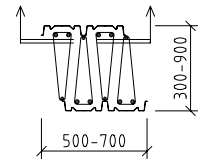


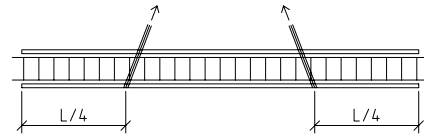
**DELIVERY**

TERMS OF DELIVERY IS FREE ON TRUCK AT THE WORK SITE IF OTHERWISE IS NOT AGREED. SUITABLE UNLOADING EQUIPMENT MUST BE AVAILABLE AT THE SITE.

**BEAMS**



THE BEAMS ARE DELIVERED IN BUNDLES WITH FOUR UNITS IN EACH BUNDLE.  
THE WEIGHT OF THE BEAMS DEPENDS ON THE HEIGHT AND THE BOTTOM REINFORCEMENT BUT IS APPROXIMATELY 9-25 KG/M LENGTH.

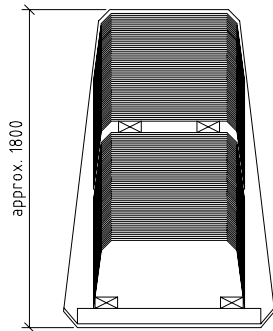


TAPE TYPE STRAPS SHOULD BE USED AT THE UNLOADING. AN ALTERNATIVE IS TO INSERT STEEL PIPES THROUGH THE BEAM BUNDLE.

PLEASE SEE ABOVE PICTURE. MAKE SURE THAT THE BOTTOM SHEET BATTENS ARE NOT DEFORMED. WHEN STORED AT THE WORK SITE THE BUNDLES ARE PLACED ON A FLAT BED, AND WITH ENOUGH SPACE BETWEEN THE BUNDLES TO MAKE IT POSSIBLE TO CONNECT THE LIFTING STRAPS WITHOUT DIFFICULTIES.

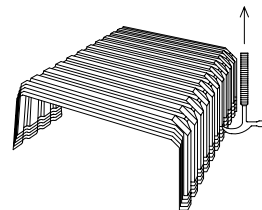
**MOULDS**

THE MOULDS ARE DELIVERED PILED INSIDE EACH OTHER WITH ABOUT 50 UNITS IN EACH PILE. THE MOULDS ARE NORMALLY DELIVERED TWO PILES HIGH, I.E WITH 100 MOULDS/PALLET.  
NORMAL MOULD WEIGHT IS 7-14 KG/UNIT DEPENDING ON THE SIZE.



PILE WEIGHT IS ABOUT 1000 KG AT MOULD HEIGHT 300 C/C 1200.  
PILE WEIGHT IS ABOUT 1300 KG AT MOULD HEIGHT 500 C/C 1200.

UNLOADING CAN BE DONE BY A CRANE OR A FORK LIFT TRUCK, AND THE PILES SHOULD BE PLACED ON AN EVEN BED AND TURNED TO ALLOW FOR THE LABELS TO BE READ EASILY. THE PILES ARE PROVIDED WITH LABELS WITH THE FOLLOWING INFORMATION:

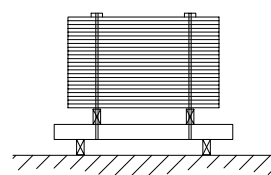


POS	NUMBER	HEIGHT/WIDTH	LENGTH

NONE STANDARD MOULDS ARE COLOR LABELED ACCORDING TO INSTRUCTION DRAWING.

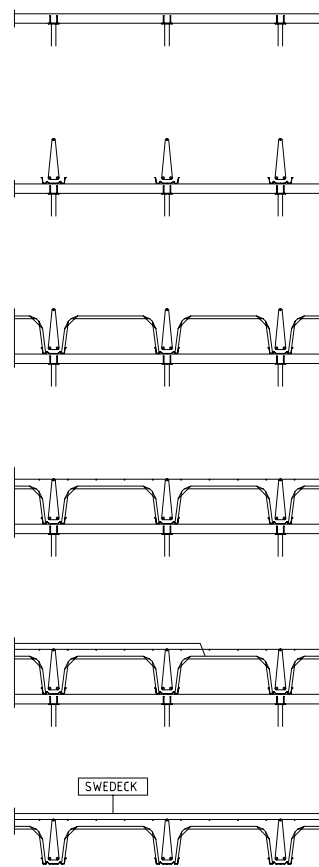
PULLING THE MOULDS APART: PRESS A HAMMER PRONG UNDER THE FIRST MOULD EDGE RIGHT IN THE CENTRE AND PULL THE MOULD FAST AND FORCEFULLY UPWARDS. DO NOT STORE PALLETTS OF MATERIAL (100 SHEETS) ON TOP OF EACH OTHER.

