

**INSTALLATION INSTRUCTIONS:**

**GENERAL:**

The modules can preferably be welded to load carrier and foundation, which eliminates problems of getting holes on top and bottom lined up. Or, for example, bolted on top and welded on bottom. The modules are delivered preassembled excl. load cells and loading cups as shown on figure 1.

**INSTALLATION:**

1. Position the preassembled modules on the foundation plates and put on the load carrier as shown in figure 1.
2. Weld modules on top and bottom as shown on figure 1. Also see note 2. Alternatively bolt as shown on figure 3.
3. Apply a layer of grease to the O-rings (30) inside the loading cups (24, 26) and assemble cups with the load cell (11). Slide load cell with cups into position. Mount the lower clamp and torque the screws. Mount also upper clamp but torque screws loosely at this stage.
4. Remove the fixation screws (22) on all weigh modules. Check that the gap between the washer (19) and the bottom unit (14) is ca 10 mm.
5. For one module at a time, lift the load carrier slightly 1-3 mm to allow removal of the spacers (18). Lifting is preferably done with a hydraulic jack positioned in suitable position close to the module.
6. Lower the load carrier onto load cell and remove the jack. Now torque the screws for the upper clamp. Set the "lift up gap" to 1-3 mm and lock the lift off screw (20) with the locking screw (21).

7. Repeat the procedure described in items 5-6 for all weigh modules.
8. For very stiff load carriers shimming might be necessary to obtain even load distribution. This should be planned and prepared prior to installation. See drawing 3-7996 for details.

**RELATED DRAWINGS:**

- 2-8023, CAD-file drawing for cutting and pasting into customer's own application drawings.
- 4-8022, Outline drawing.
- 3-7996, Shimming parts with installation instructions.
- 4-8024, Slide show, illustrating function and installation, (SFX-file).

**NOTE 1:**

x In tank/silo applications with 3 respectively 4 weigh modules can be assumed that minimum 2 modules will equally share actual side force (wind) on the tank/silo. Actual lift off force shall, for worst case, be assumed being taken by one module. For stainless modules, reduce "Max lift off force" and "Max side force" stated in table to 60%.

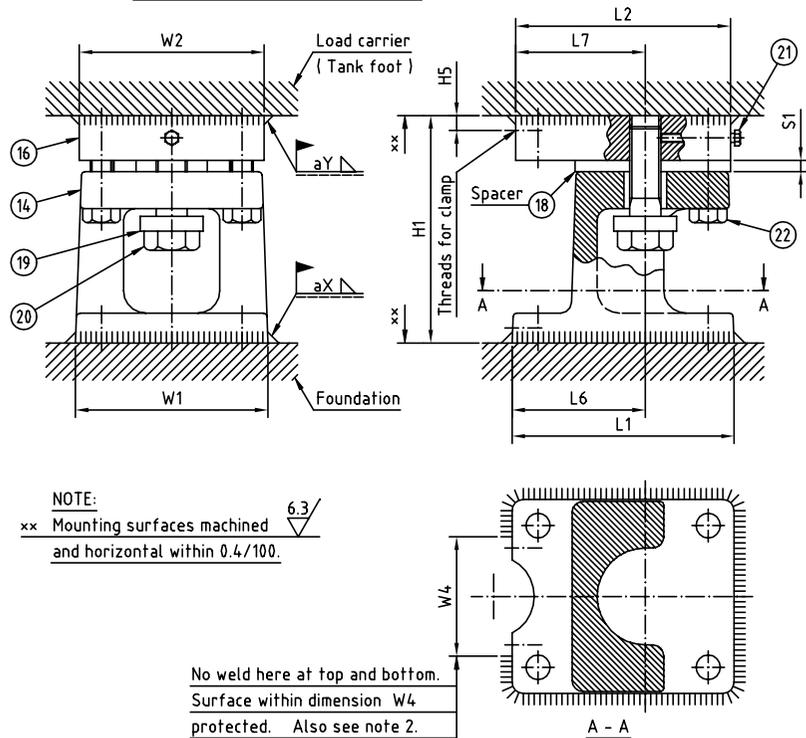
**NOTE 2:**

Material of mild steel weigh module is S355JR. Before welding, remove paint in the weld areas. Preheat material to 150-200°C. After welding, clean, apply primer and protective paint (RAL 1003).

