

# Model 175 & 135 Stair Erection Instructions

## STANDARD ERECTION INSTRUCTIONS FOR SPIRAL STAIR: DESIGN 175 & 135

The following instructions are written to cover the erection of standard Superior Spiral Stairs. Slight variation and/or additional procedures in erection may be necessary to meet conditions other than standard. When erecting multiple flight stairs, it is recommended that each flight be assembled in its entirety before beginning erection of subsequent flights.

All stairs have been completely shop assembled and are marked in accordance with shop detail drawings. Erection should be coordinated with shop drawing which shows parts' locations, hardware application, and other applicable data. If indicated on drawing, this stair is designed to comply with OSHA Spiral Stair Standards. The front or leading baluster on each tread is the structural baluster. This baluster can be identified by the welded collar and thread on one end. The intermediate or rear baluster on each tread serves only as a filler and has no structural value. This baluster can be identified by the plastic cap on one end. The cap is sized to fit snugly into the baluster hole in the tread and will cushion rattle as it holds the baluster in place.

### DESIGN 175 & 135

- 1 Anchor base plate in proper position.
- 2 Place center pole in position on base plate.
- 3 Install rubber covering in the following manner: (Applicable only to Design 175-R and 175-RAL) Apply an even coat of neoprene cement to both the steel and rubber. Allow neoprene cement to dry in accordance with instructions on can. Place rubber carefully into position and press firmly or roll entire surface. Trim off excess rubber if required.
- 4 Assemble treads on center pole in numerical order: i.e. 1, 2, 3, etc. and place in approximate position as shown in plan views.
- 5 **NOTE:** The hub of tread #1 is machined to allow for the base plate and the hubs of all treads and platforms are drilled and tapped two places for 3/8 " set screws. Make sure threads are free from paint, chips, etc. before they are assembled on center pole.
- 6 Place platform in position and secure to stair well. NOTE: Winged hub should be installed at this time if furnished instead of platform.
- 7 Place center pole trim piece over protruding center pole, rotate trim piece so that tapped holes are directly in line to receive well rail. Install well rail and anchor all points. Secure center pole trim piece with two 3/8 "x 5/16 "set screws.
- 8 Attach front or leading balusters loosely to corresponding numbered treads.
- 9 Attach spiral rail loosely to balusters with screws as indicated by detail on drawings. Secure spiral rail splices per detail on drawings. Anchor top section of spiral rail securely to platform, wall or well rail as indicated on the drawing.

- 10 **NOTE:** Spiral rail sections are marked in numerical order as stair is ascended.
- 11 Working from top of stair down, position treads so that balusters are in a true vertical position. Lock tread to center pole with 3/8 " set screws. Secure spiral rail to baluster and baluster tread.
- 12 Install intermediate balusters. Push baluster into hole in tread until hole in milled seat on upper end aligns with hole in spiral rail. Secure baluster to spiral rail.
- 13 Recheck all fasteners and make sure all are secure. Adjust alignment as required.

**FINAL OPERATION:** Drill center pole thru 3/16 " hole in hub of treads with #14 drill and install 3/16 " x 3/4 " groove pins. \*\*