



It shall apply from: **02-10-2018 r.**

**THE ASSEMBLY INSTRUCTION OF:
QUARTER - PIPE
PRODUCT CODE: 141808**

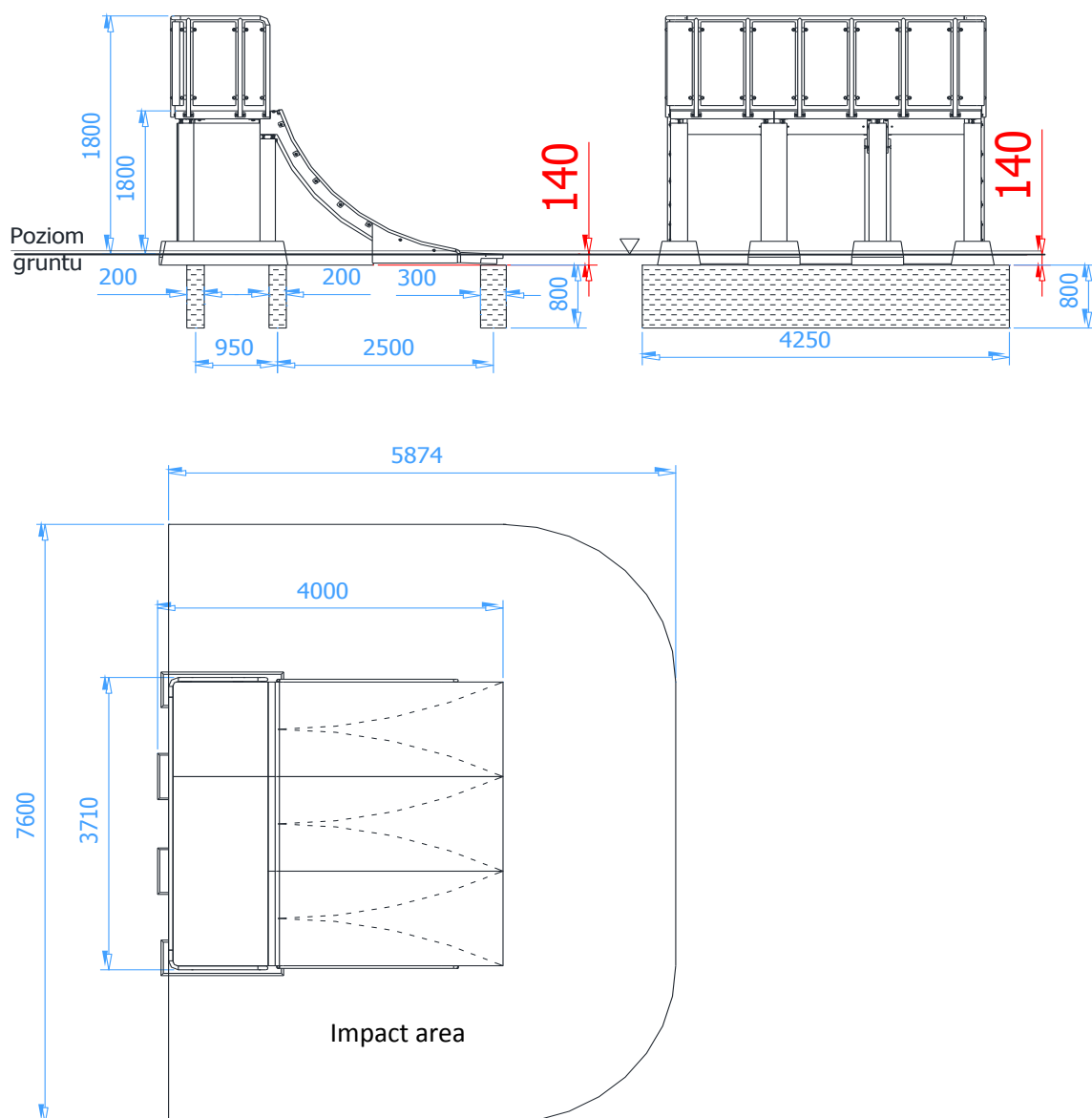


TABLE OF CONTENTS

INTRODUCTION	2
STAGE 1 – preparatory work	3
STAGE 2 – Assembly of the construction	4
1. List of components	4
2. Assembly scheme	7

INTRODUCTION

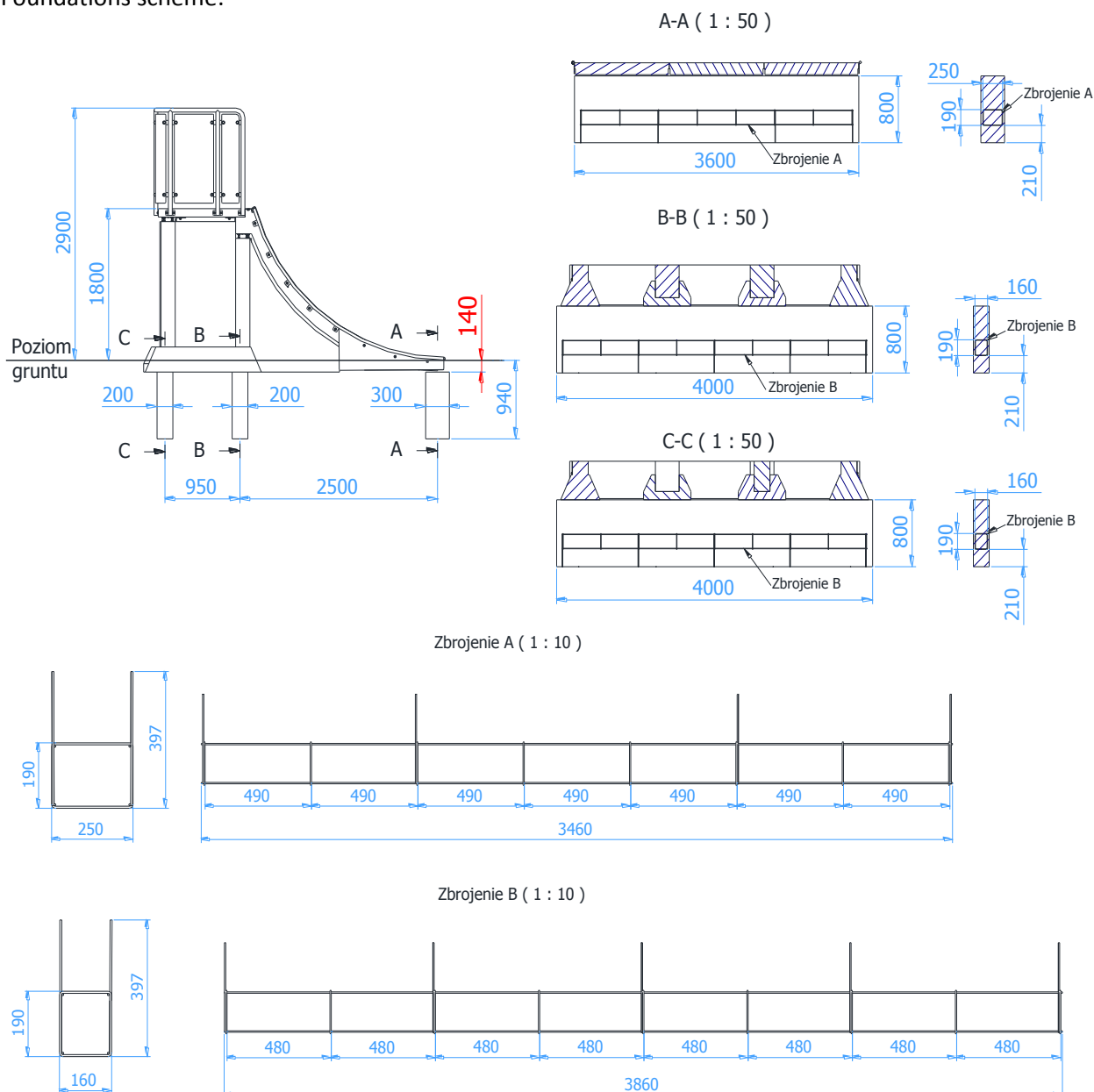
- Depth of foundations: 0,94 m
- Impact area: 5,92 x 7,60 m



