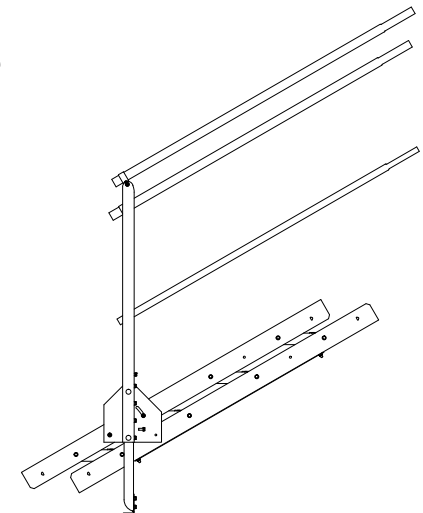
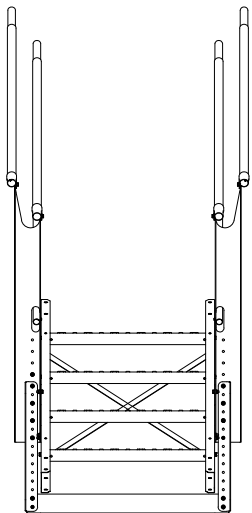


# AVT1604 Assembly Instructions

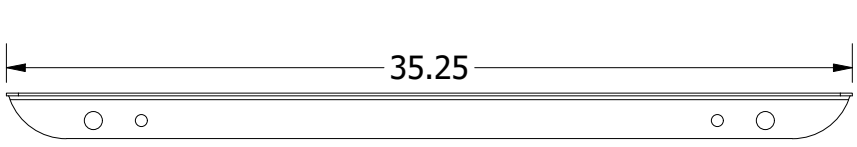
## Greene Galvanized Stairs



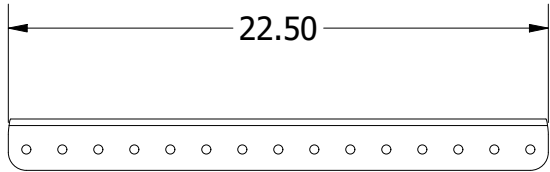
# Parts List

PARTS LIST		
PART NUMBER	DESCRIPTION	QTY
5/16-18x3/4FB	5/16"-18 x 3/4" Flange Bolt	34
5/16-18SFN	5/16"-18 Whiz Lock Nut	32
ART-1015	Post, Stair Rail, Guard Rail Left	1
ART-1016	Post, Stair Rail, Guard Rail Right	1
ART-1011	Roof Stair Leveling Plate	2
ART-5043	4-Step Siderail End	2
ART-5044	4-Step Siderail End	2
AS-00030	30" x 11" Step Tread	4
ART-1105	Post Extension	2
ART-1106	Cross Mount Foot	1
ART-1001	Stair Stringer X-Brace	2
Floor Screw	Self-Tapping Screw	6
HRC1500	1.5" Handrail P-Clamp	4
TR1506006	1.5" Handrail, 60" Long, 6" Swage	4
TR1006006	1" Handrail, 60" Long, 6" Swage	2

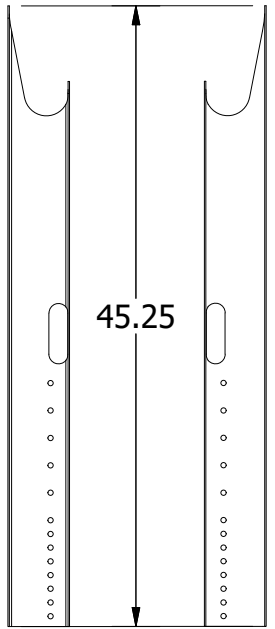
# Parts List



ART-1106

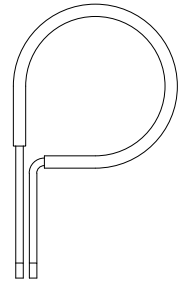


ART-1105

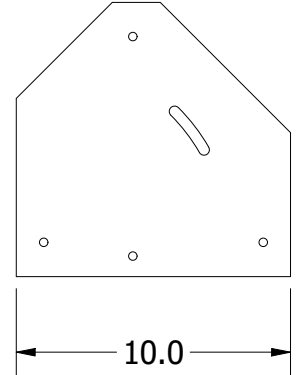


ART-1016    ART-1015

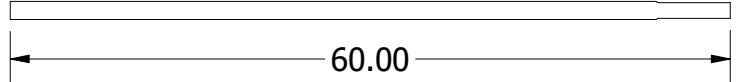
HRC1500



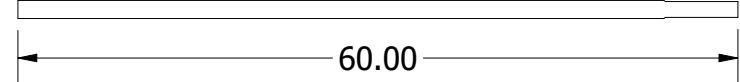
ART-1011



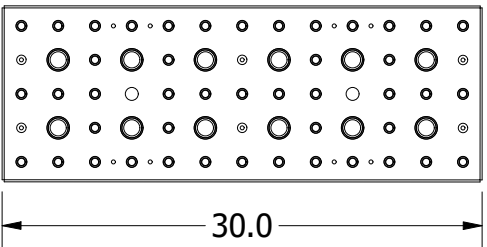
TR1506006



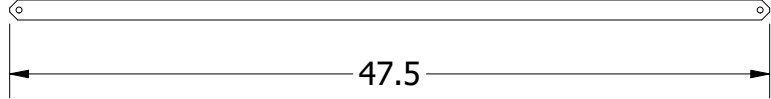
TR1006006



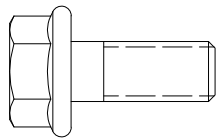
AS00030



ART-1001

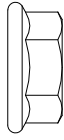


5/16-18x3/4FB



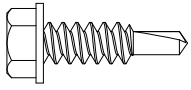
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5/16-18SFN



