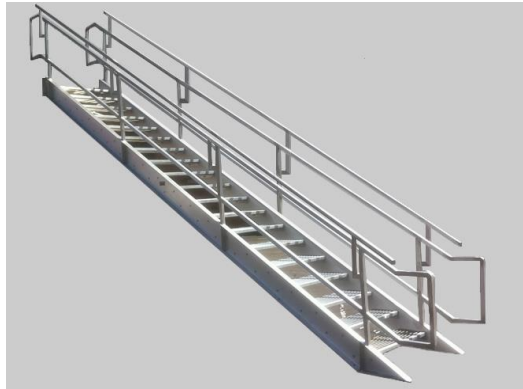


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# STAIR ASSEMBLY MANUAL FOR ALL TYPES



Rev: 2/15/18

COVER

AI1000-1

## INSTRUCTIONS APPLY TO ALL STAIR TYPES

Stair Stringer  
3/4" Mounting Holes

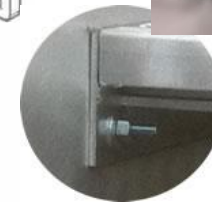
1. Assemble stair stringers by installing top and bottom treads using 3/8" bolts.
2. Lift stair assembly into position and attach to top mounting location (hardware not supplied).  
Note: Based on stair height and weight some individuals prefer to install all treads prior to placement.

