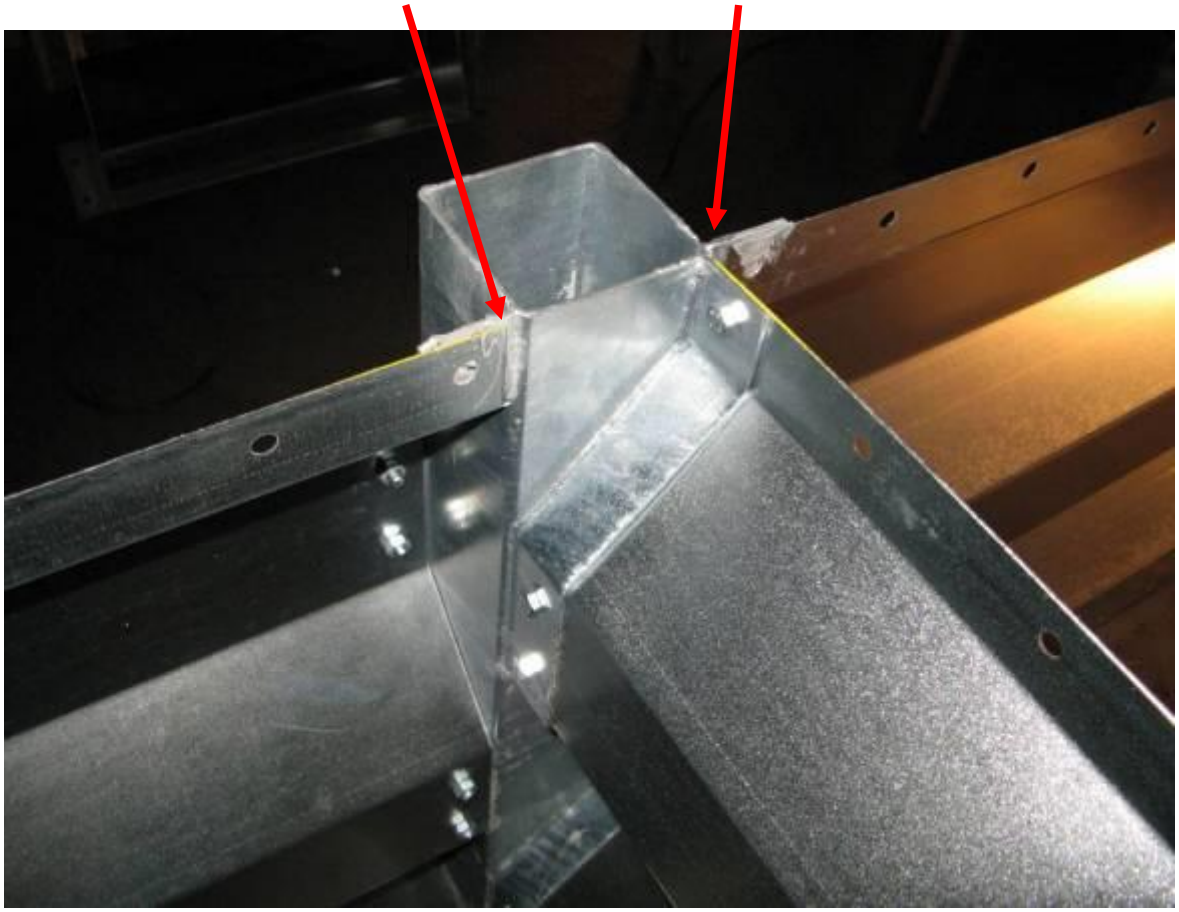
The photo shows a pole 3V and two external walls, seen from inside the silo.



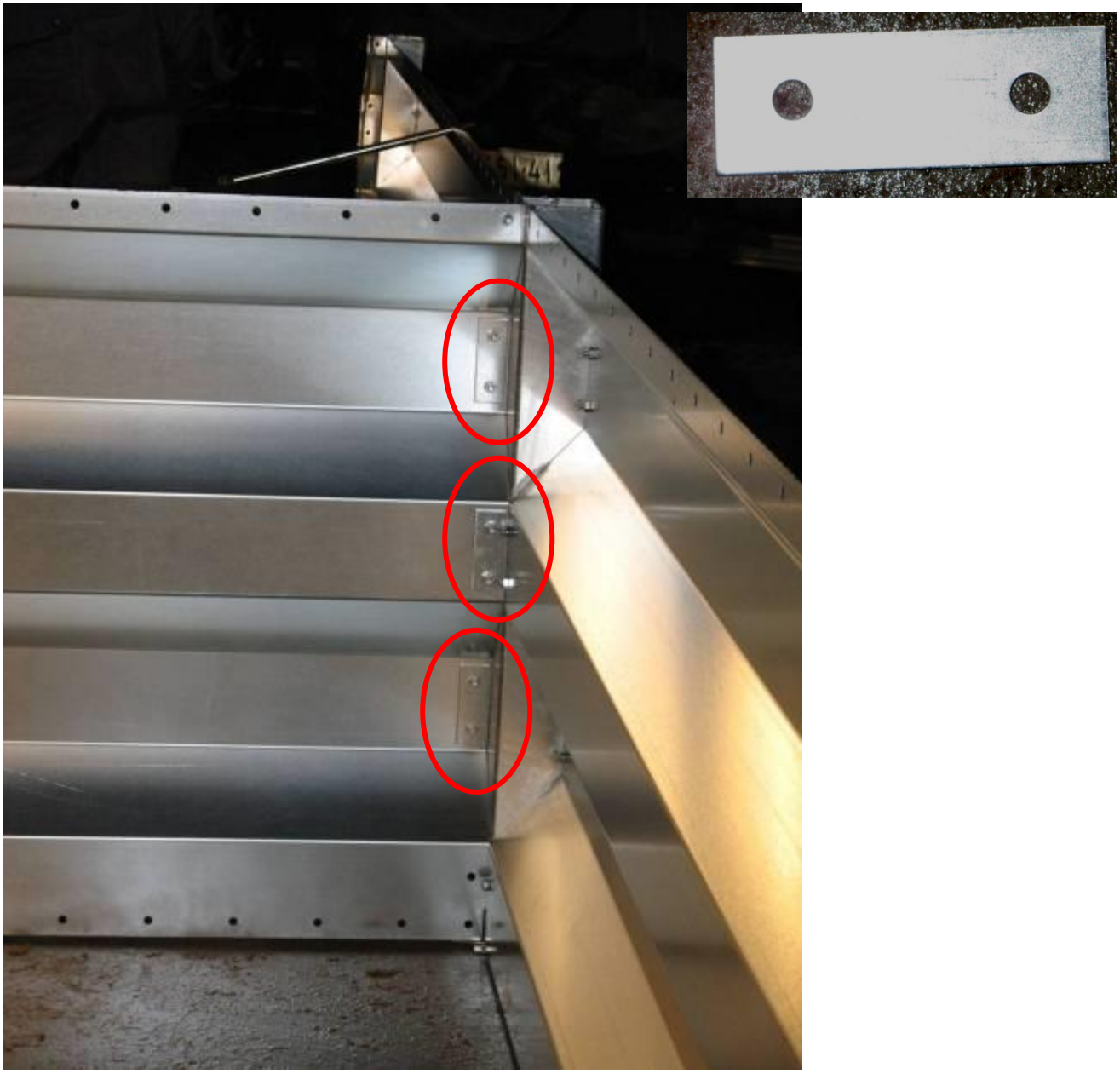
- The photo shows a pole 3V with two external walls to be attached to it, seen from outside the silo.
- The bottom and the top rows with no bolts inserted!
- Place the lower silo poles more or less to their designated installation locations in the flat-base silo.
- Next spread some weather-resistant sealing compound on each pole. The compound is spread between the edge of the flange and the row of perforations.

USE WEATHER-RESISTANT SEALING COMPOUND IN THE JOINTS OF THE OUTER PERIMETER. (MS POLYMER SEALING COMPOUND) (Wurth prod. nbr: 8093 225 42 or equivalent)

A photo showing the fastening of a partition wall to a 3V pole. The sealing compound shall be spread in the joint between each pole and the wall element on the external wall side.



Note! Do not forget the partition wall support plates (Figure 11).
Install the strip 250x2000 or 2500 according to the instructions (Figure 12) and seal the corners with butyl sealing compound, finally tighten all nuts.