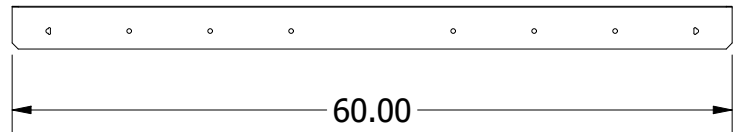
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Floor Screw



1:1

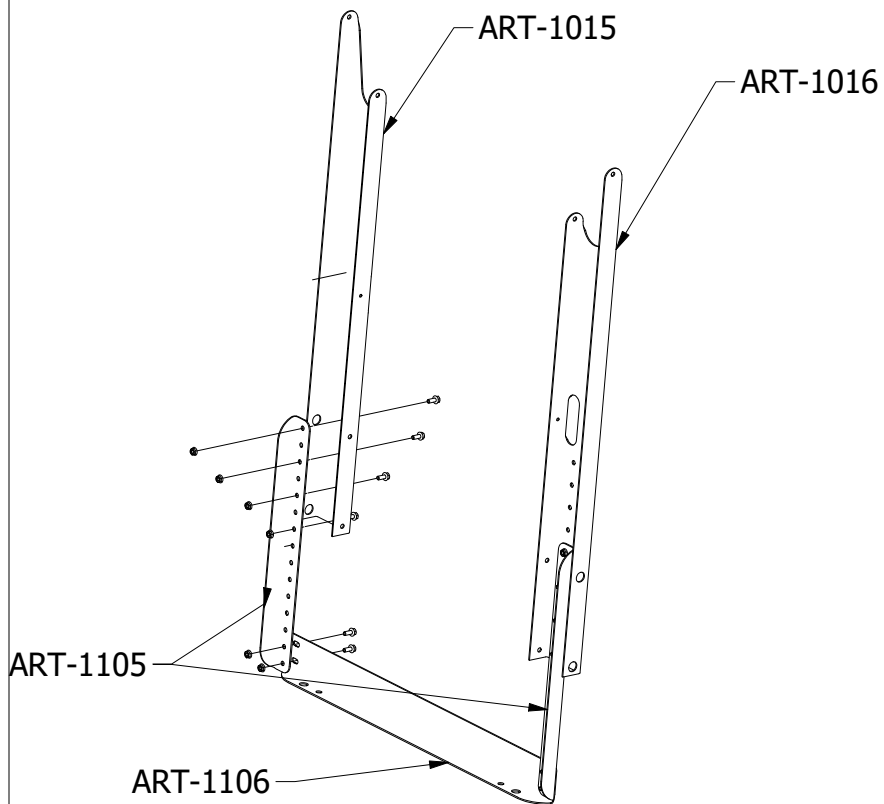
ART-5004



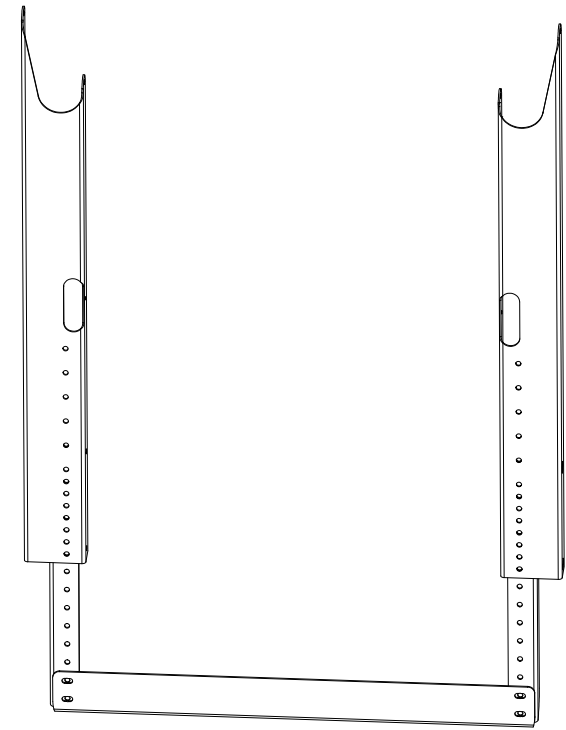
# Step 1

- A. Place the ART-1105 braces against the ART-1106 Mount as shown in Figure 1. The braces' flanges will face up the stair run when installed.
- B. Secure the braces to the cross mount using four (4) 5/16" Flange Bolts and four (4) 5/16" Lock Nuts. See Detail A for bolt hole locations on the ART-1106 brace.
- C. Place the ART-1015 and ART-1016 posts against the ART-1105 braces. The bolt spacing shown in Figure 2 are in the lowest position; adjust the height to fit the roof.
- D. Secure each in place with three (3) 5/16" Flange Bolts and three (3) 5/16" Lock Nuts.