STAGE 1 – preparatory work

- If the device is intended to be mounted on the existing surface, the surface shall be removed in the area of 4100x4250mm, to a depth of 140mm.
- Secure the assembly site to keep others at a distance.
- Set the construction in a designated place having regard to required impact area.
- Before installing the Quarter Pipe, lay the foundations according to figure below. The depth of foundations shall be adapted to a local building regulations.

Foundations scheme:



WARNING !

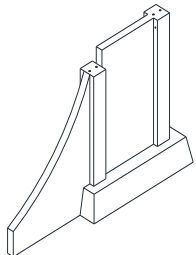
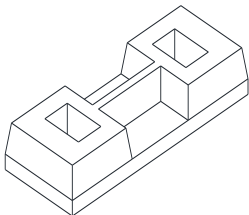
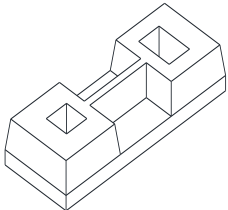



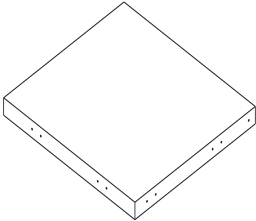
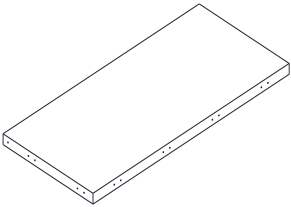
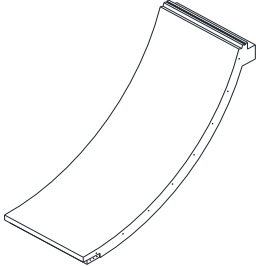
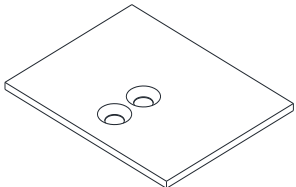
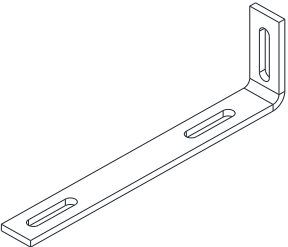
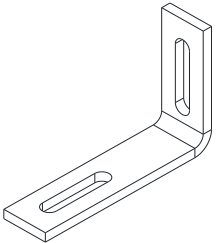
If the foundations are set precisely, the device do not require levelling. Otherwise the devices shall be levelled with the use of sheet metal underlay plates. The width of the plates depends on arisen unevenness.

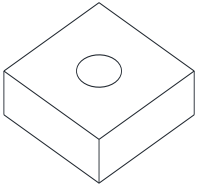
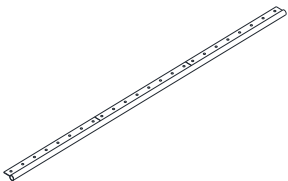
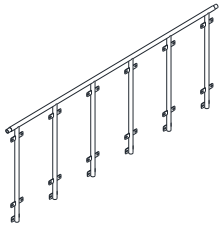
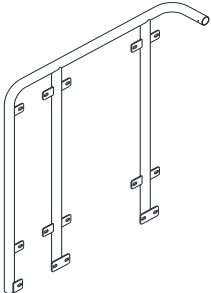
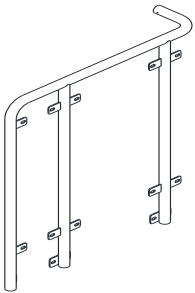
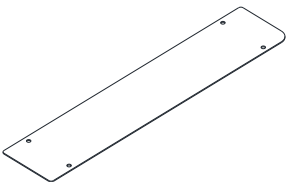
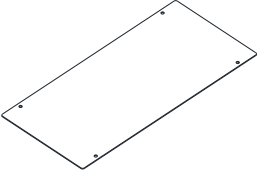
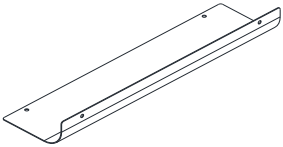
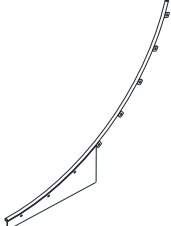
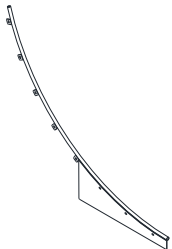


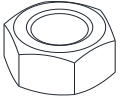

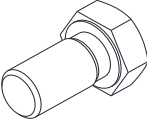
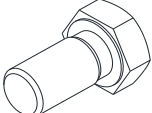
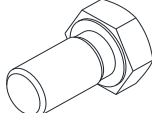
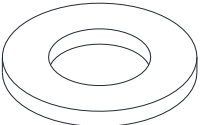
ALL ELEMENTS OF THE CONSTRUCTION SHALL BE PERFECTLY LEVELLED!