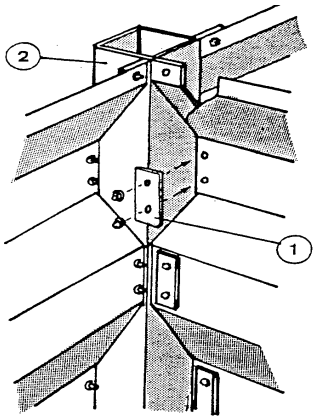


Figure 11

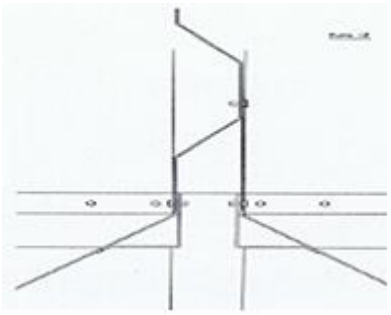


Figure 12

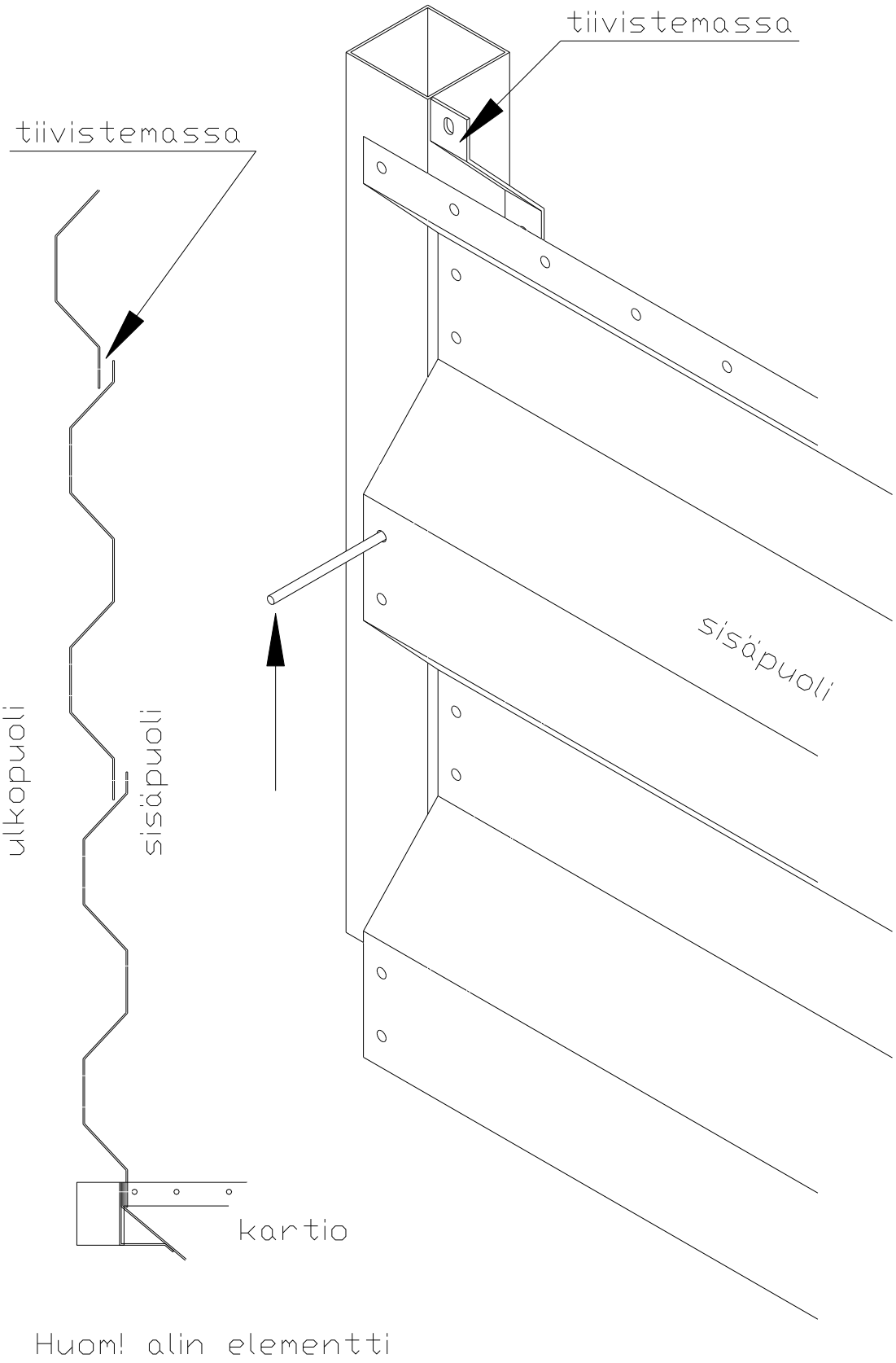
When tightening the nuts lift the element with the tapering pin so that the element pole and pole flange are aligned (see Figure on the next page). To speed up work use pneumatic tools

3.3 Assembly of the second tier

Set up the work platform according to the instructions. Install the poles as described above. Lift the required quantity of elements onto the work platform (check the thickness) and install them the same way as the first tier. Finally tighten the bolts. NOTE! THE BOTTOM EDGE OF THE ELEMENT IS MUST BE OUTSIDE THE ELEMENT BELOW when watching from outside (see the figure).

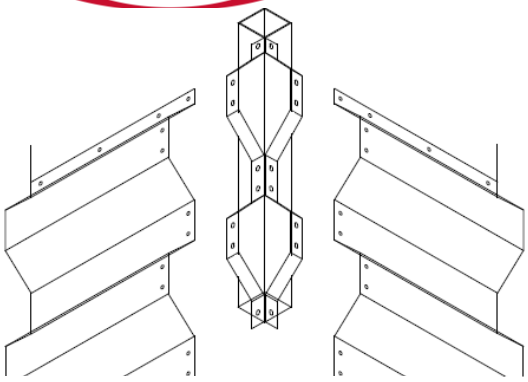
3.4. The third tier, etc.

Assembled as described above.



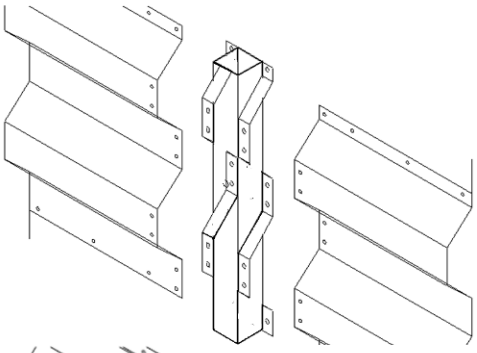
Huom! alin elementti

Figure 7

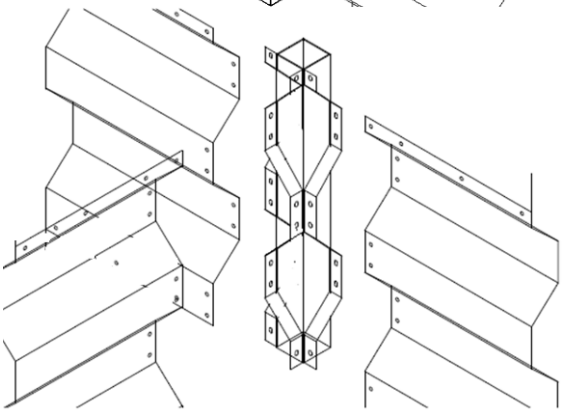


CORNER POLE 2A

Used in the outside corner of the silo.

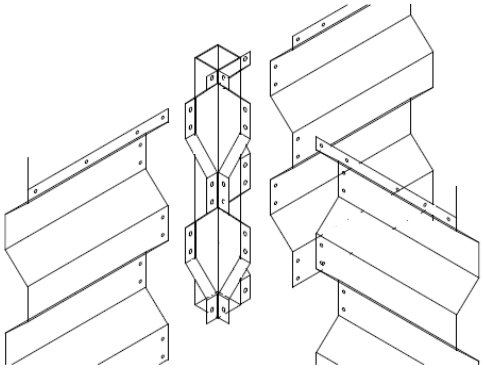


EXTENSION POLE 2B
Used to extend the elements. They feature perforations for pull-rods and support pipes.

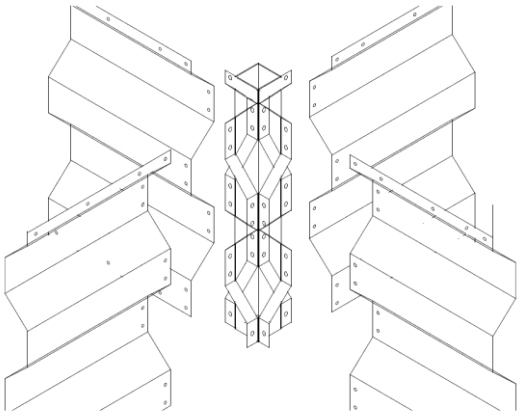


PARTITION POLE 3V

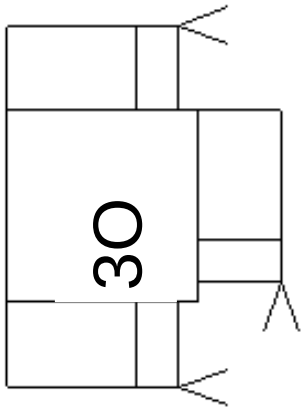
Used in a junction where three walls meet. The partition wall element is positioned against the pole plate from the left-hand side.

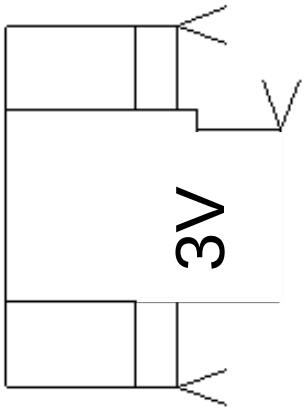


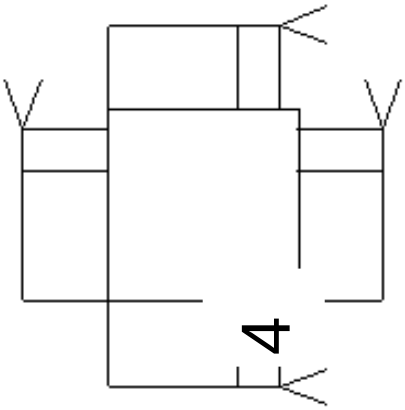
PARTITION POLE 3O
Used in a junction where three walls meet. The partition wall element is positioned against the pole plate from the right-hand side.

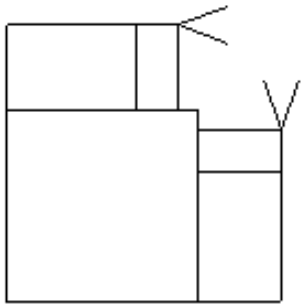


CROSS POLE 4
This is used in a junction where four walls meet.

