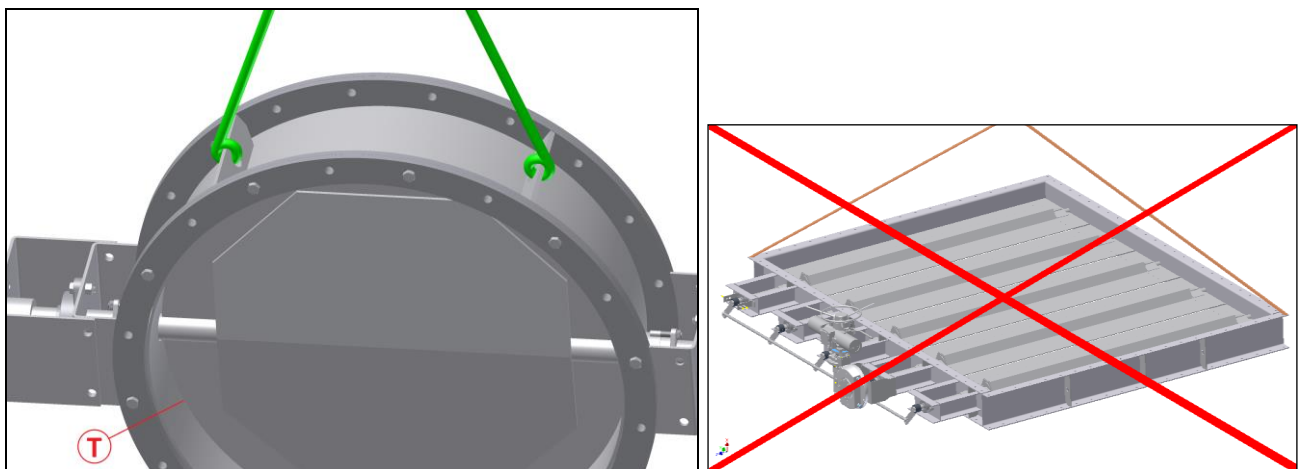


## Mounting instruction for Swedspjäll dampers (type 100-600)

### Option 1.

- Mount the counter flanges on the damper (without gasket) using a few bolts
- Close the damper
  - Attach approved lifting slings on the lifting eyes placed between the flanges and lift the damper into position (see image below):



**The damper shall not be lifted diagonally when lifted from a horizontal position; this may harm the damper frame!**

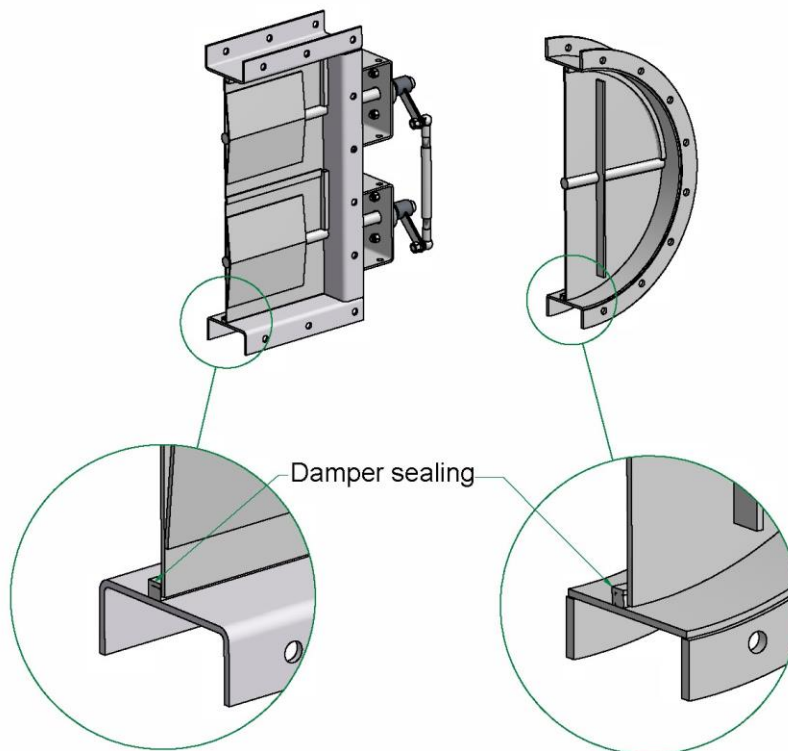
- When the damper is in place, check the sealing all around the disc on the inside of the duct - (T) on the above image. On dampers with multiple shafts: check the sealing between the discs.
  - If it doesn't seal properly the frame is bent and adjustment of the lifting points must be made.
- Spot weld the counter flange to the duct.
- Demount the bolts between damper and counter flange and remove the damper.
- Weld intermittently, alternating between both sides of the flange, before fully welding it (to prevent deformation caused by welding).
- The flange must be fully welded on the inside of the duct. The outside can be either fully welded or welded intermittently.

### Option 2.

- Lift the counter flange up against the duct.
- Measure and make sure the **flange is flat and not skewed**. Use both level and straightedge (if a straightedge isn't available a string can be used instead).
- When the flange is flat, weld it against the duct.
- **Note! If the flange is skewed, the damper will not seal properly!**
- When mounting the opposing flange, it is important that the flanges are parallel to each other and that the mounting dimension is the same all around the flange.

### Final check after mounting:

- Close the damper and enter the duct.
- Make sure the blades are pressing against the damper sealing:



### If the disc doesn't press against the sealing:

- If one or more blade doesn't seal, but are parallel to the sealing in the frame:
  - Adjust the blades accordingly (might also indicate a broken link arm):
    - Loosen the locking nut on the link arm and adjust the disc.
    - If this doesn't help, all link arms must be loosened and the entire linkage must be adjusted from the start. First, make sure the disc where the actuator is mounted is closing properly – if not, adjust the end position. Then adjust the next blade closes to this shaft (if the blade connected directly to the actuator is positioned between to shafts, adjust the crosswise). See separate instruction on how to adjust the linkage on dampers with multiple shafts.

### If the disc and sealing aren't parallel (top or bottom):

- This indicated that the damper has been mounted in an angle (and is skewed).
  - This requires the damper sealing to be moved (by an experienced welder).
  - The welds holding the sealing must first be removed.
  - The damper is then closed and the sealing is pressed against the disc and re-welded.
  - It's important that the correct welding electrode is used based on the material of the damper.