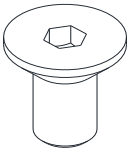
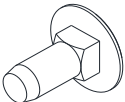
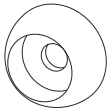
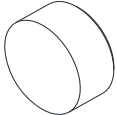
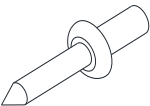
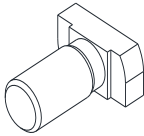
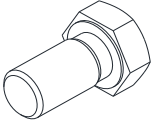
Installation shall be performed in accordance to safety & health standards.

STAGE 2 – Assembly of the construction

1. List of components

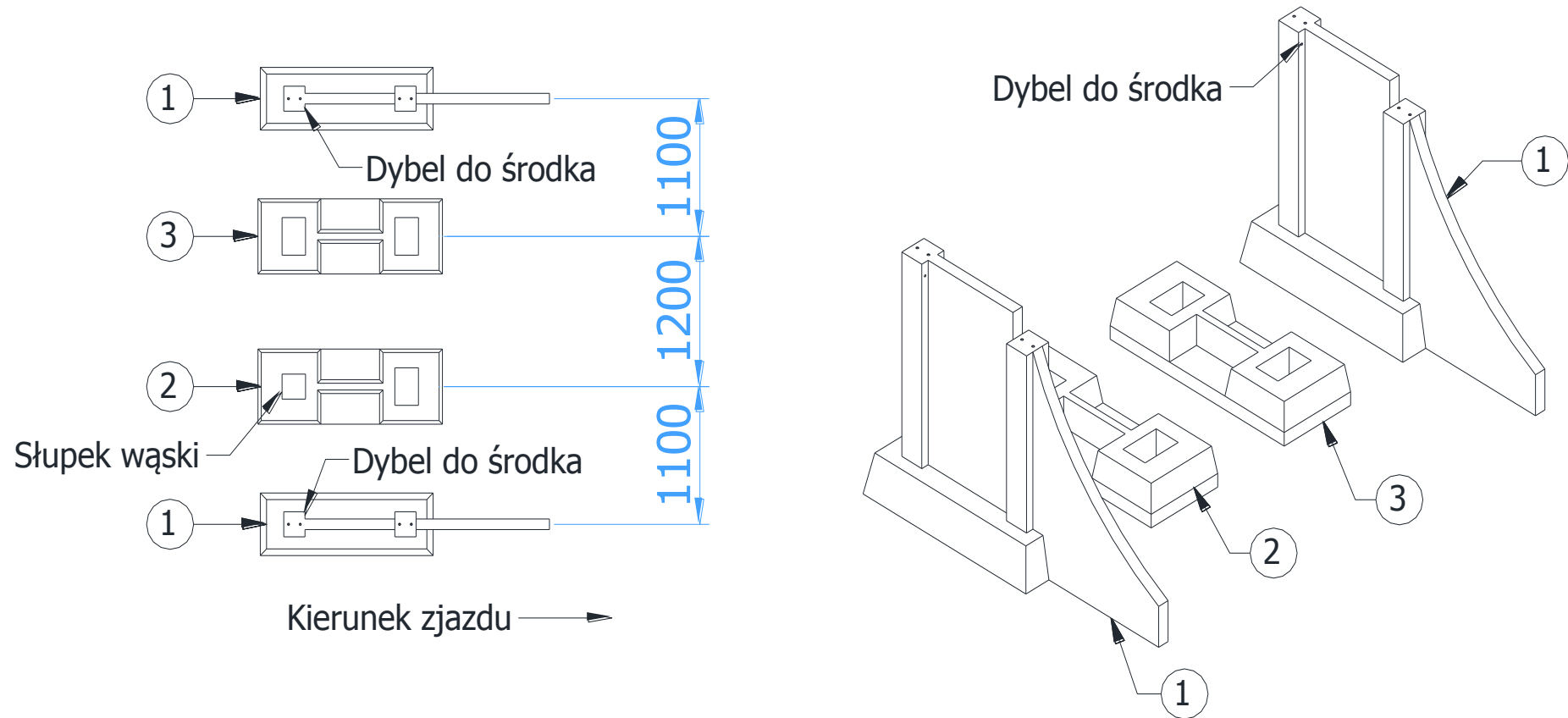
Item	Description and illustration	Item	Description and illustration	Item	Description and illustration
1	Side wall – 2pcs 	2	Large foot – 1 pc. 	3	Small foot – 1 pc. 
4	Post 20x30x1500mm – 2 pcs 	5	Post 20x20x1700mm – 1 pc. 	6	Post 20x30x1700mm – 1 pc. 
7	Small platform 1200x1100x100mm – 1 pc. 	8	Large platform 2400x1100x100mm - 1pc. 	9	Ramp – 3 pcs 
10	Supporting plate 140x110x5mm – 11 pcs 	11	Large steel angle – 6 pcs 	12	Small steel angle – 5 pcs 

13	Square nut 25x25x8mm – 24 pcs 	14	Upper rail – 1 pc. 	15	Rear barrier – 1 pc. 
16	Left barrier – 1 pc. 	17	Right barrier – 1 pc. 	18	Plate of a barrier 1065x220mm – 2 pcs 
19	Plate of a barrier 1065x498mm – 7 pcs 	20	Corner plate of a barrier – 2 pcs 	21	Left side rail – 1 pc. 
22	Right side rail – 1 pc. 	23	Washer M16 – 28pcs 	24	Washer M10 – 44pcs 
25	Nut M16 – 40 pcs 	26	Nut M10 – 44 pcs 	27	Hexagonal head screw M16x80 – 22 pcs 
28	Hexagonal head screw M16x30 – 10 pcs 	29	Hexagonal head screw M10x25 – 36 pcs 	30	Washer M10 – 36 pcs 

31	Countersunk screw M10x20 – 35 pcs 	32	Carriage bolt M10x25 – 44 pcs 	33	Screw cover– 44 pcs 
34	Screw cover – 44 pcs 	35	Blind rivet Ø4,8x24 – 4pcs 	36	Jordahl screw JH M16x30 – 18pcs 
37	Hexagonal head screw M16x100 – 22 pcs 				

