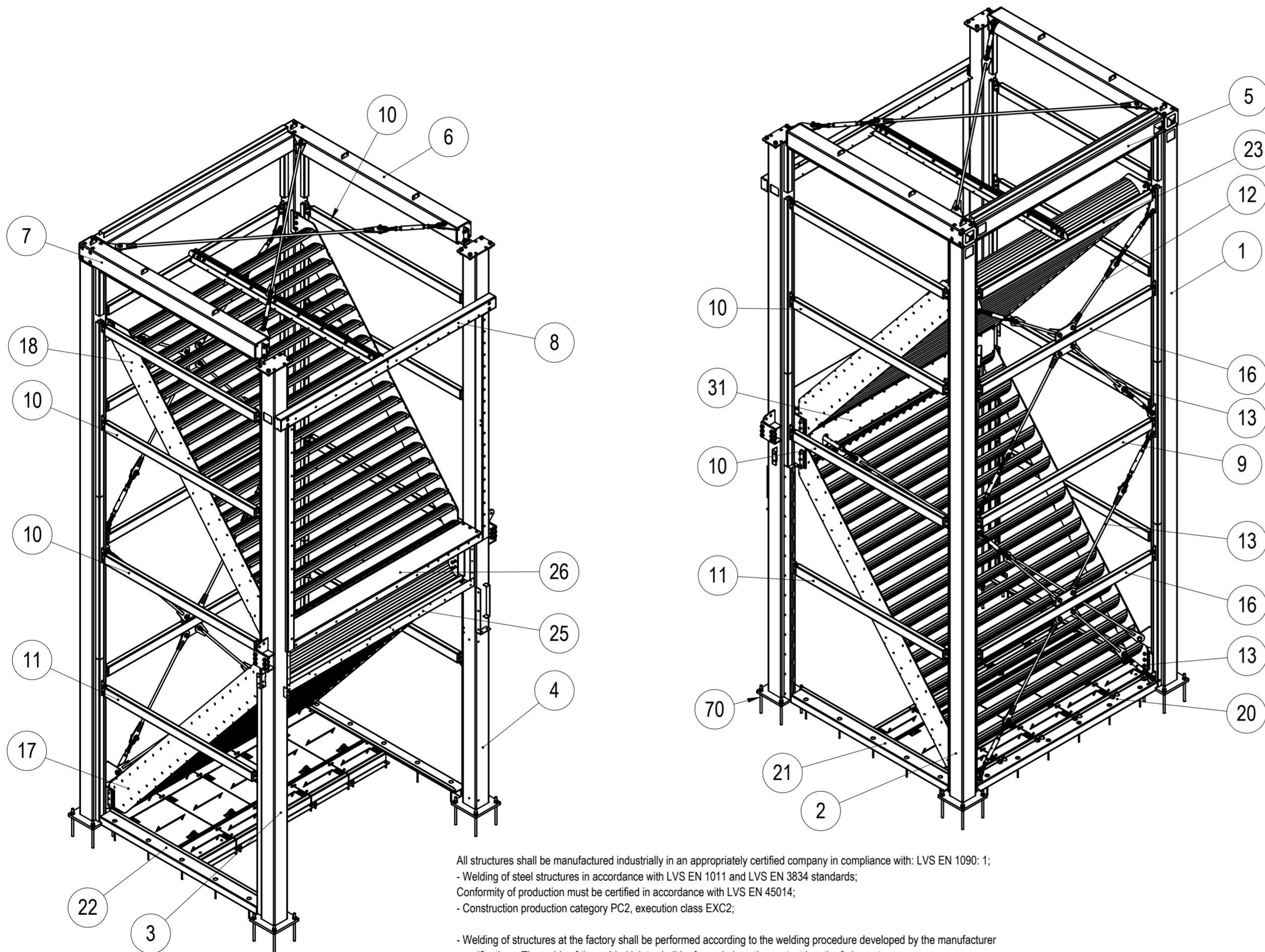


NO.	PART NO	DESCRIPTION	MATERIAL	PROCESSING	REVISION	WEIGHT	QTY
1	105-05001-00	L1 column	-	WLD HDG		379.77	1
2	105-05002-00	L2 column	-	WLD HDG		379.77	1
3	105-05003-00	R1 column	-	WLD HDG		385.36	1
4	105-05004-00	R2 column	-	WLD HDG		387.52	1
5	105-05005-00	Upper back crossbeam	-	WLD HDG		131.76	1
6	105-05006-00	Flanged side beam 2	-	WLD HDG		113.83	1
7	105-05007-00	Flanged side beam 1	-	WLD HDG		113.83	1
8	105-05008-00	Upper crossbeam front	-	WLD HDG		49.70	1
9	105-05012-00	Horizontal back beam middle	-	WLD HDG		28.11	1
10	105-05013-00	Horizontal side beam long	-	WLD HDG		24.99	6
11	105-05014-00	Horizontal side beam short	-	WLD HDG		24.55	2
12	105-05017-00	Short link + tightening fork	-	ASY		10.13	2
13	105-05018-00	Long link + tightening fork	-	ASY		11.61	6
14	105-05019-00	Deflector link + tightening fork	-	ASY		21.77	2

NO.	PART NO	DESCRIPTION	MATERIAL	PROCESSING	REVISION	WEIGHT	QTY
15	105-05023-00	Safety net flange	-	WLD HDG		3.75	2
16	105-05024-00	Horizontal beam with long link bracket	-	WLD HDG		35.36	2
17	105-05025-00	Storm Deflector 1	-	WLD HDG		1177.97	1
18	105-05026-00	Storm Deflector 2	-	WLD HDG		1176.51	1
19	105-05027-00	Top link + tightening fork	-	ASY		17.55	2
20	105-05029-00	Bottom rear beam	-	WLD HDG		28.84	1
21	105-05030-00	Bottom side beam 1	-	WLD HDG		26.16	1
22	105-05031-00	Bottom side beam 2	-	WLD HDG		26.16	1
23	105-05032-00	Horizontal side beam long	-	WLD HDG		28.84	1
24	105-30800-00	Dirt collector	-	ASY		262.29	1
25	105-05000-01	Entrance zone bracket	S355J2	LCB HDG		28.92	1
26	105-05000-02	Return air channel bracket	S355J2	LCB HDG		72.35	1
27	105-05000-03	U channel - unequal leg	S355J2	LCB HDG		20.94	2
28	105-05000-04	Threaded block	1.0503 (C45)	LC HDG		1.16	8

NO.	PART NO	DESCRIPTION	MATERIAL	PROCESSING	REVISION	WEIGHT	QTY
29	105-05000-05	Deflector shimplate 2mm	DX51+Z275	LC		0.26	26
30	105-05000-06	Deflector shimplate 1.5mm	DX51+Z275	LC		0.19	8
31	105-05000-07	Deflector gap cover plate	DX51D+Z275	LC		13.21	1
32	105-05000-08	Plywood guard plate 1	DX51D+Z275	LCB		0.84	2
33	105-05000-09	Plywood guard plate 2	DX51D+Z275	LCB		0.94	1
34	105-05000-10	Acoustic panel corner guard	DX51D+Z275	LCB		1.28	2
35	105-05000-11	Truss frame shimplate	DX51D+Z275	LC		0.56	4
36	105-05000-20	Rear plywood 1	Plywood Riga Form (laminated)	OTH		55.52	3
37	105-05000-22	Rear plywood 2	Plywood Riga Form (laminated)	OTH		40.11	1
38	105-05000-23	Rear plywood 3	Plywood Riga Form (laminated)	OTH		25.15	1
39	105-05000-24	Side plywood 1	Plywood Riga Form (laminated)	OTH		49.53	4
40	105-05000-26	Side plywood 1R	Plywood Riga Form (laminated)	OTH		35.78	1
41	105-05000-27	Side plywood 2	Plywood Riga Form (laminated)	OTH		22.44	2
42	105-05000-28	Side plywood 1L	Plywood Riga Form (laminated)	OTH		41.98	1
43	105-05000-29	Side plywood 2L	Plywood Riga Form (laminated)	OTH		41.31	1
44	105-05000-31	Side plywood 3L	Plywood Riga Form (laminated)	OTH		27.56	1
45	105-05000-32	Top plywood	Plywood Riga Form (laminated)	OTH		49.83	2
46	105-05000-33	Front plywood	Plywood Riga Form (laminated)	OTH		18.64	1
47	105-05000-70	Rear panel 1	Kingspan KS1150 AF 80mm	CND		42.18	2
48	105-05000-71	Rear panel 2	Kingspan KS1150 AF 80mm	CND		42.05	1
49	105-05000-72	Rear panel 3	Kingspan KS1150 AF 80mm	CND		42.02	1
50	105-05000-73	Rear panel 4	Kingspan KS1150 AF 80mm	CND		41.93	1
51	105-05000-74	Rear panel 5	Kingspan KS1150 AF 80mm	CND		21.31	1
52	105-05000-75	Side panel 1R	Kingspan KS1150 AF 80mm	CND		36.81	1
53	105-05000-76	Side panel 2R	Kingspan KS1150 AF 80mm	CND		37.65	1
54	105-05000-77	Side panel 3R	Kingspan KS1150 AF 80mm	CND		36.80	1
55	105-05000-78	Side panel 4R	Kingspan KS1150 AF 80mm	CND		37.05	1
56	105-05000-79	Side panel 5R	Kingspan KS1150 AF 80mm	CND		37.63	1
57	105-05000-80	Side panel 6R	Kingspan KS1150 AF 80mm	CND		19.41	1
58	105-05000-81	Side panel 1L	Kingspan KS1150 AF 80mm	CND		35.41	1
59	105-05000-82	Side panel 2L	Kingspan KS1150 AF 80mm	CND		33.27	1
60	105-05000-83	Side panel 3L	Kingspan KS1150 AF 80mm	CND		29.75	1
61	105-05000-84	Side panel 4L	Kingspan KS1150 AF 80mm	CND		27.99	1
62	105-05000-85	Side panel 5L	Kingspan KS1150 AF 80mm	CND		37.63	1
63	105-05000-86	Side panel 6L	Kingspan KS1150 AF 80mm	CND		14.74	1
64	Blind rivet 4.0x6	Würth 0935 4 6	EZn	COTS		0.00	30
65	DIN 5299-C + screw	CERTEX Art.no. 11.565299D07	EZn	COTS		0.05	27
66	Wuerth_021966450	CSK wing type drilling screw	FlakeZn	COTS		0.01	600
67	Loctite 243	Threadlocking adhesive medium strength 45ml	-	COTS		0.00	1
68	Bossard_5403131	Bent eye bolt M6x60	EZn	COTS		0.02	27
69	DIN 976-1 M10 8.8 HDG L=200	Metric thread stud bolt	HDG-8.8	COTS		0.12	16
70	DIN 976-1 M20 8.8 HDG L=350	Metric thread stud bolts	HDG-8.8	COTS		0.86	16
71	DIN 7504K ST6.3x25	Hex head self-drilling screw	EZn	COTS		0.01	44
72	DIN 7504K ST6.3x100	Hex head self-drilling screw	EZn	COTS		0.03	300
73	ISO4017 (DIN933) M6x20	Hex bolt	EZn-8.8	COTS		0.01	24
74	ISO4014 (DIN931) M16x60	Hex bolt with shank	HDG-8.8	COTS		0.13	24
75	ISO4032 (DIN934) M6	Hex nut	EZn-8	COTS		0.00	78
76	ISO4032 (DIN934) M10	Hex nut	HDG-8	COTS		0.01	16
77	ISO4032 (DIN934) M12	Hex nut	EZn-8	COTS		0.02	8
78	ISO4032 (DIN934) M20	Hex nut	HDG-8	COTS		0.07	16
79	ISO7089 (DIN125) M6	Plain Washer	EZn-HV200	COTS		0.00	102
80	ISO7089 (DIN125) M10	Plain Washer	HDG-HV200	COTS		0.00	16
81	ISO7089 (DIN125) M12	Plain Washer	HDG-HV200	COTS		0.01	156
82	ISO7089 (DIN125) M16	Plain Washer	HDG-HV200	COTS		0.01	64
83	ISO7089 (DIN125) M20	Plain Washer	HDG-HV200	COTS		0.02	56
84	ISO10642 (DIN7991) M12x45	CSK socket screw	EZn-8.8	COTS		0.05	8
85	SB EN 15048-1 ISO4014 (DIN931) M12x45	SB Hex bolt with shank	HDG-8.8	COTS		0.06	48
86	SB EN 15048-1 ISO4014 (DIN931) M16x65	SB Hex bolt with shank	HDG-8.8	COTS		0.14	4
87	SB EN 15048-1 ISO4017 (DIN933) M12x40	SB Hex bolt	HDG-8.8	COTS		0.05	26
88	SB EN 15048-1 ISO4017 (DIN933) M16x50	SB Hex bolt	HDG-8.8	COTS		0.12	16
89	SB EN 15048-1 ISO4017 (DIN933) M20x60	SB Hex bolt	HDG-8.8	COTS		0.22	20
90	SB EN 15048-1 ISO4032 (DIN934) M12	SB Hex nut	HDG-8	COTS		0.02	74
91	SB EN 15048-1 ISO4032 (DIN934) M16	SB Hex nut	HDG-8	COTS		0.04	20
92	SB EN 15048-1 ISO4032 (DIN934) M20	SB Hex nut	HDG-8	COTS		0.07	20
93	Scell-it_XPRO_2500ml	Vinyl ester resin for concrete	-	COTS		0.00	1
94	Wood screw d5x25	SPAX Flange head Cross Z2	EZn	COTS		0.00	94

