

## Supported Catwalk Assembly

### Parts List (5' or 10')

| Part Name                | Letter  | Part #     |      | Description      | Length        |         | Quantity |     |    |
|--------------------------|---|------------|------|------------------|---------------|---------|----------|-----|----|
|                          |   | 5'         | 10'  |                  | 5'            | 10'     | 5'       | 10' |    |
|                          |   | ↓Catconsu↓ |      |                  |               |         |          |     |    |
| Main Side Channel        | A   | .059       | .M99 | Formed Channel   | 60"           | 120"    | 2        | 2   |    |
| Middle Support Channel   | B   | .329       | .329 | C-Channel        | 40"           | 40"     | 3        | 5   |    |
| Joiner Channel           | C   | .709       | .709 | C-Channel        | 24"           | 24"     | 2        | 2   |    |
| Railing Uprights         | D   | .109       | .109 | Formed Channel   | 60"           | 60"     | 4        | 4   |    |
| Handrail Brackets        | E   | .029       | .029 | NA               | NA            | NA      | 4        | 4   |    |
| Handrails (side)         | F   | .259       | .209 | Angle            | 60"           | 120"    | 4        | 4   |    |
| Handrails (end)          | G   | .039       | .039 | Angle            |               |         | 2        | 2   |    |
| Floor Section            | H   | .524       | .409 | Flat + Toe Board | 60"           | 120"    | 1        | 1   |    |
| Under Support Angles     | I   | .659       | .699 | Angle            | 60"           | 120"    | 2        | 2   |    |
| Bottom Support Channels  | J   | .509       | .509 | C-Channel        | 40"           | 40"     | 2        | 2   |    |
| Side Support Angles      | K   | .159       | .159 | Angle            | Truss Section |         | 4        | 8   |    |
| Middle Support Angles    | L   | .169       | .169 | Angle            | 23 3/8"       | 23 3/8" | 2        | 2   |    |
| End Toe Board            | Not shown   | .019       | .019 | Angle            | 40"           | 40"     | 2        | 2   |    |
| 5/16" x 3/4" bolt        | <b>All bolts used are to be Grade 8 strength ONLY<br/>Torque to a 120 ft. lbs minimum</b> |            |      |                  |               |         |          | 60  | 70 |
| 5/16" x 3/4" button head |   |            |      |                  |               |         |          | 32  | 46 |
| 1/2" x 1" bolt           |   |            |      |                  |               |         |          | 18  | 26 |

**Note:** End Handrails, Toe Boards & Handrail Brackets are included in Starters Kit only

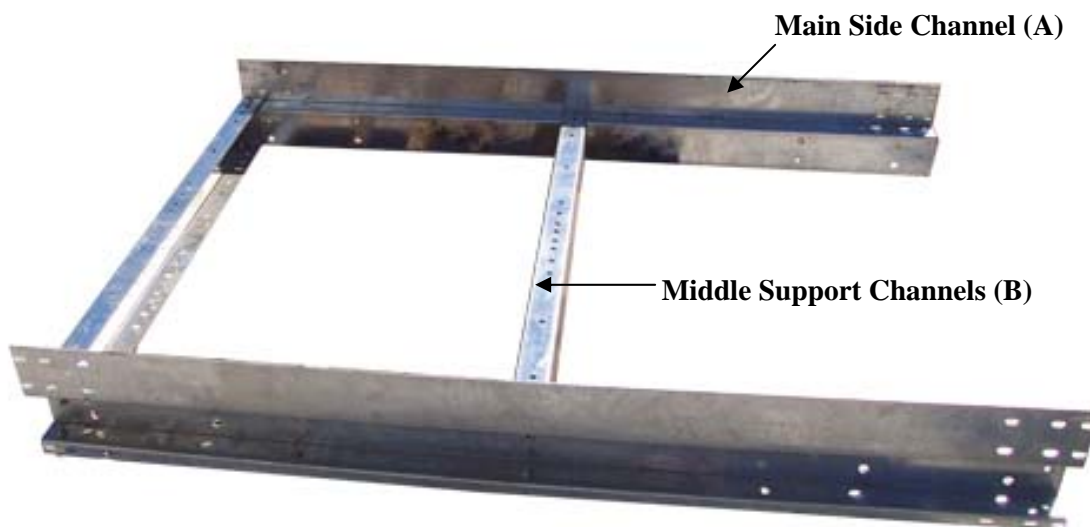
### Manway Catwalk only ( no conveyer )

Middle Support Angles ( L ) are not required and thus Step #9 does not apply.