2. Assembly scheme

- **WARNING! ALL ELEMENTS OF THE CONSTRUCTION SHALL BE PERFECTLY LEVELLED!**
- Set the concrete elements in a right place, on the foundations, according to the figure below:

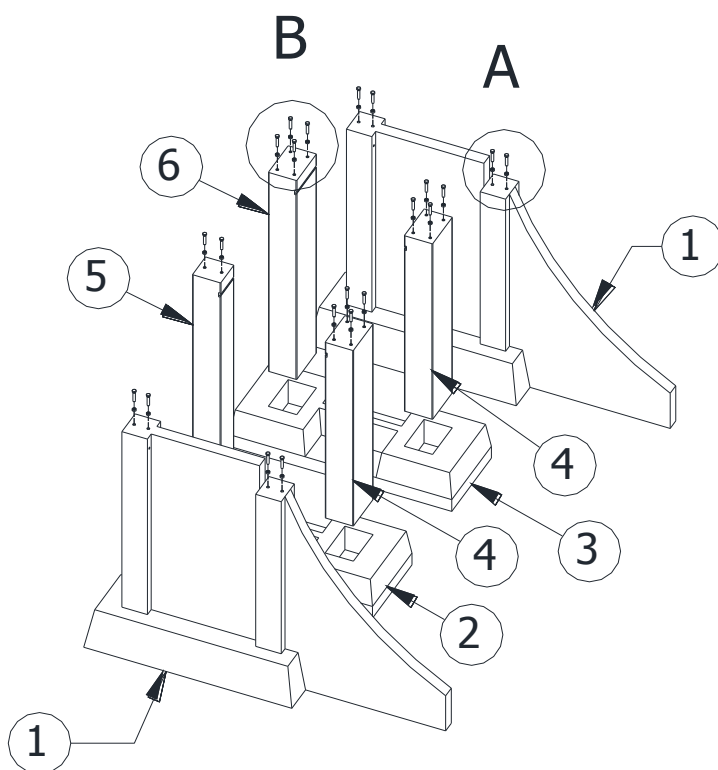


ASSEMBLY INSTRUCTION

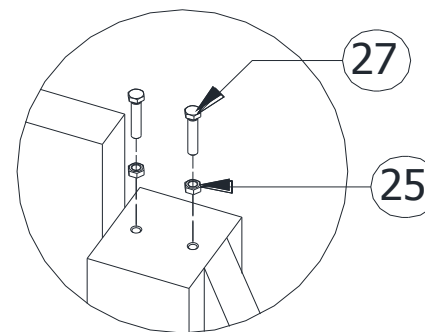
Product code: Quarter-Pipe



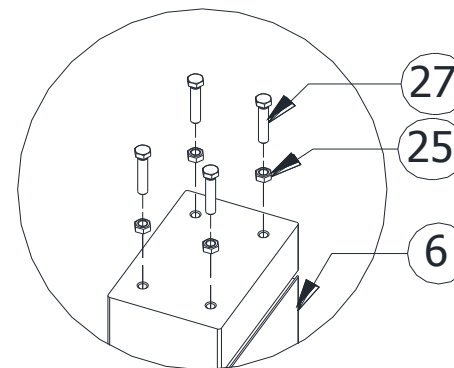
- Put the posts (item 4, 5, 6) into the feet (item 2, 3)
- Screw the screws M16x80 (item 27) with washers M16 (item 25) into the upper surfaces of posts (item 4, 5, 6) and side walls (item 1)
Warning! In case of large differences in level of the ground, use the M16x100 screw (item 37) instead of screw M16x80 (item 27).



A (1 : 20)

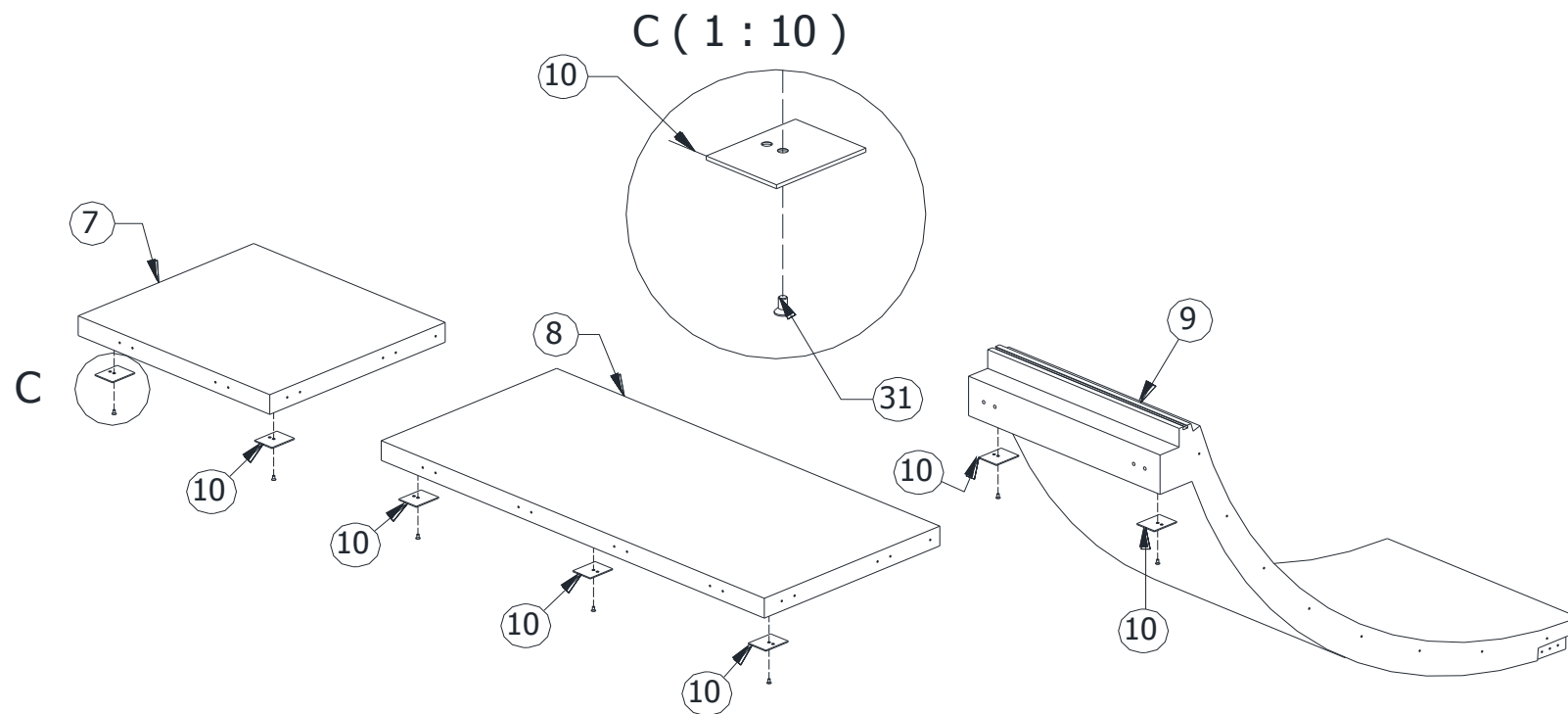


B (1 : 20)