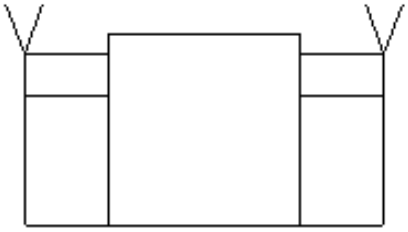








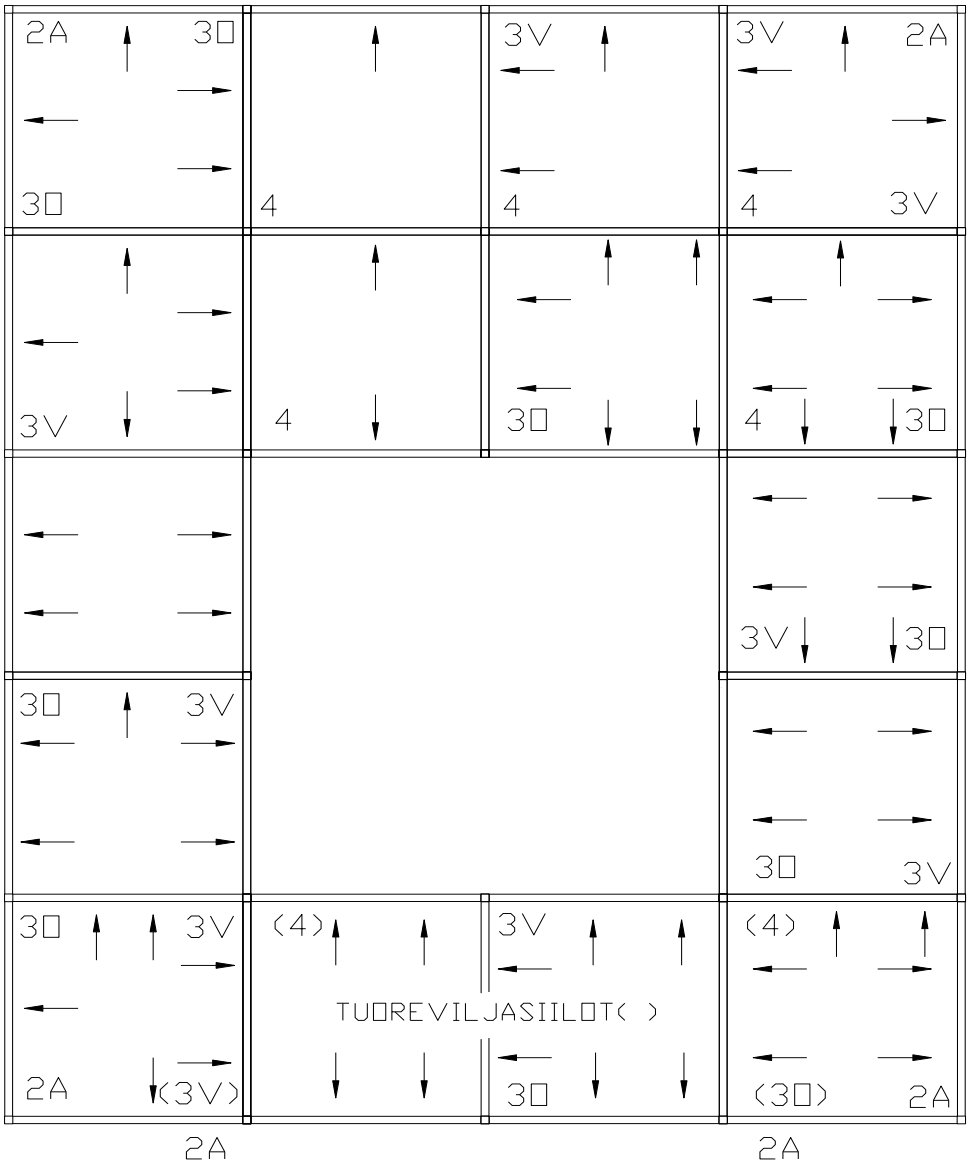
2A



2B

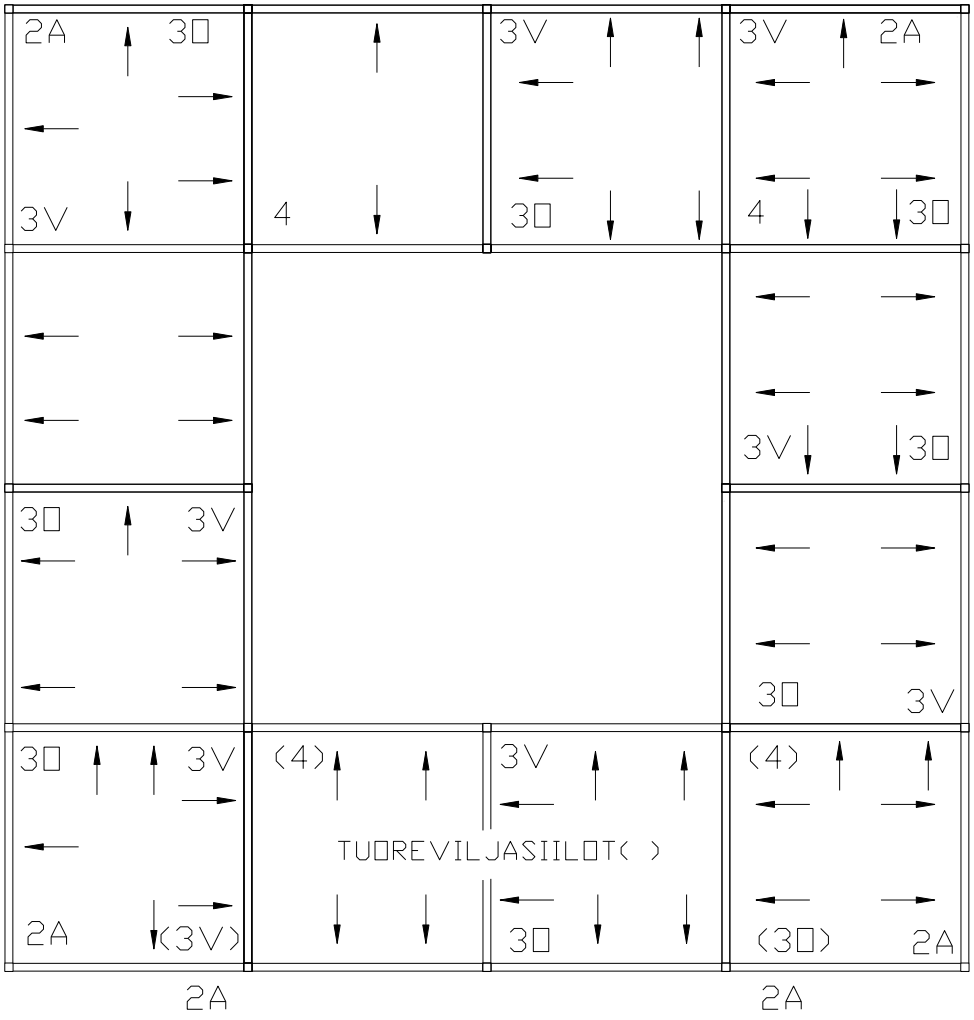
Figure 9

Installation diagram for silo poles



SIILOTOLPPIEN ASENNUSKAAVIO

Figure 10



SIILOTOLPPIEN ASENNUSKAAVIO

3.5 Operations required for the assembly of silos for green cereals

Using a gauge made of planks, make sure the space required for the silo base (size 4090 or 5090) stays the same, starting from the bottom tier (Figure 13). If the dimension changes when the assembly work progresses, it shall be either decreased with straps or increased with jacks. The silo base support beams IPE 240 or IPE 360 are welded to their spots at the height shown in the figures, and are supported on the base with 4 U-80 beams (Figure 13). Lift the silo bases to their designated location and assemble the silos as described above. Take note of the alterations made to the poles where the green cereal silos are located; see the assembly diagram (Photo D).

Installation of the U-beams of the green cereal silos. A U-beam is fastened to each pole.

3.6 Roof of the silo

Fasten a plank (50x100mm, Figure 14) to the top edge of the elements of the topmost tier with e.g. 8x50 cover screws. Use the planks as runners for the cover. Interval between runners: according to the thickness of the cover and the element length. Cover material: e.g. matchboard or plywood- Leave filler ports 500x500; position the ports in the corner located closest to the elevator (not behind a barrier) (Photo F). The top pole layer differs from the others because in these poles are welded fastening plates to join deck structure and roof rafters. See the next section 2.6.1.

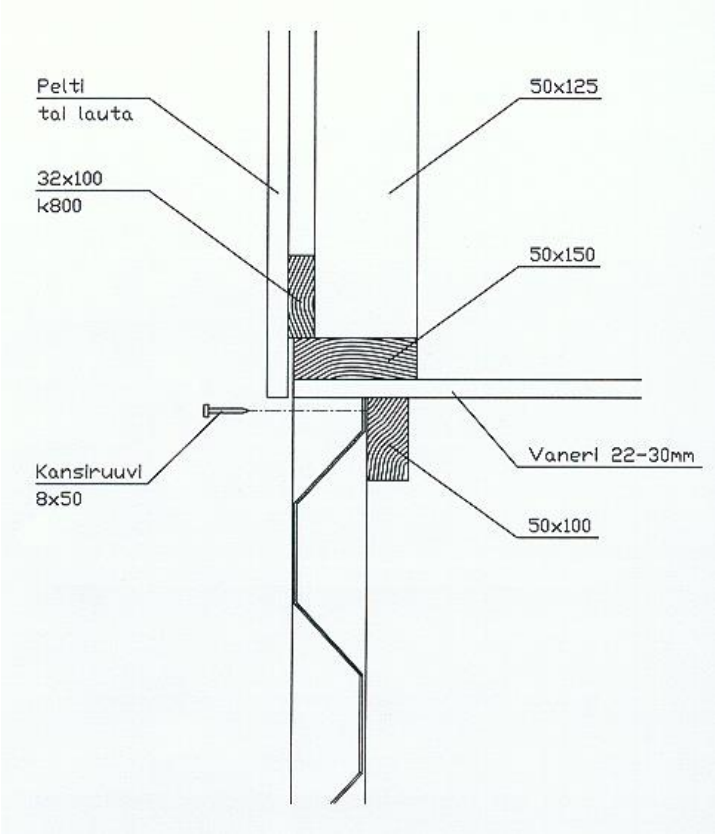
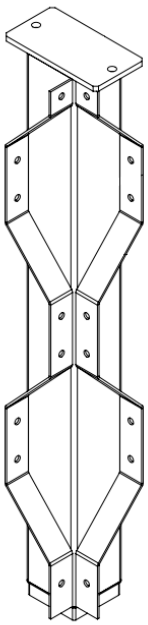


Figure 14

3.6.1 Top pole layer

The top floor poles are different from the other poles because they are pre-welded with connecting flanges for attaching the deck structure and roof rafters. Each pole has its own top floor pole model. Attached are views of the top floor poles. The installation diagrams show in detail correct postions of each top poles.



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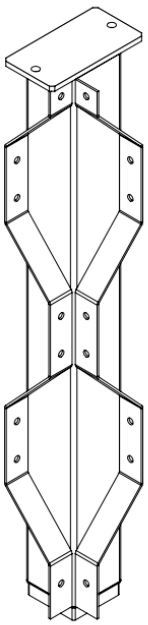

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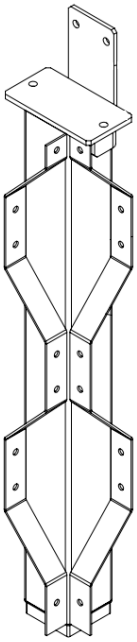

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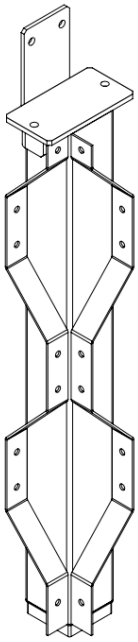

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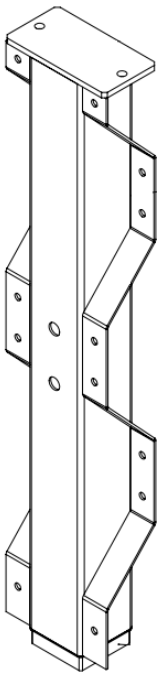

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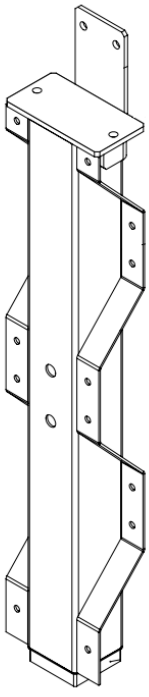

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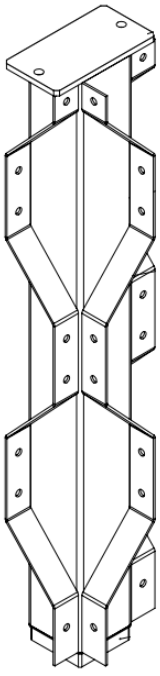

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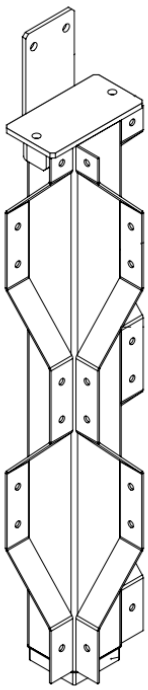

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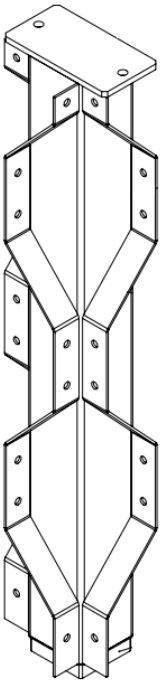

