



by  ALBINI & FONTANOT

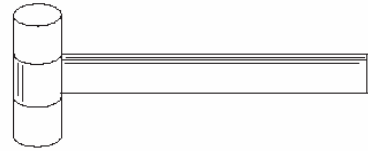
ENDURO STEEL

English ASSEMBLY INSTRUCTIONS

Text Instructions Begin on Page 8



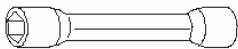
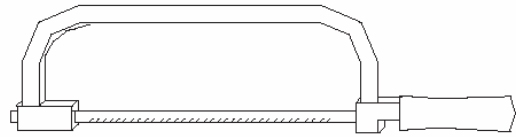
Ø 8x300 12x120 14x150 mm



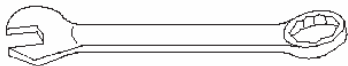
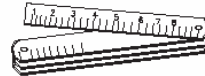
Ø 2,5 3,5 4,5 9 mm



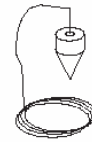
PH 2



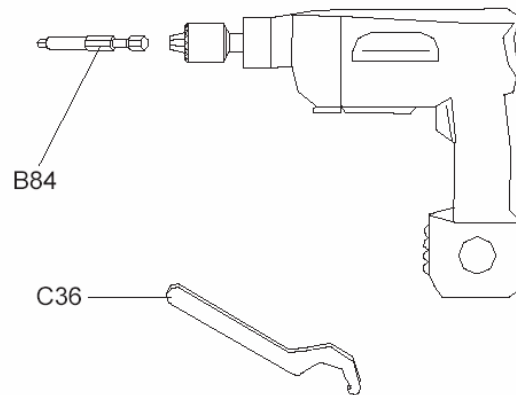
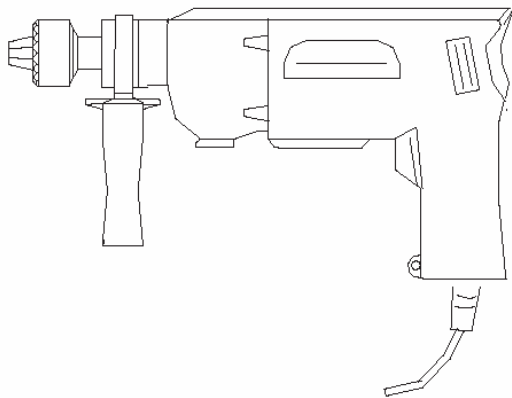
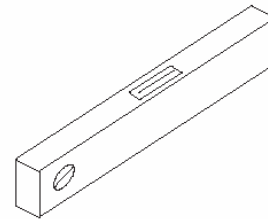
12 / 13 mm

