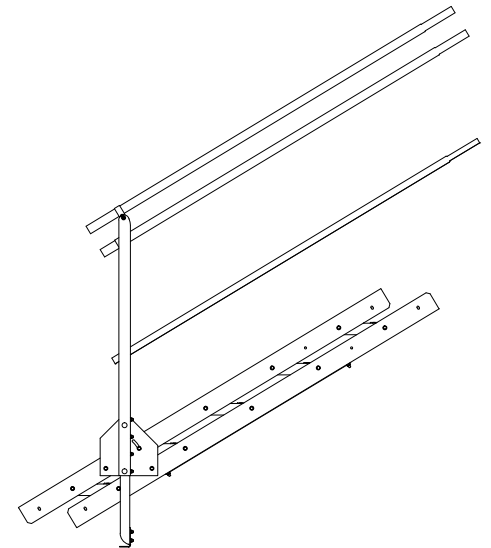
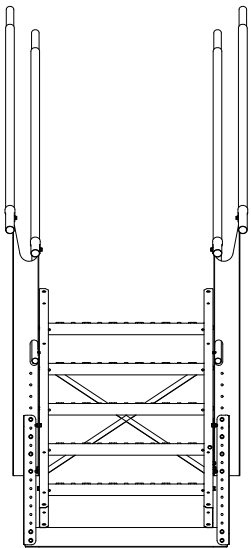


# AVT1605 Assembly Instructions

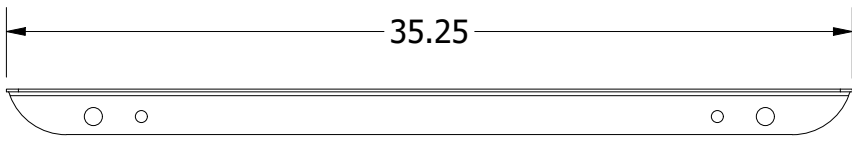
## Greene Galvanized Stairs



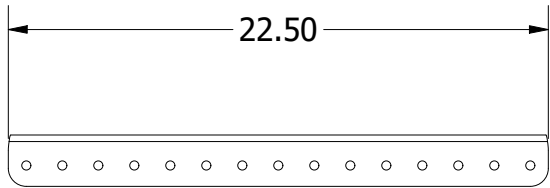
# Parts List

PARTS LIST		
PART NUMBER	DESCRIPTION	QTY
5/16-18x3/4FB	5/16"-18 x 3/4" Flange Bolt	46
5/16-18SFN	5/16"-18 Whiz Lock Nut	46
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-5005	5-Step Siderail End	4
ART-1105	Post Extension	2
AS-00030	30" x 11" Step Tread	5
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
TR1507406	1.5" Handrail, 74" Long, 6" Swage	4
TR1007406	1" Handrail, 74" Long, 6"Swage	2