5/8" Bolts

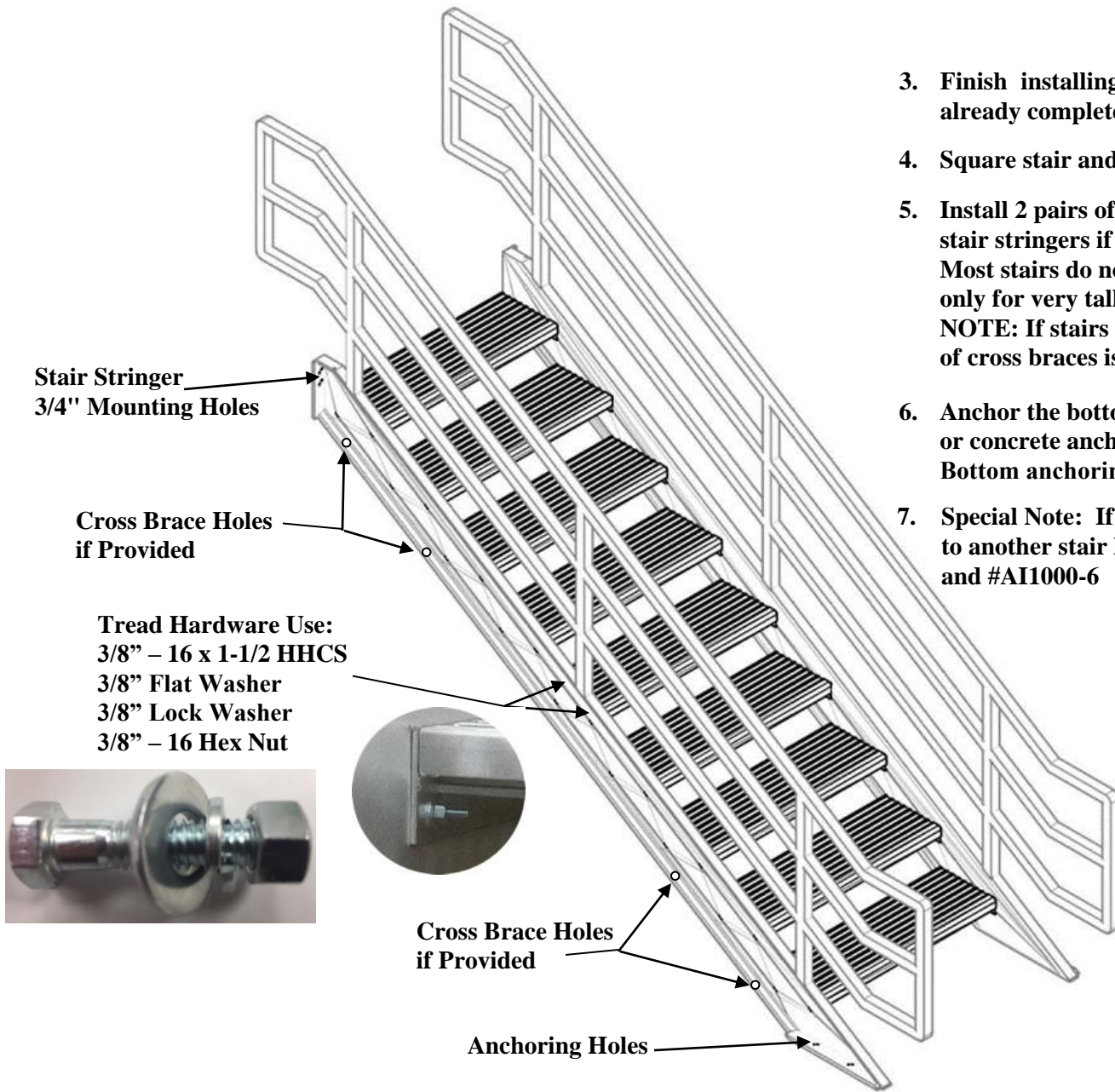


If stair was supplied with an extension platform or landing, the top mounting hardware is supplied using (4) 5/8"-11 x 2 bolts, lock washers, and hex nuts.