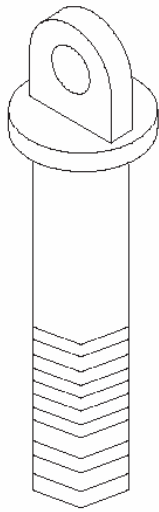


13 17 19 30 mm

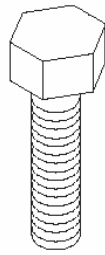


2,5 3 5 12 mm

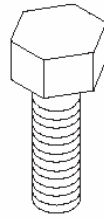




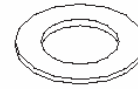
B01



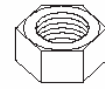
B44



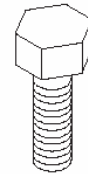
B89



B27



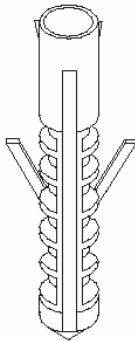
B23



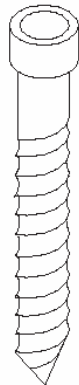
B55



B54



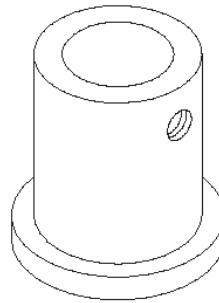
B12



B11



C29



F01



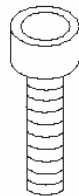
C31



C13



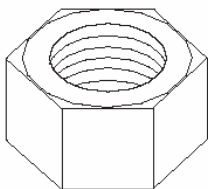
B82



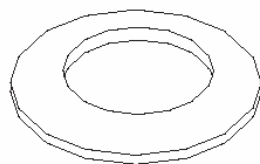
B36



B37



B03



B04



X02

FIG. 1

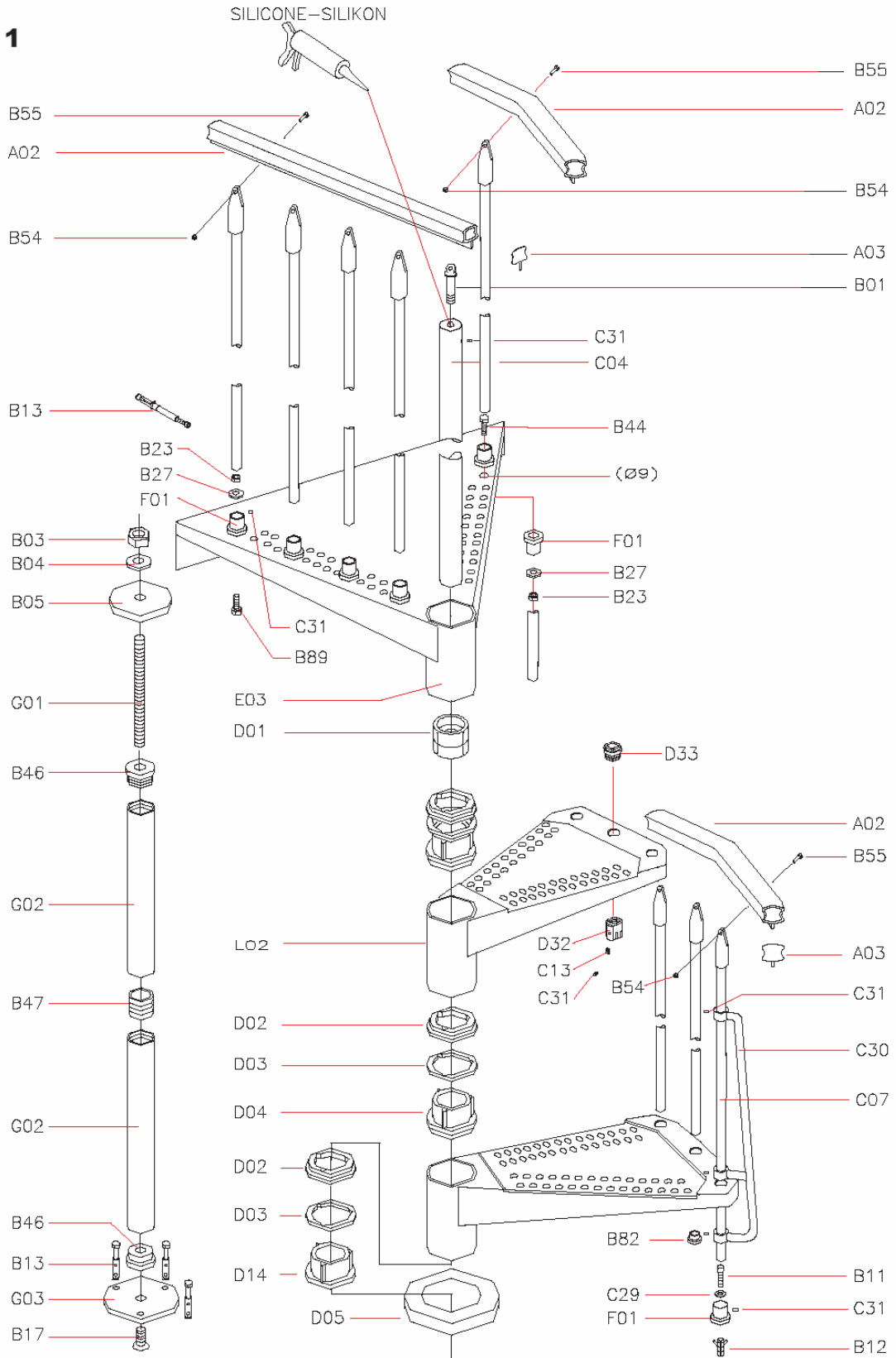


FIG. 2

