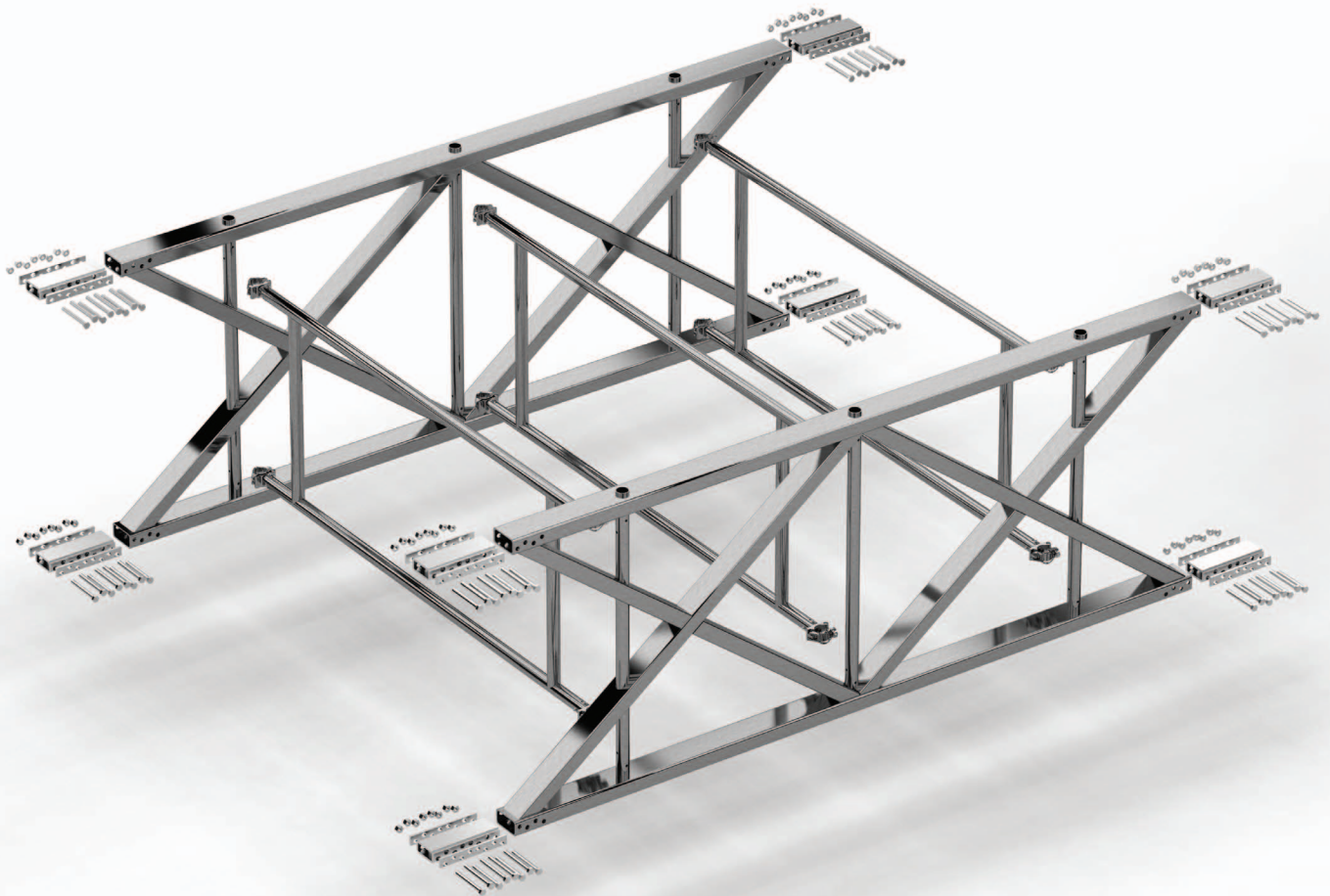




PROSCAFF ENTERPRISES INC.