The following assembly instructions include a 5' starters package and a 10' section of catwalk being joined. This manual can be used for any catwalk assembly of the Supported type (includes truss assembly under main channels). For simplicity we have shown the sections being assembled as one, an alternative when large spans are being constructed would be to assemble each section separately and attach them individually at the end.

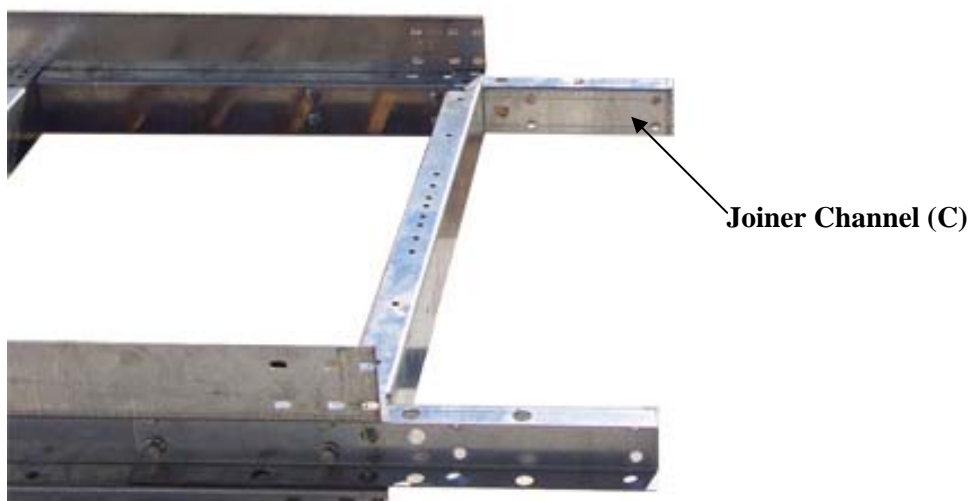
### **Step #1**

Locate your (2) Main Side Channels (A) for the starters package and proceed to bolt the Middle Support Channels (B) to the Main Channels (exclude each Joint end Support they will be added in the next step). Refer to diagram for clarification.



### **Step #2**

Now bolt the (2) Joiner Channels (C) to the end that will be joined to the next section using  $\frac{1}{2}$ " x 1" bolts (do not tighten bolts this will come in a later step). The Middle Support Channels for the ends can now be bolted into place.



### **Step #3**

Now prepare your next 5' or 10' section by locating your Main Side Channels (A) attaching the Middle Support Channels (excluding the ends again), and bolting your Joiner Channels into place (same process as Steps 1&2).

### **Step #4**

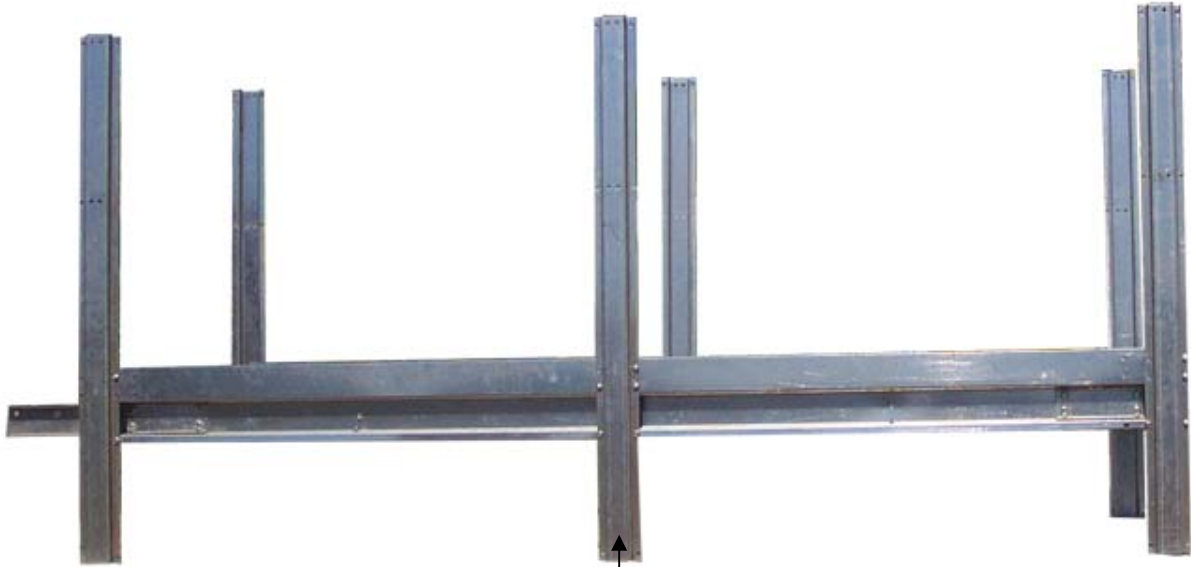
The two sections will now be joined together. To make things easier we suggest raising the sections off the ground. Start by sliding the sections together and bolting with **8, 1/2" x 1"** bolts. All Joiner channel bolts can now be tightened & remaining Middle Support channels can be added.

