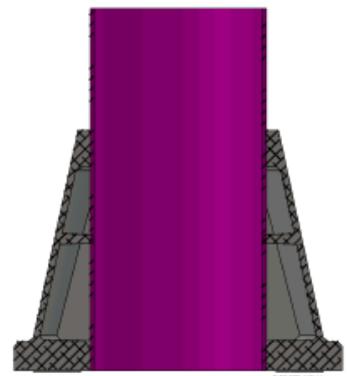


This installation manual has to be read before the installation of Sapa products

General Conditions; the fasteners are clean and they must be free from burrs, strange metal parts, sand and so on. One sided clamping of the base plate caused by damage of the bold or the skew screw-on of the nut and bold must be avoided. When the tightening moments mentioned below are exceeded, all cast pieces can be damaged unrecoverable. Please follow the tightening moments below!

Casted 2part Base plate

1. Check if the fasteners are greased*, especially the stainless bolts and nuts
2. Fasten the base plate parts onto the foundation by hand
3. Fasten cross over with equal clearance on both sides (avoid canting!)
4. Don't use air tools for fastening. Maximum tightening moment according to table 1
5. **Note:** the base part of the column must be lowered into the base plate until the bottom sections are in line, before tightening. This to avoid Canting.



Maximum tightening moments for stainless fasteners	
Bold dimension (A2 klasse 70)	Tightening moment Nm
M10	35
M12	50
M16	100
M18	125



Cast pieces for brackets

1. Check if the crater bolts are greased*
2. Don't use air tools for fastening
3. Max. tightening moment crater bolts **M10** is 22Nm



Sapa Pole Products

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Invisible joint

1. Check if the crater bolts are greased*
2. Don't use air tools for fastening
3. Max. tightening moment crater bolts **M8** is 12Nm
4. Mount the bracket before the installation of the column (This will help to outline the column)



NOTICE! : The bracket can be placed and mounted in 4 positions in respect of the door. The mounting position can't be taken from the drawing, because there it is always drawn at 90° in respect of the door. The right mounting position can be taken from the calculation of strength. If this info is not available, then the position can be taken from the sticker on the delivered columns. If this says "NK"; "Free choice", then 180° or 0° is recommended.



Air tools may not be used, because the fasteners can score due to the relatively high speed of the fastening. This also counts when these tools are adjustable. The same goes for electrical tools, but when they can be adjusted at the right tightening moment, these tools can be used.

* We advise "Never Seez" as lubricant for stainless fasteners.



If poles are not installed immediately after delivery, we recommend removing the screws of the invisible joint and mounting these again until installation. This prevents the screws to get stuck as a result of external influences.

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