**END PANELS**



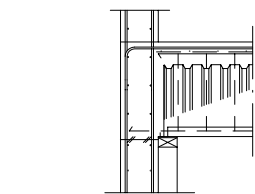
THE END PANELS WEIGHT 2-6 KG/UNIT.  
THE END PANELS ARE DELIVERED PILED AND STRAPPED TO A SPECIAL PALLET.

**WORKING ORDER PRINCIPLES**

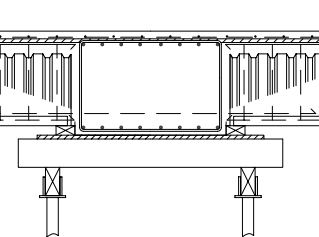


1. STRINGERS ARE MOUNTED AGAINST THE BEAMS WITH C/C ACCORDING TO THE DRAWING. C/C OF THE PROPS SUPPORT DEPENDS ON THE STRINGER DIMENSIONS, THE WEIGHT OF THE FINISHED FLOOR STRUCTURE AND THE C/C OF THE STRINGERS. THE CAMBER HEIGHT OF THE FLOOR SHOULD ALSO BE CONSIDERED.
2. REINFORCEMENT BEAMS ARE LAID OUT WITH C/C ACCORDING TO DRAWING.
3. THE NUMBER OF MOULDS ACCORDING TO THE DRAWING ARE LAID OUT. THE LAYING OF THE MOULDS SHOULD BE DONE IN ONE DIRECTION AND OPPOSITE TO THE CONVENIENT CASTING DIRECTION. PLEASE REFER TO FIGURE UNDER MOULD DETAILS.
4. THE FLOOR REINFORCEMENT STRUCTURE IS COMPLETED WITH A CHECKER NET IN THE FLANGE. IT IS LAID ON TOP OF THE REINFORCEMENT BEAMS. IN CASE OF CONTINUOUS SPAN SUPPORT REINFORCEMENT IS ADDED.
5. AFTER THE REINFORCEMENT AND THE MOULDS ARE THUS IN PLACE, THE FLOOR CAN BE CAST.
6. THE STRINGERS AND THE PROPS ARE REMOVED.

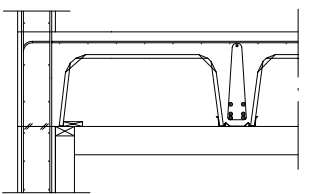
**SPECIAL DETAILS**



CONCRETE JOINTS IN WALLS, WHICH SERVE AS RIB SUPPORT SHOULD BE PLACED IF POSSIBLE A LITTLE BELOW THE RIBS (1-2 CM).