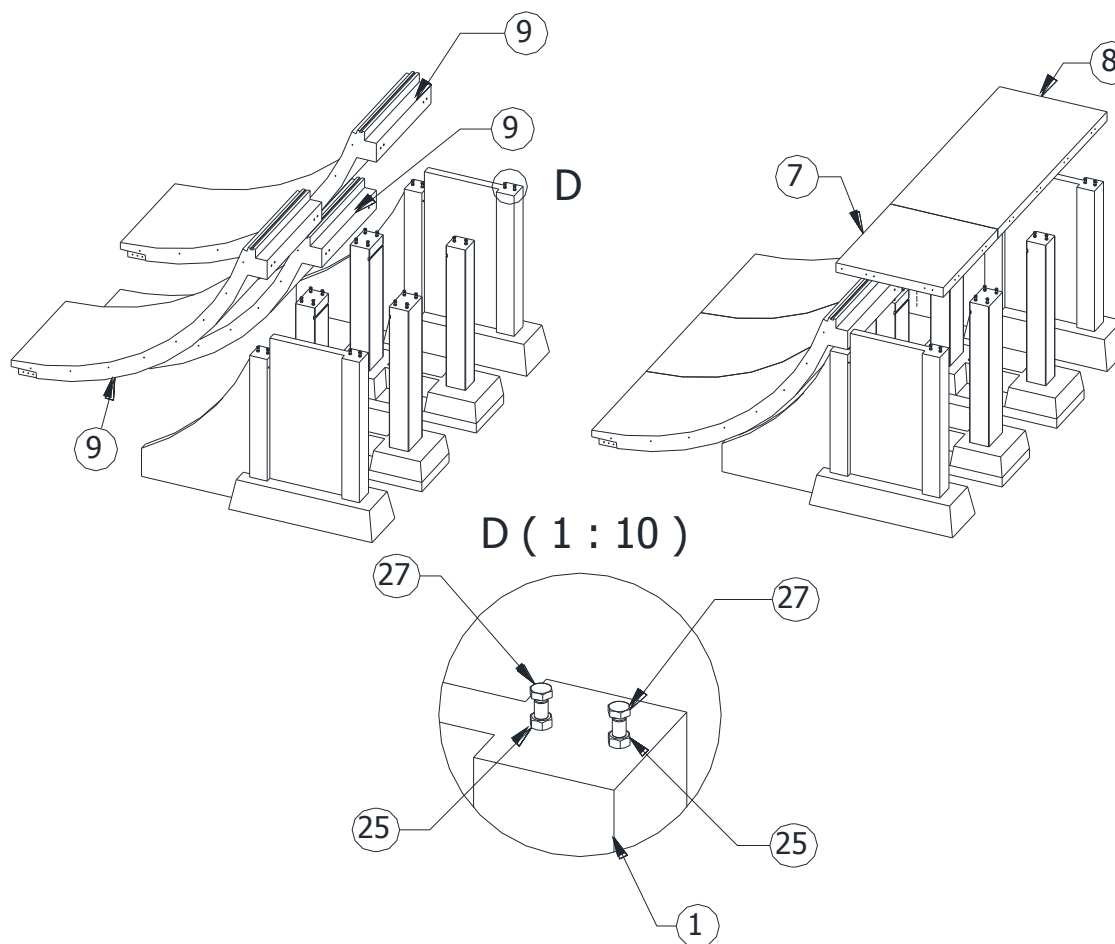
- Screw the supporting plates 110x140x5mm (item 10) to all platforms (item 7, 8) and ramps (item 9) by using countersunk screws M10x20 (item 31)



ASSEMBLY INSTRUCTION
Product code: Quarter-Pipe



- Set the ramps (item 9)
- Set the platforms (item 7, 8) in a right place according to the figure below
- Level the construction by unscrewing or tightening screws M16x80 (item 27). After levelling, tight the nut (item 25) on the screws to prevent them from loosening.