## Figure 1



## Figure 2



### PARTS USED IN STEP 1

PART NUMBER	DESCRIPTION	QTY
ART-1106	Cross Mount Foot	1
ART-1105	Post Extension	2
ART-1015	Right Stair Post	1
ART-1016	Left Stair Post	1
5/16-18x3/4FB	5/16"-18 x 3/4" Flange Bolt	10
5/16-18SFN	5/16"-18 Whiz Lock Nut	10

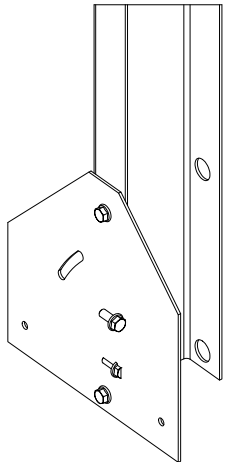
DRAWN Marcus Wilmsmeyer	1/17/2019	Greene Galvanized Stairs East Lynn, IL 217.375.4244 www.greenebinstairs.com	
CHECKED		TITLE A-Series Roof Stairs - 4-Step Assembly Instructions	
QA		SIZE A	DWG NO AVT1604
MFG		SCALE 1/14	REV
APPROVED		SHEET 4 OF 10	

# Step 2

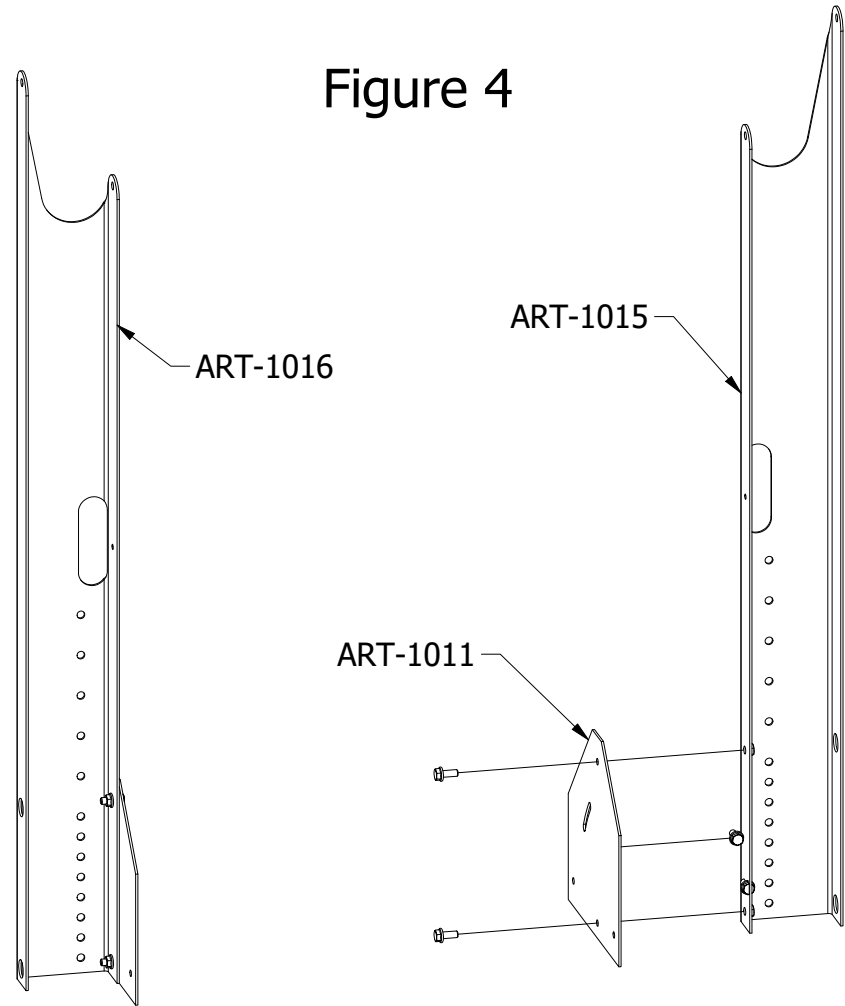
- A. Take two (2) ART-1011 Levelling Brackets and attach them to the ART-1015 and ART-1016 posts as shown in Figure 3 and Figure 4.
- B. Secure the brackets in place using four (4) 5/16" Flange Bolts and four (4) 5/16" Lock Nuts.

PARTS USED IN STEP 2		
PART NUMBER	DESCRIPTION	QTY
5/16-18x3/4FB	5/16"-18 x 3/4" Flange Bolt	4
5/16-18SFN	5/16"-18 Whiz Lock Nut	4
ART-1011	Roof Stair Leveling Plate	2

## Figure 3



## Figure 4



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QA		SIZE A	DWG NO AVT1604
MFG		SCALE 1/9	REV
APPROVED		SHEET 5 OF 10	

# Step 3

- A. Place four (4) AS00030 Step Treads in line with two (2) ART-5004 Siderails and two (2) ART-5004 Siderails as shown in Figure 5.
- B. Using fourteen (14) 5/16" Flange Bolts and fourteen (14) 5/16" Lock Nuts, secure the step treads to the siderails. On the second-lowest stair, omit two of the bolts and nuts; they will be added on a later step.