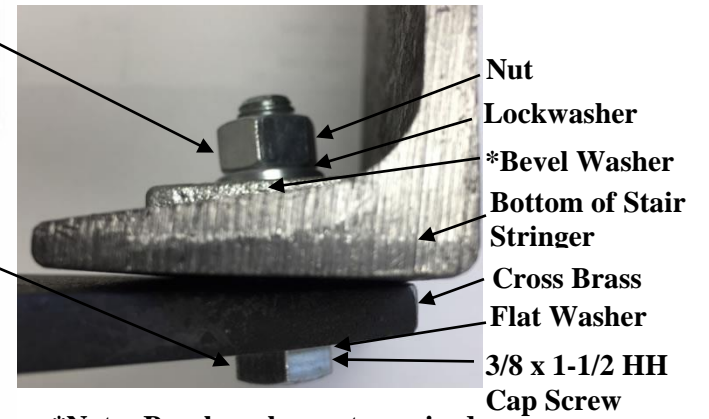
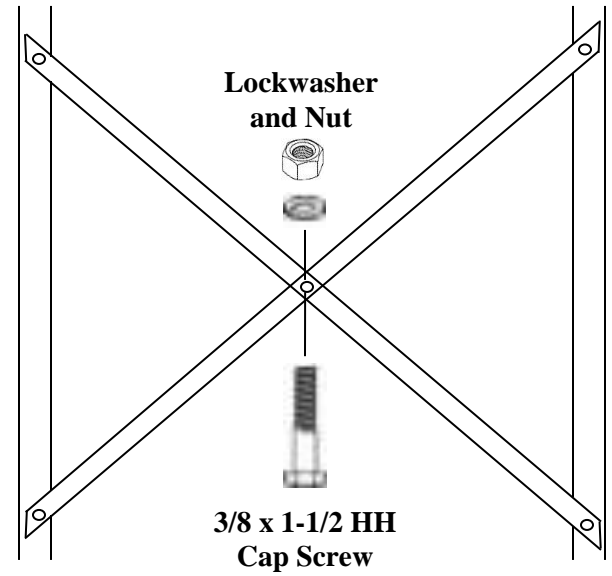
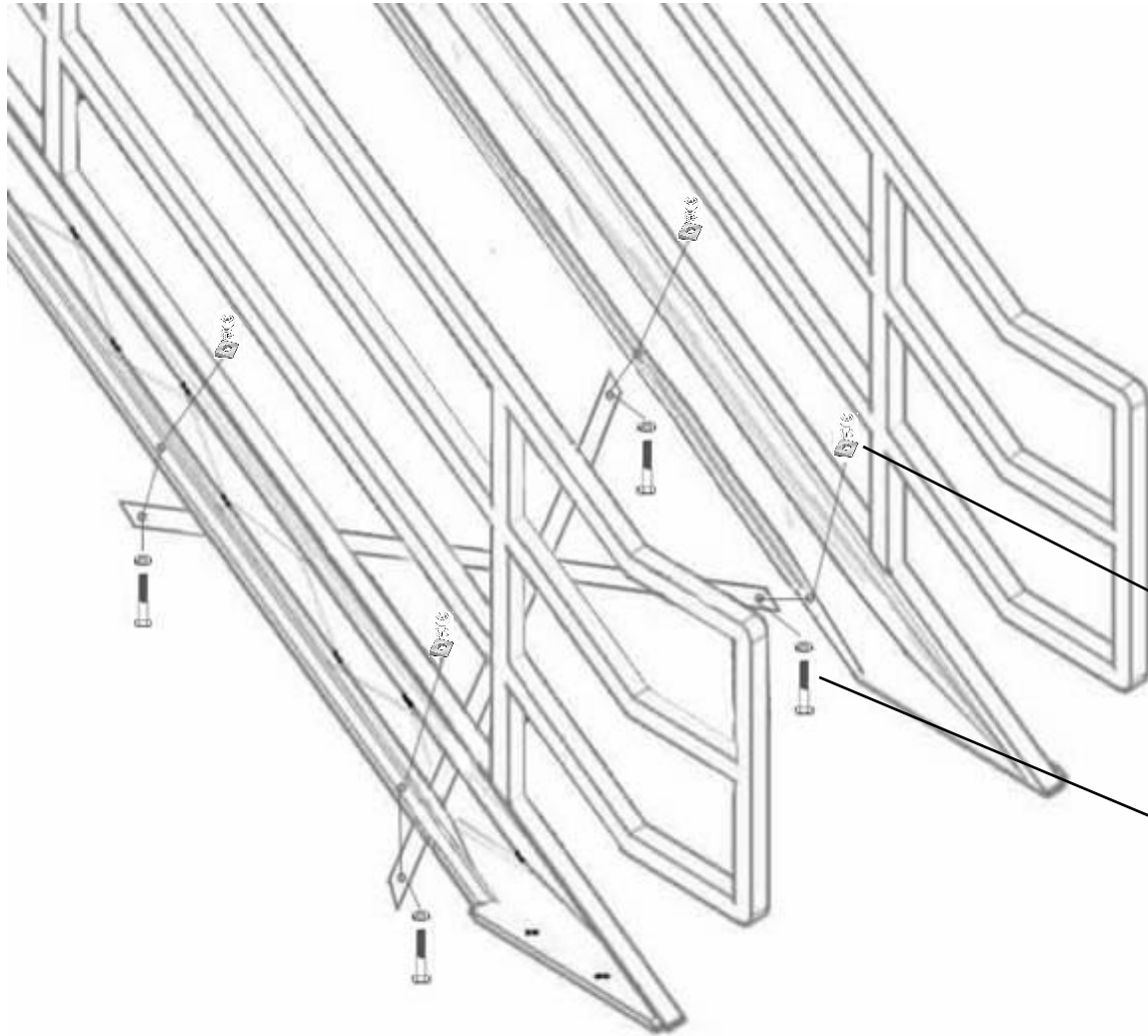
Tread Hardware Use:  
3/8" - 16 x 1-1/2 HHCS  
3/8" Flat Washer  
3/8" Lock Washer  
3/8" - 16 Hex Nut