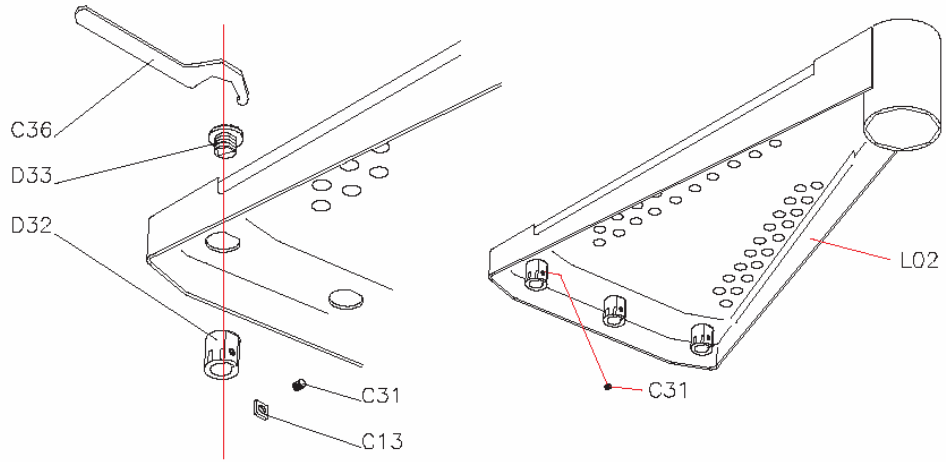


FIG. 3

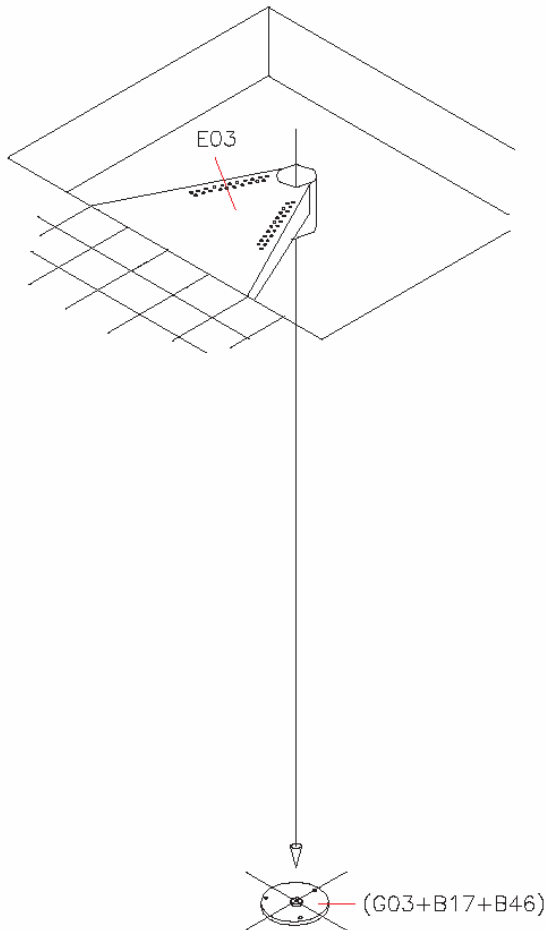


FIG. 4

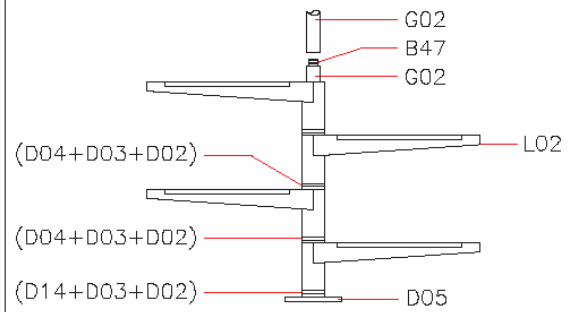


FIG. 5

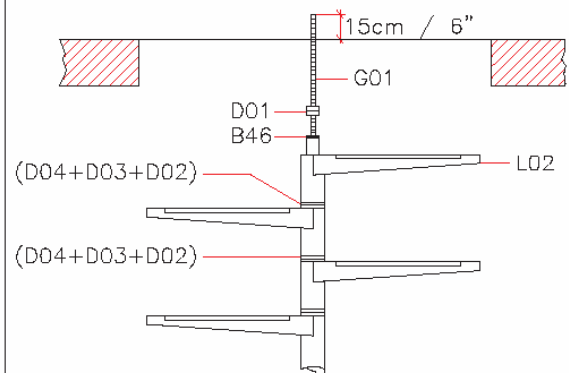
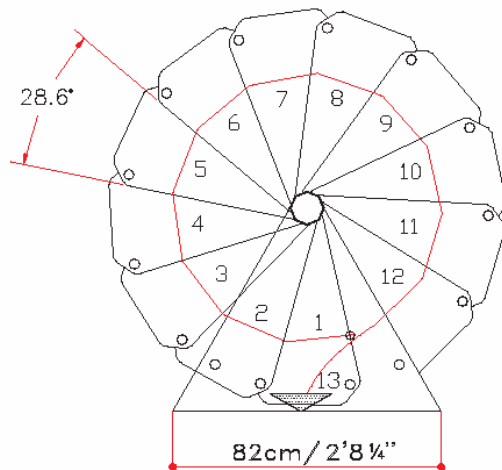
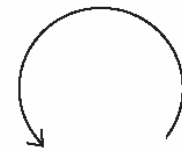
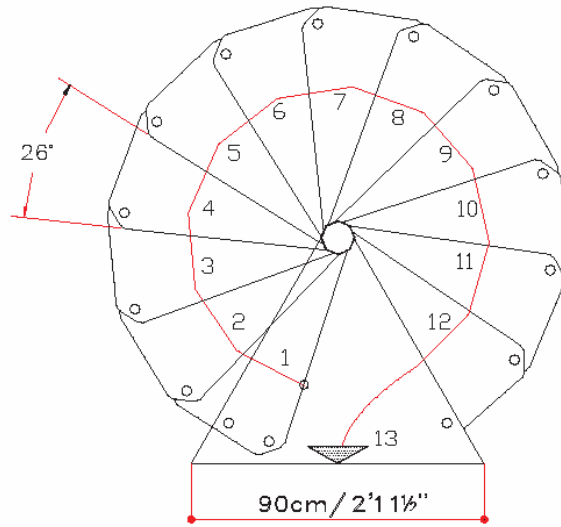
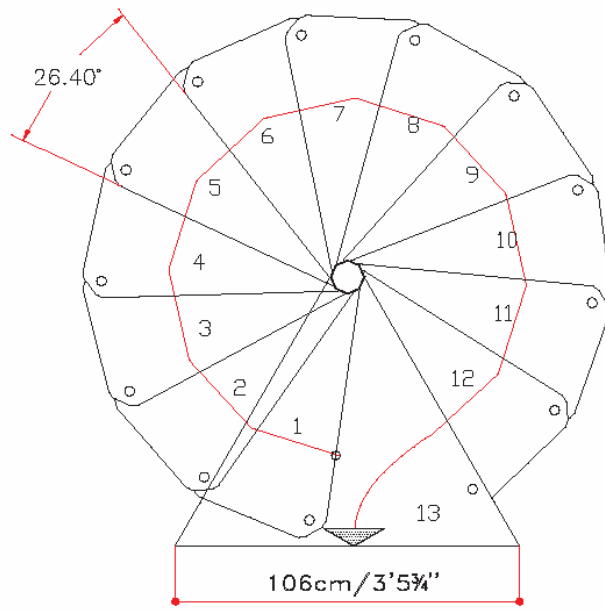


FIG. 6



Ø120cm
Ø3'11 1/4"

