



# Rigging and Assembly Instructions



## 4' WIDE AT/USS INDUCED DRAFT COOLING TOWERS

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# AT/USS Cooling Towers

## Introduction

Thank you for purchasing your EVAPCO cooling tower. This manual will provide instructions for installation of the cooling tower. If any questions arise during the installation, please contact your local EVAPCO representative or us directly at our Global Headquarters location.

## International Building Code Provisions

The International Building Code (IBC) is a comprehensive set of regulations addressing the structural design and installation requirements for building systems – including HVAC and industrial refrigeration equipment. As of June 2008, all 50 states plus Washington D.C. have adopted the International Building Code. The code provisions require that evaporative cooling equipment and all other components permanently installed on a structure must meet the same seismic design criteria as the building. The AT/USS Series of Open Cooling Towers are IBC 2006 compliant up to 1g with standard construction and up to 5.12g with additional structural modifications.

All items attached to the Evapco AT/USS cooling tower must be independently reviewed and isolated to meet applicable wind and seismic loads. This includes piping, ductwork, conduit, and electrical connections. These items must be flexibly attached to the Evapco unit so as not to transmit additional loads to the equipment as a result of seismic or wind forces.

## Method of Shipment

Model AT 14-54 is normally shipped fully assembled while all other models are shipped with the top section separate from the bottom section. These sections have mating flanges and will join together in a waterproof joint when sealed and bolted together as described in the following instructions. Miscellaneous items such as sealer tape, self-tapping screws and any other required materials, are packaged and placed inside the pan for shipment.

## Storage

Do not place tarps or other coverings over the top of the units if the units are to be stored before installation. Excessive heat can build up if the units are covered, causing possible damage to the PVC eliminators, PVC louvers, or PVC fill. **For extended storage beyond six months rotate the fan motor shaft(s) monthly.**

## Structural Steel Support

Two structural “I” beams running the length of the unit are all that is required for support of the units. These beams should be located underneath the outer flanges of the unit (see Figure 1). Mounting holes, 3/4” in diameter, are located in the bottom flange of the unit to provide for bolting it to the structural steel (see certified print for exact bolt hole location). Bolt the bottom section to the steel support before rigging the top section.

Beams should be sized in accordance with accepted structural practices. Maximum deflection of the beam under the unit to be 1/360 of the unit length, not to exceed 1/2”. Deflection may be calculated by using 55% of the operating weight as a uniform load on each beam (see certified print for operating weight).

The supporting “I” beams should be level before setting the unit. Do not level the unit by shimming between the bottom flange and the beams as this will not provide proper longitudinal support.

Support beams and anchor bolts are to be furnished by others. Always refer to certified print for unit weights, dimensions and technical data.

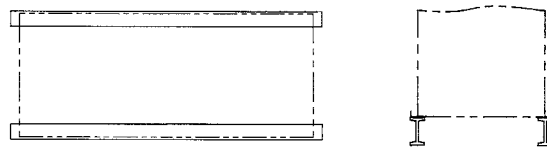


Figure 1 - Structural Steel Support.

## Rigging Bottom Section Lifting Bottom Section

Lifting devices are located in the upper corners of the bottom section for lifting and final positioning purposes as shown in Figure 2. The hook of the crane must be a minimum dimension of “H” above the top of the section being lifted to prevent undue strain on the lifting devices. See Table 1 for the minimum “H” dimension. These lifting devices should not be used for extended lifts or where any hazard exists unless safety slings are employed under the section. **(See “Extended Lifts” on page 3 for proper arrangement.)** Bolt the bottom section to the steel support before rigging the top section.

UNIT NO.	MIN. H
AT 14-64 to 94	5 Feet
AT 14-66 to 96	5 Feet
AT 14-69 to 99	9 Feet
AT 14-612 to 912	11 Feet

Table 1 - Minimum H Dimension for Bottom Sections.

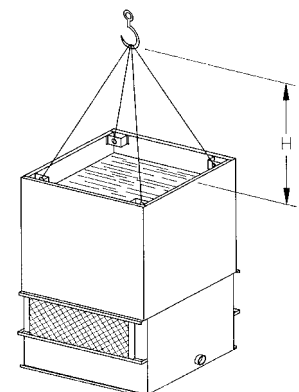


Figure 2 - Bottom Section.