SKYTRUSS ASSEMBLY INSTRUCTIONS

U.S. Patent published

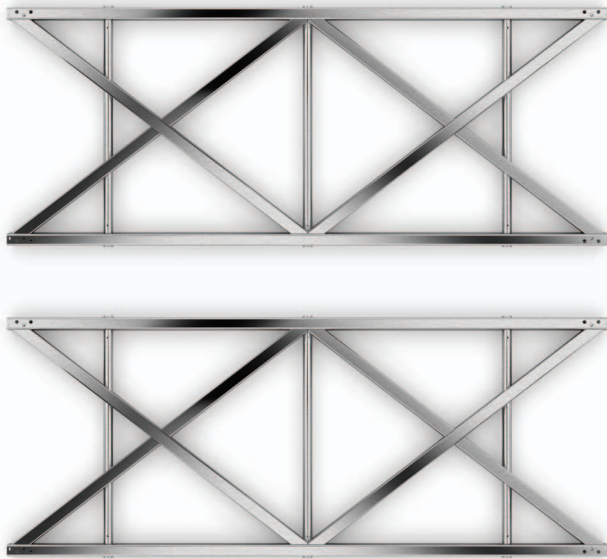


ASSEMBLY COMPONENTS:

Assembly of two truss elements requires a connection set that contains the following:
2 SkyTruss connectors, 4 SkyTruss stiffener plates, 16 M16x150 bolts and 16 M16 flange nuts

[02]

TRUSSES [3M TRUSS BELOW]



KG: 50.4 LB: 111.8

[02]

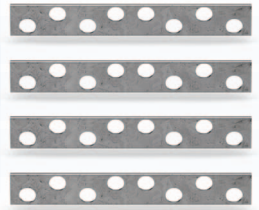
CONNECTORS



KG: 5.6 LB: 12.3

[04]

STIFFENER PLATES



KG: 0.43 LB: 0.95

[16]

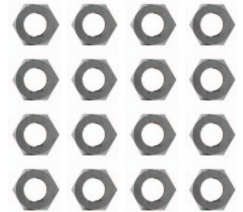
M16 BOLTS



KG: 0.28 LB: 0.616

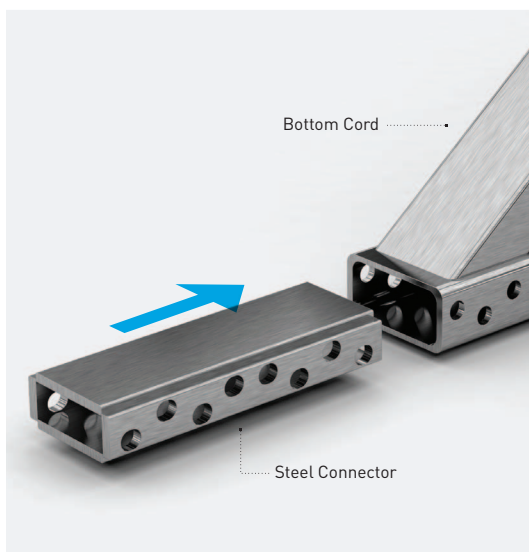
[16]