PARTS USED IN STEP 3		
PART NUMBER	DESCRIPTION	QTY
ART-5004	4-Step End Side Rail	4
AS00030	30" x 11" Stair Tread	4
5/16-18x3/4FB	5/16"-18 x 3/4" Flange Bolt	14
5/16-18SFN	5/16"-18 Whiz Lock Nut	14

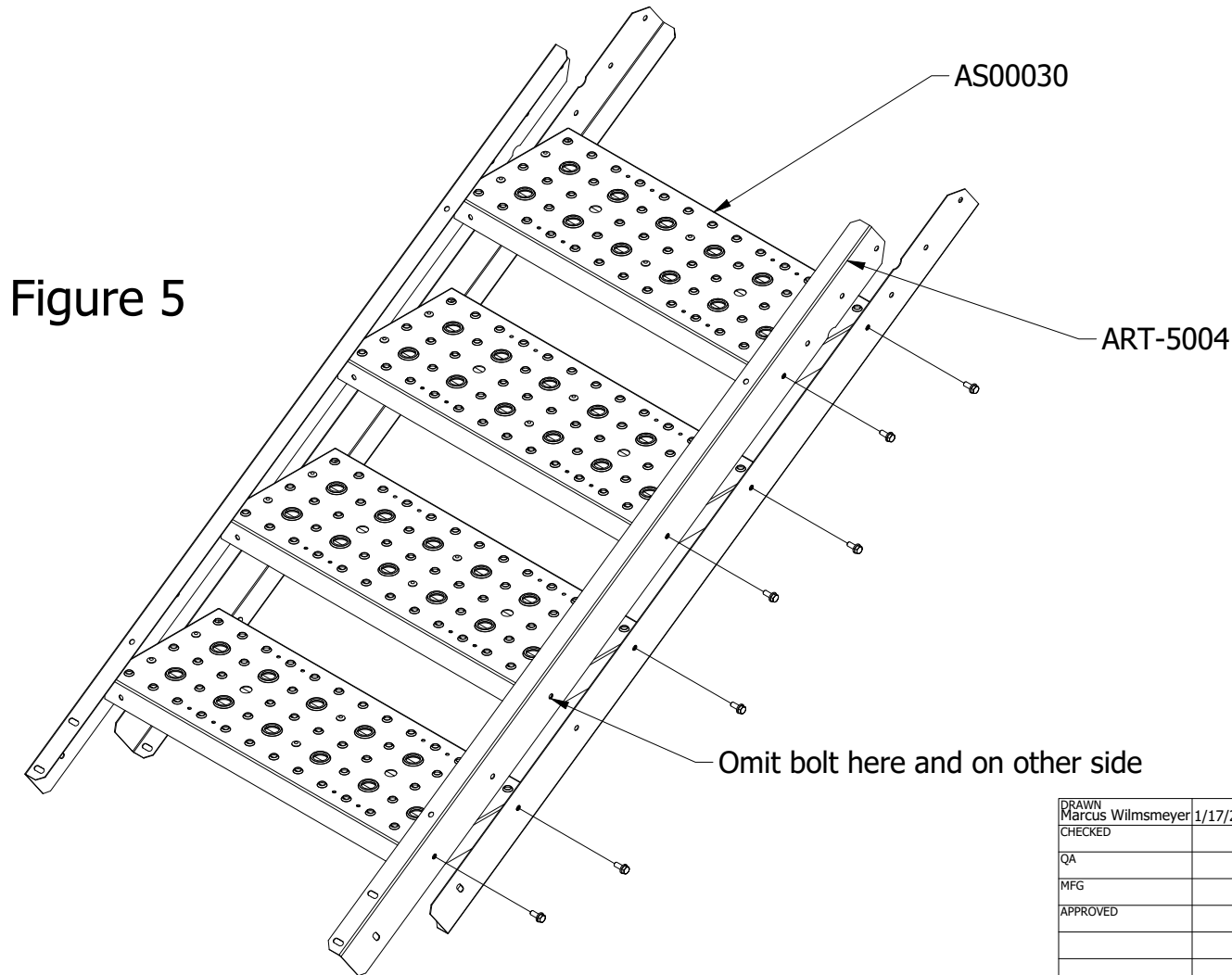


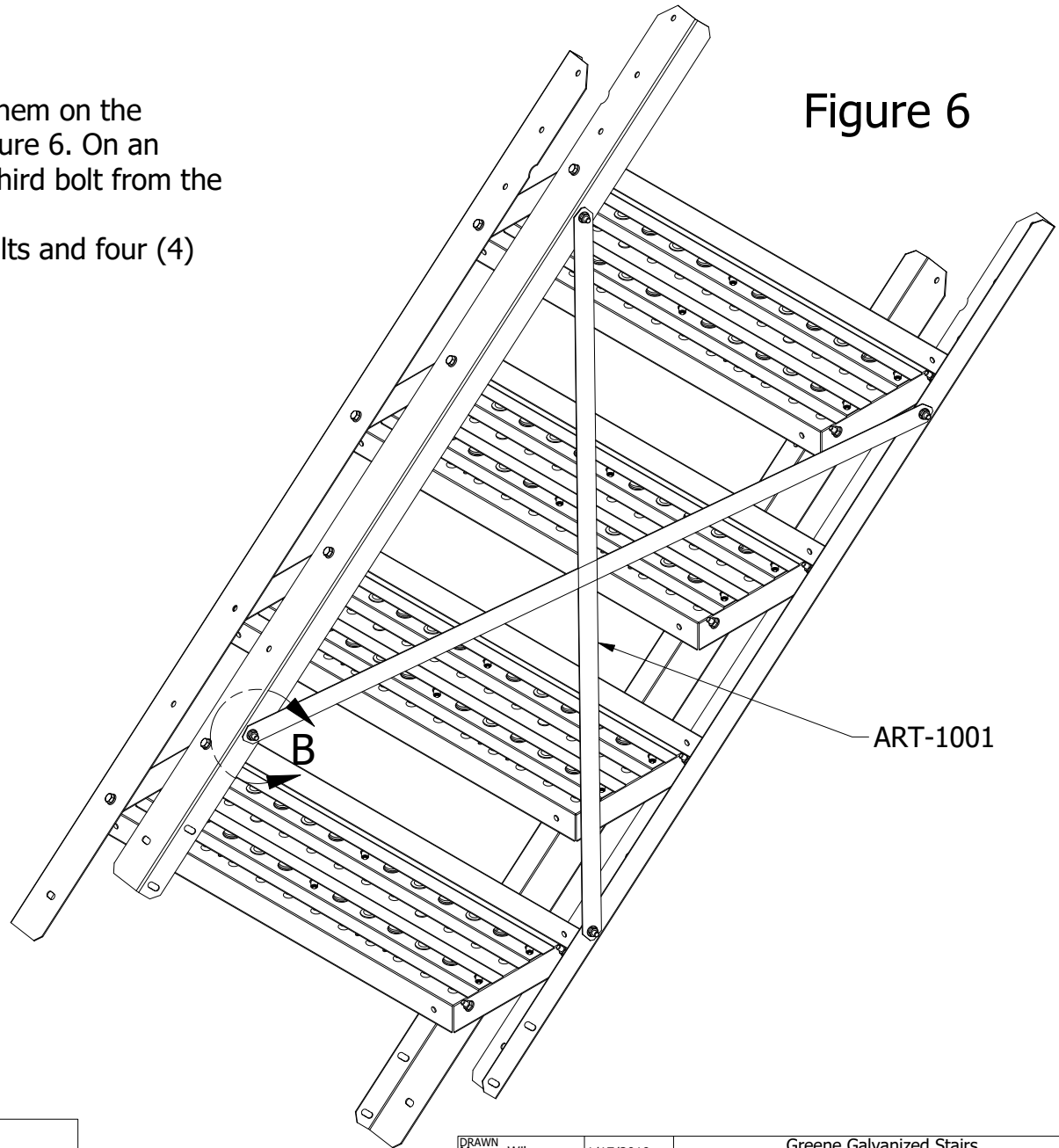
Figure 5

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QA		SIZE A	DWG NO AVT1604
MFG		SCALE 1/12	REV
APPROVED		SHEET 6 OF 10	

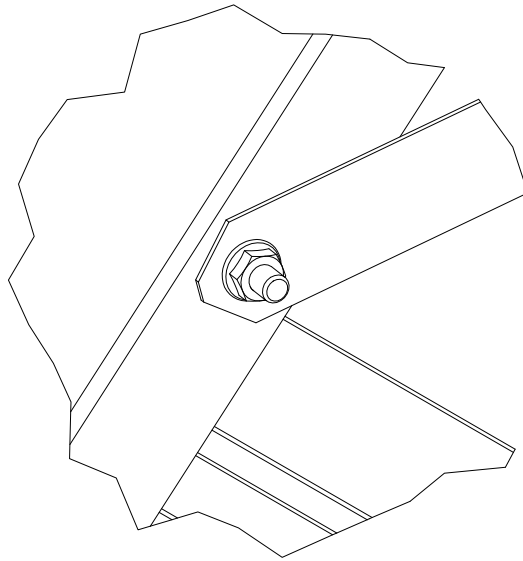
# Step 4

- A. Take the two (2) Cross Braces and position them on the bottom of the stair assembly as shown in Figure 6. On an ART5014, these braces will line up with the third bolt from the bottom end on the siderails.
- B. Secure in place with four (4) 5/16" Flange Bolts and four (4) 5/16" Lock Nuts.

Figure 6



DETAIL B



PARTS USED IN STEP 4		
PART NUMBER	DESCRIPTION	QTY
5/16-18x3/4FB	5/16"-18 x 3/4" Flange Bolt	4
5/16-18SFN	5/16"-18 Whiz Lock Nut	4
ART-1001	Roof Stair Cross Brace	2

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QA		SIZE A	DWG NO AVT1604
MFG		SCALE 1/10	REV
APPROVED		SHEET 7 OF 10	

# Step 5

- A. Using six (6) 5/16" Flange Bolts and six (6) 5/16" Lock Nuts, bolt the siderails to the leveling bracket. Review Figures 7 and 8 for the bolt layout.
- B. Tighten the bolts on the leveling plates after the final placement.