Isometric views without acoustic panels and plywood panels



All structures shall be manufactured industrially in an appropriately certified company in compliance with: LVS EN 1090-1;
 - Welding of steel structures in accordance with LVS EN 1011 and LVS EN 3834 standards;
 Conformity of production must be certified in accordance with LVS EN 45014;
 - Construction production category PC2, execution class EXC2;

- Welding of structures at the factory shall be performed according to the welding procedure developed by the manufacturer specifications. The welds of the welded joints shall be formed along the contact length of elements, assuming that the thickness of the corner seam (leg length) cannot exceed $a = 0.85 (z = 1.2)$ of the thickness of the thinnest element (unless otherwise indicated in the drawings);
 - Butt welds must have 100% penetration.

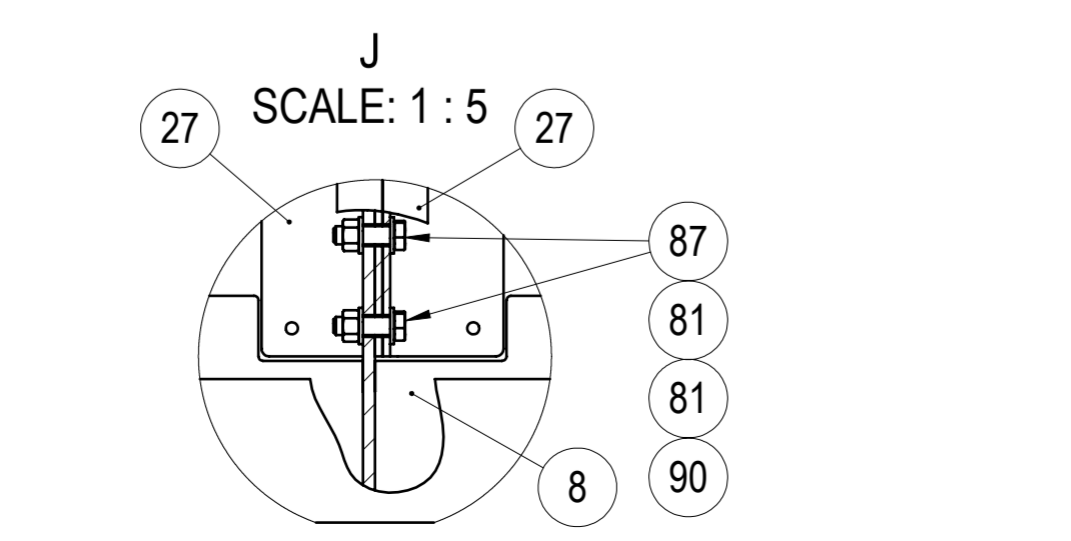
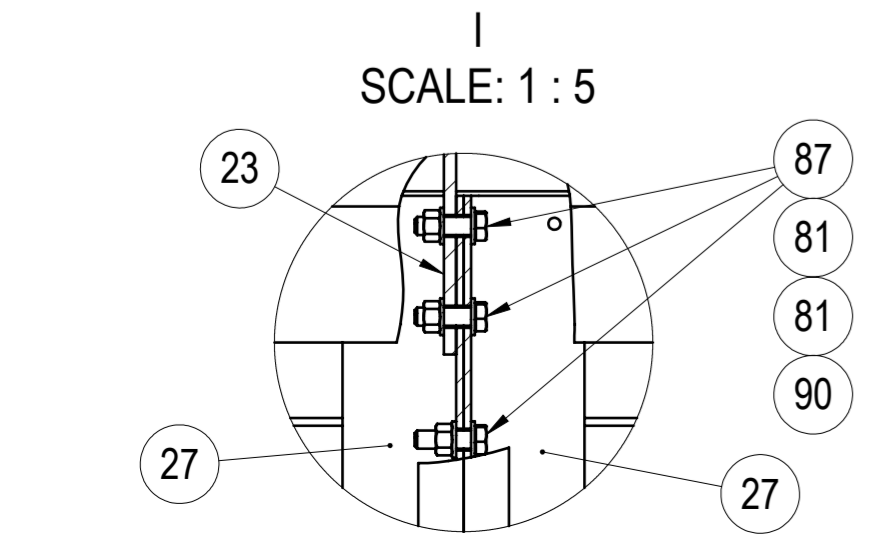
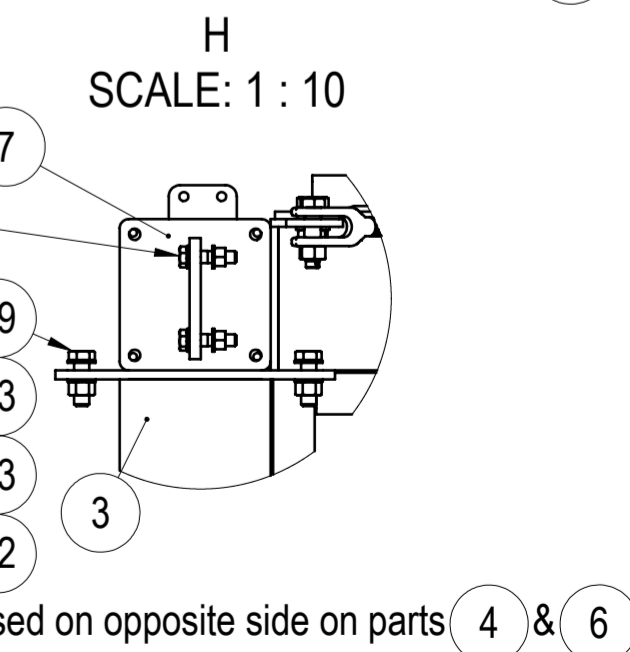
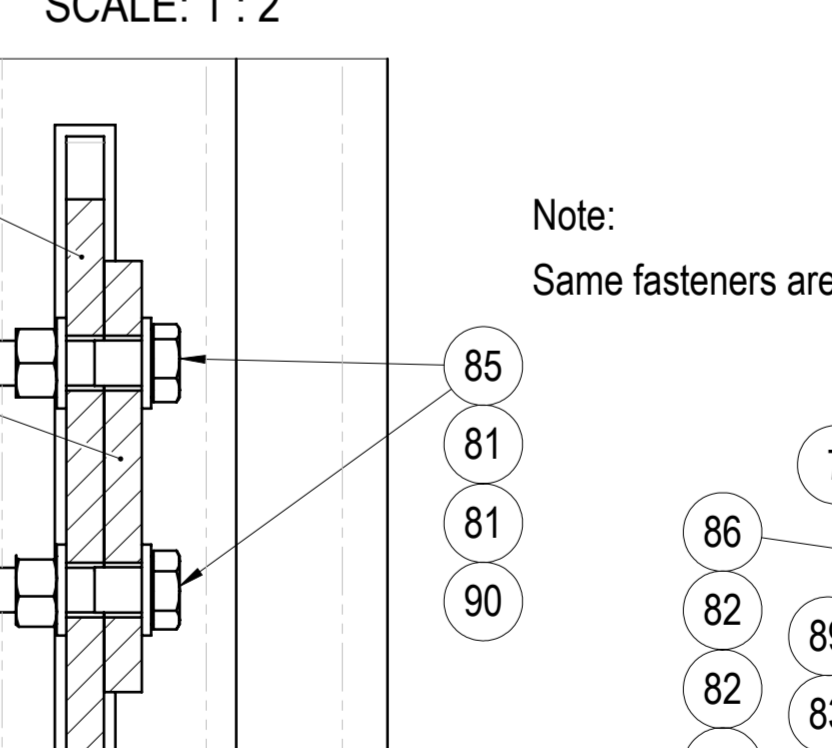