# AT/USS Cooling Towers

## Application of Sealer Tape

Once the bottom section has been set on the supporting steel and bolted in place, the top flanges should be wiped down to remove any dirt or moisture. Sealer Tape should be placed over the mounting hole centerline on the side flanges. Apply two strips of sealer tape, one partially overlapping the other, on the end flanges.

The sealer tape should overlap on the corners as shown in Figure 3. Do not splice the sealer tape along the end flanges and preferably not on the side flanges if it can be avoided. **Always remove the paper backing from the sealer tape.**

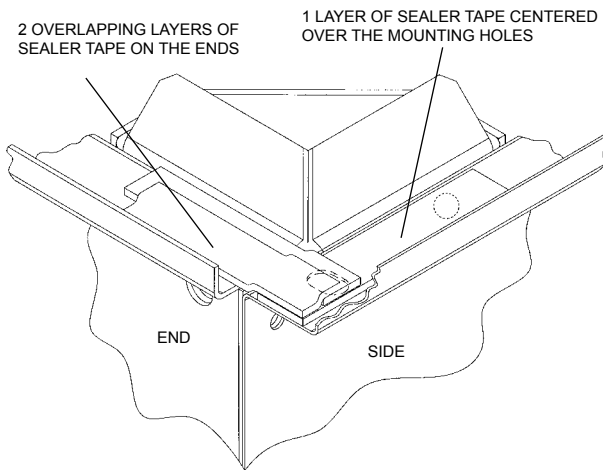


Figure 3 - Sealer tape on flange of Bottom Section.

## Top Section

“U” bolts are provided in the four corners of the top section for lifting and final positioning (See Figure 4). On units with two fans per top section, models AT 14-69 through 14-912, spreader bars must always be used between the cables at the top of the unit to prevent damage to the fan cylinders. See Figure 5 for proper arrangement of cables on fan sections with dual fans. The hook of the crane must be a minimum dimension “H” above the top section being lifted to prevent undue strain on the “U” bolts. See Table 2 for the minimum “H” dimension.

UNIT NO.	MIN. H
AT 14-64 to 94	5 Feet
AT 14-66 to 96	6 Feet
AT 14-69 to 99	8 Feet
AT 14-612 to 912	11 Feet

Table 2 - Minimum H Dimension for Top Sections.

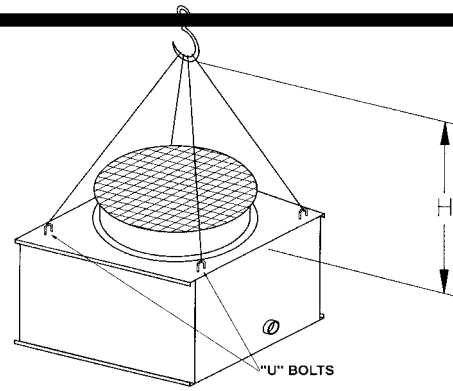


Figure 4 - Top Sections, Models AT 14-64 through AT 14-96.

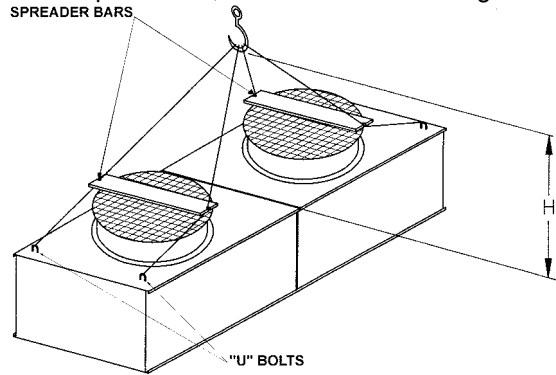


Figure 5 - Top Section, Models AT 14-69 through AT 14-912.

## Extended Lifts

**Important: The lifting devices and “U” bolts should be used for final positioning only and for lifting where no danger exists. If they are used for extended lifts, safety slings should be provided under the sections.**

The preferred method for extended lifts is to use slings under the unit (see Figure 6). Spreader bars should always be used between the cables at the top of the section to prevent damage to the upper flanges or fan cylinders.

Safety slings and skids should be removed before final positioning of the unit.