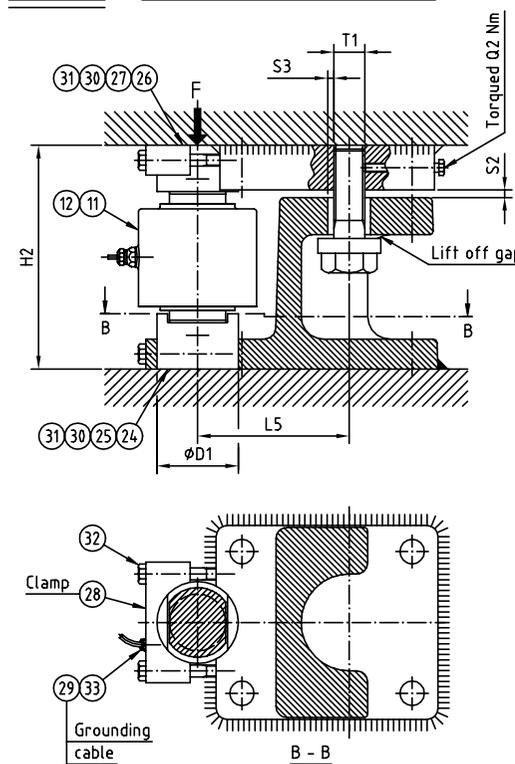
Rev.	Date	Sign/Apply	Description
1	030626	N.A	Forces and text changed
2	030923	N.A	Clamps changed
3	040202	N.A	Weld sizes changed.
4	050126	N.A/K.N	Note 2 added.
5	050202	K.N/K.N	Note 2 modified
6	050805	P.N/K.N	In note 2, colour changed
			Torque Q2 added.

Load cell type/capacity	Parts list standard	Parts list stainless	D1	D2	H1	H2	H3	H4	H5	L1	L2	L3	L4	L5	L6	L7	S1	S2	S3	T1	T2	W1	W2	W3	W4	Q1 Nm	Q2 Nm	Weld size X mm	Weld size Y mm	Max lift off force kN x	Max side force kN x	Weight excl. load cell kg
RC3-50t/100t	4-8003-A/B	4-8013-A/B	85	26	254	250	34	50	15	260	250	200	45	165	150	145	12	8	7	M36	M24	210	200	150	130	700	35	12	7	300	150	65
RC3-150t	4-8004-A	4-8014-A	110	33	305	300	40	60	20	300	290	230	60	205	180	175	15	10	8	M42	M30	260	250	190	160	1300	60	15	8	400	200	113
RC3-300t	4-8005-A	4-8015-A	135	39	405	400	60	70	25	370	350	280	65	235	215	205	15	10	10	M56	M36	320	300	230	200	2300	140	20	10	600	300	225

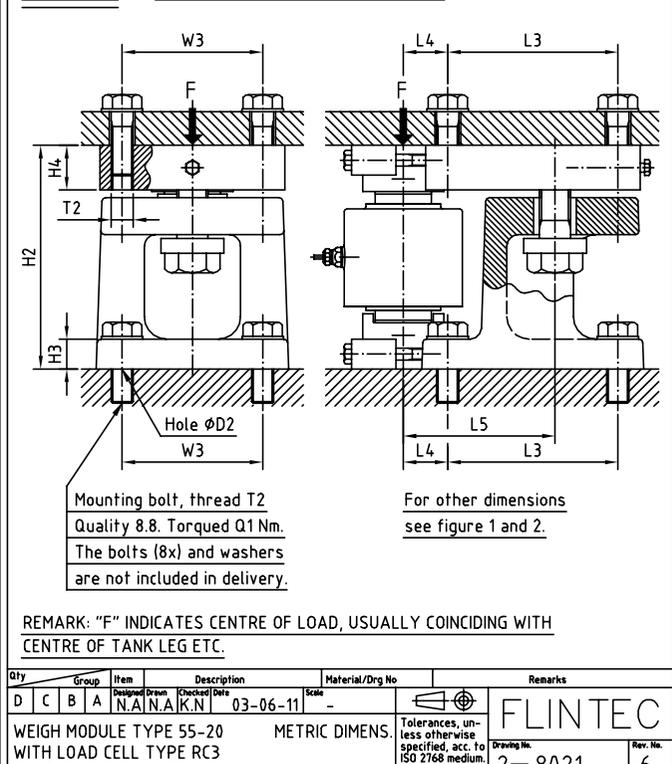
**FIGURE 1** MODULE ASSEMBLED FOR SHIPMENT, POSITIONED ON SITE AND SHOWING THE WELDED ALTERNATIVE.



**FIGURE 2** WELDED MODULE FINALLY INSTALLED.



**FIGURE 3** BOLTED MODULE FINALLY INSTALLED.



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Qty	Group	Item	Description	Material/Dwg No	Remarks					
D	C	B	A	N.A	N.A	K.N	03-06-11	-		
WEIGH MODULE TYPE 55-20 METRIC DIMENS.										
WITH LOAD CELL TYPE RC3										
ASSEMBLY WITH INSTALLATION INSTRUCTIONS										
Tolerances, unless otherwise specified, acc. to ISO 2768 medium. Hole tol. acc. to ISO tol. H12.										
Drawing No. 2-8021									Rev. No. 6	