Top and Bottom Tread Assembly



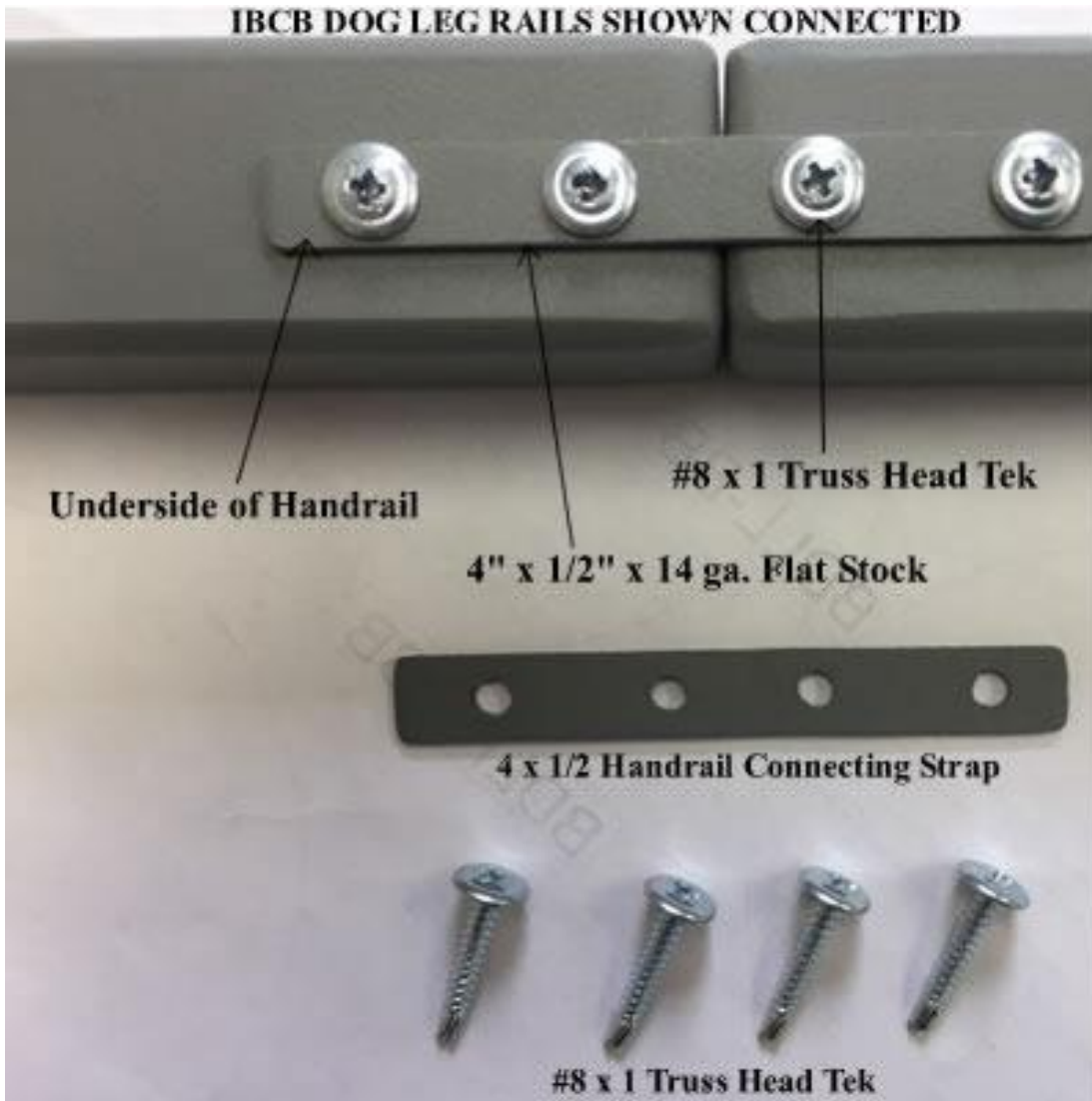
Remaining Tread Assembly



**\*Note: Bevel washer not required on aluminum stairs.**

**Cross Brace Assembly**

**IBCB DOG LEG RAILS SHOWN CONNECTED**



**Bottom View of ICB Dog Leg**



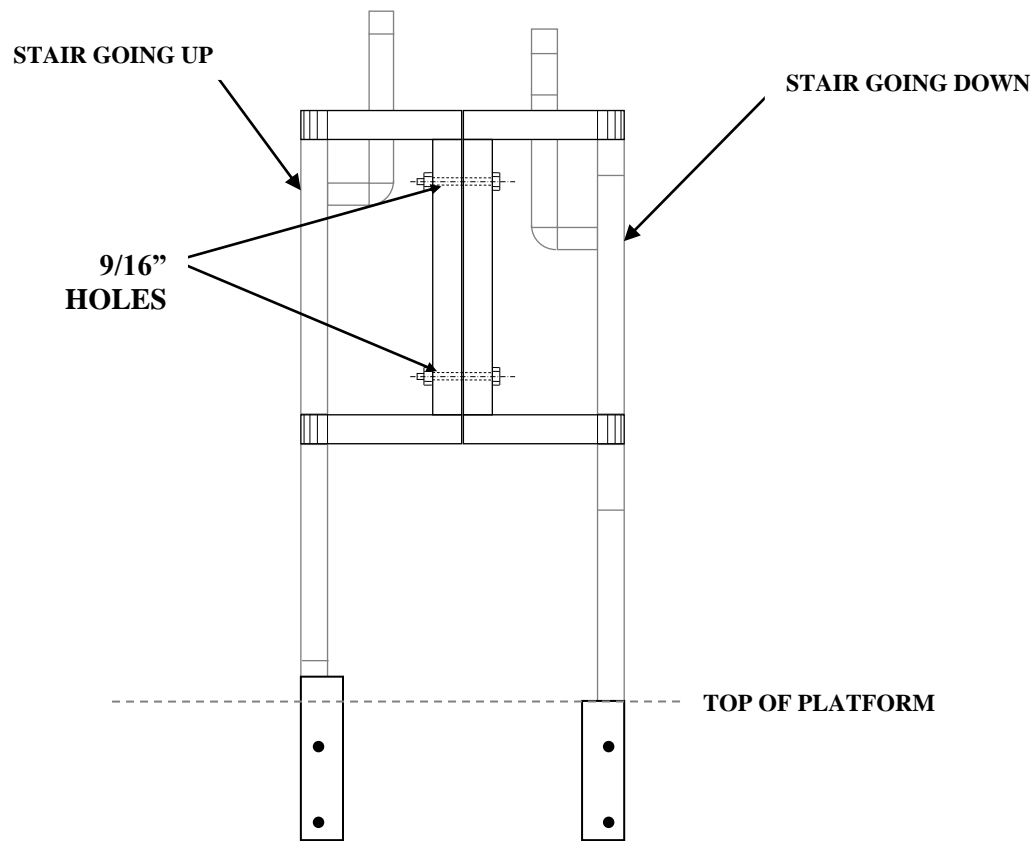
**Top View of ICB Connected Dog Legs**

For many stair tower installations, it is sometimes necessary to connect stair handrails using a “dog leg” design. The figure on left shows the connection method used for single handrail connections such as stairs made for IBC full compliance (Inboard rail with vertical picket guard type ICB).

Clamp and align the connecting handrail pieces so that they provide a smooth and continuous transition from one stair to the next.

Join the underside of the butting handrails using a 4” x 1/2” x 14 gauge flat strap and #8 x 1 modified truss head tek screws. See Photo on the left.

**For stairs made for IBC industrial conformance (outboard guard type IIOS)**



**Clamp and align the connecting handrail pieces so they provide a smooth and continuous transition from one stair to the next.**

**Attach the two sections of handrail together using:**

- 1/2" – 13 x 4 1/2" Hex Head Cap Screws
- 1/2" Loc Washer
- 1/2" – 13 Hex Nut