M16 NUTS



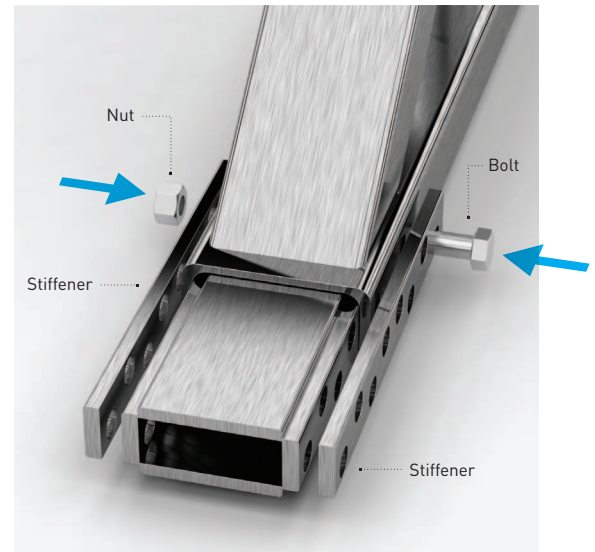
KG: 0.04

STEP
01



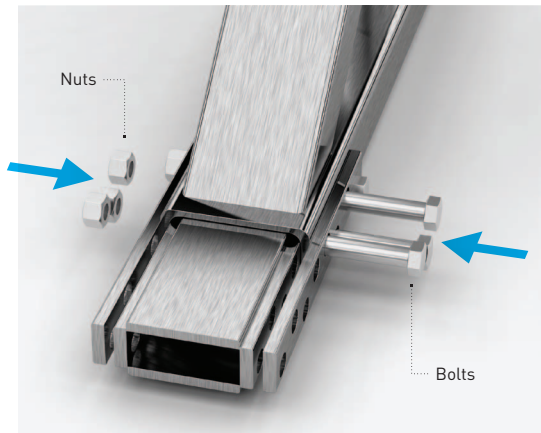
Insert steel connector into bottom cord. Trusses are fully symmetrical top to bottom and side to side.

STEP
02



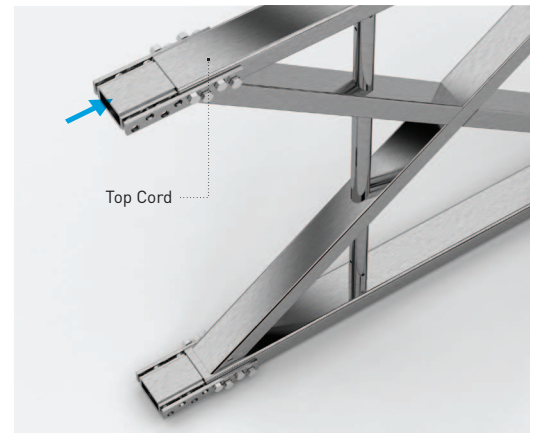
Insert bolt through a stiffener, then through the SkyTruss and finally through a second stiffener, secure bolt with a flange nut and hand tighten.

STEP 03



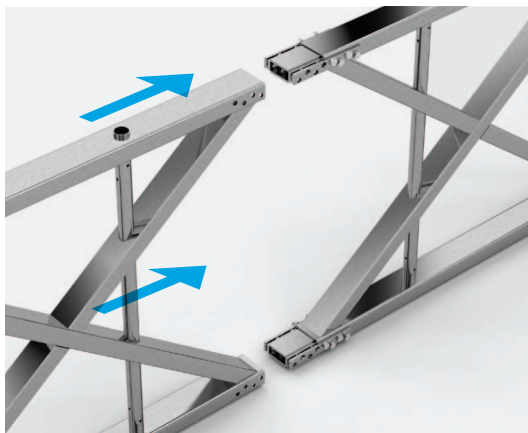
Insert three more bolts and secure with flange nuts.

STEP 04



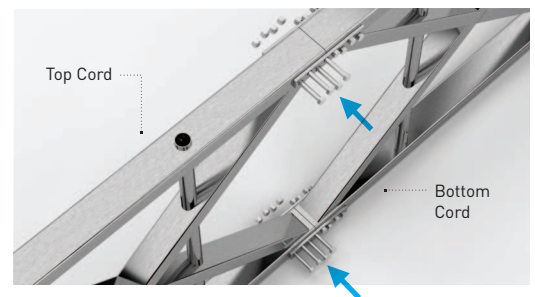
Repeat steps 1-3 on the top cord.

STEP 05



With the stiffeners and connectors installed on one truss element, slide the second truss onto the connectors.

STEP 06



[6.A] Install and hand tighten the remaining eight bolts and flange nuts (four on the top cord, four on the bottom).