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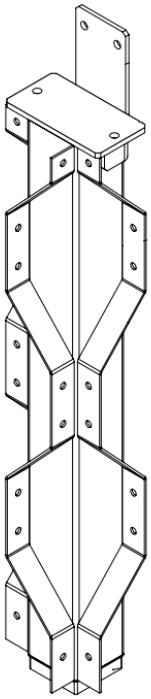

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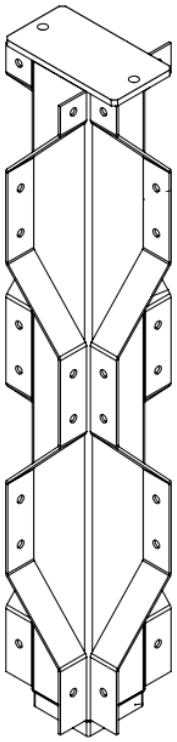
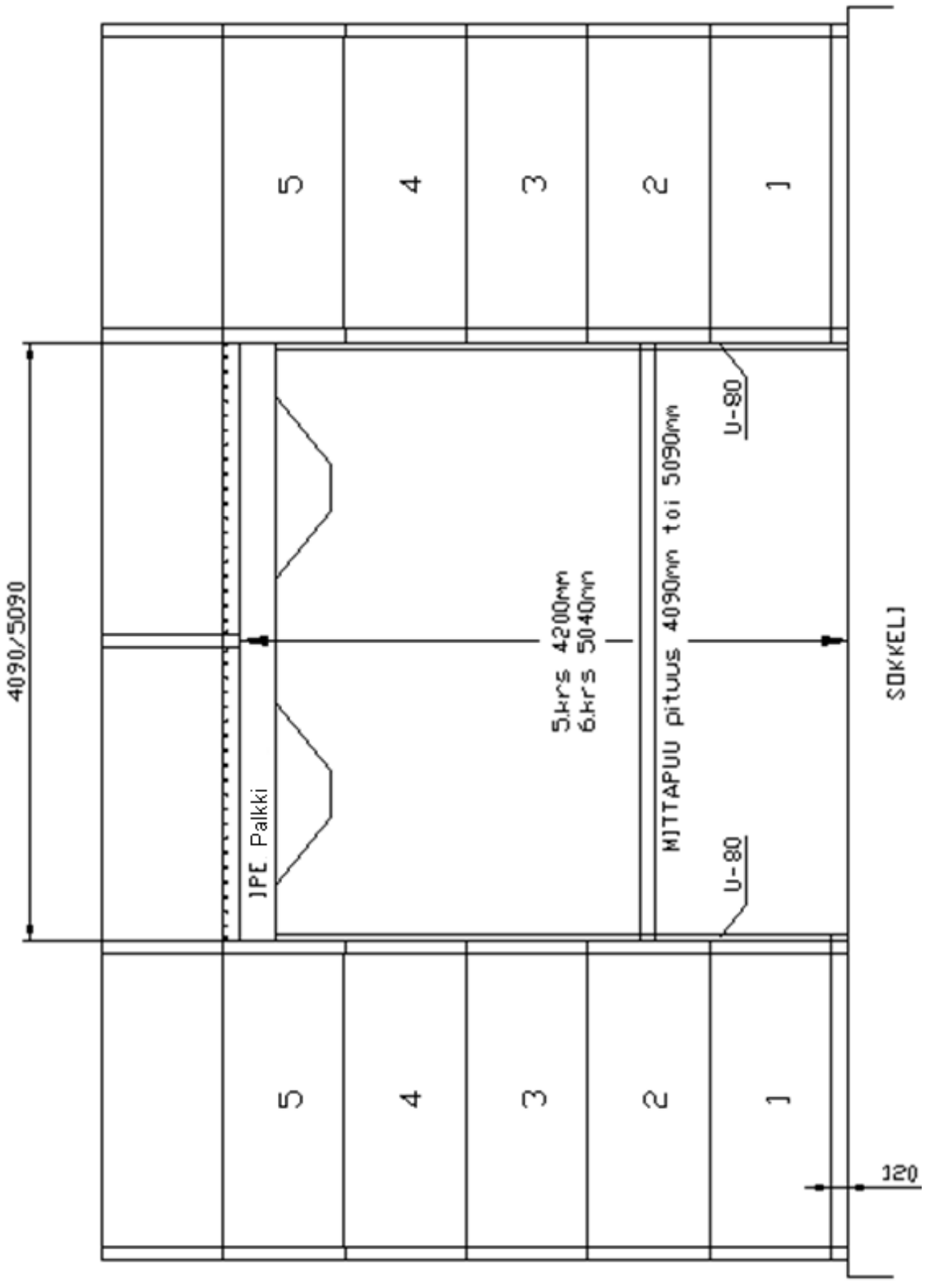


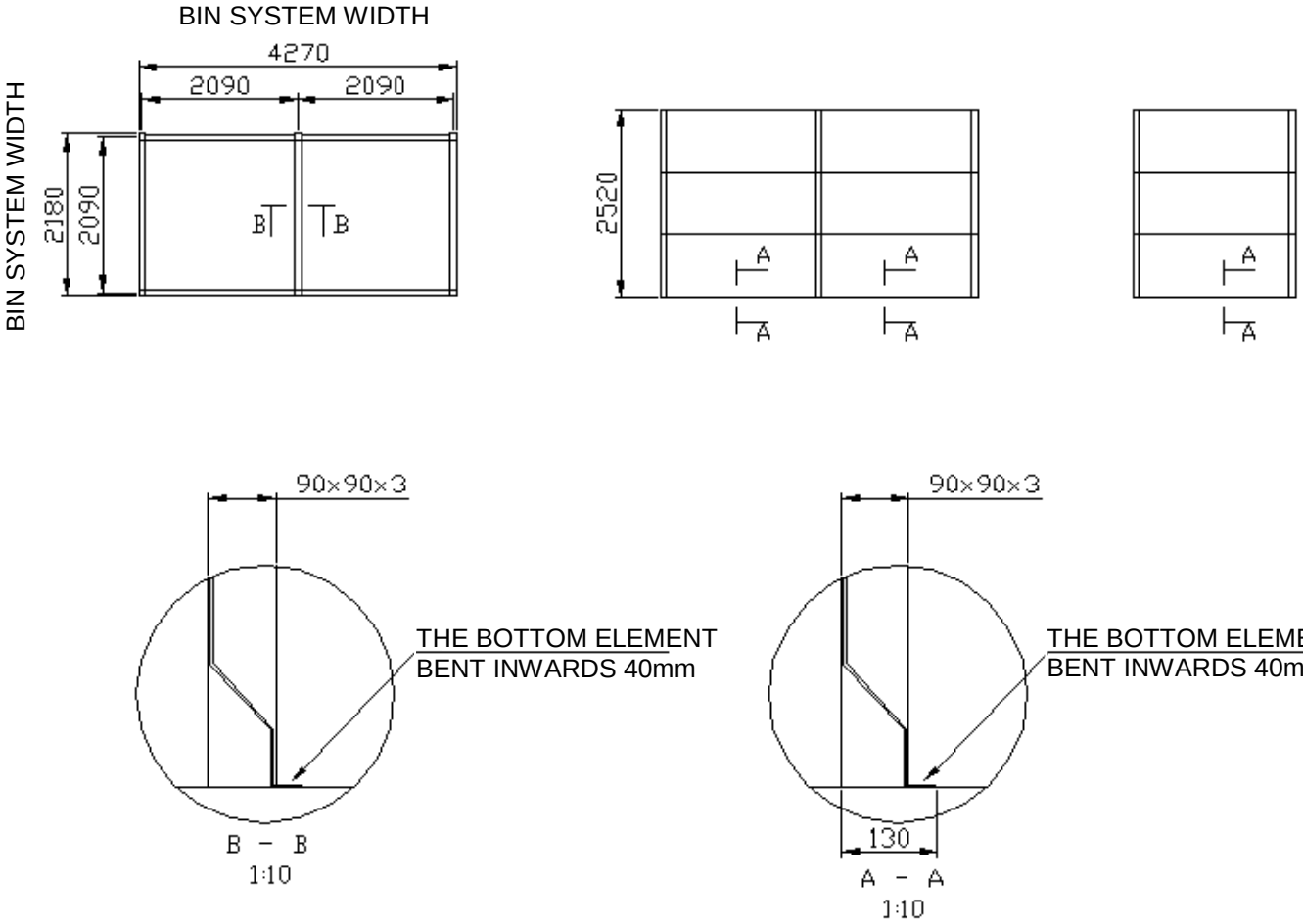
300205_T1

Figure 13

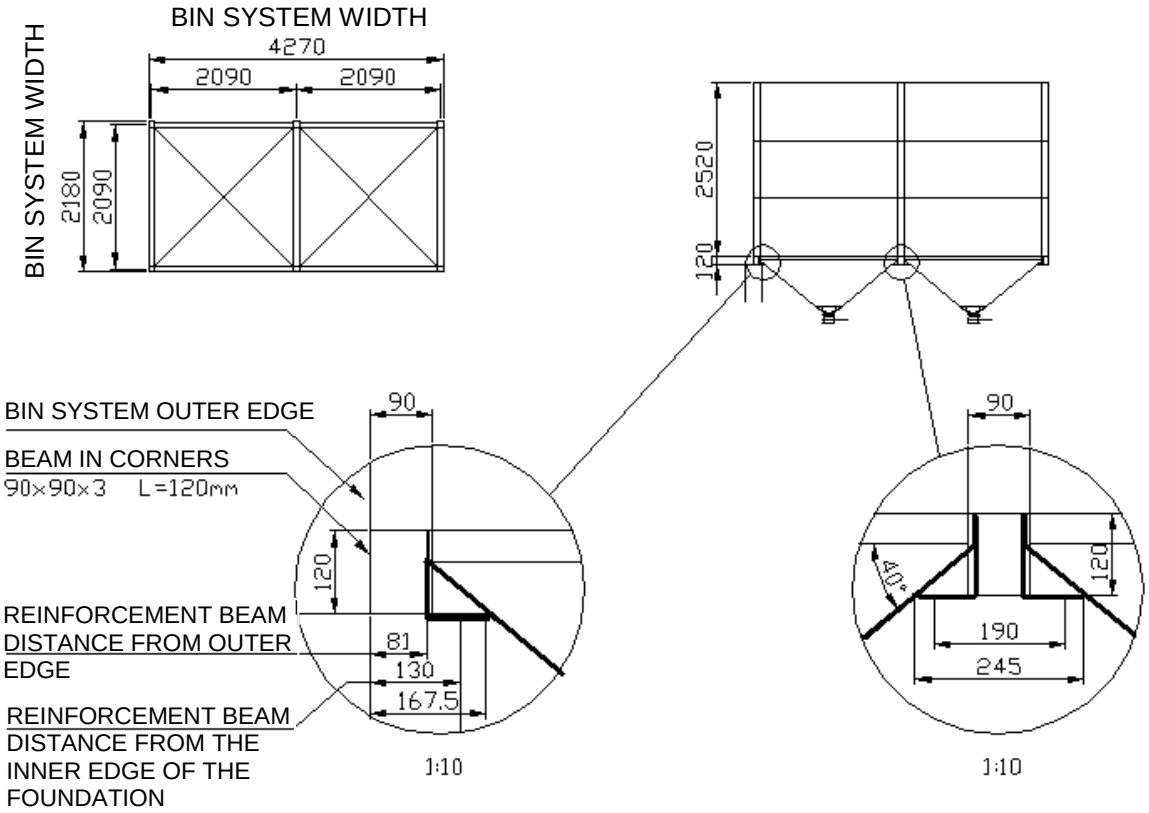


IPE Palkki rakennesuunnittelijan ohjeiden mukaan!