**Note: the catwalk has been designed to arc therefore each joint is required to peek, thus inserting bolts could be difficult we suggest jacking up the joint to help with the installation of the bolts.**



**Step #5**

Now locate your Railing Uprights (D) for both sections, they are fastened every 5'. The end posts can be mounted flush with either end of the catwalk while joint posts attach to both sections of the catwalk.



↑  
**Railing Uprights (D)**



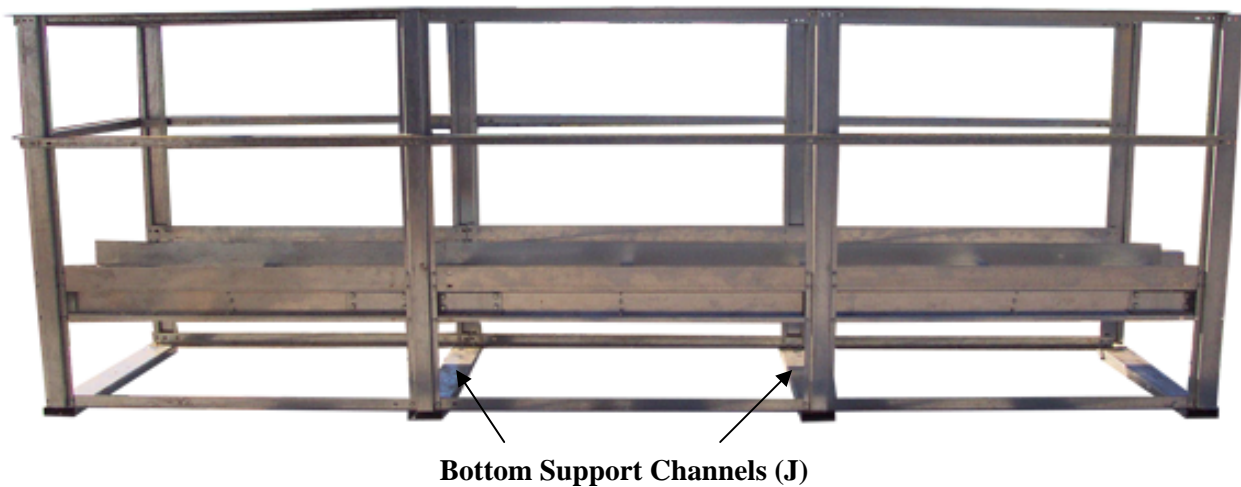
**Step #6**

The Floor Section (**H**) can now be bolted into place, using  $5/16" \times 3/4"$  button head bolts. Fasten the floor down with the toe board in the centre of the catwalk. The handrails can also be added in this section, locate the Side Handrails (**F**) for each section and mount with  $5/16" \times 3/4"$  button head bolts. The End Rails (**G**) require (2) Handrail Brackets (**E**) fastened to the Railing Uprights prior to being installed with  $5/16" \times 3/4"$  button head bolts.



**Step #7**

Now locate the Under Support Angles (**I**) for each section, they are mounted inside the uprights facing in as shown on the diagram. Bolt together flush at the end, and overlapped on the Railing Uprights at any Joints. The Bottom Support Channels (**J**) can also be attached at this point. They are to be mounted underneath each Railing Upright flush at ends, and overlapped at any Joint connection.



**Step #8**

The Side Support Angles (**K**) can now be added. Arrange as shown bolting to the Under Support Angles, and Bottom Support Channels using  $\frac{1}{2}$ " x 1" bolts.



**Side Support Angles (K)**

**Step #9**

The Middle Support Angles (**L**) can now be added in a triangular pattern as shown in the diagram. They will fasten to the middle Support Channels and the end of the Under Support Channels every 5' using  $\frac{5}{16}$ " x  $\frac{3}{4}$ " bolts. ( Conveyor Catwalk only - Does not apply to Manway Catwalk )



**Middle Support Angles (L)**

Your catwalk should now resemble this:



**Do not forget to close in both ends of your catwalk with the supplied handrails, angle brackets and toe boards. It is the owner's responsibility to ensure all unauthorized personnel are unable to access these assemblies. Failure to follow these precautions could result in serious injury or death.**