PARTS USED IN STEP 5		
PART NUMBER	DESCRIPTION	QTY
5/16-18x3/4FB	5/16"-18 x 3/4" Flange Bolt	6
5/16-18SFN	5/16"-18 Whiz Lock Nut	6

Figure 7

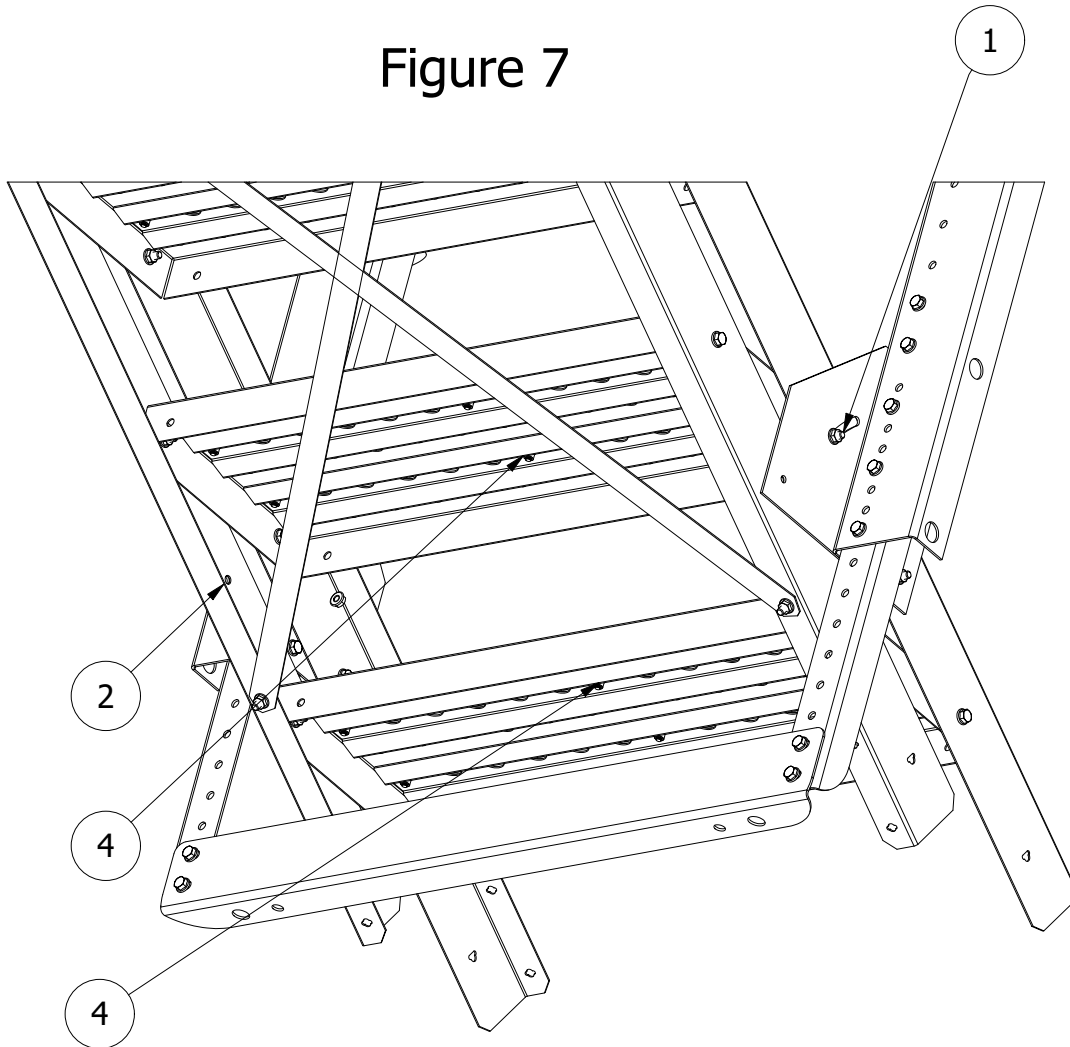
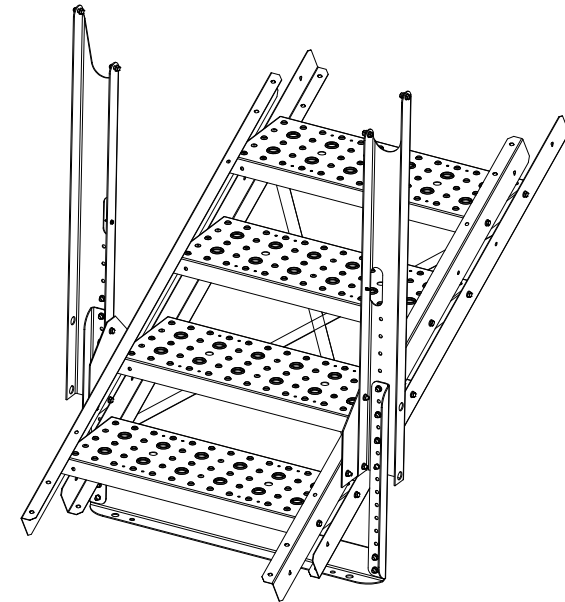