FLAT BOTTOM BINS

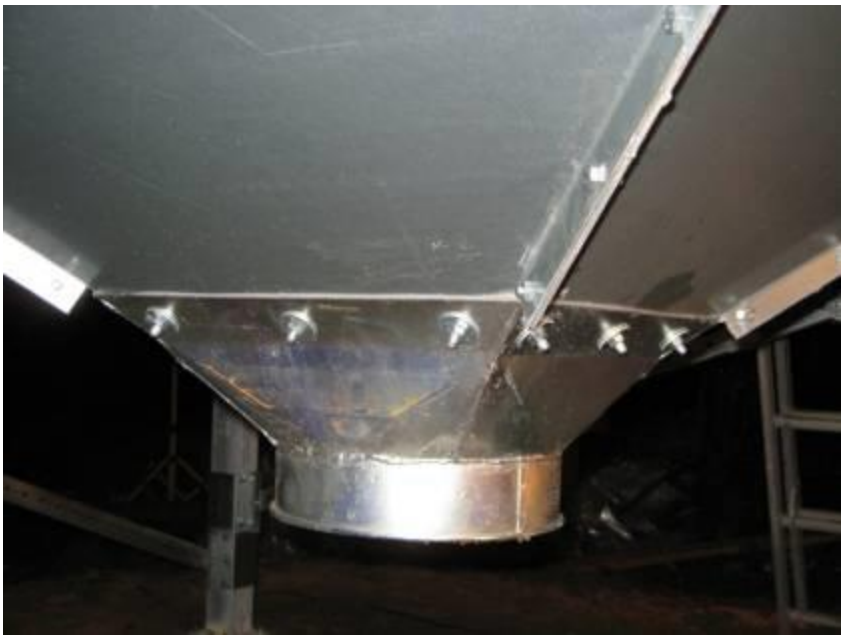


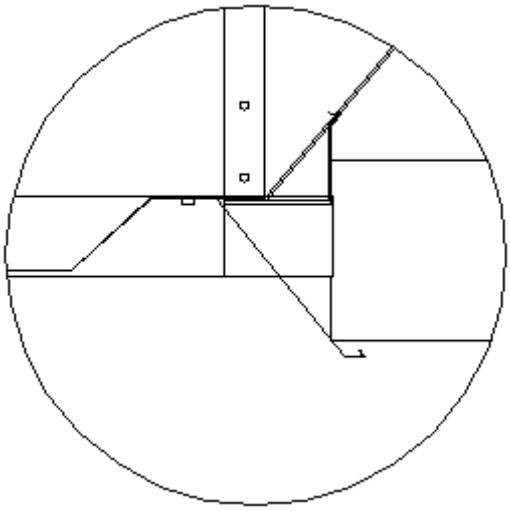
CONE BOTTOM BINS



4. DISCHARGE TROUGH INTO THE SILO CONE

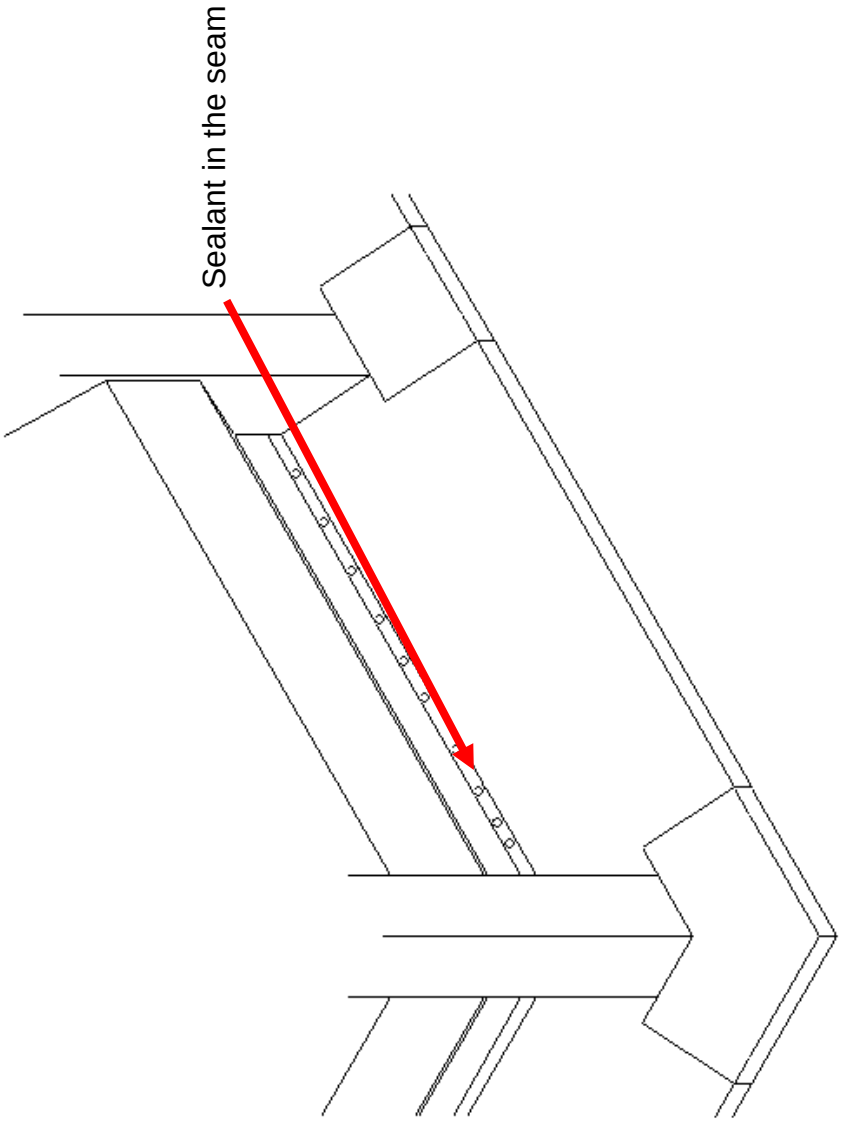
The discharge troughs (300071) are fastened to the bottom part of the cone plate with sealing compound in the seam.

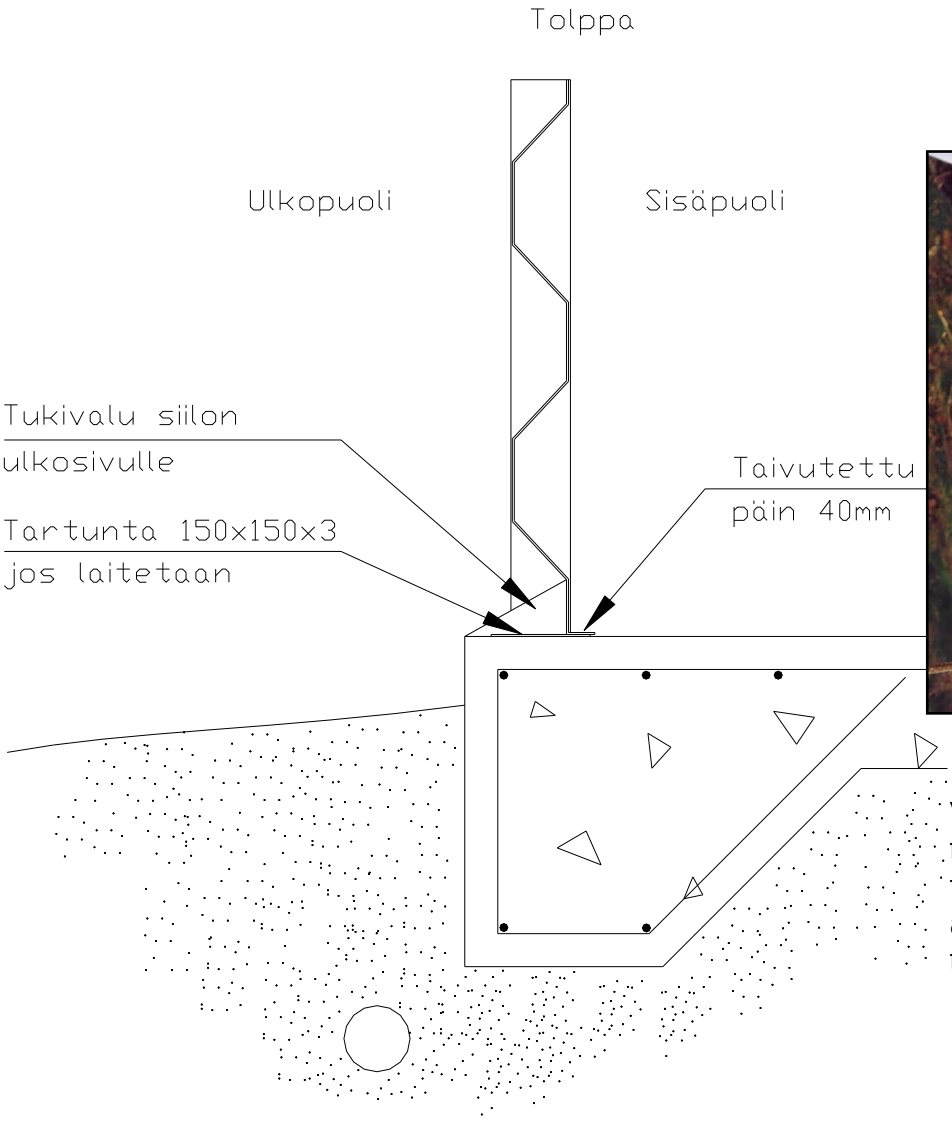




Drop list

Install with
sealing compound
and self-drilling screws





Verifying the conformity of the dimensions of a foundation mounted silo against the dimensions on the construction design.

5. ASSEMBLY ON A FLAT BASE ON A CONCRETE FOUNDATION

1. Place the lower silo poles so that they are more or less in their designated installation locations in the flat-base silo.

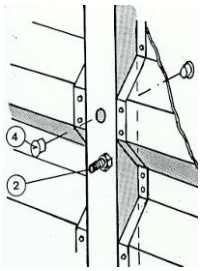
2. Start to assemble the elements. The thickest element will be the bottom element. In flat-base silos the edge of the bottom element is bent 90º. The bent edge is placed against the assembly base.

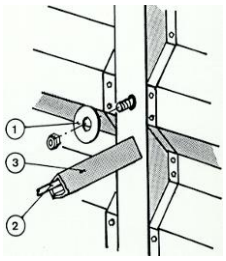
3. The elements are always positioned against the flange of the pole such that the element is inside, towards the non-welded side of the flange.