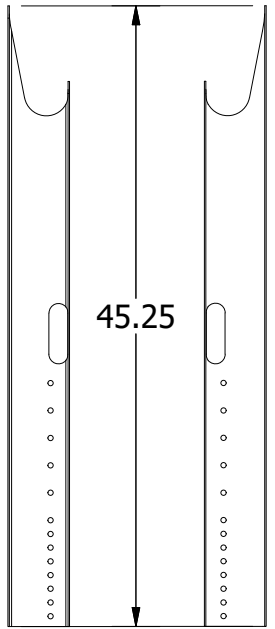
# Parts List



ART-1106

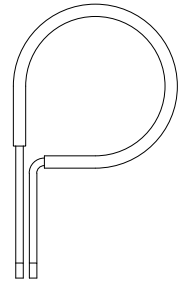


ART-1105

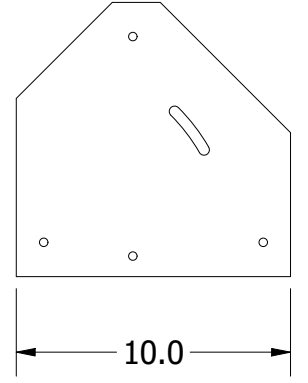


ART-1016    ART-1015

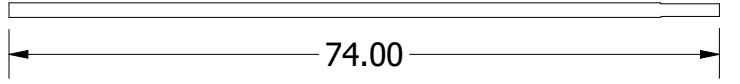
HRC1500



ART-1011



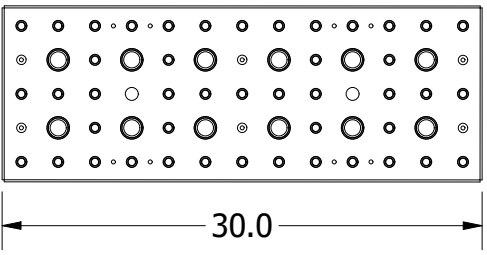
TR1007406



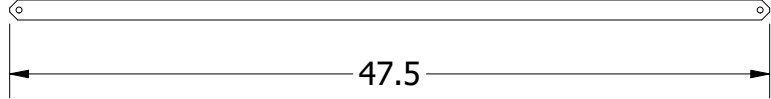
TR1507406



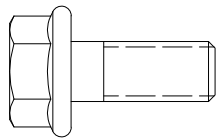
AS00030



ART-1001

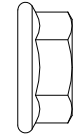


5/16-18x3/4FB



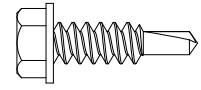
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5/16-18SFN



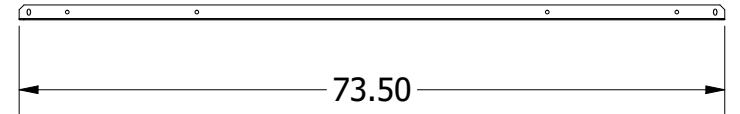
1:1

Floor Screw



1:1

ART-5005



# 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 roof run when installed.
- B. Secure the braces to the roof mount using four (4) 5/16" Flange Bolts and four (4) 5/16" Lock Nuts.
- 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.
- D. Secure each in place with three (3) 5/16" Flange Bolts and three (3) 5/16" Lock Nuts.

Figure 1

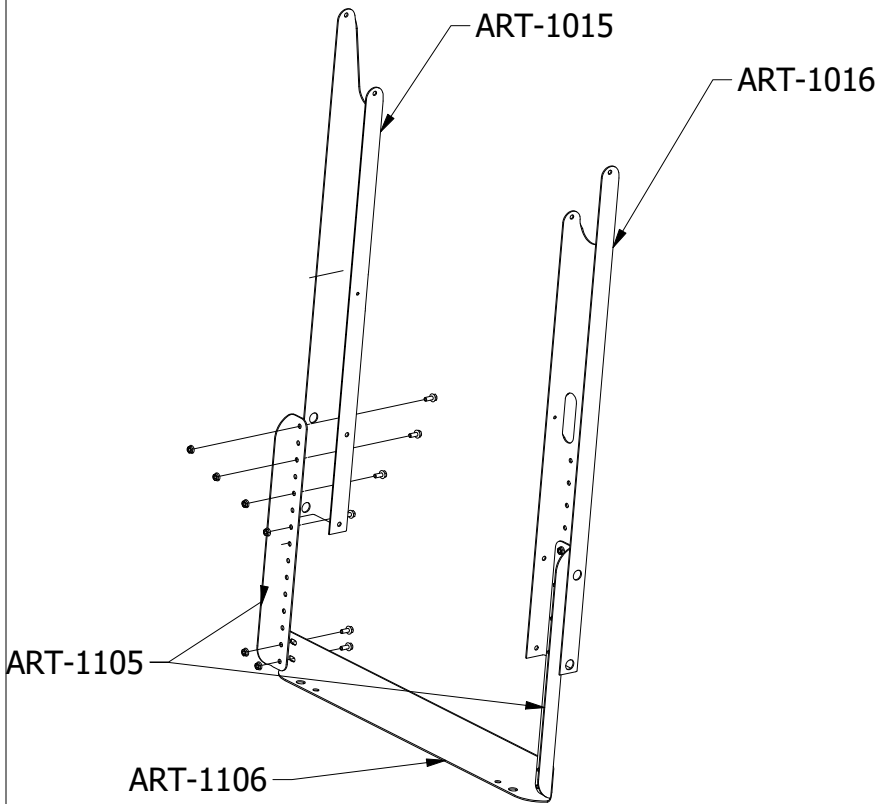
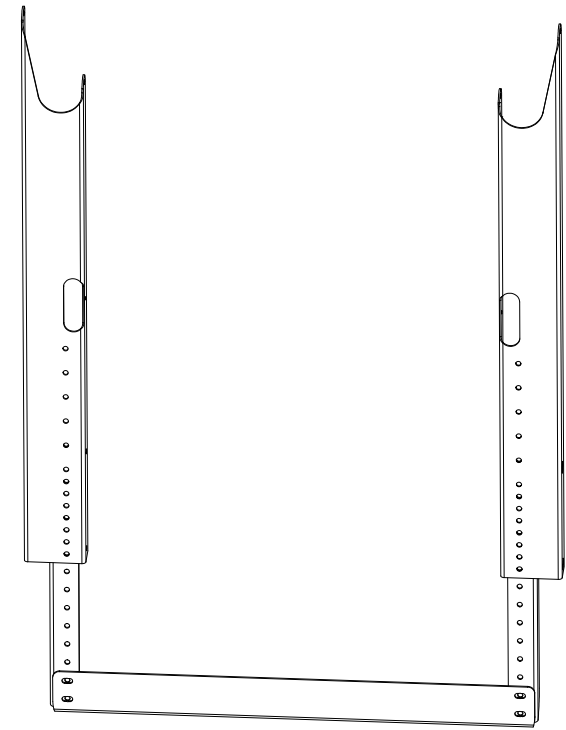