Figure 8

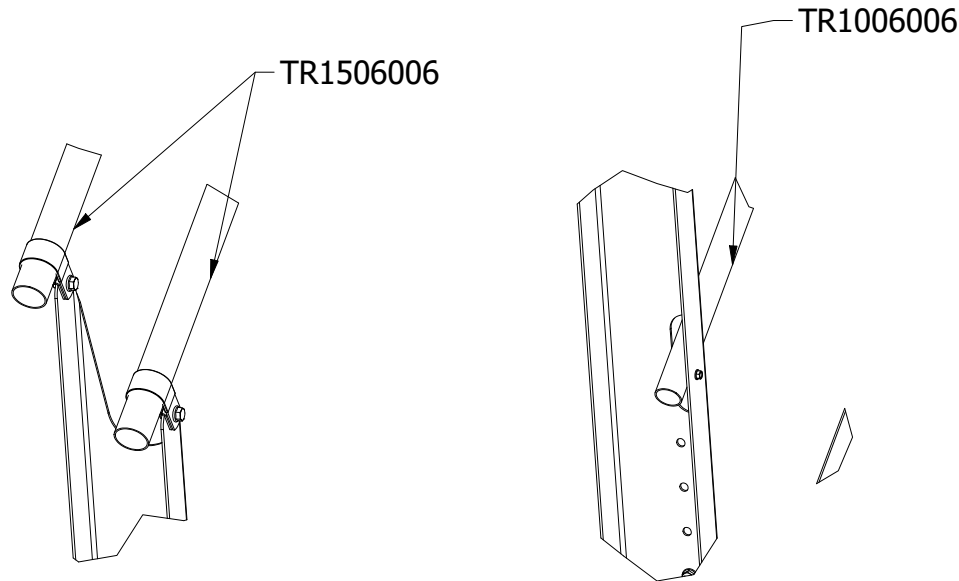


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QA		SIZE A	DWG NO AVT1604
MFG		SCALE 1 / 8	REV
APPROVED		SHEET 8 OF 10	



# Step 6

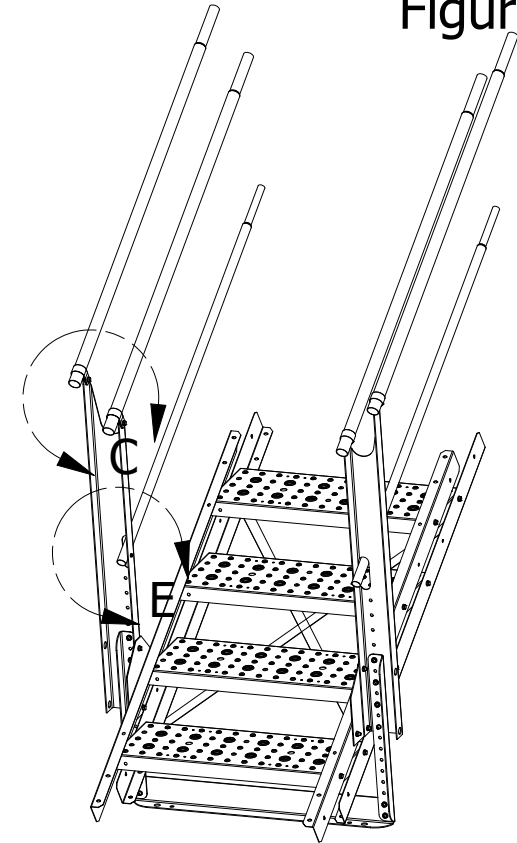
- A. Taking the four (4) TR1506006 Swaged Pipes (1.5" dia.), position the pipes as shown in Figure 9, Detail C. Secure the pipes to the posts using four (4) HRC1500 P-Clamps, four (4) 5/16" Flange Bolts, and four (4) 5/16" Lock Nuts.
- B. After the four TR1506006 have been position to the desired location, use four (4) Self-Tapping Screws and secure the 1.5" pipe to the P-Clamp. The screws should be drilled through the bottom of the P-clamp, to minimize interference with hands.
- C. Take the two (2) TR1006006 Swaged Pipes (1" dia.), and position them as shown in Figure 9, Detail D. Secure them to the posts by using two (2) Self-Tapping Screws. There is a hole on the post to aid in starting the Self-Tapping Screw.