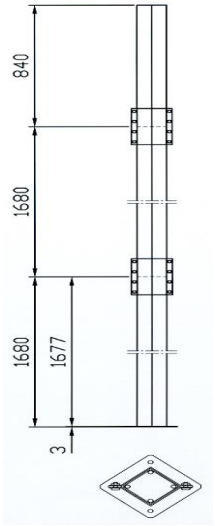
4. First assemble the complete bottom tier; tighten screws to finger-tightness. Do not insert screws in the top hole, because the bottom hole will be aligned with it.

5. By cross-measuring the structure check the proper location and shape of the bottom tier. After that tighten the screws fully.

6. Continue with the next element layer. From the outside, the lower edge of the upper element always comes on top of the lower element.





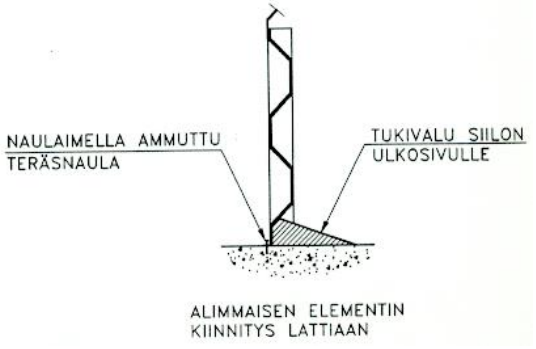


7. If the silo is higher than the height of 2 elements, place 100x33x3 mm floating plates to the lower partition walls of the tier on that side of the wall where there is no pole flange.

8. Silos without partition walls assembled using extension poles 2B, are equipped with pull-rods support pipes. Pull-rods are installed on every tier. The support pipe is provided on the bottom tier and then on every second tier. See the figures.The central pole is installed, whe the length of the support pipe and the support rc poles are assembled with bands; see the figure.

al

9. The external and partition walls of a flat-base silo are either supported with cast concrete support, shown in the figure; or fastened through the flanges to the foundation using a nail gun; 2–3 nails /element. You can also use deck screws.

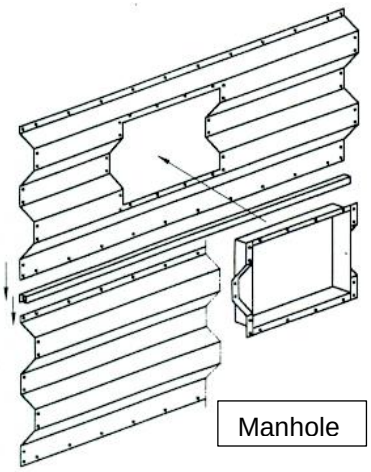


6. MANHOLE, DISCHARGE CHUTE AND LEAD-THROUGH FOR THE AUGER

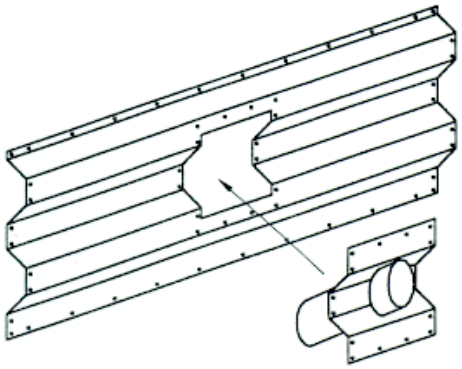
Generally the manhole is mounted in the second element tier from the foundation. In this case a reinforcement beam is installed between the first and the second element, shown in the fig.

The opening for the manhole is drawn on the element and it is cut out with a cutting disc. The manhole is inserted in the hole, and holes matching the perforations of the manhole flange are drilled in the elements.

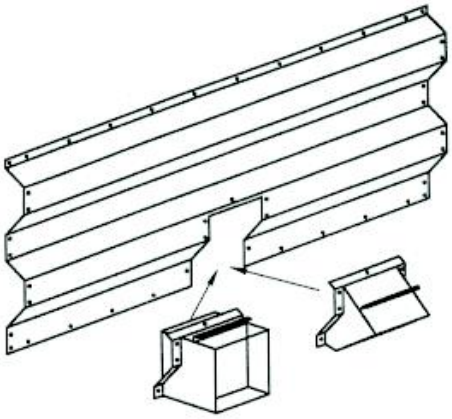
The lead-through for the auger and the discharge chutes are fastened the same way.



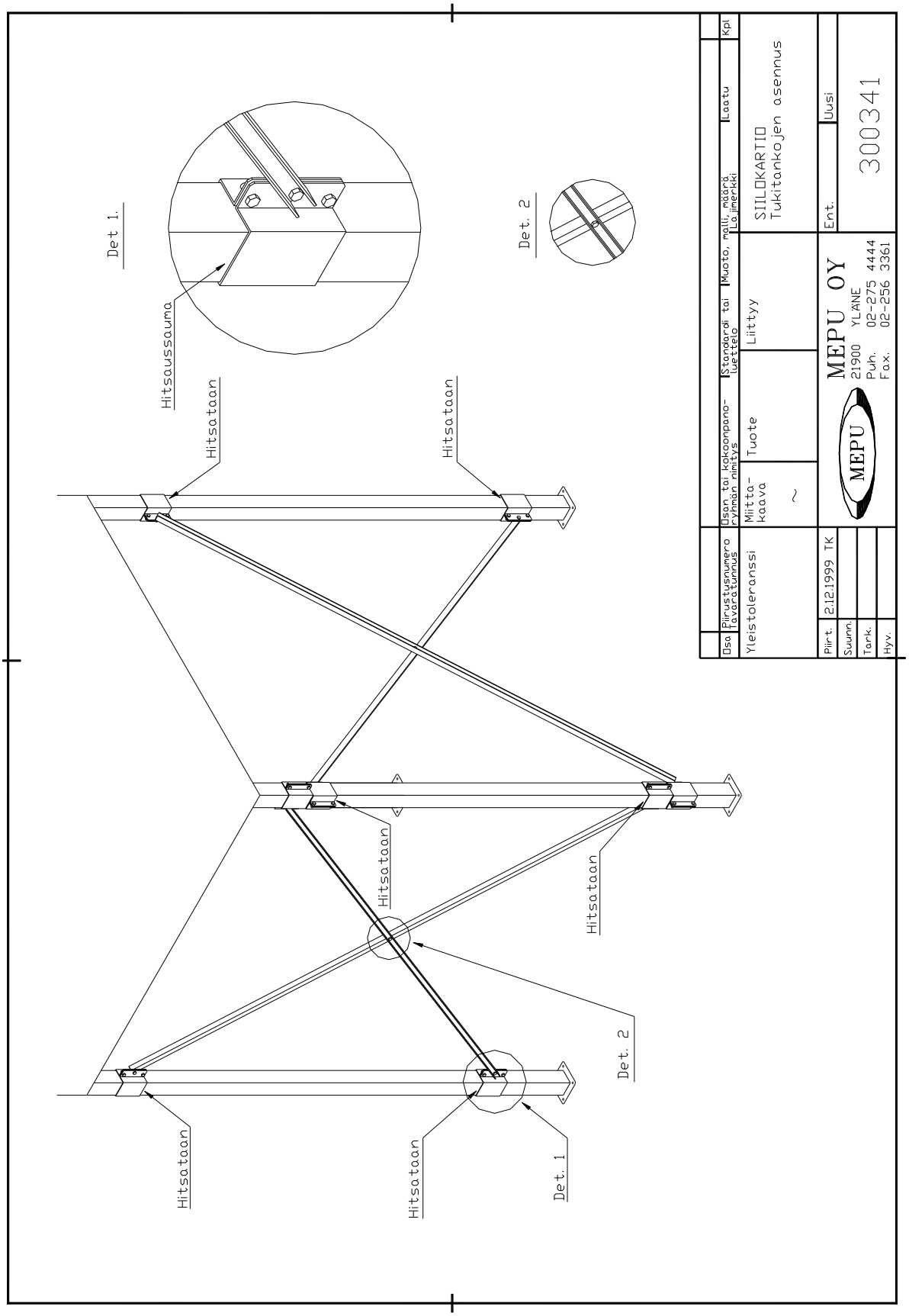
Manhole



Lead-trough for auger



Discharge chutes


Det 1.
Det. 2
Hitsaussauma
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Det. 2
Det. 1
Osa
Piirustusnumero
Tavaratunnus
Yleistoleranssi
Osan tai kokoonpanoryhmän nimitys
Mitta-kaava
Standardi tai luettelo
Tuote
Muoto, malli, määrä
Liittyy
Laatu
Kpl
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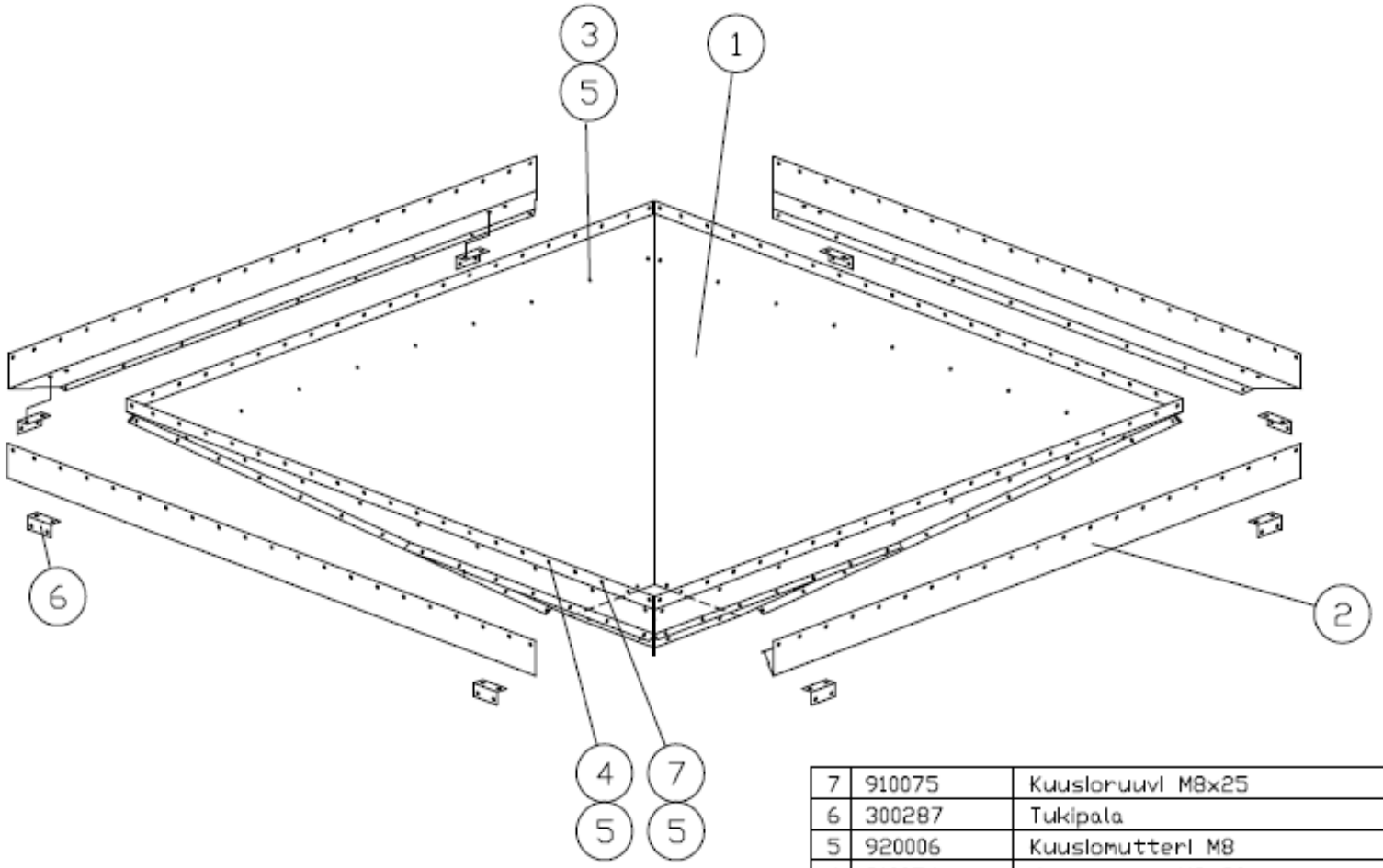
Uusi
300341



