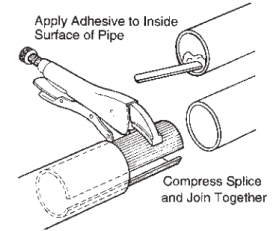


Series 5 Assembly Notes

Railing Splices

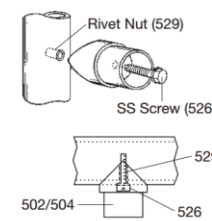
- Railing splices are designed for a tight press fit and must be compressed with a pliers to permit them to slip into the pipe. The areas to be joined should be cleaned thoroughly. Mix adhesive according to manufacturer's directions. Mix only enough that you can use within 1/2 hour. Apply adhesive to inside surface of pipe. Compress splice sleeve with a pliers, then slip into the pipe. Wipe off excess adhesive after components are properly joined. The areas connected together should be left undisturbed for eight hours, longer in cold weather.



Tee Fitting and Hardware Options

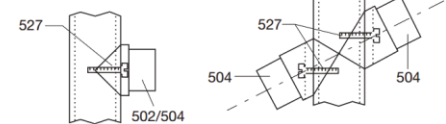
- To attach a 502 tee or 504 angle tee to a post, a stainless-steel screw (526) is positioned through the fitting and into a stainless-steel rivet nut (529) in the tubular post.
- Note: A stainless steel rivet nut CANNOT be used at any location mounting into a reinforcement rod.**
- When mounting a 502 tee or 504 angle tee into a location with a reinforcement rod, a stainless-steel screw (527) must be used.
- When two tees (502 tee or 504 angle tee) are located directly opposite each other to form a cross at 12° or less, a stainless steel thru bolt (524) and locknut are used.
- Note: This method can be used in locations with or without reinforcement rods.**

Attachment of tee fitting to post

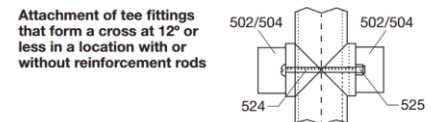


Parts Description	
502	- Tee Fitting
504	- Angle Tee Fitting
524	- S.S. Thru Bolt (1/4" x 3-14")
525	- S.S. Locknut
526	- S.S. Screw (1/4" x 1-14")
527	- S.S. Screw (1/4" x 1")
529	- S.S. Rivet Nut

Attachment of tee fitting to post in a location with a reinforcement rod

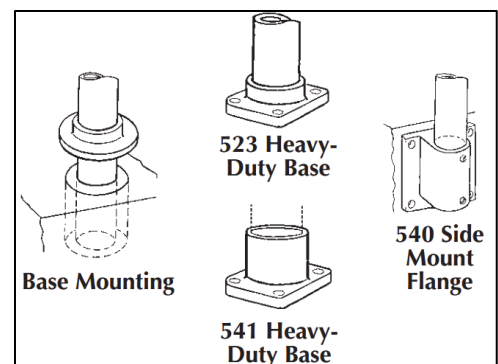
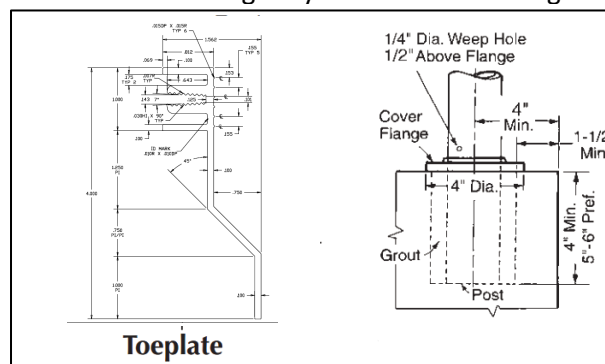
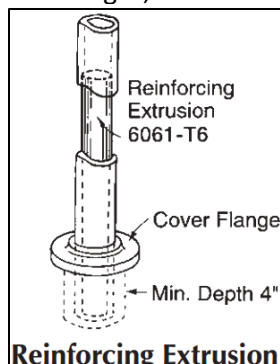


Attachment of tee fittings that form a cross at 12° or less in a location with or without reinforcement rods



Mounting Options

- Pipe or picket railing can be embedded in concrete and grouted, or mounted on decks and platforms with base flanges, or side-mounted on fascia or stringer by means of fascia flanges



Technical Support

Workmanship

- For continuous spans in excess of 40 feet, expansion joints should be provided. To make an expansion joint, one end of the spliced joint should not have structural adhesive applied so that it is free to move in or out of the pipe. If a joint is provided every 30 feet, the width of the gap should allow 1/8" expansion for each 40°F of expected temperature rise. All pipe railing splices should be made no more than 12" from the nearest post.
- All pipe cuts shall be square and accurate for minimum joint-gap. Cuts shall be clean and free of chamfer, from deburring, nicks and burrs. Holes shall be drilled the proper size for a tight flush fit of rivets and screws. All posts grouted in concrete must have one 1/4" diameter weep hole, 1/2" above post collar, in the plane of the rail.