Figure 2



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

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QA		SIZE A	DWG NO AVT1605
MFG		SCALE 1/14	REV
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# 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

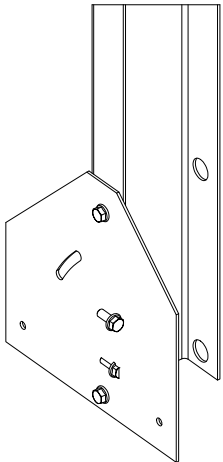
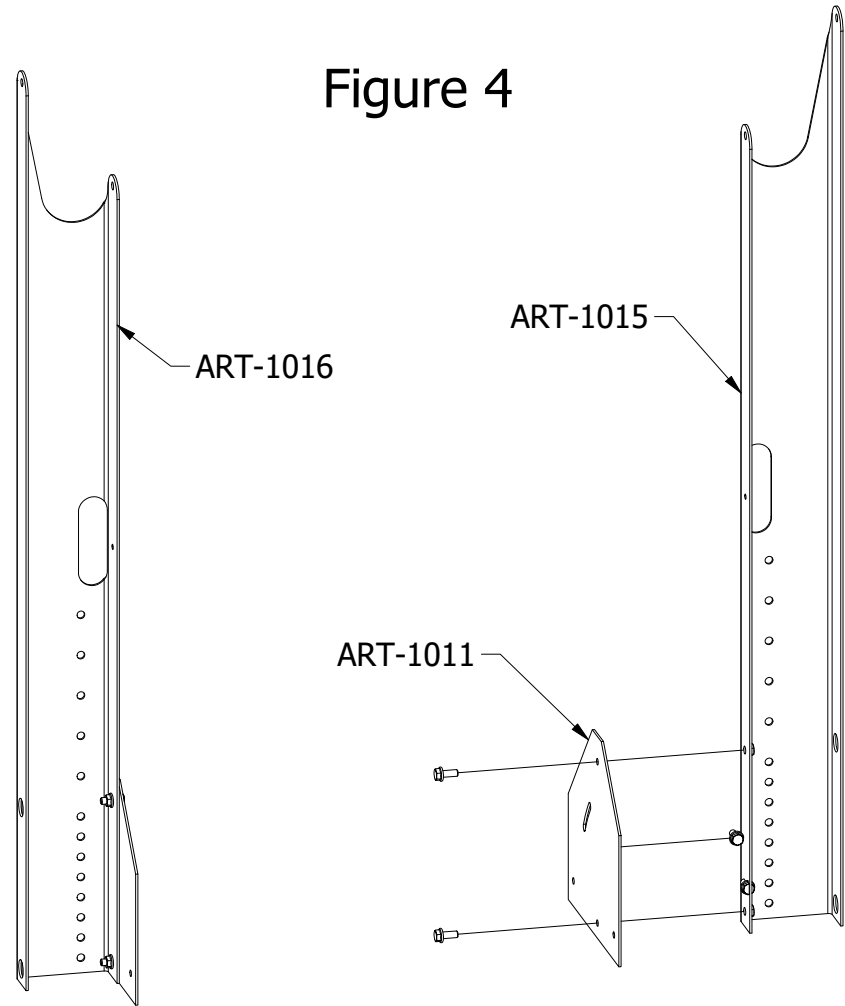