FIG. 7

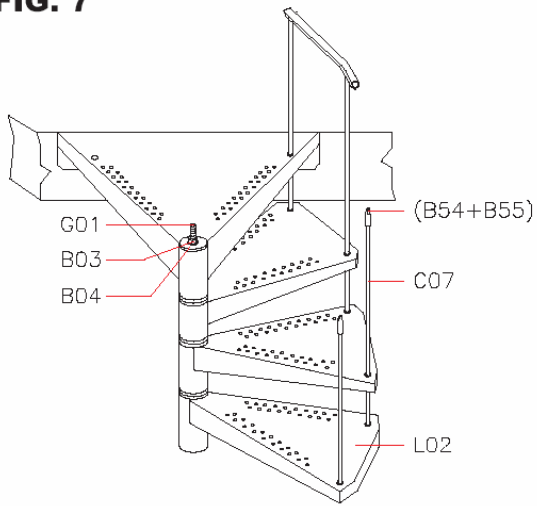


FIG. 8

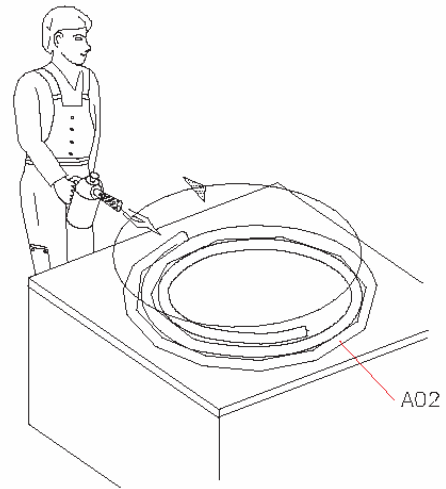


FIG. 9

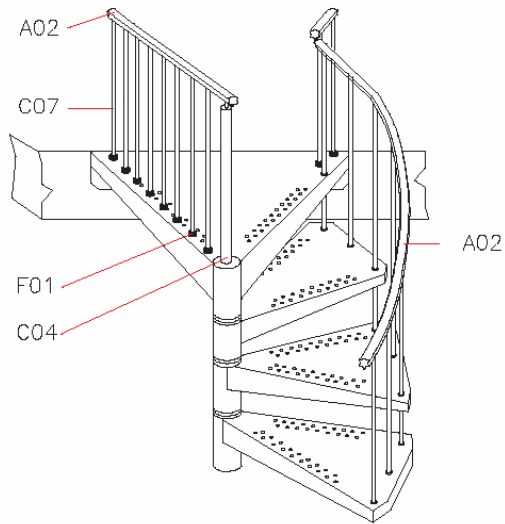


FIG. 10

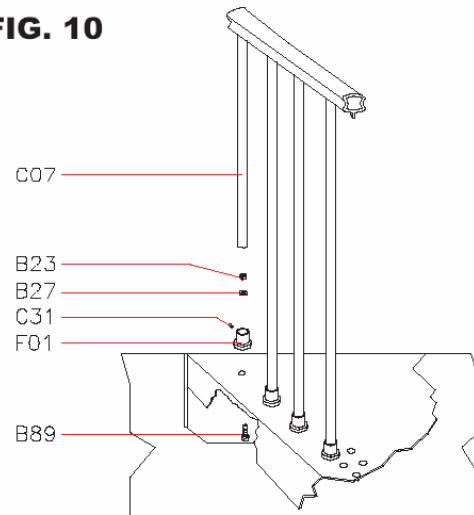
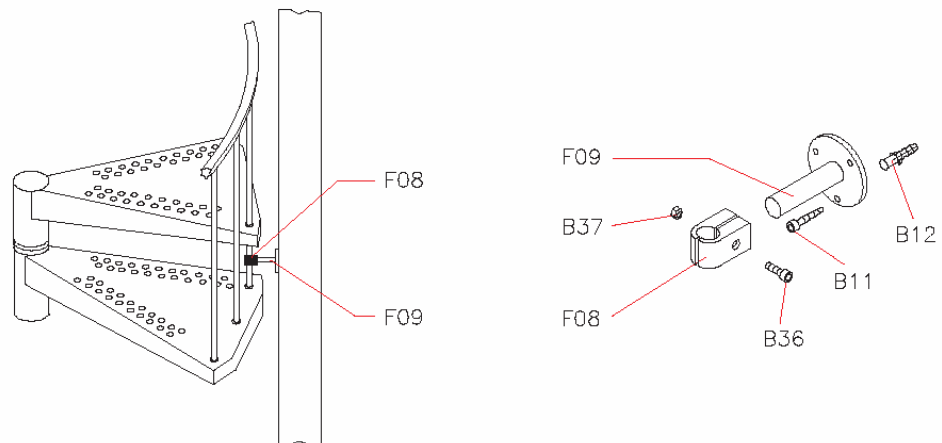


FIG. 11



Before starting the assembly process, unpack all components of the staircase. Lay them out on a large surface and check the quantity of all the pieces, by consulting the table TAB.1 (A = Code, B = Quantity).

Inside the staircase box you will also find a video tape which we suggest watching before proceeding to assemble.

For the USA only: call the customer support line at 1-888 STAIRKT, should you have any case of need.

Preliminary Assembly

1. Insert the elements C13 and C31 into the cylinders D32. Assemble the cylinders D32 into the treads (L02) by using the elements D33. Tighten by means of the article C36.
2. Carefully measure the floor-to-floor height and determine the required number of spacers (D03) (TAB.2).
3. Assemble the spacers (D14, D03, D02) together in one piece. Do the same for the spacers (D04, D03, D02).
4. Assemble the base G03, B17 and B46 (fig. 1).

Assembly

5. Determine and mark on the floor the fixing point of the base (G03+B17+B46) by laying the landing (E03) on the ceiling (fig. 3).
6. Place the base (G03+B17+B46) and drill with drill bit \varnothing 14 (fig. 3).
7. Fix the base (G03+B17+B46) onto the floor with the parts B13.
8. Screw the pole (G02) into the base (G03+B17+B46) (fig. 1).
9. Insert the base cover (D05) (fig. 4).
10. Insert the spacers (D14+D03+D02) (fig. 4).
11. Insert the first tread (L02) into the pole (G02). Then continue with the assembly, by adding alternatively one spacer (D04+D03+D02) and one tread (L02). At this stage, the treads have to be positioned alternately one to the right and one to the left, so as to distribute the weight in a balanced way (fig. 4).
12. When you reach the end of the pole (G02), screw the part B47 on it, then add the second pole (G02) and continue with the stair assembly (fig. 4)
13. When you reach the end of the pole (G02), screw on it the part B46 and the part G01 (screw the part G01, till its upper end sticks out approximately 15cm (6") from the stair height. Continue adding the treads, by using the part D01 inserted into the spacers (D04+D03+D02) (fig.5).
14. Finally add the stair landing (E03). Fasten the parts B05, B04 and screw the part B03 sufficiently, keeping in mind that the treads still have to rotate (fig. 1).