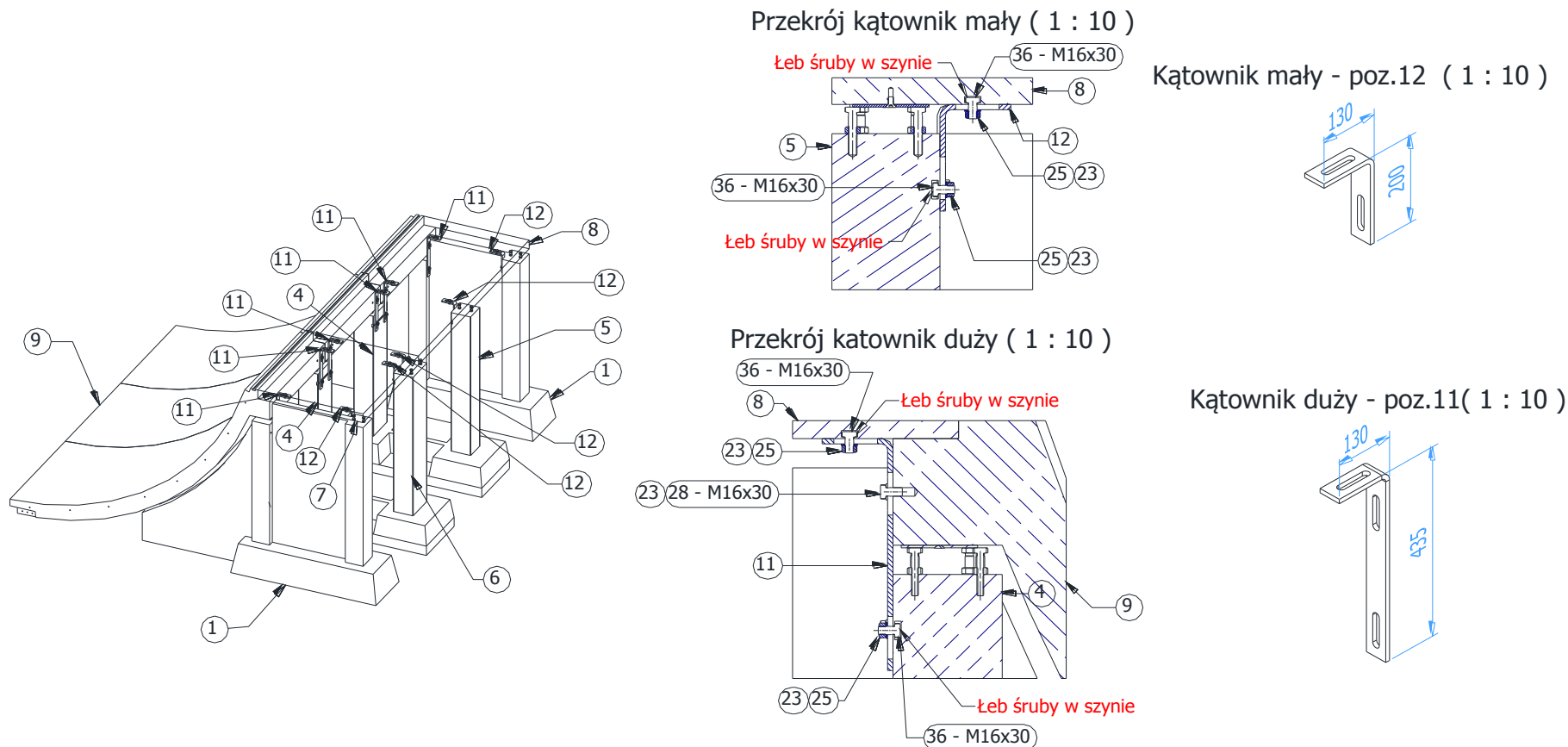


ASSEMBLY INSTRUCTION

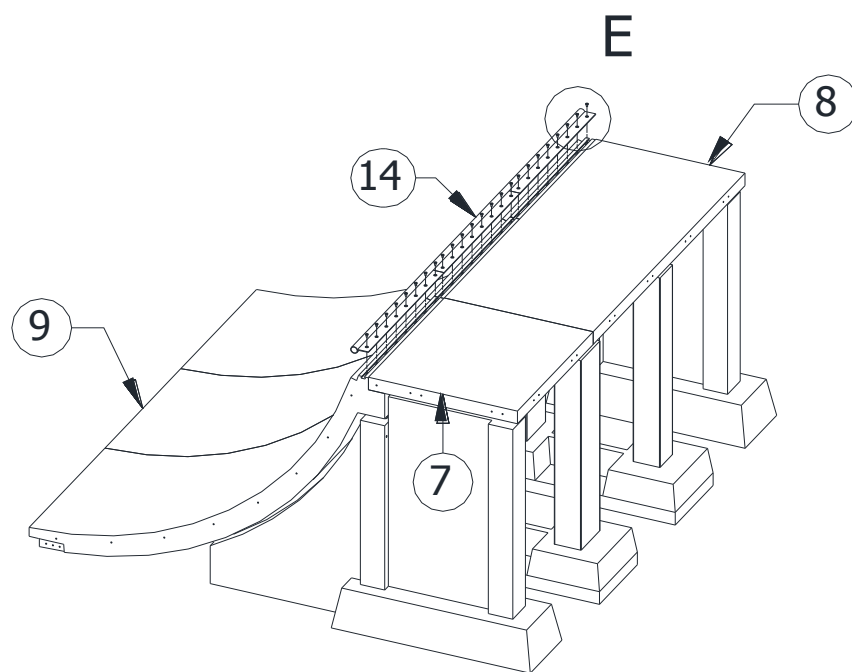
Product code: Quarter-Pipe



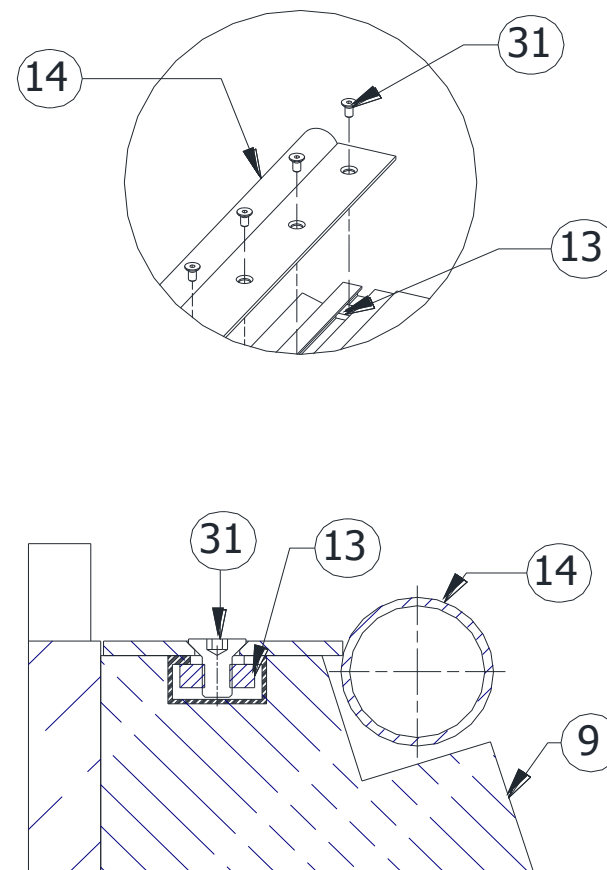
- Screw the platforms (item 7, 8) and ramps (item 9) to the posts (item 4, 5, 6) and to the side walls (item 1) by using steel angles (item 11, 12) and screws M16x30 (item 28, 36). Screw the large steel angles (item 11) from the side of ramps (item 9). See the accurate spacing of the steel angles and the mounting method on the figure below:



- Screw the upper rails (item 14) to the upper surface of the ramps (item 9): put the square nuts 25x25x8mm (item 13) into the rail in ramp (item 9) and screw the upper rail (item 14) by using screws M10x20 (item 31).