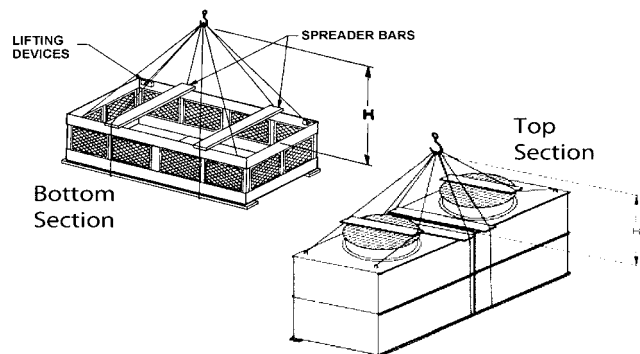


Figure 6 - Proper Rigging Method for Extended Lifts.

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## Assembly of the Top Section to the Bottom Section

Before assembling the top section to the bottom section, remove any loose parts shipped in the pan.

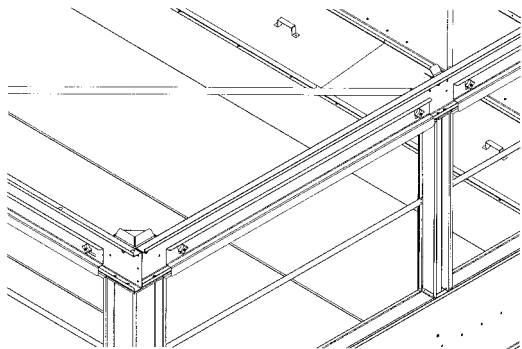
Wipe the flanges on the bottom of the top section. Check to see that the water distribution connection on the top section is in the correct position relative to the bottom section (see certified print).

Lower the top section to within several inches of the bottom section making sure the two sections do not touch and the sealer is not disturbed.

Place self-tapping screws in all four corner bolt holes. Then continue to install the rest of the self-tapping screws working from the corners toward the center, using drift pins to align the holes. A self-tapper must be installed in every hole on the side flanges although none are required on the end flanges.

**NOTE: 5/16" bolts and nuts are used on stainless steel units.**

**NOTE: Drift pins provided in rigging box to assist with alignment.**



**Figure 7 - Mating Upper Section to Bottom Section.**

## Rigging Fully Assembled Towers

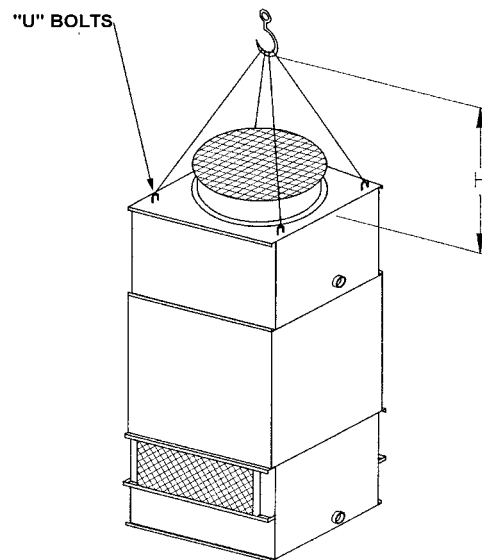
Table 3 lists units which can be assembled prior to final positioning for rigging in one lift. The unit is assembled by the procedures described in the "Assembly of the Top Section to the Bottom Section" starting on Page 3.

All "U" bolts on the top section are to be used for lifting and final positioning of the unit as shown in Figure 8 and 9. The hook of the crane must be a minimum dimension of "H" above the top of the unit being lifted to prevent undue strain on the "U" bolts. See Table 3 for minimum "H" dimension.

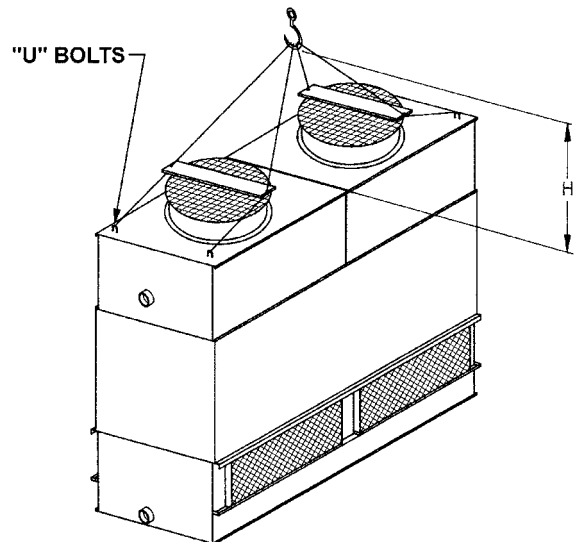
The "U" Bolts should not be used for extended lifts or where any hazard exists unless safety slings are employed under the section. (See "Extended Lifts" on page 3 for proper arrangement.)