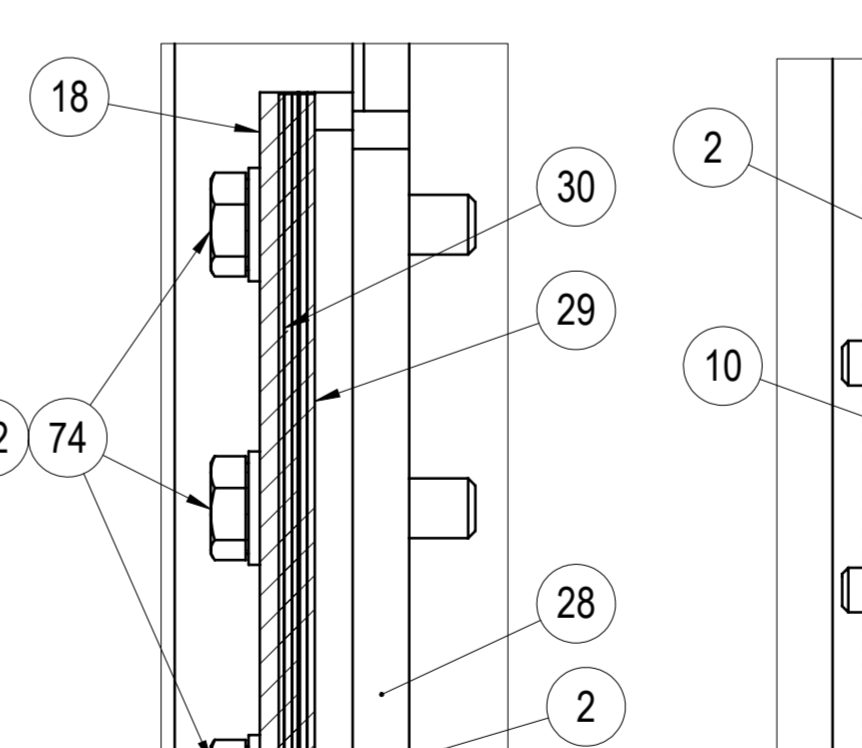
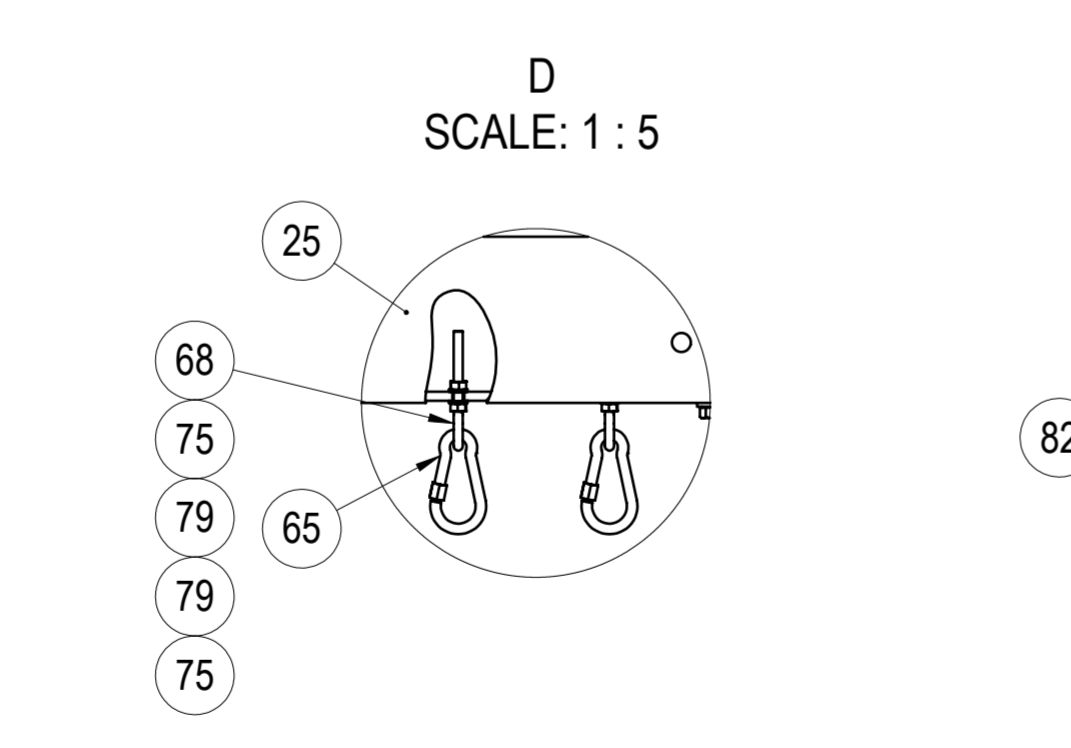
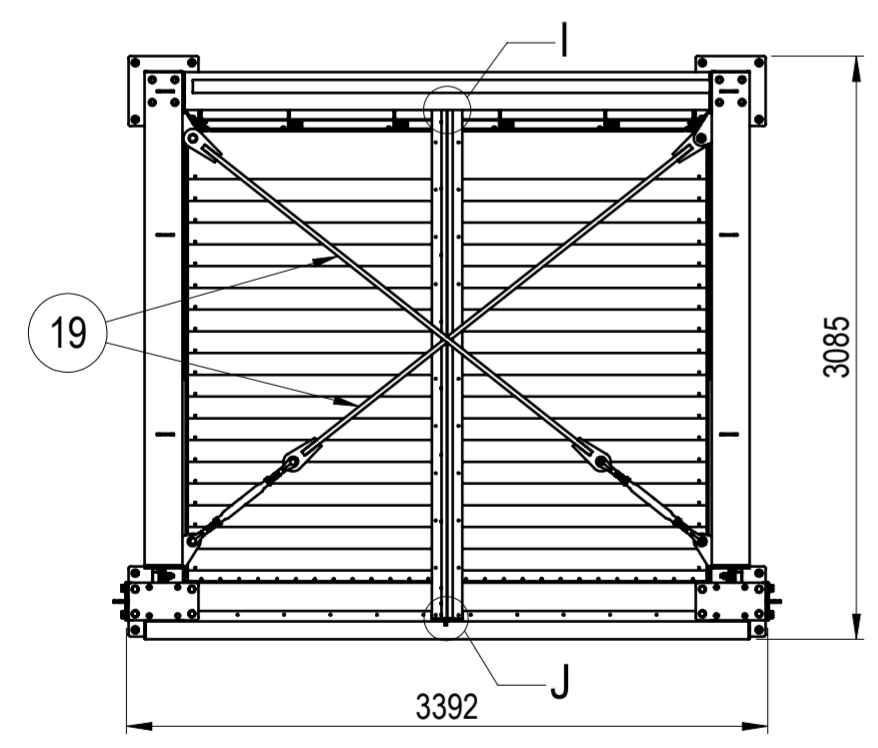
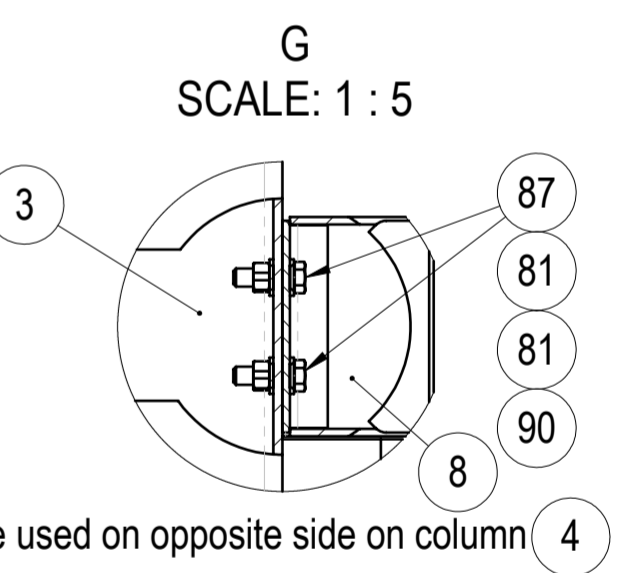
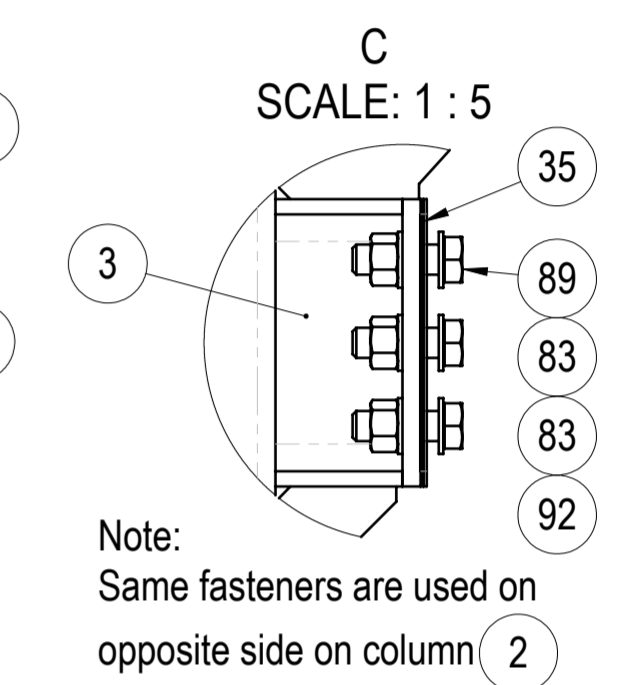
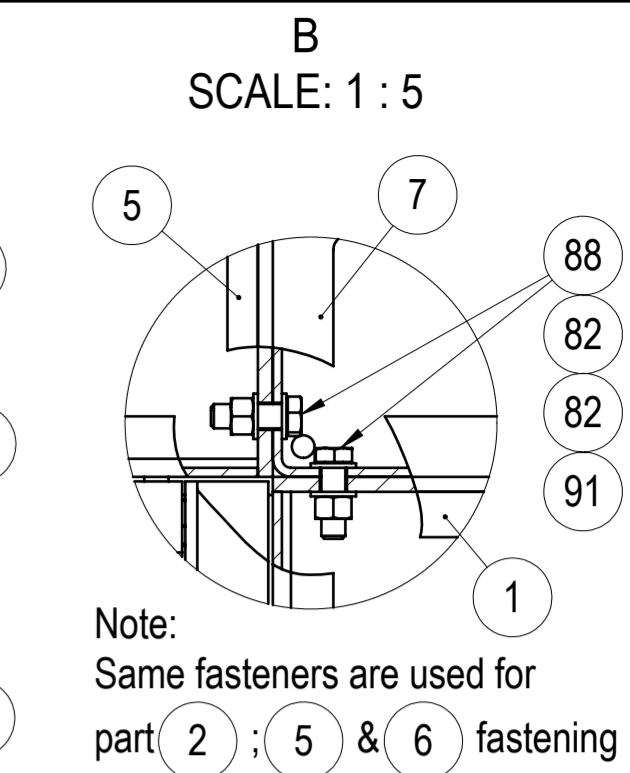
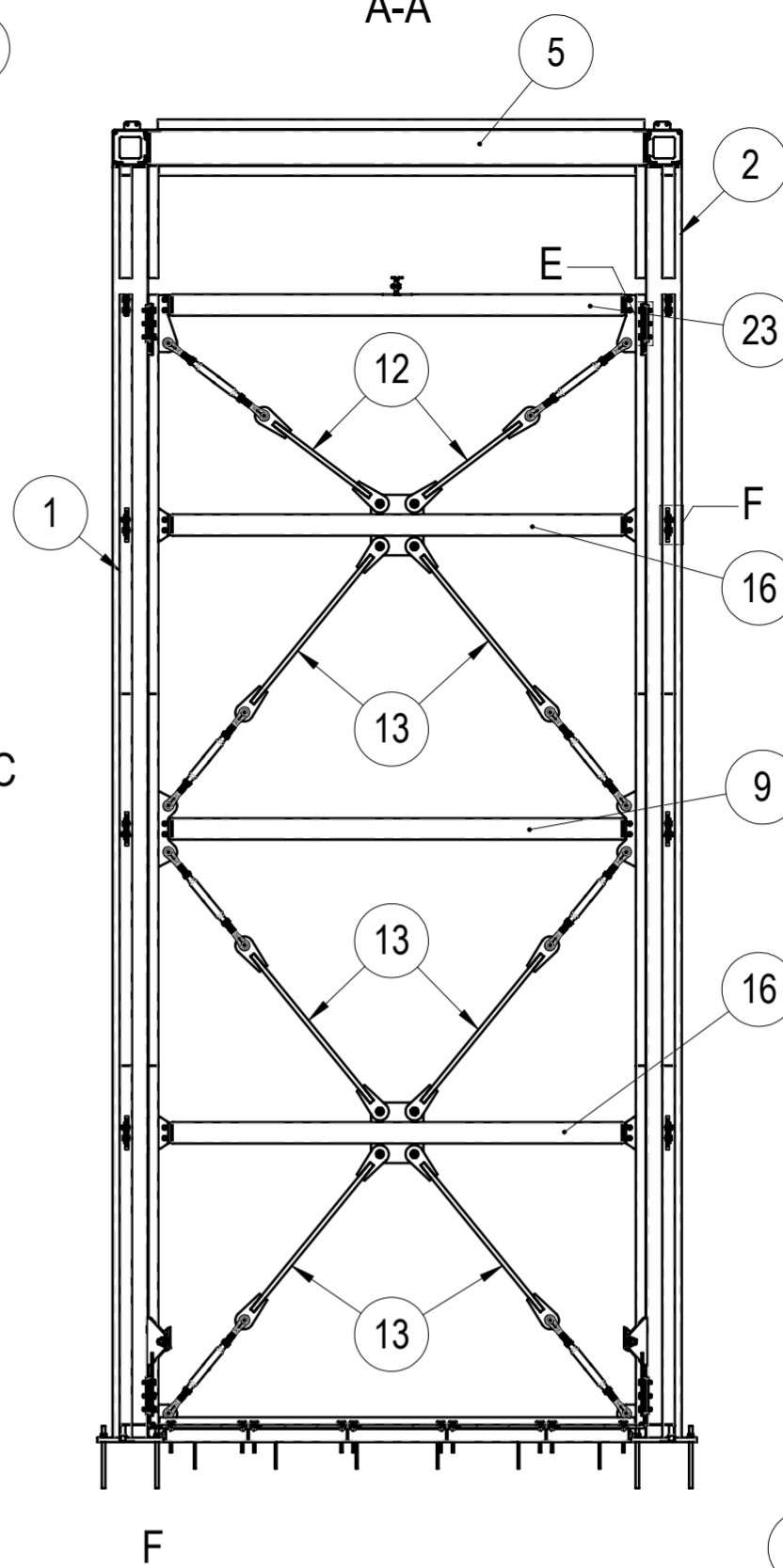
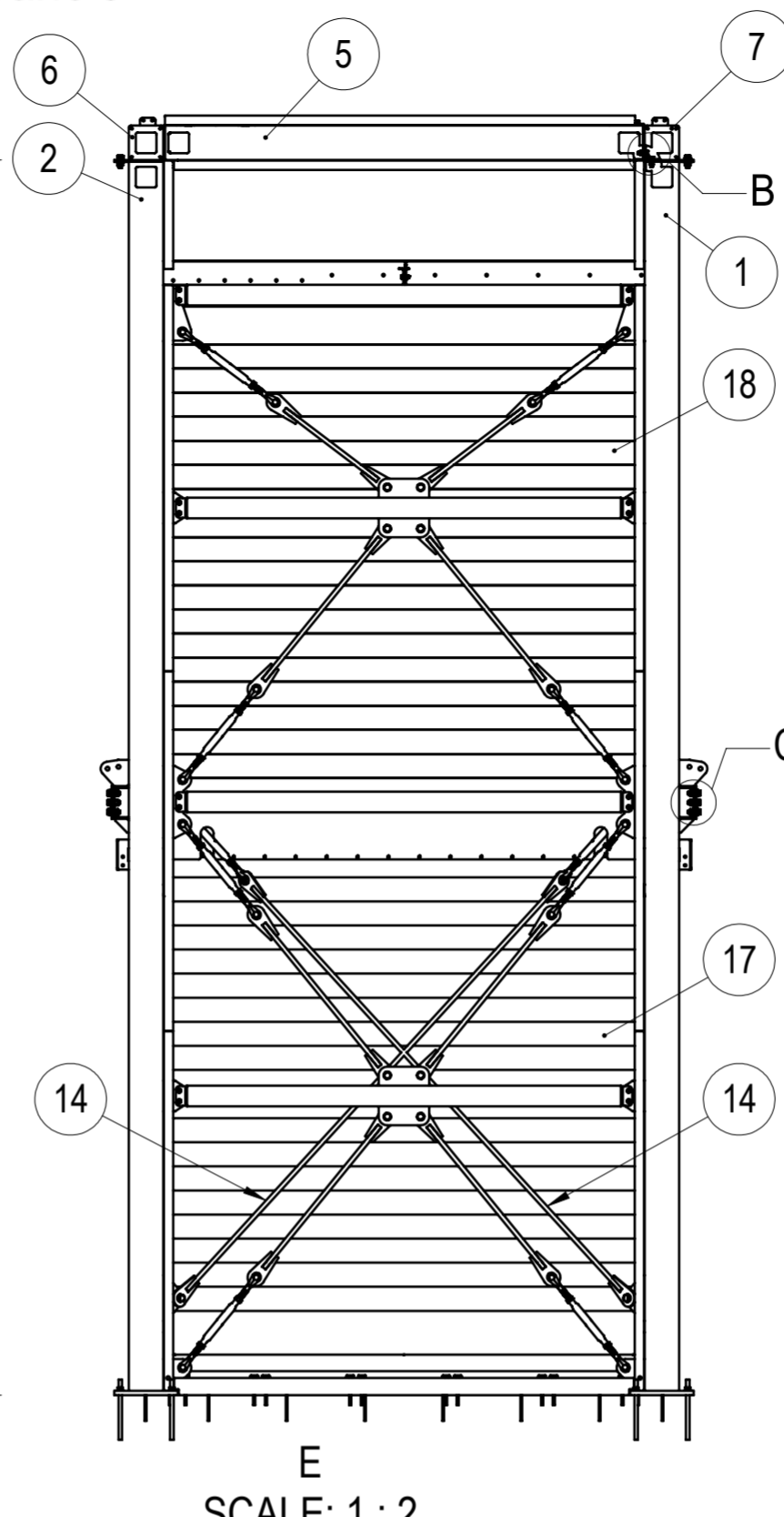
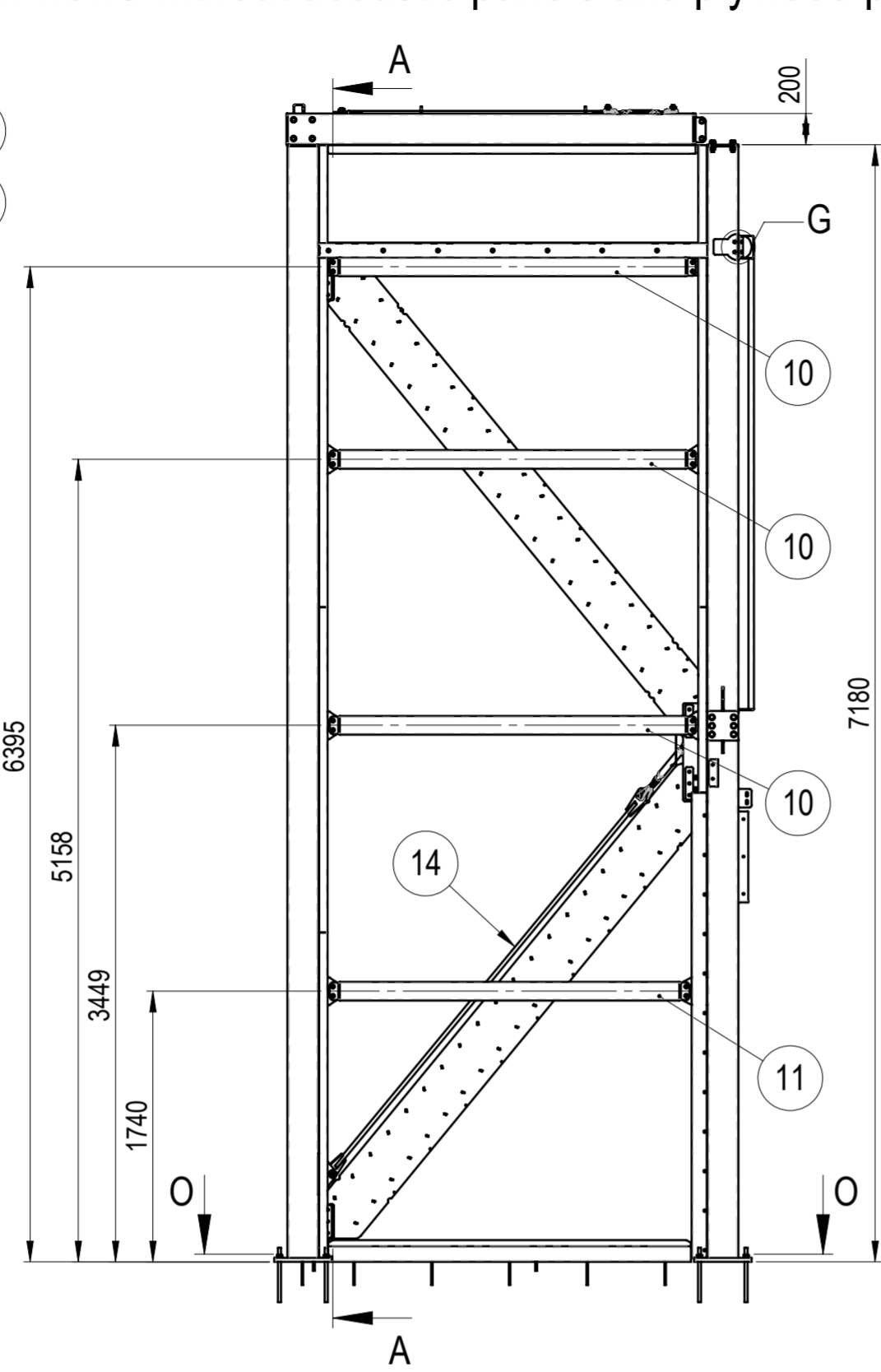
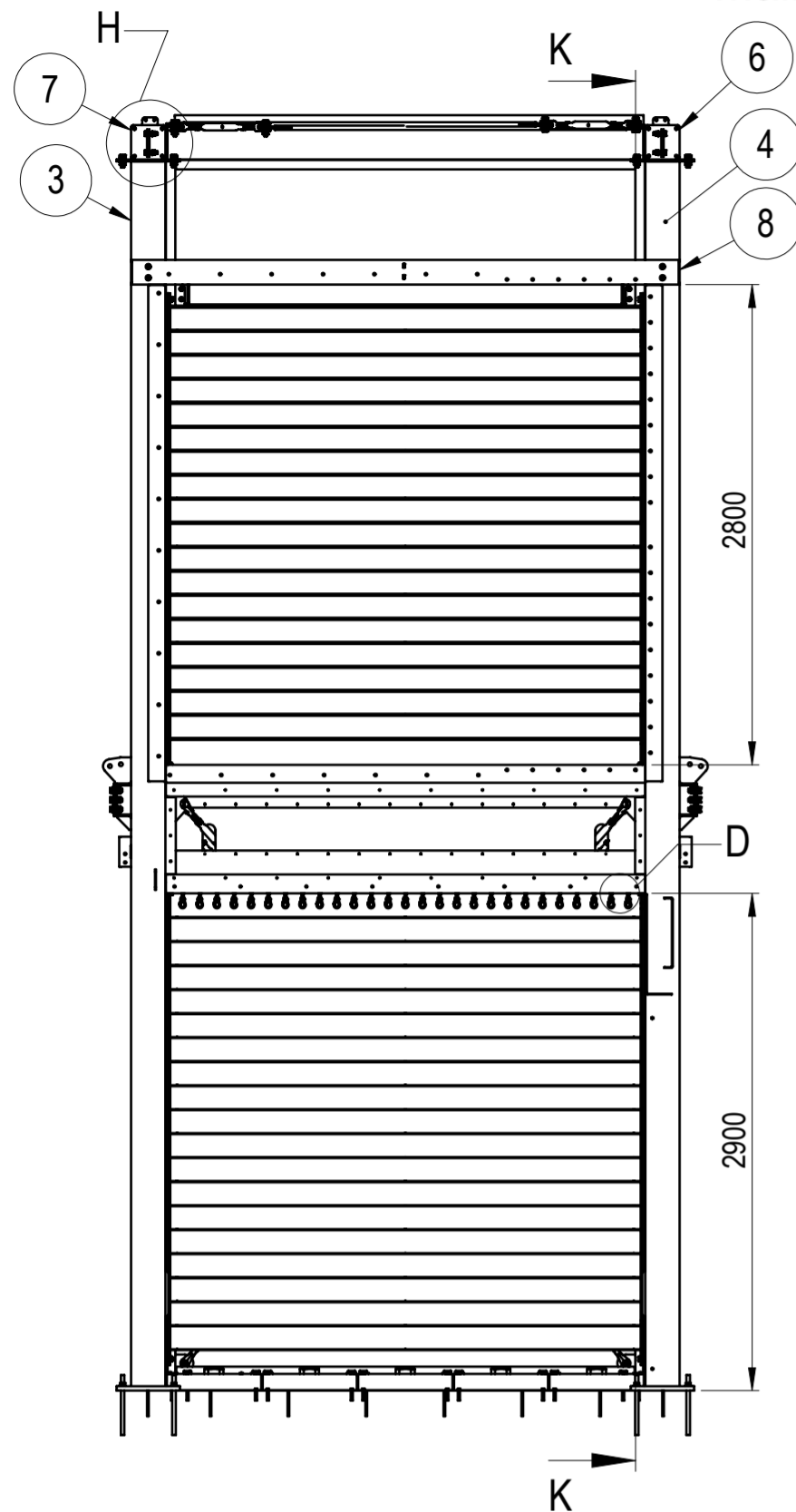
- The steel grade must comply with S355J2 according to EN 1993-1-1 and according to EN 10025-2;