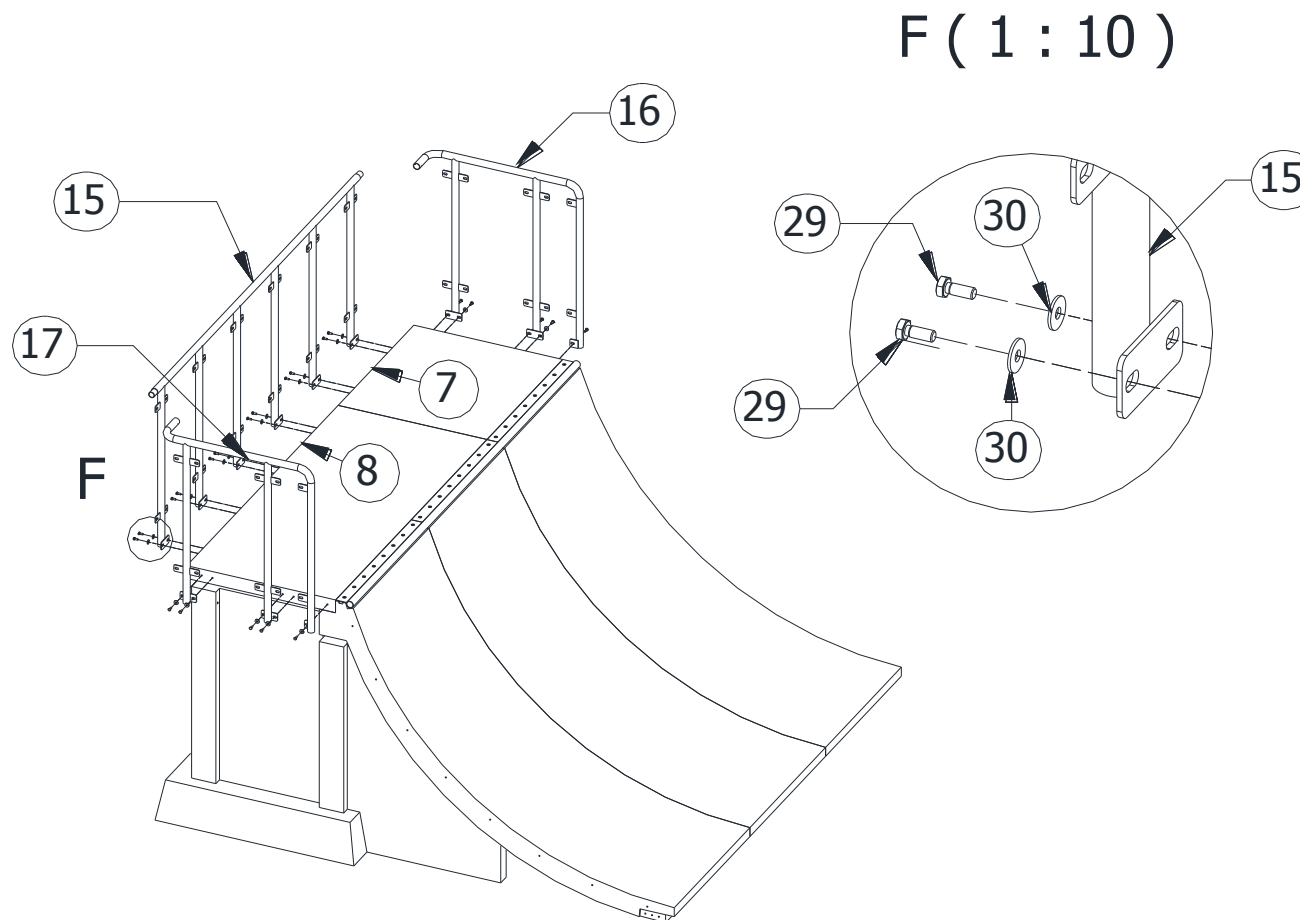
E (1 : 15)



- Loosely screw the rear barrier (item 15) to the platforms (item 7, 8) by using screw M10x25 (item 29) with washers M10 (item 30).
- After screwing the rear barrier (item 15), loosely screw the side barriers (item 16, 17) by using screws M10x25 (item 29) and washers M10 (item 30).



- The barrier shall be set such as to eliminate a slack between its components. Tighten the screws (item 29).



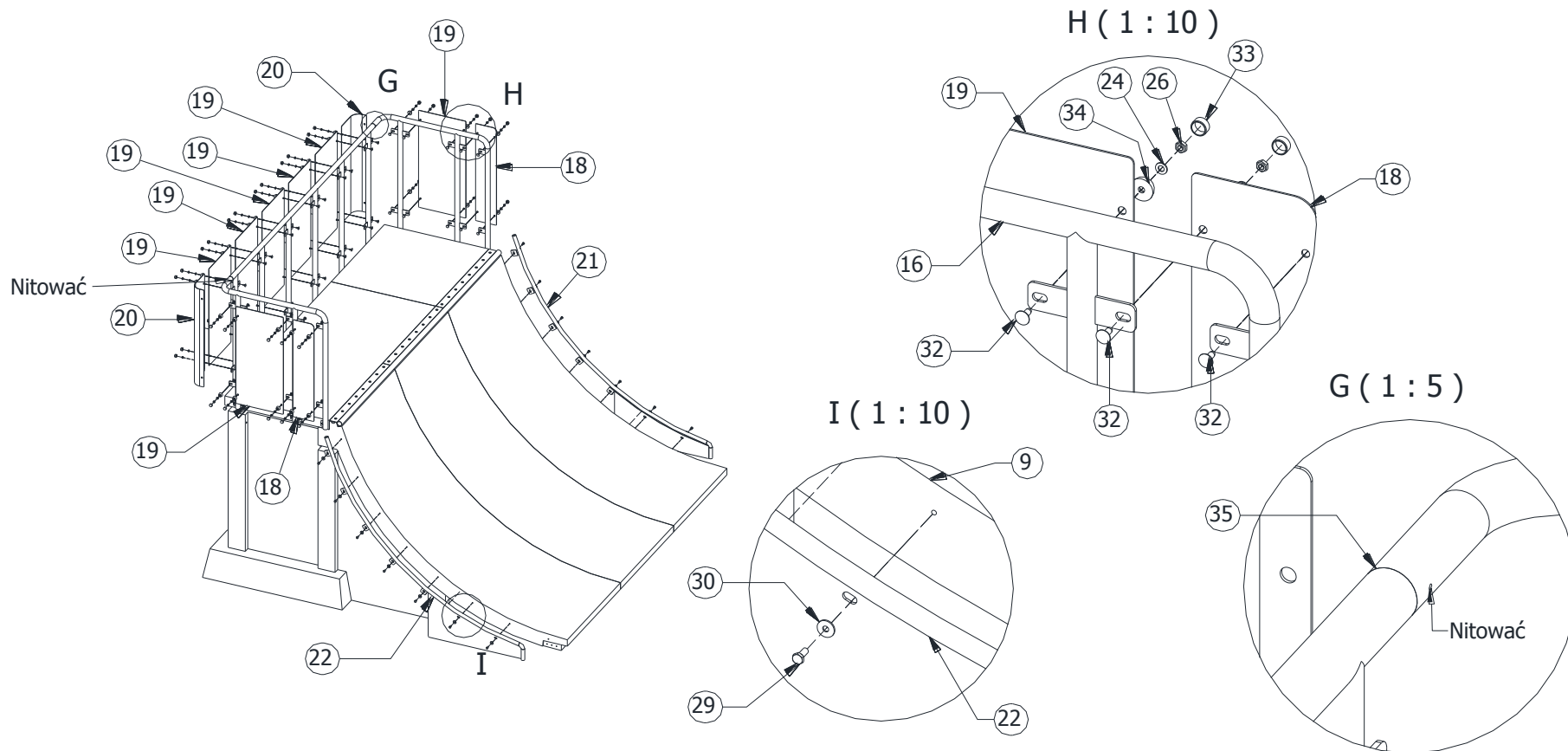
- Rivet the barrier (at the joint of its particular components) by using blind rivets $\varnothing 4,8 \times 24$ (item 35).