Figure 4



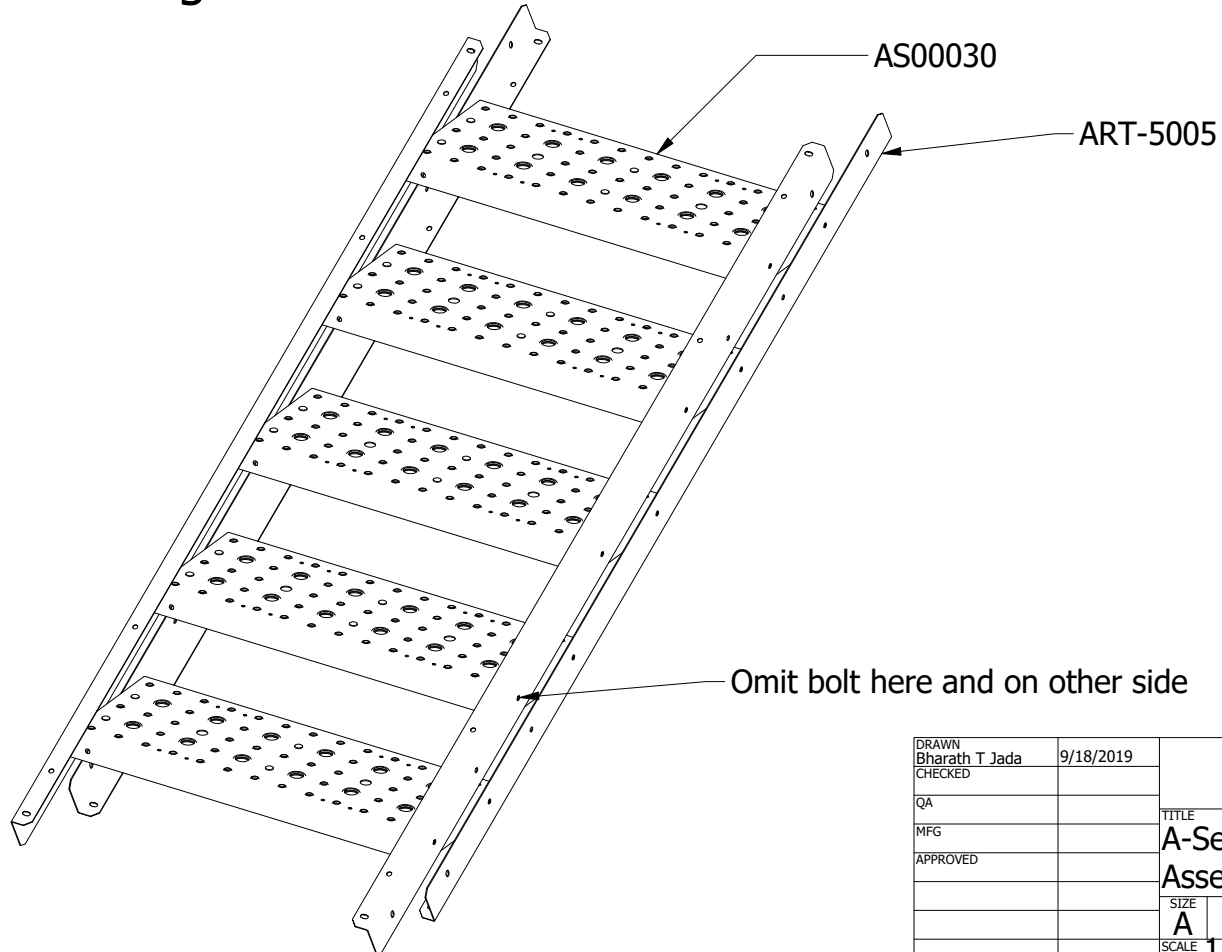
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# Step 3