Fitting of the Landing

15. Drill with drill bit \varnothing 14 in relation to the holes.
16. Block the part B13 completely (fig. 1).

Assembly of the Railing

17. Spread-out the treads (L02) fan-like, after having chosen the rotation direction (fig. 6). It is now possible to use the stair.
18. Starting from the landing (E03), insert the first long railing baluster (C07): 1) measure the rise between the tread (L02) and the landing (E03) and add 2,5cm (1"), 2) cut the final part of the long baluster (C07), 3) pierce with the drill bit \varnothing 9 the landing (E03), 4) assemble the parts F01 using the parts B07 and B23, 5) insert the just cut baluster part between the lower part F01 and the tread (L02), 6) tighten the parts C31 of the tread and of the landing, 7) insert and fasten with the part C31 the resting part of the baluster (C07) into the upper part F01 (fig. 1). Turn the balusters (C07) maintaining the holes looking to the stair center.
19. Insert the longer balusters (C07), which connect the treads (L02), one by one. Tighten only the part C31 of the lower tread (fig. 2).
20. Check the vertical position of all the assembled balusters (C07). This control is very important for best results.
21. Tighten securely the part B03 (fig. 7).
22. Tighten securely the part C31 of the upper tread (fig. 2).
23. Check once more the vertical position of the railing balusters (C07) and, if necessary, correct it, by repeating the previous operations.
24. Set the first baluster (C07) together with the reinforcing part (C30). Cut one long baluster (C07) to obtain the same size as all others you assembled previously (fig. 1).
25. Fix into the floor in relation to the first baluster (C07), the part F01, by piercing with the drill bit \varnothing 8. Use the parts B11, B12, C29 and C31 (fig. 1).
26. Warm the handrail (A02) until it becomes malleable: 1) put the handrail onto the cover of the wooden box, 2) warm for about five minutes making circular movements continuously without holding on, 3) turn it on its other part and repeat that operation.
27. Set the handrail (A02) onto the balusters (C07) starting from the top before it becomes cold (fig. 7).

28. Drill the handrail (A02) in relation to the present holes and fasten with the parts B54 and B55.
29. Insert quickly all the other balusters, paying attention to their vertical position, into the treads (L02), tighten the part C31 and fasten to the handrail (A02) using the parts B54 and B55 (for the stairs with a diameter larger than 140cm (4' 7 1/8"), it is advisable to assemble first the shorter balusters).
30. Cut the excess piece of the handrail (A02) in relation to the first railing baluster (C07).
31. Complete the handrail (A02) by assembling the parts A03. Use the glue (X01) (fig. 1).
32. Complete the railing assembly inserting the parts B82 into the lower part of the balusters (C07) (fig. 1).

Assembly of the Balustrade

33. Screw the baluster (C04) into the part G01 that sticks out from the landing (E03) (fig. 1).
34. Assemble the parts F01, using the parts B07, B06, B23 into the holes of the landing (E03), maintaining a similar distance as between the balusters (C07) of the railing, which had been assembled previously. (fig. 1).
35. Set the shorter balusters (C07) and tighten the part C31.
36. Fix the part B01 into the baluster (C04), by using the part C31 and some silicone (fig. 1).
37. Fix the handrail (A02), using the parts B54 and B55 (fig. 1).
38. In case that there are walls around the stair well and on their position, it could be necessary to position one or two more balusters.
39. In that case it is necessary to consider either the distance between all other balusters, or otherwise the distance from the wall. For the fixing it is suggested to pierce with a drill bit \varnothing 9 the landing (E03) and to use the fixing parts F01, B02, B07, B06, B23. Whereas for the fixing into the floor it is suggested to pierce the floor with a drill bit \varnothing 12 and to use the parts F01, C31, B07, B06, B23 (fig. 10).

Final Assembly

40. In order to reinforce the staircase at the intermediate points, you must fix into the wall the parts F09 and connect them to the balusters (C07) by means of the parts F08. Pierce the wall with a drill bit \varnothing 8 and use the parts B36, B37, B11, B12 (fig. 11).
41. Stick the panels (H03, H04), to the landing (E03) using the part B96 (fig. 1).

Characteristics of staircases for outdoors

Arkè products are made of excellent quality and treated with the best technological process; the staircase model ENDURO STEEL, especially, has the following features:

- Stainless steel screws
- Balusters made of pre-galvanized sheet with the addition of cold galvanizing on the welded joints.
- Treads and landing are welded by a welding robot and they are hot-dip galvanized on 450° after degreasing and passivation in full respect of normative standards UNI E 14.07.000.0 and certification ISO 9002.