- Geometry of IPE profiles according to EN 19-57;
 - Geometry of HEA profiles according to EN 53-62;
 - U-profile geometry according to EN 10279;
 - Geometry of RHS pipe profiles according to EN 10219-2;
 - Geometry of SHS pipe profiles according to EN 10219-2;
 - Sheets according to EN 10029.

- For all metric thread fasteners, use Loctite 243 threadlocker on final assembly.

WEMPS ENGINEERING SERVICES		MATERIAL	WEIGHT	DEBURR AND BREAK SHARP EDGES	REVISION	DATE
		-	6719.978 Kg	DO NOT SCALE DRAWING		08.05.2026
		SURFACE PROTECTION	MACHINING	THERMAL CUTTING	WELDING	SCALE
		-	ISO 2768 mK	ISO 9013 441	ISO 13920 BF	FORMAT
NAME	SIGNATURE	PART NO.				
Designed by	D. Dislers	105-05000-00				
Drawn by	D. Dislers	DESCRIPTION				
Technical ref		Left turning channel				
						SHEET 1/5

Main views without acoustic panels and plywood panels



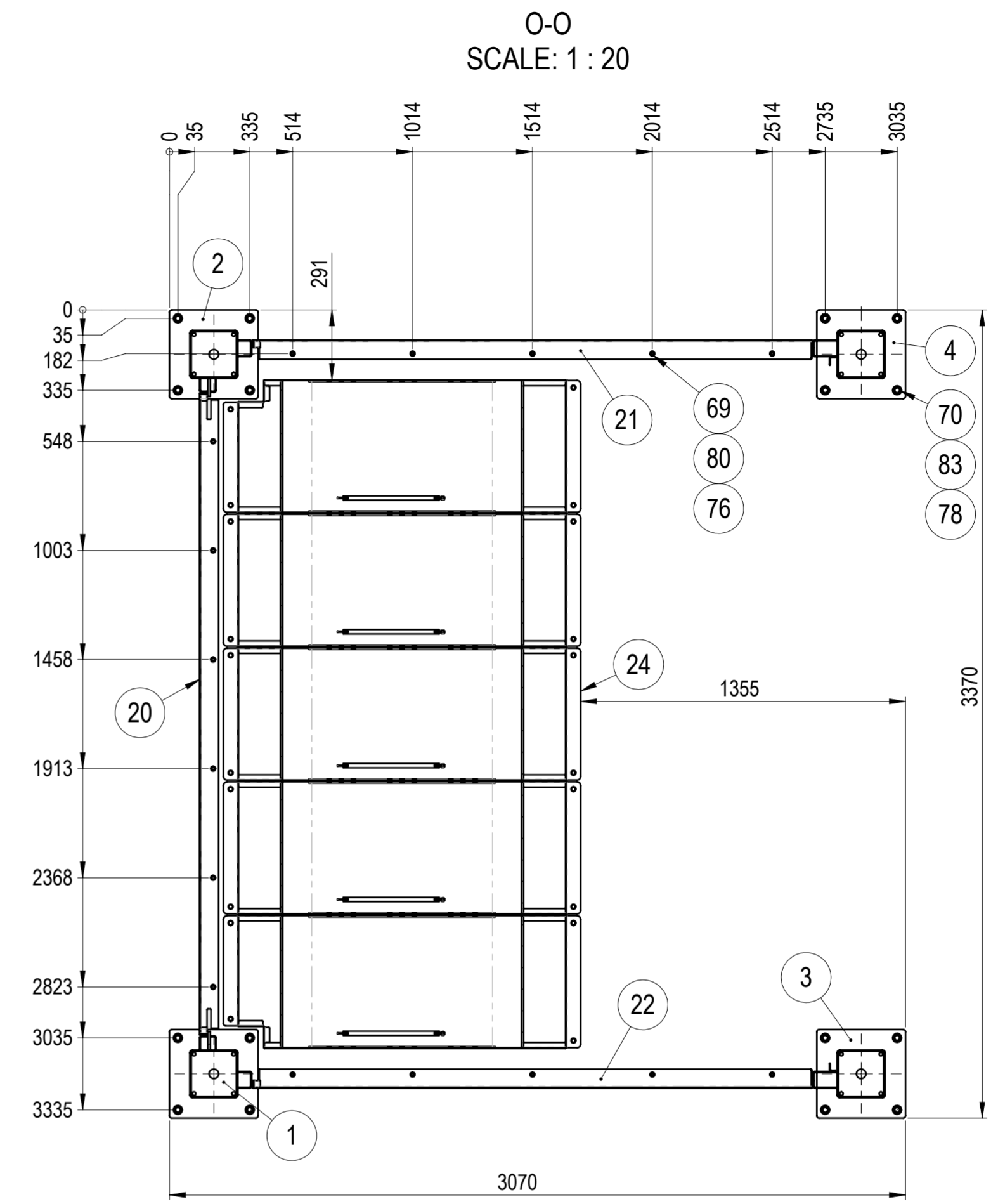
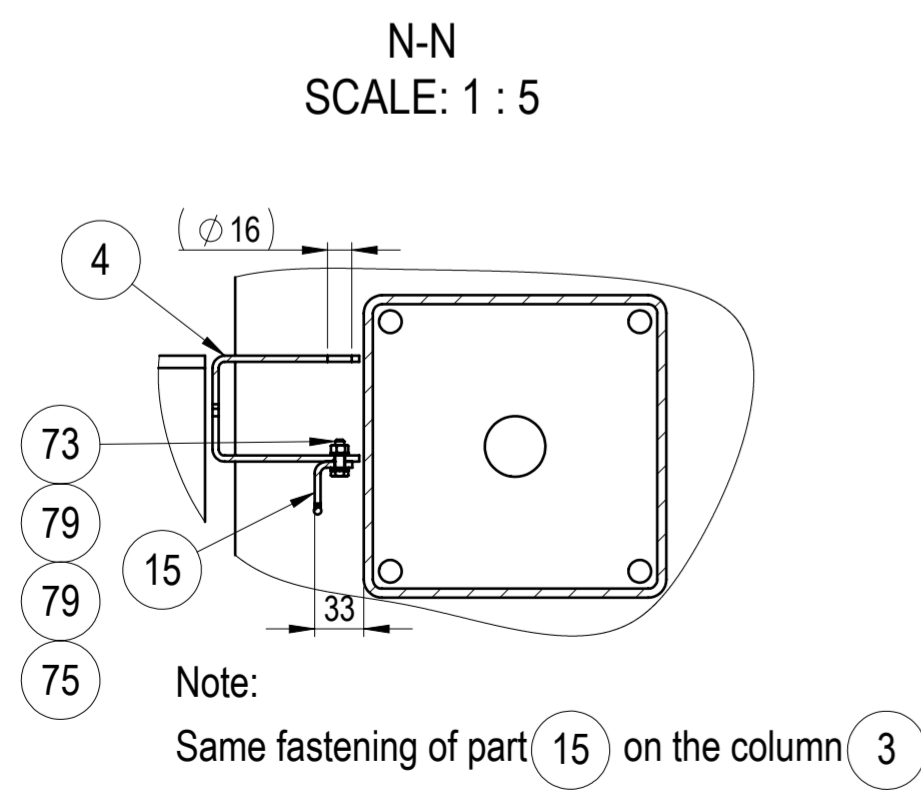
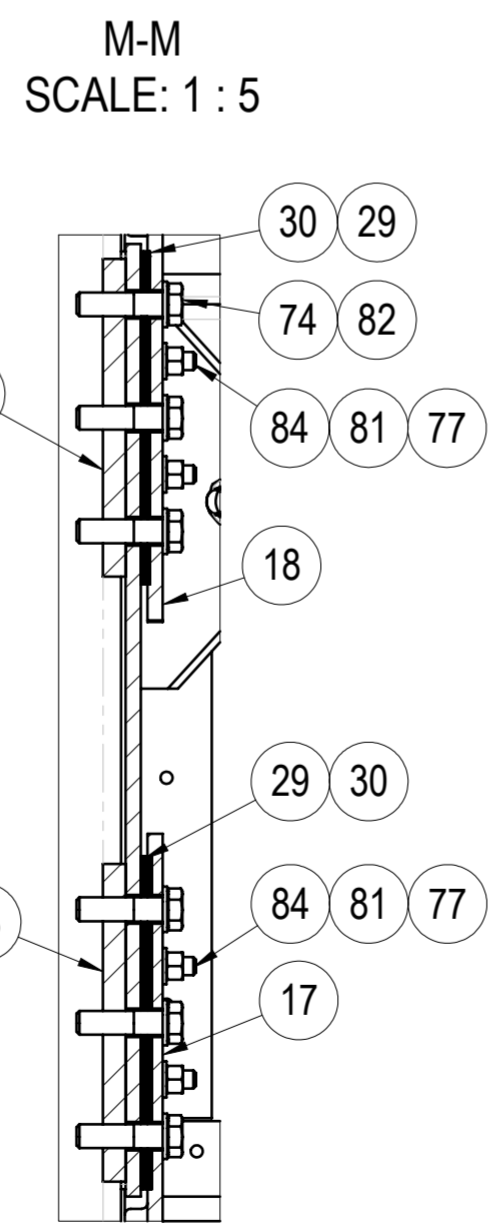
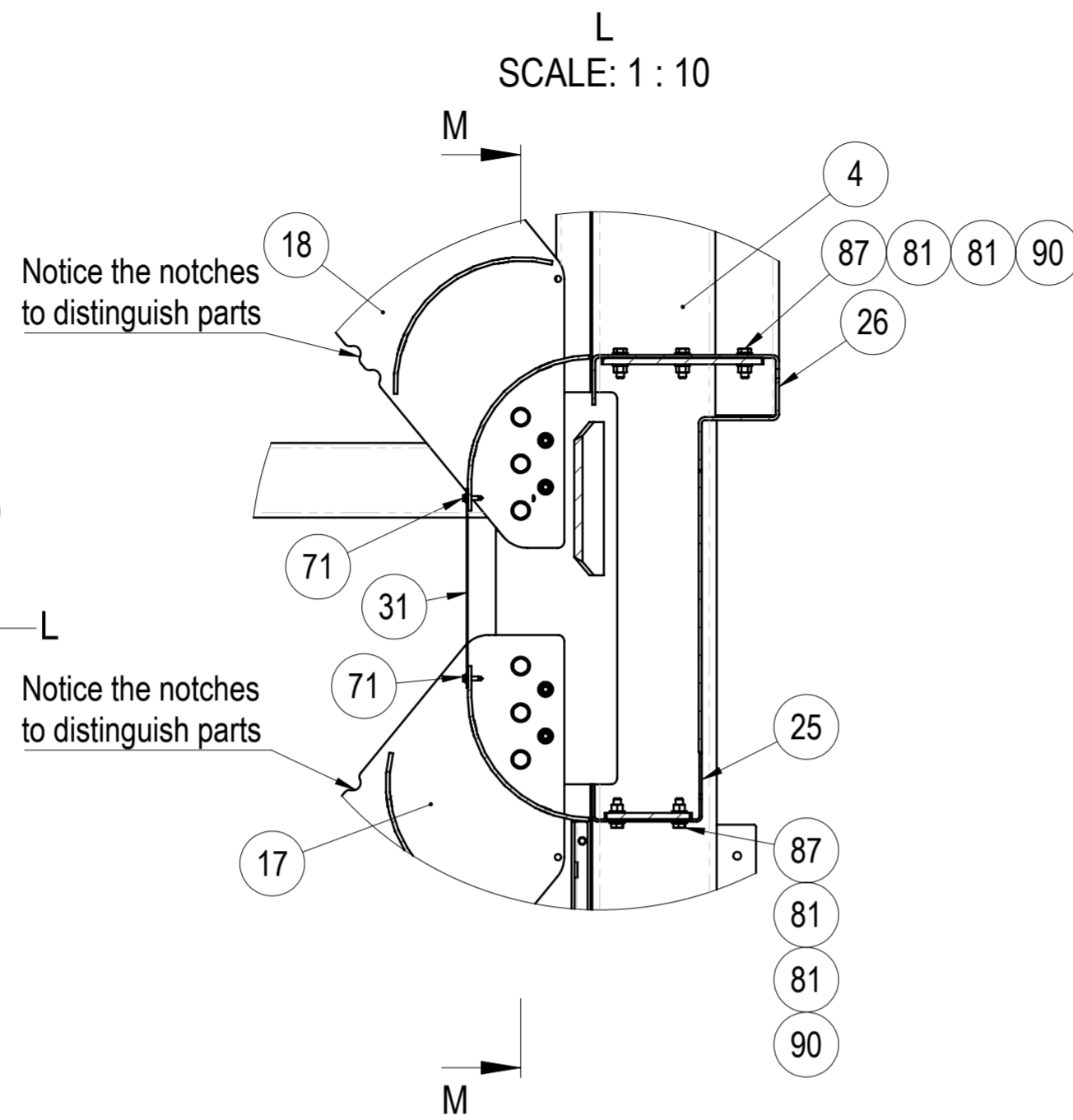
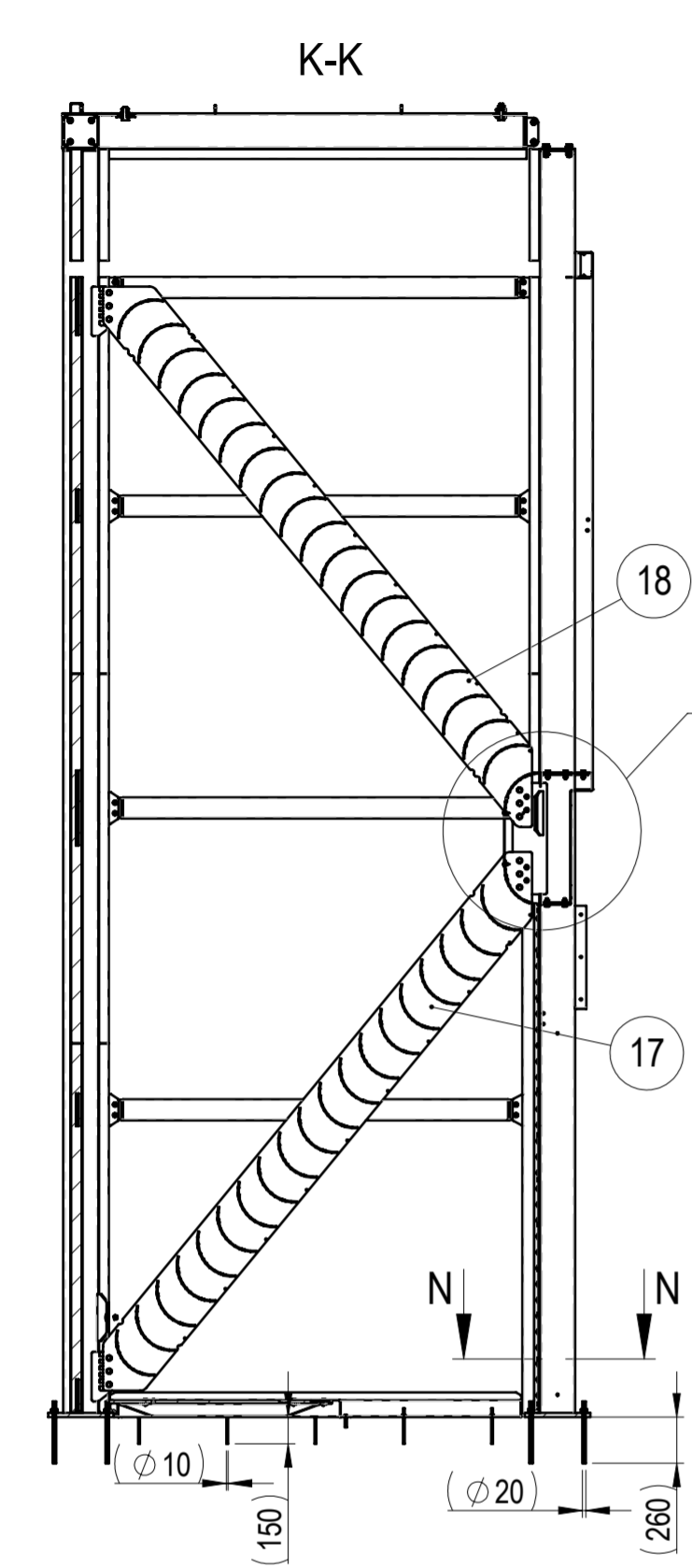
Notes:
1.) Same fasteners are used on opposite side and for part 17 .
2.) Deflector shimplates 29 & 30 must be used if necessary.