- A. Place four (5) AS00030 Step Treads in line with two (2) ART-5005 Siderails and two (2) ART-5005 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-5005	5-Step End Side Rail	5
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

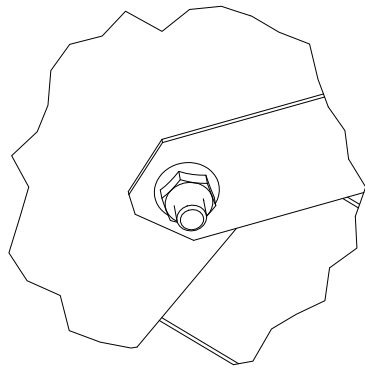
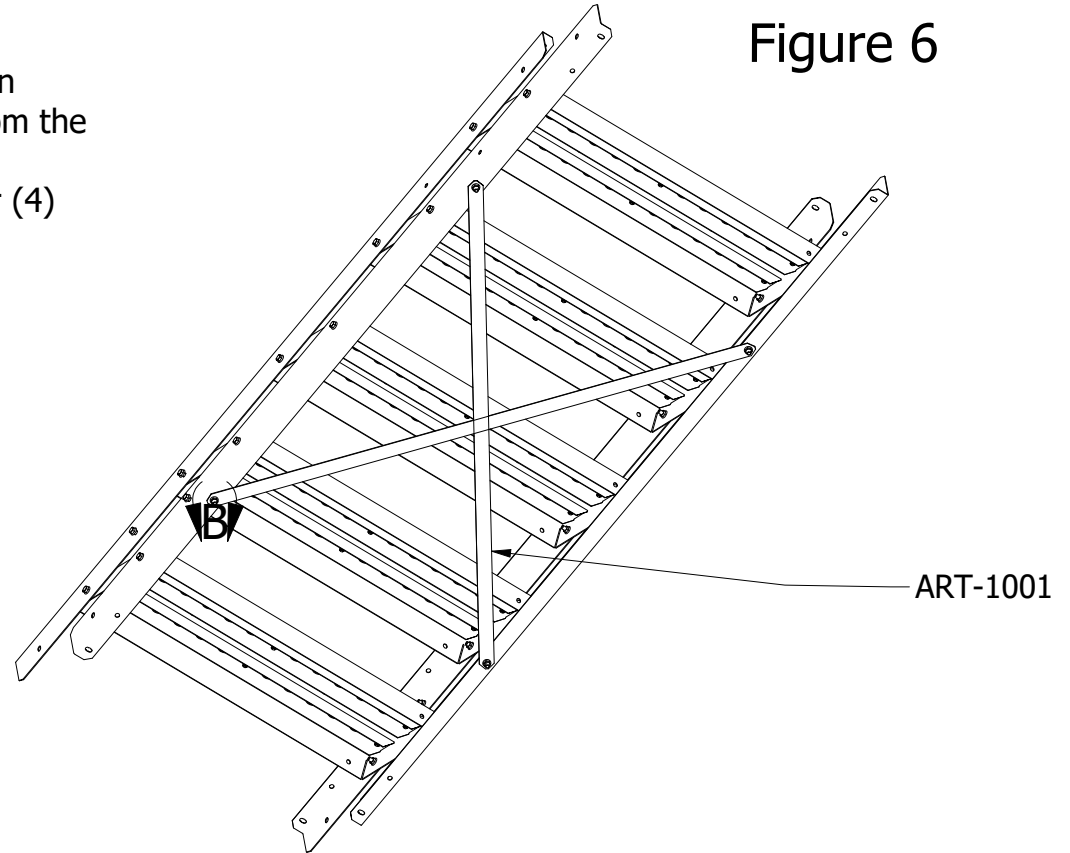


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MFG		DWG NO AVT1605	
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# Step 4

- 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 AVT1605
MFG		SCALE 1/16	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 on the roof.