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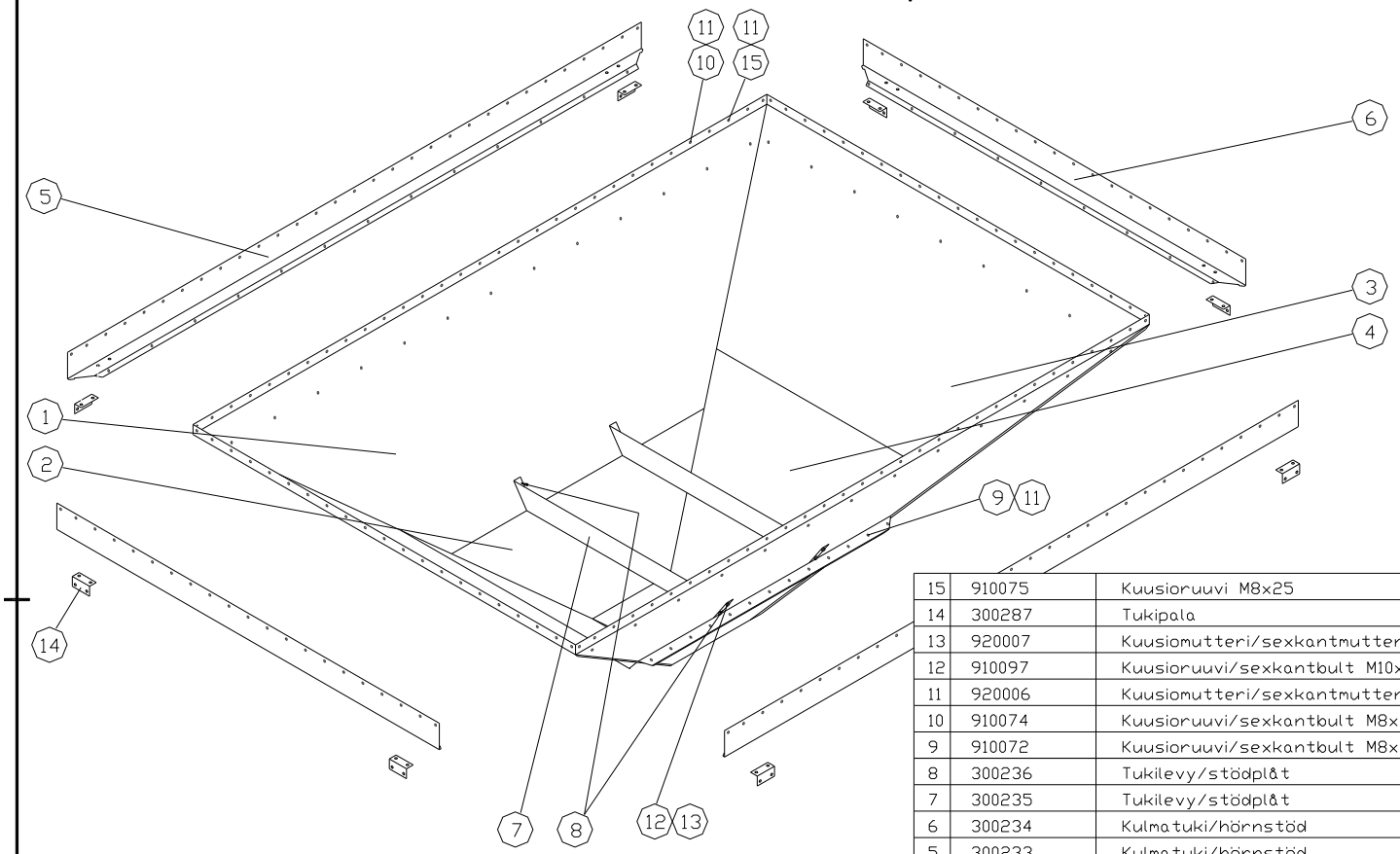
5	920006	Kuuslomutterl M8	180
4	910074	Kuusloruuvl M8x20	52
3	910072	Kuusloruuvl M8x16	112
2	300107	Kulmatukl	4
1	300106	Kartiolevy	4

Osa	Piirustusnumero Tavaratunnus	Osan tai kokoonpano-ryhmän nimitys	Standardi tai luettelo	Muoto, koko, määrä Laji merkki	Laatu	Kpl
	Yleistoleranssi	Mitta-kaava	Tuote	Liittyy	SIILOKARTIO 2000x2000	

Piirt.	16.12.98 TK	MEPU OY	Ent.	Uusi
Suunn.		21900 YLÄNE		
Tark.		Puh. 02-275 4444	300105C	
Hyv.		Fax. 02-256 3361		



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11	920006	Kuusiomutteri/sexkantmutter M8	260
10	910074	Kuusioruuvi/sexkantbult M8x20	72
9	910072	Kuusioruuvi/sexkantbult M8x16	188
8	300236	Tukilevy/stödplåt	8
7	300235	Tukilevy/stödplåt	2
6	300234	Kulmatuki/hörnstöd	2
5	300233	Kulmatuki/hörnstöd	2
4	300232	Alakartiolevy/konans plåt, nedre del	2
3	300231	Yläkartiolevy/konans plåt, övre del	2
2	300230	Alakartiolevy/konans plåt, nedre del	2
1	300229	Yläkartiolevy/konans plåt, övre del	2

Osa	Piirustusnumero Tavaratunnus	Osan tai kokoonpano-ryhmän nimitys	Standardi tai luettelo	Muoto, malli, määrä	Lajimerkki	Laatu	Kpl

Yleistoleranssi | Mitta-kaava | Tuote/liittyy

TÄMÄ PIIRUSTUS ON Mepu Oy:n OMAISUUTTA EIKÄ SITÄ SAA LUOVUTTAA KOLMANNELLE OSAPUOLELLE ILMAN Mepu Oy:n KIRJALLISTA SUOSTUMUSTA

SIILOKARTIO 3000x2000
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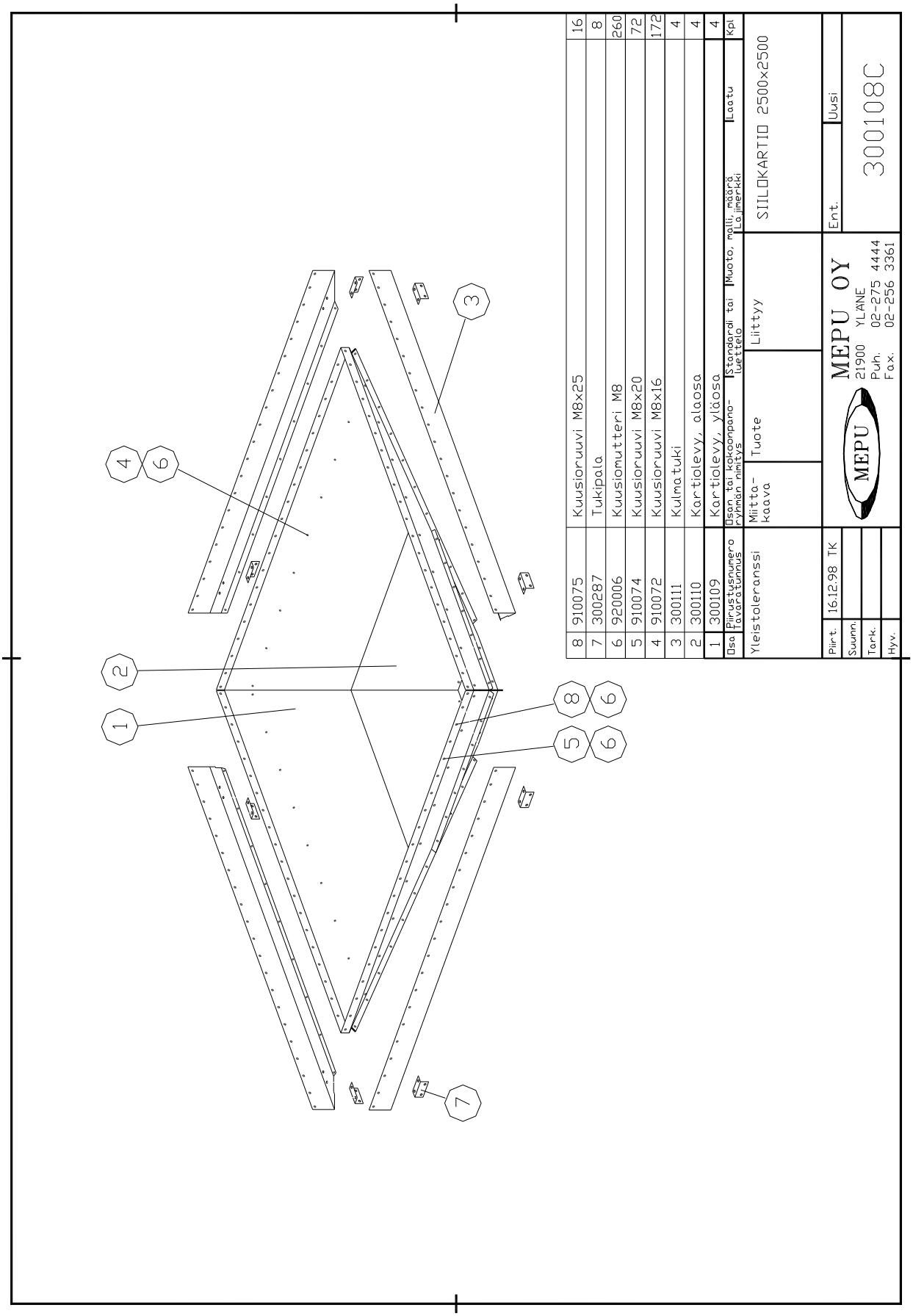
Ent. | Uusi