Note:
Same fasteners used for parts 9 11
16 23 (at both ends of the beams)

Note:
Same fasteners are used on opposite side on parts 4 & 6

		MATERIAL	WEIGHT	DEBURR AND BREAK SHARP EDGES	REVISION	DATE
		-	6719.978 Kg	DO NOT SCALE DRAWING		08.05.2026
Designed by D. Dislers Drawn by D. Dislers Technical ref.		SURFACE PROTECTION	MACHINING	THERMAL CUTTING	WELDING	SCALE
		-	ISO 2768 mK	ISO 9013 441	ISO 13920 BF	1:40 A2
PART NO.		105-05000-00		DESCRIPTION		FORMAT
		Left turning channel				SHEET 2/5

Section views without acoustic panels and plywood panels

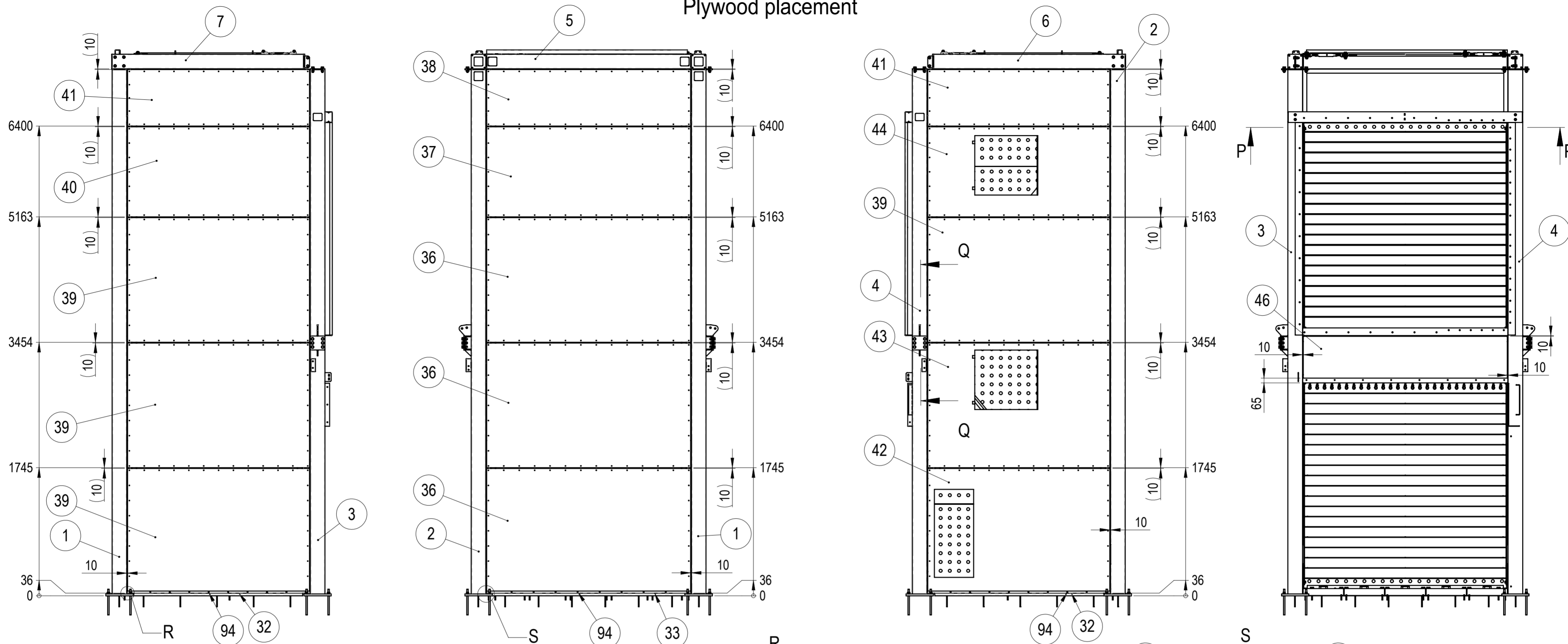


Notes:

- For (70) anchor fastening, drill ϕ 24 holes in concrete. Recommended anchor embedment depth is 260mm.
- For (69) anchor fastening, drill ϕ 12 holes in concrete. Recommended anchor embedment depth is 150mm.
- For dirt collector assembly (24) fastening to concrete, refer to drawing 105-30800-00.
- Prepare holes and install anchor studs (69) & (70) using Scell-it Xpro Vinylester chemical resin. Follow the manufacturer's instructions for proper installation guidelines.

		MATERIAL	WEIGHT	DEBURR AND BREAK SHARP EDGES	REVISION	DATE	
		-	6719.978 Kg	DO NOT SCALE DRAWING		08.05.2026	
Designed by D. Dislers Drawn by D. Dislers Technical ref.		SURFACE PROTECTION	MACHINING	THERMAL CUTTING	WELDING	SCALE	
		-	ISO 2768 mK	ISO 9013 441	ISO 13920 BF	1:40 A2	
PART NO.		105-05000-00					
DESCRIPTION		Left turning channel				SHEET 3/5	

Plywood placement

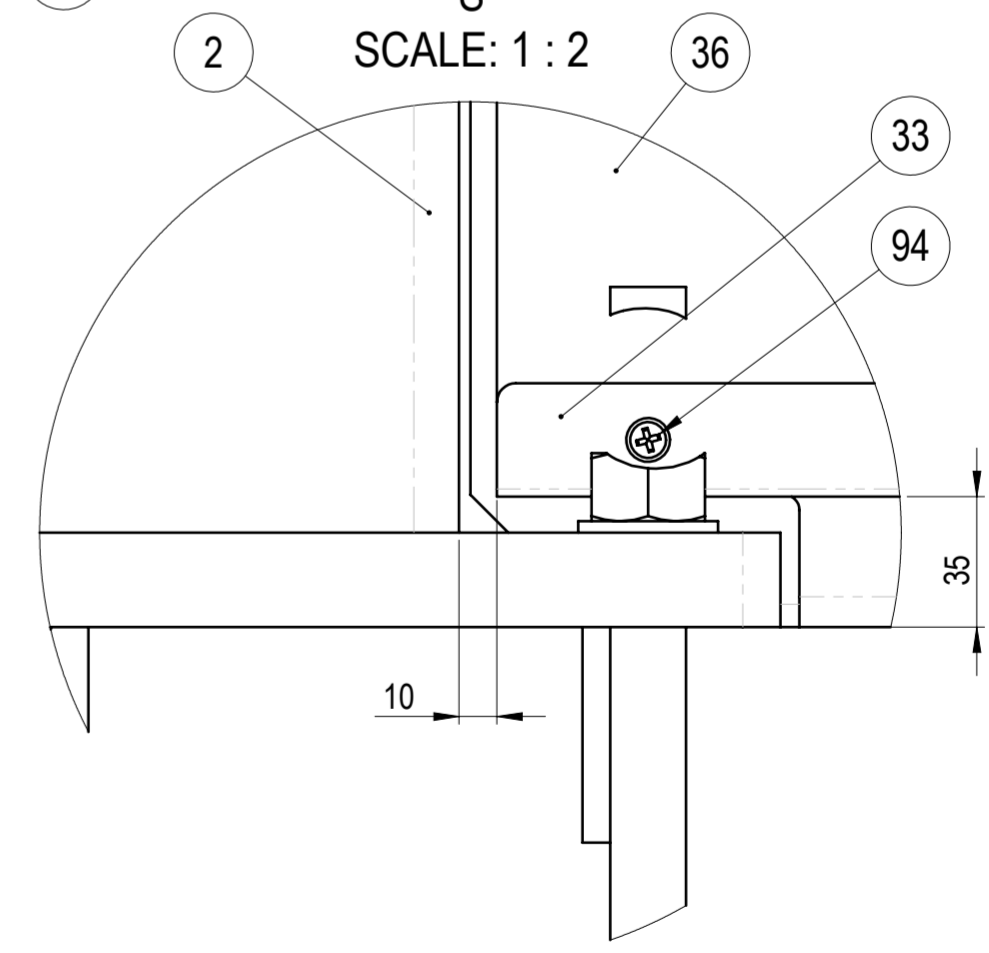
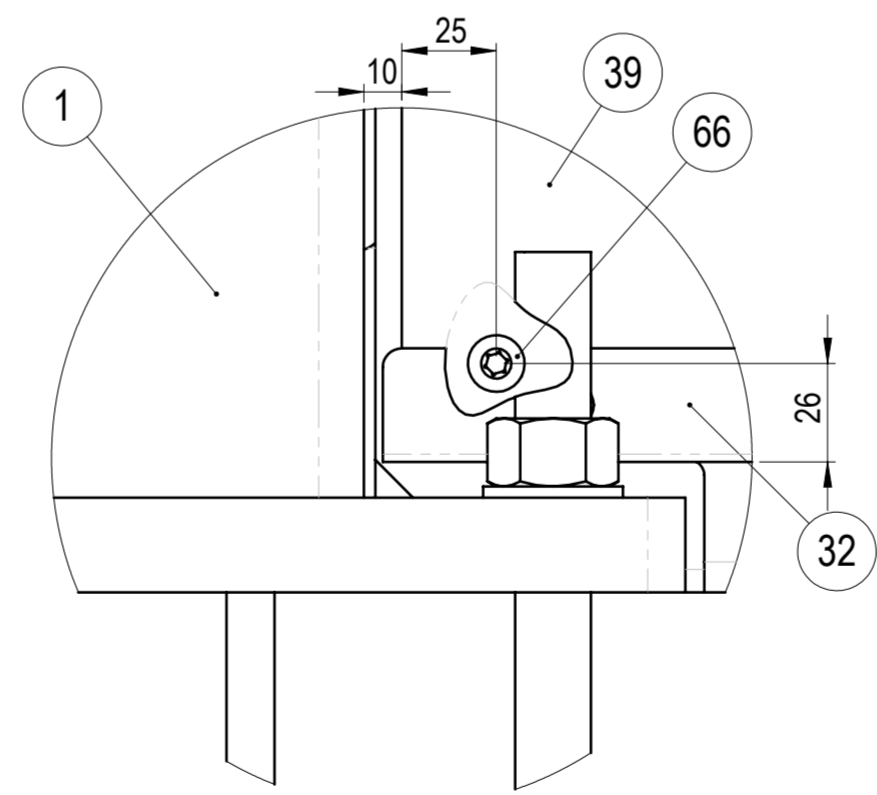