UNIT NO.	MIN. H
AT 14-64 to 94	5 Feet
AT 14-66 to 96	6 Feet
AT 14-69 to 99	9 Feet
AT 14-612 to 912	12 Feet

**Table 3 - Minimum H Dimension for Fully Assembled Units.**



**Figure 8 - Fully Assembled Unit, Models AT 14-64 through 14-96.**



**Figure 9 - Fully Assembled Unit, Models AT 14-69 through 14-912.**

# AT/USS Cooling Towers

## General Information - Start-up & Maintenance

### Start-up Details

#### Shipping Chocks and Debris

Remove any chocks that have been placed inside the unit for shipping purposes. Clean all debris from the pan prior to start-up. Close and secure all access doors.

#### Bleed-off Line

Make sure a bleed line and valve are installed on the pump discharge side of the system piping to a convenient drain. The bleed-off valve should be open. For installation details, see the "Maintenance Instructions Bulletin."

#### Strainer

Check the strainer(s) in the pan to make sure they are in the proper location over the pump suction, alongside of the anticavitation hood. See Figure 10.

#### Screens

Protective fan screens are provided across the top of the fan cylinders of all models. Check and tighten all bolts.

#### Adjustment of Float Valve

The float valve should be adjusted to maintain the proper water level as specified in the maintenance instructions. At start-up, the pan should be filled to the overflow level.

During operation, the water level will drop to no more than 5" below the overflow. The water level can be checked during operation by opening the removable louver section at the valve while the pump is running and the fans are off.

#### Starting Sequence

Before starting the unit, check that all access openings, safety screens and covers are in place. Then start the unit as outlined below:

1. Fill the pan to the overflow level.
2. Start the water pumps. Check the water flow to the unit by checking the spray water pressure at the water inlet. It should be the same as the pressure indicated on the certified drawing.
3. Start the fans. Check the fans for proper rotation. Directional arrows are placed on the side of the fan cylinder.

**NOTE: Do not operate the fans while the pump is off. Damage to the PVC fill can result during dry operation. Always start the water pumps first, with the fan motors following.**

## Maintenance

Once the installation is complete and the unit is turned on, it is important that it be properly maintained. Maintenance is not difficult or time-consuming but must be done regularly to assure full performance of the unit. Refer to the maintenance instructions enclosed with the unit for proper maintenance procedures.

### Freeze Protection

Proper freeze protection must be provided if the unit is located in a cold climate. Refer to maintenance instructions as well as product bulletins for further information.

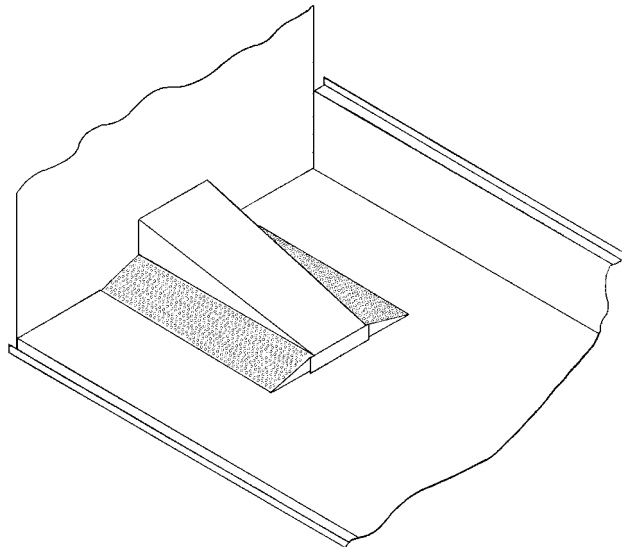


Figure 10 - Strainer Location.

## Rigging Hardware Parts List

The following table lists those parts which are shipped together with the unit(s) for field assembly and/or spare parts.

AT Model Number	Flume Hardware	Rigging Hardware <sup>1</sup>	Sealer Tape	Nozzles
14-64 to 14-94	0	25	2	0
14-66 to 14-96	0	35	2	0
14-69 to 14-99	0	45	2	0
14-612 to 14-912	0	55	3	0

#### Notes:

1. 5/16 x 1" taper. Stainless units use 5/16" nuts and bolts.