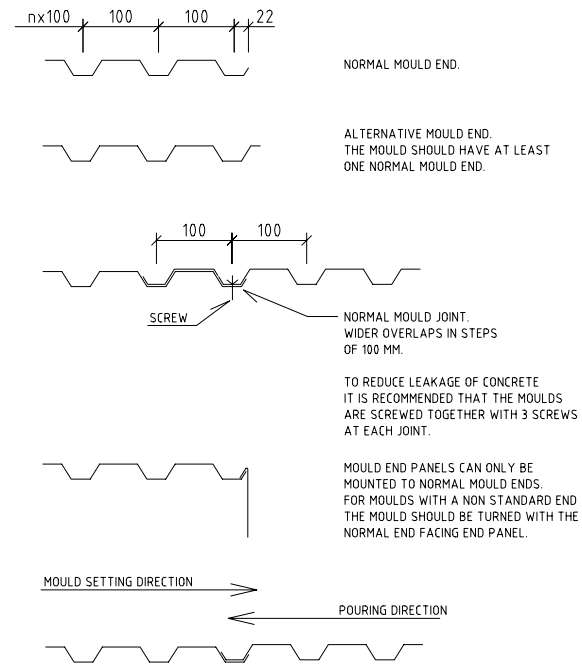


THE SETTING OF THE MOULDS AT THE MAIN BEAMS AND AT THE FACADE BEAMS, SHOULD BE DONE WITH SUPPORTS FOR THE CONNECTING RIBS. THE REINFORCEMENT FOR THE MAIN BEAM CAN BE DONE IN ONE OF THE FOLLOWING ORDERS:  
1. BEFORE THE MOULDS FOR THE RIB STRUCTURE HAS BEEN SET UP.  
2. AFTER THE MOULDS FOR THE RIB STRUCTURE HAS BEEN SET UP WHICH THEN CAN BE USED AS A WORKING PLATFORM.



SUPPORTS SHOULD BE SET AT THE LONGITUDINAL CONNECTIONS BETWEEN THE FLOOR STRUCTURE AND THE WALLS OR THE BEAMS.

**MOULD DETAILS**



NORMAL MOULD END.

ALTERNATIVE MOULD END. THE MOULD SHOULD HAVE AT LEAST ONE NORMAL MOULD END.

NORMAL MOULD JOINT. WIDER OVERLAPS IN STEPS OF 100 MM.

TO REDUCE LEAKAGE OF CONCRETE IT IS RECOMMENDED THAT THE MOULDS ARE SCREWED TOGETHER WITH 3 SCREWS AT EACH JOINT.

MOULD END PANELS CAN ONLY BE MOUNTED TO NORMAL MOULD ENDS. FOR MOULDS WITH A NON STANDARD END THE MOULD SHOULD BE TURNED WITH THE NORMAL END FACING END PANEL.

**POURING**

**BEFORE POURING**

INSPECT THE ENTIRE MOULD AND REINFORCEMENT STRUCTURE FROM BELOW AND LOOK PARTICULARLY AT THE MOULD JOINTS AND THE END PANELS.

CHECK THAT THE RIBS ARE SECURED WITH NAILS OR WITH CLEATS AGAINST "MOULD WALKING". THIS SHOULD BE DONE IN ONE OR MORE OF THE STRINGERS. THIS ROW OF STRINGERS SHOULD BE CROSS BRIDGED.

**POURING**

1. THE RIB BEAMS ARE FILLED WITH CONCRETE TO HALF OF THE HEIGHT.
2. CONCRETE IS POURED INTO THE CONNECTING WALLS AND BEAMS TO ABOUT HALF HEIGHT.
3. THE FLOOR IS CAST TO FULL HEIGHT. PLEASE MAKE SURE THAT AT LEAST TWO RIBS AHEAD ARE HALF FILLED BEFORE CASTING THE FLOOR TO FULL HEIGHT. THIS IS NECESSARY TO ENSURE STABILITY OF THE MOULD.

**PAY SPECIAL ATTENTION TO:**

DO NOT VIBRATE THE CONCRETE CLOSE TO THE END PANELS TOO MUCH. HOWEVER THE CONCRETE IN THE RIB CONNECTION WITH WALL/BEAM SHOULD BE VIBRATED NORMALLY. AT THE MIDDLE OF THE END PANELS IT IS SUFFICIENT TO JUST DIP THE VIBRATING ROD BRIEFLY INTO THE CONCRETE.

**NOTE!**

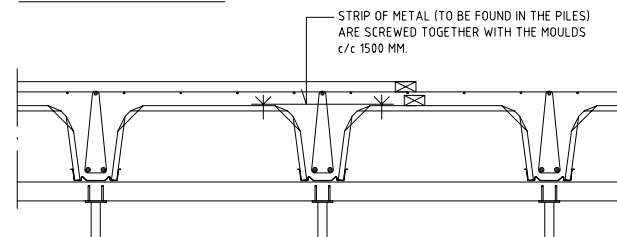
WHEN THE MOULDS ARE TO BE VISIBLE AND THERE IS HIGH DEMANDS OF THE FINISH, THEY SHOULD BE WASHED FROM CEMENT SPLASHES IMMEDIATELY AFTER THE POURING.

**CONCRETE JOINTS:**

JOINTS ARE NORMALLY PLACED PARALLELL TO THE RIBS AND WITH STOPPERS IN THE PRESSURE PLATE. PLEASE REFER TO FIGURE BELOW.