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

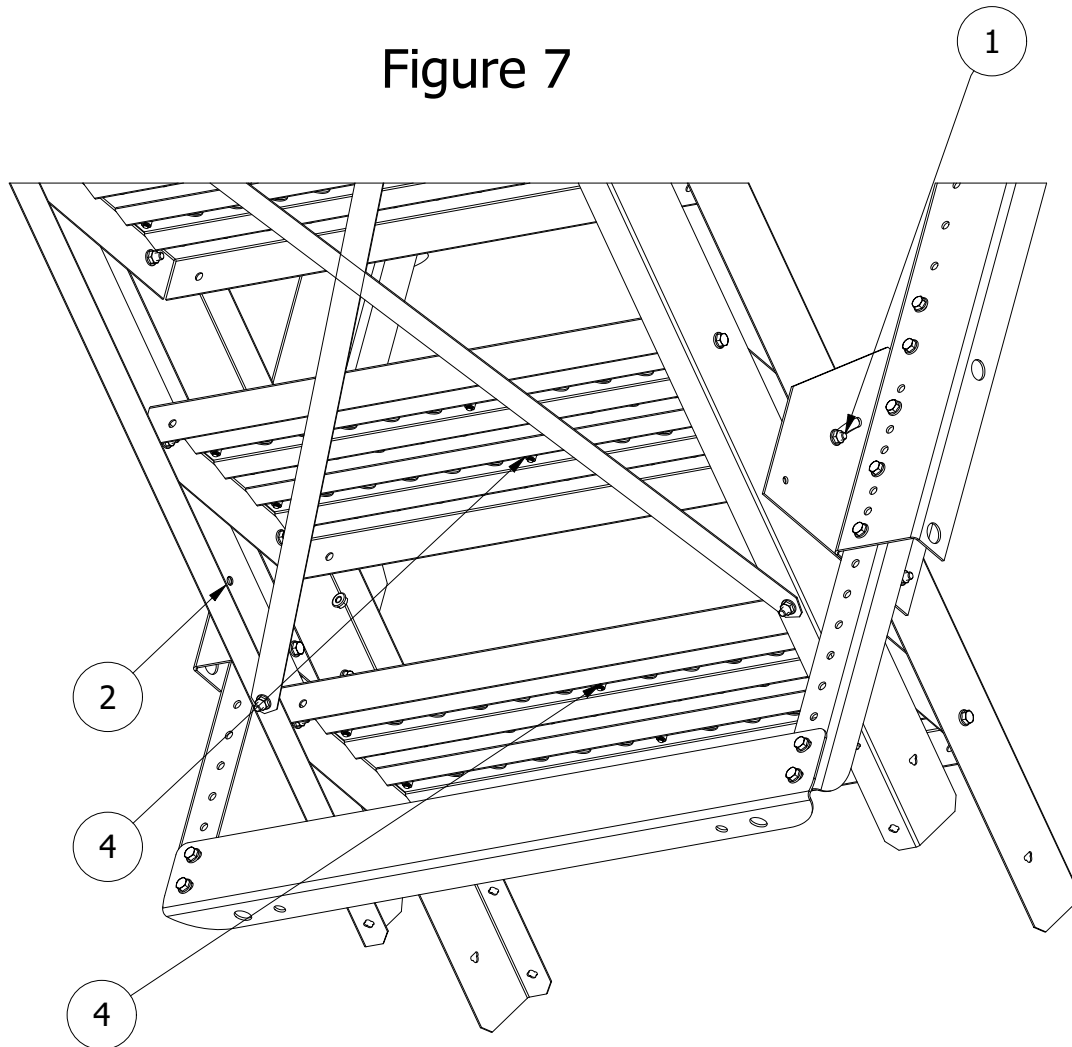
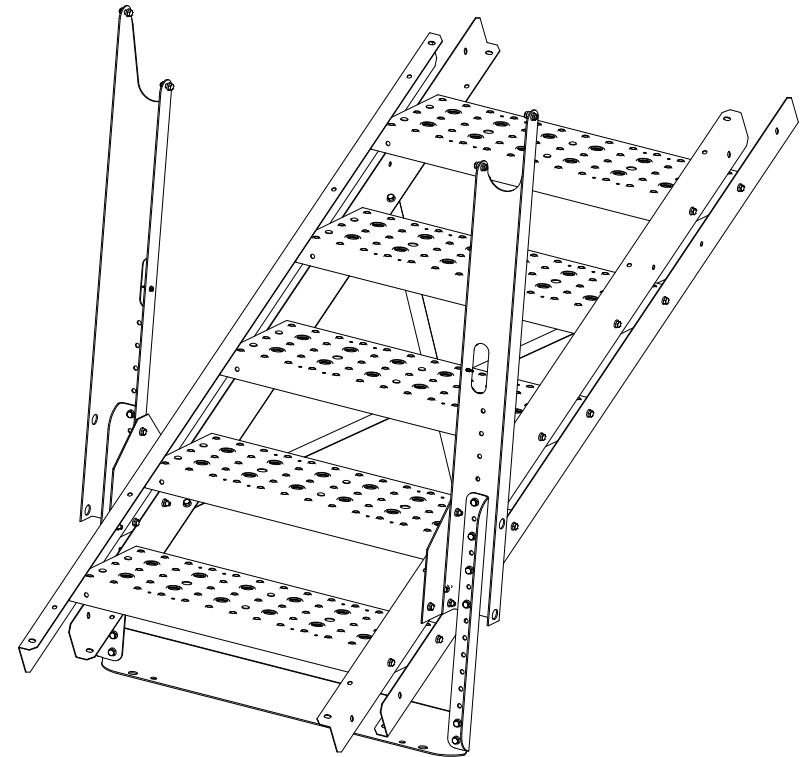


