

Installation manual for cast pieces

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

General conditions are that; the fasteners are clean, that is; free from burrs, strange metal parts, chips, sand and so on, and that 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 under mentioned tightening moments are exceeded, all cast pieces can be damaged unrecoverable. Follow the tightening moment below!

Cast base plates

1. check if the fasteners are greased*, especially the stainless bolts and nuts,
2. fasten the base plate parts on to the foundation by hand,
3. fasten cross over with equal clearance on both sides (*avoid canting!*),
4. don't use air tools for fastening,
5. maximum tightening moment according to table 1.

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

Table 1, Maximum tightening moments.



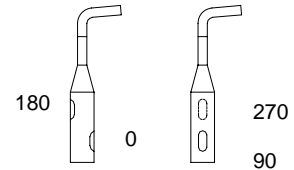
Cast pieces for brackets

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



Invisible mounting piece

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.

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