It's a usual feature of the hot-galvanized products to present small areas in which the zinc is not perfectly adhered. It's also possible to damage the galvanized surface during the assembly. To guarantee a long life product, you will find a kit of liquid zinc in the box to lay on with a brush for possible retouches after the assembly. We suggest to check the wholeness of your staircase at regular intervals, and to retouch possible damaged areas with similar products easily to be found on the market. It's a usual feature of the hot-galvanized products that they become matt after some time, that's because of a normal oxidation process of the zinc in all weather conditions. The staircase may be painted immediately after a preventive application of a suitable primer or, without any particular cautions, after an exposition to weather conditions of at least 12-18 months.

TAB.1 PARTS LIST

A	B		
	<u>Ø 120</u> 3' 11 1/4"	<u>Ø 140</u> 4' 7 1/8"	<u>Ø 160</u> 5' 3"
A02	1	1	1
A03	8	8	8
B01	1	1	1
B03	1	1	1
B04	1	1	1
B05	1	1	1
B06	6	7	8
B07	5	6	7
B11	7	7	10
B12	7	7	10
B13	6	6	6
B17	1	1	1
B23	8	9	10
B27	8	9	10
B36	2	2	3
B37	2	2	3
B44	1	1	1
B46	2	2	2
B47	1	1	1
B54	30	43	44
B55	30	43	44
B82	25	38	38
B89	7	8	9
C04	1	1	1
C07	32	45	46
C13	36	48	48
C29	1	1	1
C30	1	1	1
C31	50	63	64
C36	1	1	1
D01	4	4	4
D02	13	13	13
D03	65	65	65
D04	12	12	12
D05	1	1	1
D14	1	1	1
D32	36	48	48
D33	36	48	48
E03	1	1	1
F01	10	11	12
F08	2	2	3
F09	2	2	3
G01	1	1	1
G02	2	2	2
G03	1	1	1
L02	12	12	12
X02	1	1	1

TAB.2

To determine the necessary number of spacers (D03), you must look-up the table TAB.2 (H = Height, A = Rises).

Example: given a floor-to-floor height of 298cm (9' 9 3/8") and a staircase with 13 treads, you must proceed as follows;

1. at height (298cm (9' 9 3/8")) in the row H) look-up the number of necessary spacers (i.e. 50 spacers in the row A/13)
2. Distribute the spacers (D03), one at a time, among the combined parts D14-D04 and D02 all (for the single spacer D14 you can use at the most 3 spacers (D03); for the spacers (D04) you can use at the most 5 spacers (D03).
1. The final result is the following: 3 spacers (D03) between D14 and D02, 3 more spacers (D03) on a spacer chosen between D04 and D02 and 4 spacers (D03) between D04 and D02 of the remaining eleven spacers.