R
SCALE: 1 : 2

S
SCALE: 1 : 2

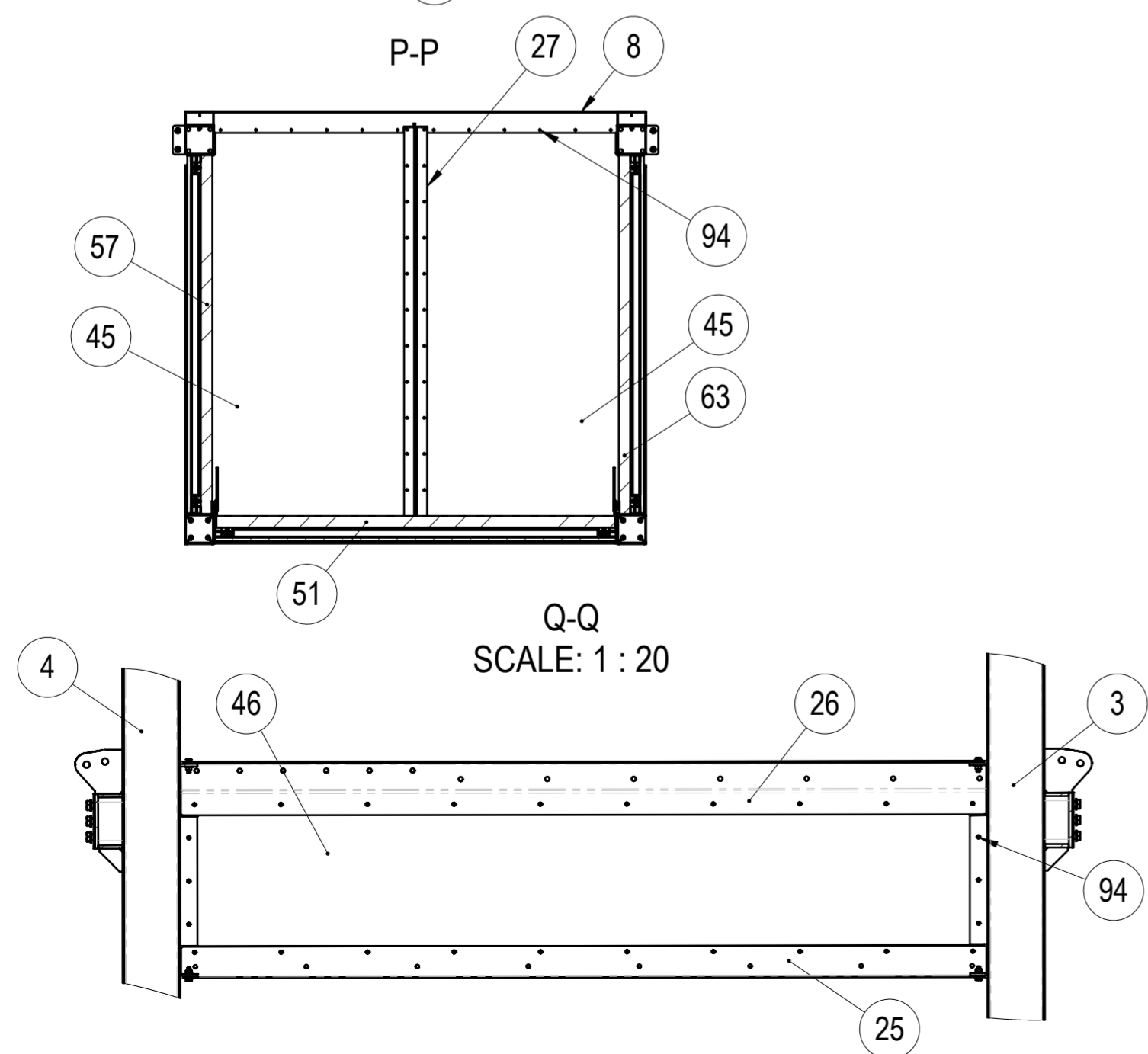
P-P

Q-Q
SCALE: 1 : 20



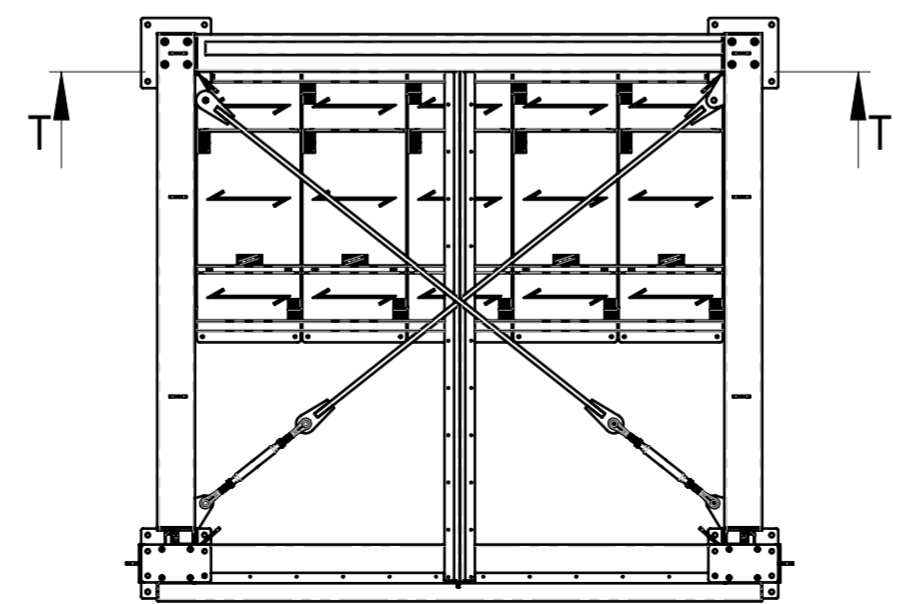
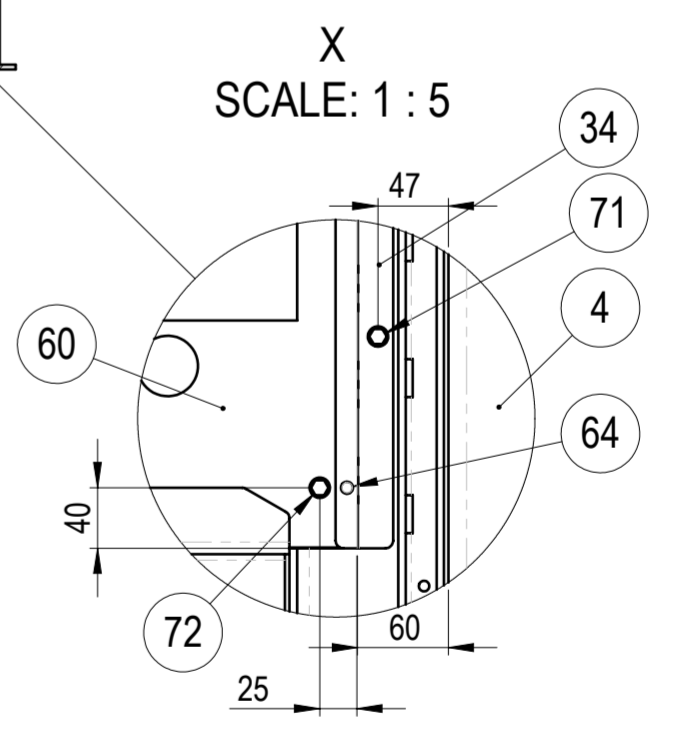
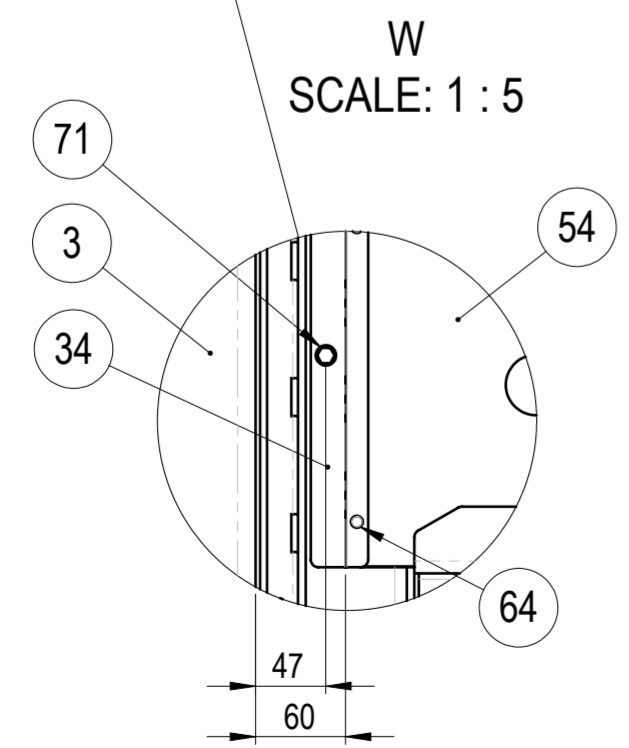
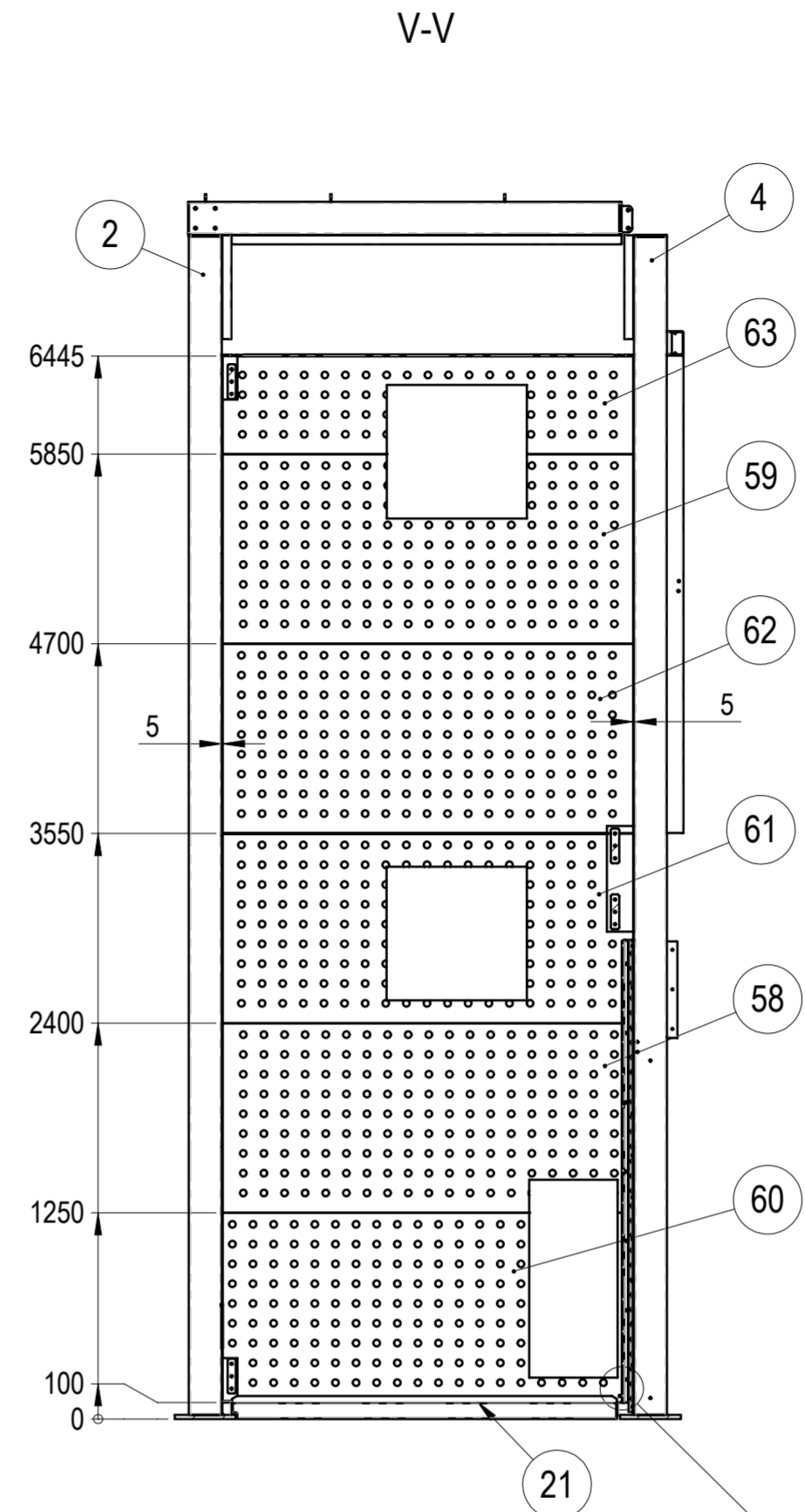
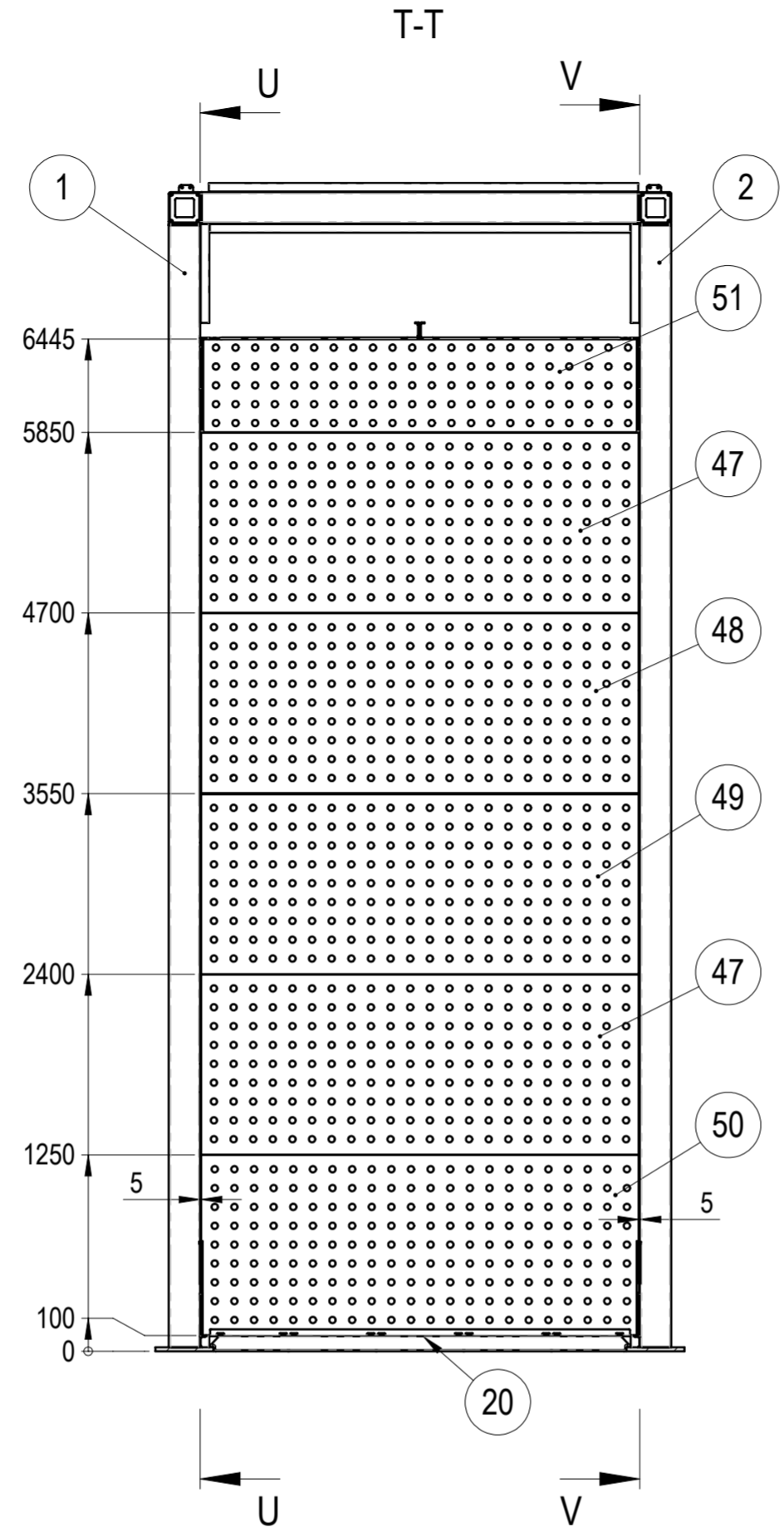
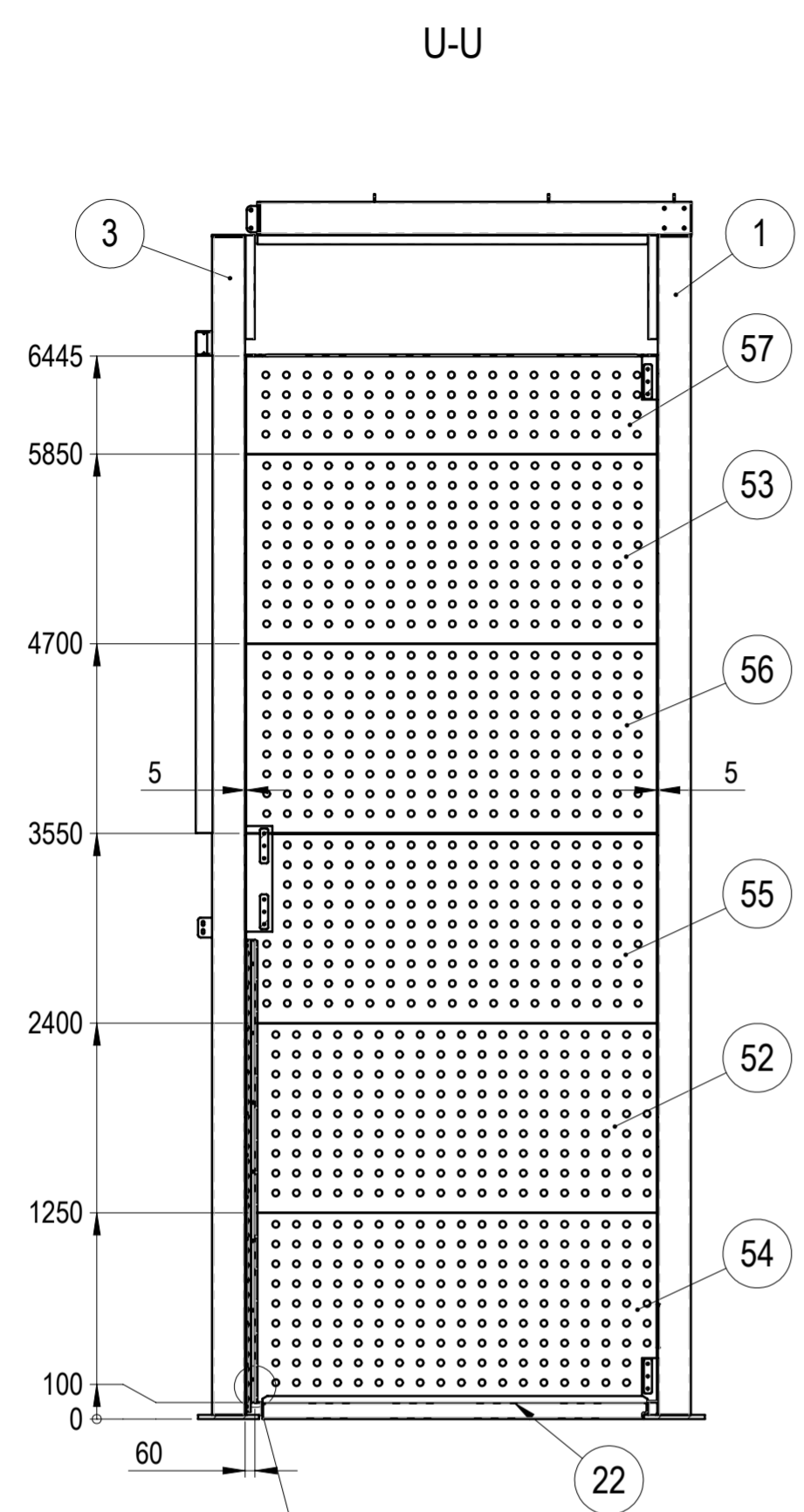
Notes:

1. Use CSK wing type drilling screws (Pos. 66) for all plywood panels at the $\varnothing 8$ pre-drilled holes.
2. For those panels, that don't have pre-drilled holes (Pos. 45 & 46) use D5x25 wood screws (pos. 94) from inside of channel



		MATERIAL	WEIGHT	DEBURR AND BREAK SHARP EDGES	REVISION	DATE	
		-	6719.978 Kg	DO NOT SCALE DRAWING		08.05.2026	
Designed by D. Dislers Drawn by D. Dislers Technical ref.		SURFACE PROTECTION	MACHINING	THERMAL CUTTING	WELDING	SCALE	
		-	ISO 2768 mK	ISO 9013 441	ISO 13920 BF	1:40	
		NAME	SIGNATURE	PART NO.	105-05000-00		
		DESCRIPTION				Left turning channel	
						SHEET 4/5	

Acoustic panels fastening



Note:
 Fasten all acoustic panels to the steel structure using fasteners (72), installed from the channel inner side.
 Maintain a vertical spacing of 200mm from center of the fasteners, positioning them 25mm from the panel side edge.

WEMPS ENGINEERING SERVICES		MATERIAL	WEIGHT	DEBURR AND BREAK SHARP EDGES	REVISION	DATE
		-	6719.978 Kg	DO NOT SCALE DRAWING		08.05.2026
		SURFACE PROTECTION	MACHINING	THERMAL CUTTING	WELDING	SCALE
		-	ISO 2768 mK	ISO 9013 441	ISO 13920 BF	1:40
NAME	SIGNATURE	PART NO.		SCALE		FORMAT
Designed by	D. Dislers	105-05000-00		1:40		A2
Drawn by	D. Dislers	DESCRIPTION		FORM		
Technical ref.		Left turning channel		SHEET 5/5		