Figure 8



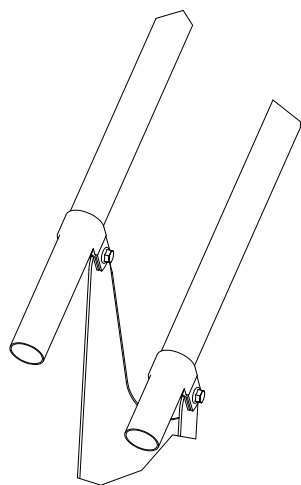
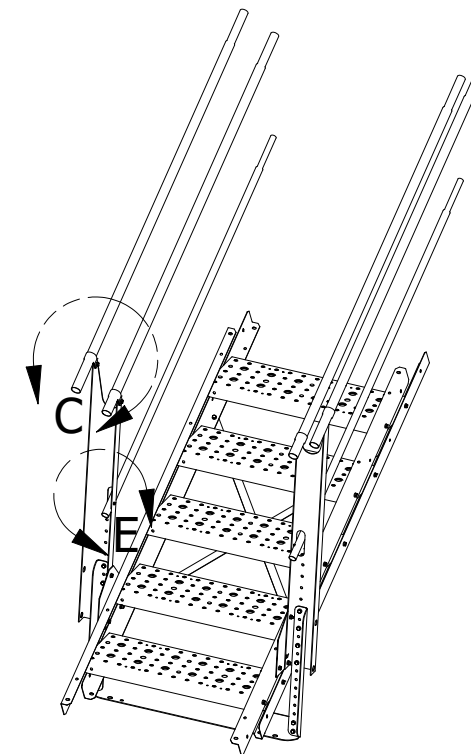
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		SHEET	8 OF 10



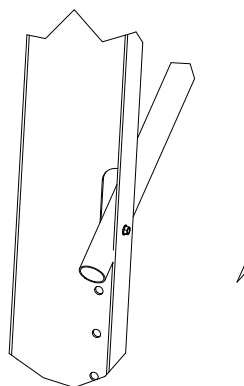
# Step 6

## Figure 9

- A. Taking the four (4) TR1507406 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 TR1507406 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) TR1007406 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