CONCRETE JOINTS ACROSS THE RIBS SHOULD BE MADE AT THE 1/3 POINTS OF THE SPAN AND WITH STRETCH METAL STOPPERS DOWN INTO THE RIB.

**CONCRETE JOINTS**



STRIP OF METAL (TO BE FOUND IN THE PILES) ARE SCREWED TOGETHER WITH THE MOULDS c/c 1500 MM.

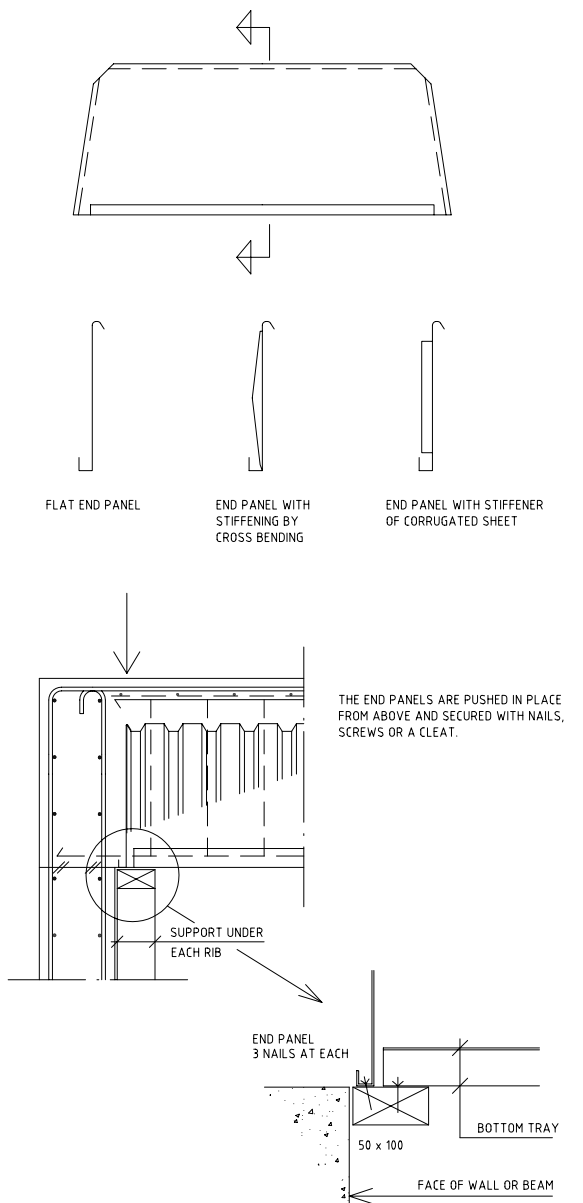
**REMOVAL OF UNDERSTRUCTURE**

THE UNDERSTRUCTURE IS REMOVED WHEN THE CONCRETE HAS GAINED SUFFICIENT STRENGTH.

IF NO INSTRUCTIONS ARE GIVEN ON THE DRAWINGS PLEASE CONTACT THE DESIGNER OR THE SUPPLIER OF THE RIBBED SLAB.

SOME OF THE RAILS AND PROPS MAY HAVE TO REMAIN IN PLACE.

**END PANELS**



FLAT END PANEL

END PANEL WITH STIFFENING BY CROSS BENDING

END PANEL WITH STIFFENER OF CORRUGATED SHEET

THE END PANELS ARE PUSHED IN PLACE FROM ABOVE AND SECURED WITH NAILS, SCREWS OR A CLEAT.

SUPPORT UNDER EACH RIB

END PANEL 3 NAILS AT EACH

BOTTOM TRAY

FACE OF WALL OR BEAM



**RIBBED SLAB**  
**SweDeck**  
Tallhammarsvågen 11  
S-186 33 VALLENTUNA  
Tel. +46 8 511 751 00  
Fax. +46 8 511 717 00

REV	DESCRIPTION	SIGN	DATE

PROJECT No	DRAWN N.J	DESIGN
DATE	APPROVED	
SWEDECK RIBBED SLAB		
FORMWORK AND REINFORCEMENT SYSTEM		
SCALE	DRAWING NR	REV
		M-00