DETAIL C

DETAIL E

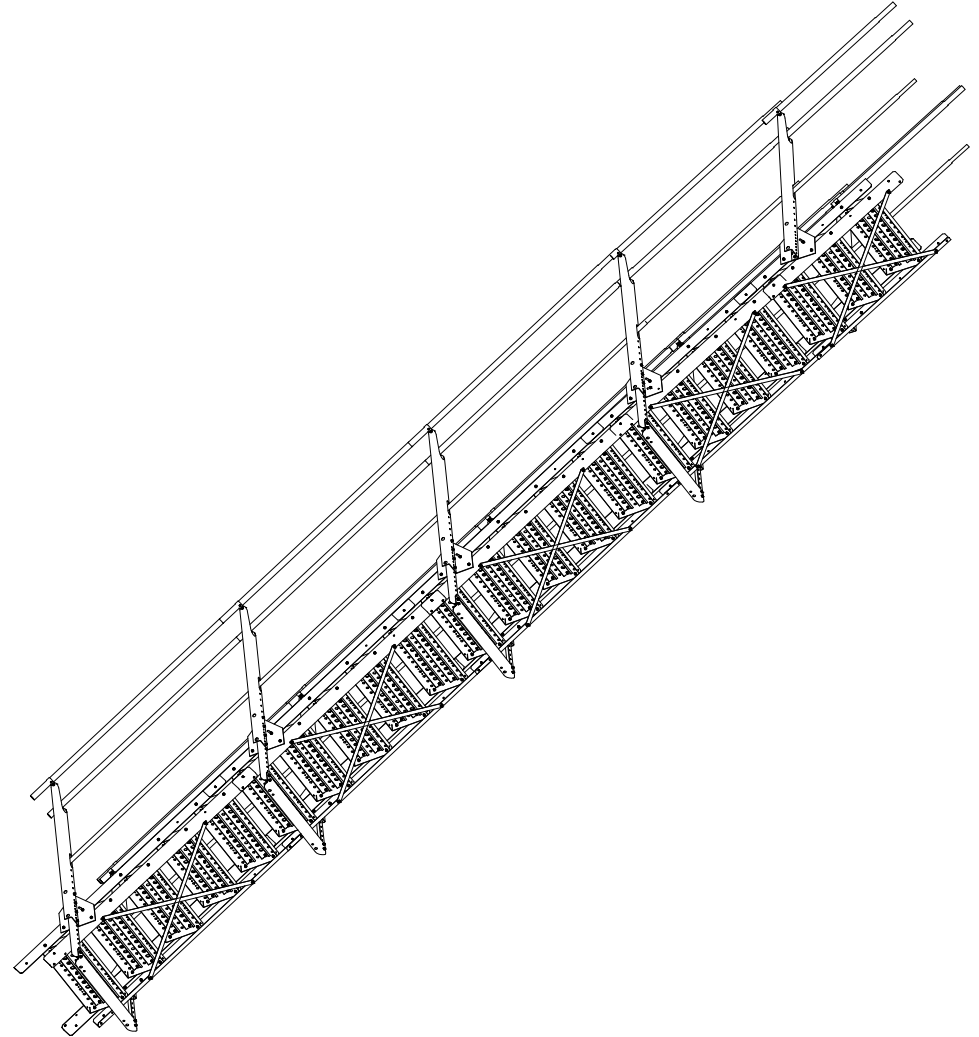
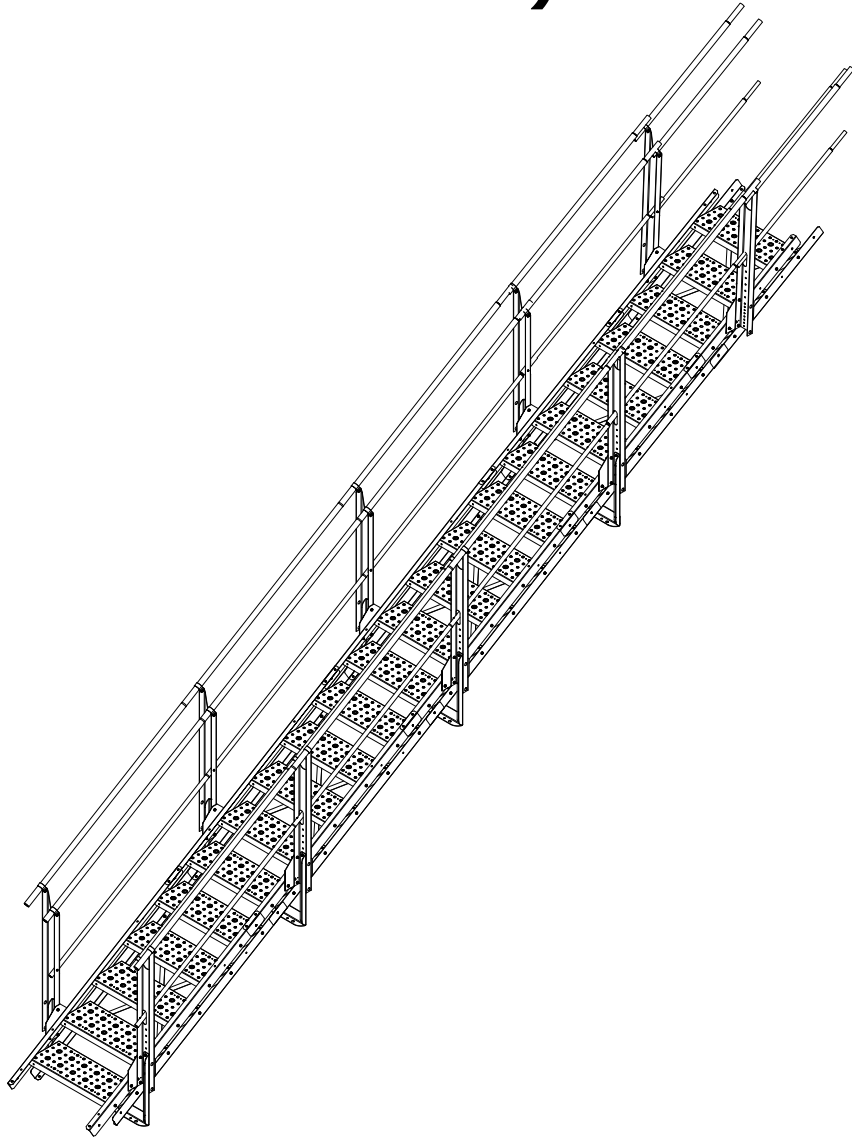
Figure 9



PARTS USED IN STEP 6		
PART NUMBER	DESCRIPTION	QTY
5/16-18x3/4FB	5/16"-18 x 3/4" Flange Bolt	4
5/16-18SFN	5/16"-18 Whiz Lock Nut	4
Floor Screws	Self-Tapping Screw	6
HRC1500	1.5" Handrail P-Clamp	4
TR1506006	1.5" 42" Handrail, No Swage	4
TR1006006	1" 42" Handrail, No Swage	2

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QA		SIZE A	DWG NO AVT1604
MFG		SCALE 1/24	REV
APPROVED		SHEET 9 OF 10	

# Sample 22 Step Assembly - ( applies to multiple step package assemblies including 17,20,21 step assemblies)



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CHECKED		TITLE	
QA		A-Series Roof Stairs - 4-Step Assembly Instructions	
MFG		SIZE	DWG NO
APPROVED		A	AVT1604
		SCALE	1 / 50
		SHEET	10 OF 10