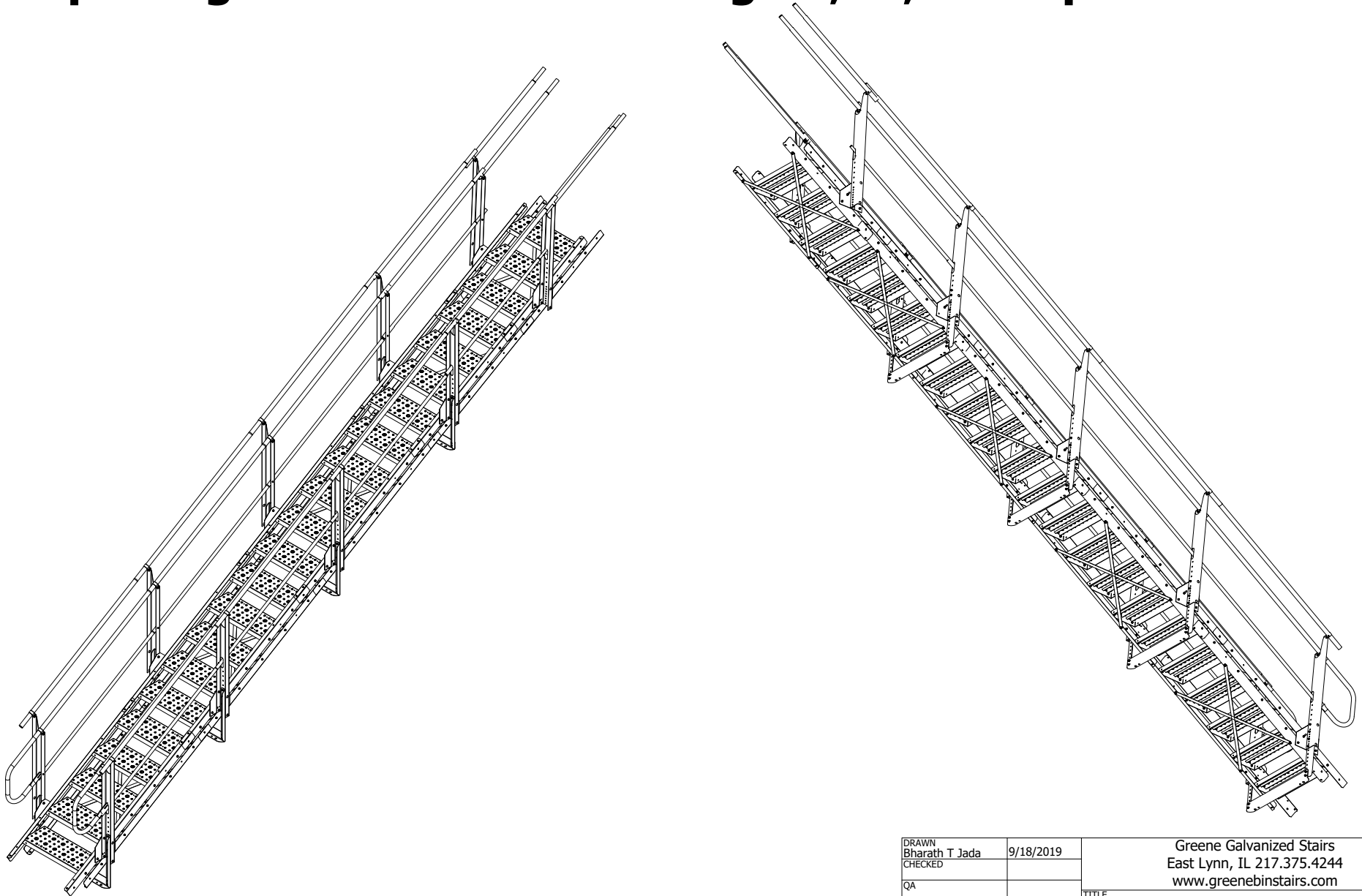


DETAIL E

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
TR1507406	1.5" 74" Handrail, 6" Swage	4
TR1007406	1" 74" Handrail, 6" Swage	2

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MFG		SCALE 1 / 30	REV
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# Sample 22 Step Assembly - ( applies to multiple step package assemblies including 17,20,21 step assemblies)



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		SCALE	REV
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