

Model 220 & 201 Stair Erection Instructions

STANDARD ERECTION INSTRUCTIONS FOR SPIRAL STAIR: DESIGN 220 & 201

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 as a filler and has no structural value. This baluster can be identified by the plastic cap on the 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 220 & 201

- 1 Anchor base plate in proper position.
- 2 Place center pole in position on base plate.
- 3 Assemble treads on center pole in numerical order: i.e. 1, 2, 3, etc. and place in approximate position as shown in plan views:
- 4 **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.
- 5 Place platform in position and secure to stair well. Lock platform to center pole with 3/8 " set screws. NOTE: Winged hub should be installed at this time if furnished instead of platform.
- 6 Place center pole trim piece over protruding center pole, rotate trim piece so that tapped holed are directly in line to receive well rail. Install well rail and anchor all points. Secure center pole trim piece with two 5/16 " x 5/16 " set screws.
- 7 Attach front or leading balusters loosely to corresponding numbered treads.
- 8 Attach spiral rail loosely to balusters with screws as indicated by detail on drawing. Secure spiral rail splices per detail on drawing. Anchor top section of spiral rail securely to platform or well rail as indicated on the drawing.
- 9 **NOTE:** Spiral rail sections are marked in numerical order as stair is ascended.
- 10 At this point, the platform should be secured to well opening as outlined in step 4 and the spiral rail should be secured as outlined in step 7. Starting at the top of the stair and working down, proceed as follows: Shift tread

- immediately below platform axially until terminal post is used and spiral rail returns to well rail or wall, proceed as follows: Shift tread immediately below platform and rear edge of tread are parallel. Secure tread to center pole and secure nut on carriage bolt in platform.
- 11 Move to second tread below the platform and shift tread axially until baluster on tread immediately below platform comes into true vertical position. Lock tread to center pole with 3/8 " set screws. Secure baluster to spiral rail and secure nut on baluster. Repeat sequence with each tread ascending stair until all balusters are aligned and secured.
 - 12 Install intermediate or rear baluster. 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.
 - 14 FINAL OPERATION: Install leg, riser #1, on stud on bottom of spiral rail. Anchor flange to floor:

NOTE: Not applicable on 201 or 251.