TAB.2 SPACER CHART

H		A		H		A		H		A	
		10	11			12	13			14	
KIT											
6'	10 5/8"	0		8'	3 1/4"	0		9'	7 3/4"	0	
6'	11 1/8"	2		8'	3 5/8"	2		9'	8 1/8"	2	
6'	11 1/2"	4		8'	4 "	4		9'	8 1/2"	4	
6'	11 7/8"	6		8'	4 3/8"	6		9'	8 7/8"	6	
7'	1 1/4"	8		8'	4 3/4"	8		9'	9 3/8"	8	
7'	5/8"	10		8'	5 1/8"	10		9'	9 3/4"	10	
7'	1 "	12		8'	5 5/8"	12		9'	10 1/8"	12	
7'	1 3/8"	14		8'	6 "	14		9'	10 1/2"	14	
7'	1 7/8"	16		8'	6 3/8"	16		9'	10 7/8"	16	
7'	2 1/4"	18		8'	6 3/4"	18		9'	11 1/4"	18	
7'	2 5/8"	20		8'	7 1/8"	20		9'	11 3/4"	20	
7'	3 "	22		8'	7 1/2"	22		10'	1 1/8"	22	
7'	3 3/8"	24		8'	8 "	24		10'	1 1/2"	24	
7'	3 3/4"	26		8'	8 3/8"	26		10'	7/8"	26	
7'	4 1/4"	28		8'	8 3/4"	28		10'	1 1/4"	28	
7'	4 5/8"	30		8'	9 1/8"	30		10'	1 5/8"	30	
7'	5 "	32		8'	9 1/2"	32		10'	2 "	32	
7'	5 3/8"	34		8'	9 7/8"	34		10'	2 1/2"	34	
7'	5 3/4"	36		8'	10 1/4"	36		10'	2 7/8"	36	
7'	6 1/8"	38		8'	10 3/4"	38		10'	3 1/4"	38	
7'	6 1/2"	40		8'	11 1/8"	40		10'	3 5/8"	40	
7'	7 "	42	0	8'	11 1/2"	42	0	10'	4 "	42	
7'	7 3/8"	44	2	8'	11 7/8"	44	2	10'	4 3/8"	44	
7'	7 3/4"	46	4	9'	1 1/4"	46	4	10'	4 3/4"	46	
7'	8 1/8"	48	6	9'	5/8"	48	6	10'	5 1/4"	48	
7'	8 1/2"	50	8	9'	1 "	50	8	10'	5 5/8"	50	
7'	8 7/8"	10		9'	1 1/2"	52	10	10'	6 "	52	
7'	9 1/4"	12		9'	1 7/8"	54	12	10'	6 3/8"	54	
7'	9 3/4"	14		9'	2 1/4"	56	14	10'	6 3/4"	56	
7'	10 1/8"	16		9'	2 5/8"	58	16	10'	7 1/8"	58	
7'	10 1/2"	18		9'	3 "	60	18	10'	7 1/2"	60	
7'	10 7/8"	20		9'	3 3/8"	20		10'	8 "	62	
7'	11 1/4"	22		9'	3 7/8"	22		10'	8 3/8"	64	
7'	11 5/8"	24		9'	4 1/4"	24		10'	8 3/4"	66	
8'	1 1/8"	26		9'	4 5/8"	26		10'	9 1/8"	68	
8'	1/2"	28		9'	5 "	28		10'	9 1/2"	70	
8'	7/8"	30		9'	5 3/8"	30		10'	9 7/8"		
8'	1 1/4"	32		9'	5 3/4"	32		10'	10 3/8"		
8'	1 5/8"	34		9'	6 1/8"	34		10'	10 3/4"		
8'	2 "	36		9'	6 5/8"	36		10'	11 1/8"		
8'	2 3/8"	38		9'	7 "	38		10'	11 1/2"		
8'	2 7/8"	40		9'	7 3/8"	40		10'	11 7/8"		
8'	3 1/4"	42		9'	7 3/4"	42		11'	1 1/4"		
8'	3 5/8"	44		9'	8 1/8"	44		11'	5/8"		
8'	4 "	46		9'	8 1/2"	46		11'	1 1/8"		
8'	4 3/8"	48		9'	8 7/8"	48		11'	1 1/2"		
8'	4 3/4"	50		9'	9 3/8"	50		11'	1 7/8"		
8'	5 1/8"	52		9'	9 3/4"	52		11'	2 1/4"		
8'	5 5/8"	54		9'	10 1/8"	54		11'	2 5/8"		
8'	6 "			9'	10 1/2"	56		11'	3 "		
8'	6 3/8"			9'	10 7/8"	58		11'	3 3/8"		
8'	6 3/4"			9'	11 1/4"	60		11'	3 7/8"		
8'	7 1/8"			9'	11 3/4"	62		11'	4 1/4"		
8'	7 1/2"			10'	1 1/8"	64		11'	4 5/8"		
8'	8 "			10'	1/2"			11'	5 "		
8'	8 3/8"			10'	7/8"			11'	5 3/8"		
8'	8 3/4"			10'	1 1/4"			11'	5 3/4"		
8'	9 1/8"			10'	1 5/8"			11'	6 1/4"		
8'	9 1/2"			10'	2 "			11'	6 5/8"		
8'	9 7/8"			10'	2 1/2"			11'	7 "		
8'	10 1/4"			10'	2 7/8"			11'	7 3/8"		
8'	10 3/4"			10'	3 1/4"			11'	7 3/4"		
8'	11 1/8"			10'	3 5/8"			11'	8 1/8"		
8'	11 1/2"			10'	4 "			11'	8 1/2"		

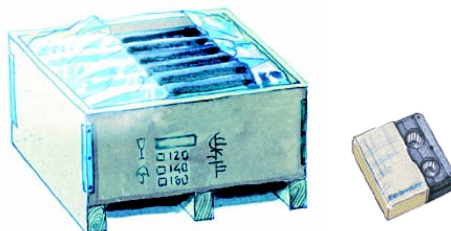
For further information pertaining to these assembly instructions, additional parts or general questions regarding products or assembly please call, fax or email us at:

ARKÉ by Albini and Fontanot
One Broadway, Suite 600
Cambridge, MA 02142

Phone: (617) 670-9070

Fax: (617) 742-1577

Email: info@arkestairs.com



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