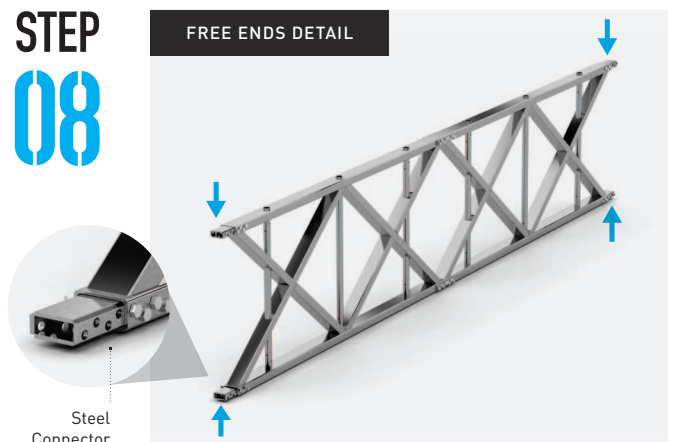
[6.B] All bolts must be torqued to **80-100 Nm/60-73 LBF FT** in the following sequence.

STEP 07



Repeat the above steps until the desired length of truss has been assembled. Ensure stiffeners are installed on both sides, top and bottom.

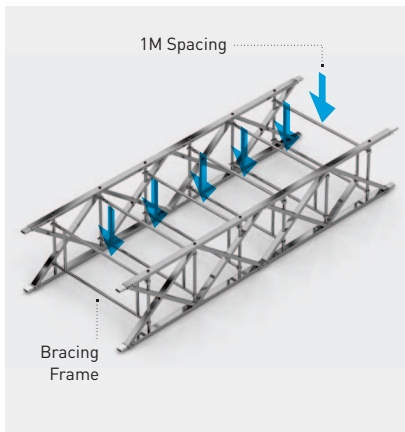
STEP 08



Insert connectors into the four free ends of the truss and secure with bolts and nuts, stiffener not required.

TRUSS ENDS MUST HAVE CONNECTORS IN THEM WHEN BEARING LOADS.

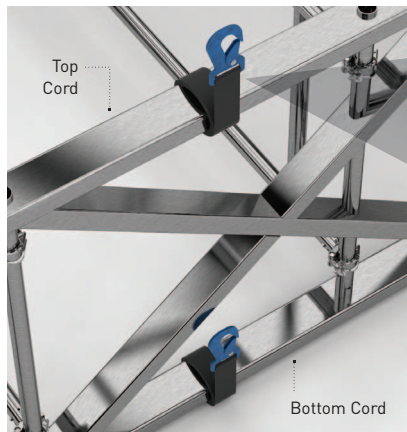
ADDITIONAL INFORMATION:



[01]

BRACING:

When using bracing, Proscaff recommends using bracing every 1M (every vertical). Additional horizontal bracing (tube and clamp) can be installed as per Application Engineers recommendations.



[02]

FLYING TRUSS:

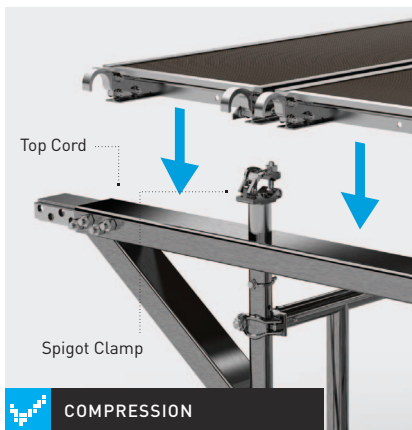
Assembled trusses can be flown into place, do not rig with wire ropes or chains, only synthetic slings. Using wire ropes or chains can damage the truss. Slings should only be attached to the top and/or bottom cords, not on the diagonal or vertical members.

[03]

DEFLECTION:

With properly assembled trusses the mechanical deflections for length 18M or less should be near zero.

Deflections listed in the SkyTruss Load Charts are for elastic deflection from applied loads and do not include mechanical deflection [deflection under self load].



[04]

SPIGOT CLAMPS:

Spigot clamps are to be used in compression only.

DO NOT USE THE PROSCAFF SPIGOT CLAMP FOR SUSPENSION/HANGING ANY LOAD!

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