300228C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7 300287 Tukipala 8
6 920006 Kuusiomutteri M8 260
5 910074 Kuusioruuvi M8x20 72
4 910072 Kuusioruuvi M8x16 172
3 300111 Kulmatuki 4
2 300110 Kartiolevy, alaosa 4
1 300109 Kartiolevy, yläosa 4
Osa | Piirustusnumero tai varaosatunnus | Osan tai kokoonpanoryhmän nimitys | Standardi tai luettelo | Muoto, malli, määrä tai lisämerkki | Laatu | Kpl
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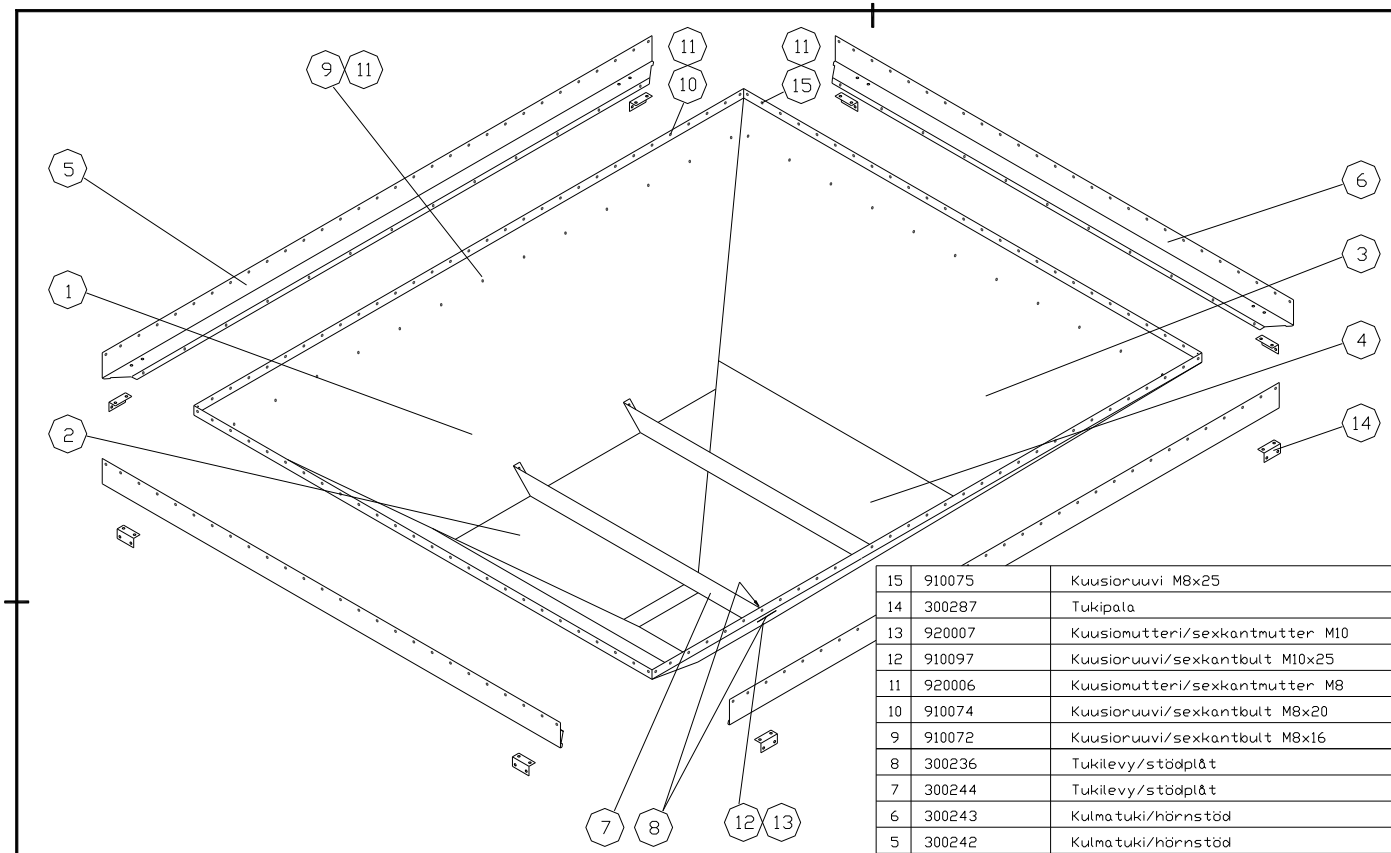

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13	920007	Kuusiomutteri/sexkantmutter M10	8
12	910097	Kuusioruuvi/sexkantbult M10x25	8
11	920006	Kuusiomutteri/sexkantmutter M8	298
10	910074	Kuusioruuvi/sexkantbult M8x20	82
9	910072	Kuusioruuvi/sexkantbult M8x16	200
8	300236	Tukilevy/stödplåt	8
7	300244	Tukilevy/stödplåt	2
6	300243	Kulmatuki/hörnstöd	2
5	300242	Kulmatuki/hörnstöd	2
4	300241	Kartiolevy, alaosa/konans plåt, nedre del	2
3	300240	Kartiolevy, yläosa/konans plåt, övre del	2
2	300239	Kartiolevy, alaosa/konans plåt, nedre del	2
1	300238	Kartiolevy, yläosa/konans plåt, övre del	2

Osa	Piirustusnumero Tavaratunnus	Osan tai kokoonpano-ryhmän nimitys	Standardi tai luettelo	Muoto, malli, määrä	Laatu	Kpl

Yleistoleranssi	Mitta-kaava	Tuote/liittyy	TÄMÄ PIIRUSTUS ON Mepu Oyn OMAISUUTTA EIKÄ SITÄ SAA LUOVUTTAA KOLMANNELLE OSAPUOLELLE ILMAN Mepu Oyn KIRJALLISTA SUOSTUMUSTA

SIILOKARTIO 3000x2500
SILO KONA

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Hyv.	

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Fax. 02-256 3361

Ent. | Uusi

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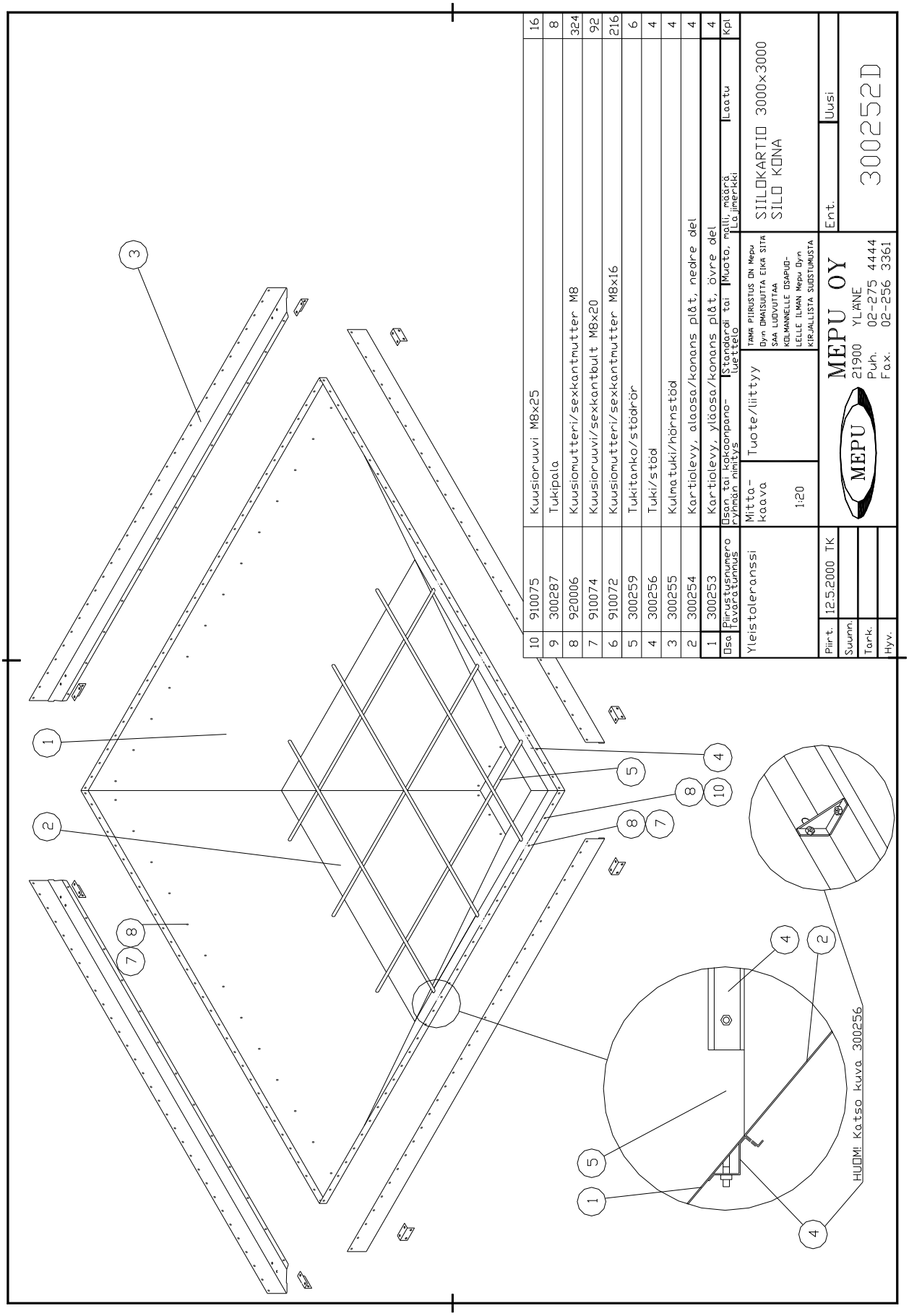
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6 910072 Kuusiomutteri/sexkantmutter M8x16 216
5 300259 Tukitanko/stödrör 6
4 300256 Tuki/stöd 4
3 300255 Kulmatuki/hörnstöd 4
2 300254 Kartiolevy, alaosa/konans plåt, nedre del 4
1 300253 Kartiolevy, yläosa/konans plåt, övre del 4
Osa Piirustusnumero tavaratunnus
Yleistoleranssi
Piirt. 12.5.2000 TK
Suunn.
Tark.
Hyv.
Osan tai kokoonpanoryhmän nimitys
Standardi tai luettelo
Muoto, malli, määrä tai jämerkki
Laatu
Kpl
Mitta-kaava 1:20
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TÄMÄ PIIRUSTUS ON Mepu Oyn OMAISUUTTA EIKÄ SITÄ SAA LUOVUTTAA KOLMANNELLE OSAPUOLELLE ILMAN Mepu Oyn KIRJALLISTA SUOSTUMUSTA
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Uusi
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300252D
HUOM! Katso kuva 300256

Installation of the silo cone spacer plates.

7. Installation of the U-beams of the green cereal silos. A U-beam is fastened to each pole.

Pohjakartioiden asennus

F

Siilon kansivaneerointi

Spreading the sealing compound.

Inspection measurement of the silo on the substrate according to the dimensions of structural design.

Mepu´s service and spare parts:

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