ASSEMBLY INSTRUCTION

Product code: Quarter-Pipe



- Screw the plates (item 18, 19, 20) to the barriers (item 15, 16, 17) by using the carriage bolt M10x25 (item 32), the washer M10 (item 24), the nut M10 (item 26) and the screw covers (item 34 and 33). Warning! Both screw covers of item 34 and 33 shall be located from the side of the nut!
- Screw the side rails (item 21, 22) to the ramps (item 9) by using screws M10x25 (item 29) and washers M10 (item 30).



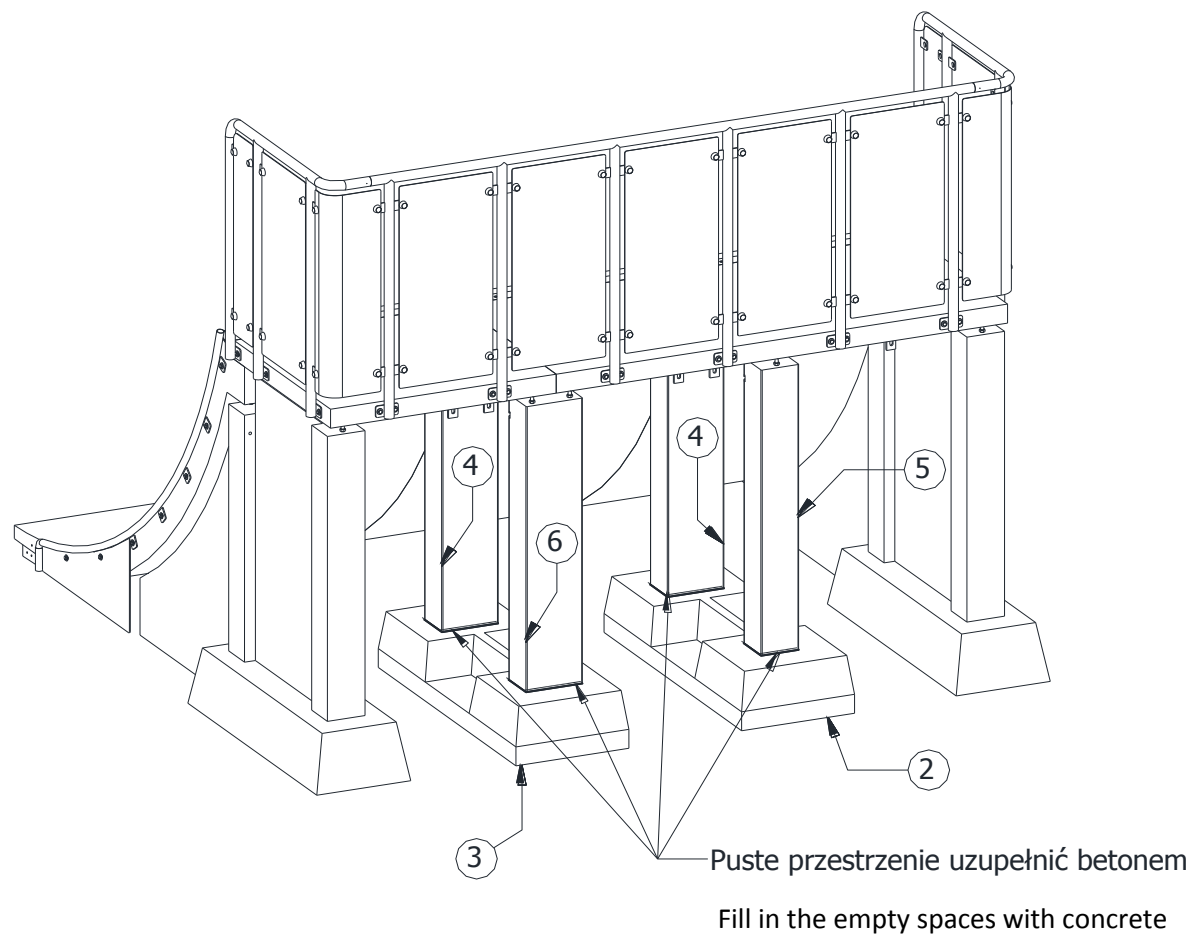
- Fill in spaces between the posts (item 4, 5, 6) and feet (item 2, 3) with concrete.

ASSEMBLY INSTRUCTION

Product code: Quarter-Pipe



- Optionally, the space under the floor plates can be covered with covering steel sheets. In such case, drill the holes in covering steel sheets, posts and side walls – in appropriate locations. For screwing the steel sheets, use 20 bolts $\text{Ø}8 \times 40 \text{mm}$.



- Remove the slacks in joints.
- Put the statutory plate.