THE FOLLOWING EIGHT (8) PAGES ARE TYPICAL ERECTION SEQUENCE PAGES FOR A "SYSTEM 2" BUILDING, THESE PAGES ARE SIMILAR FOR A SYSTEM 3 BUILDING. IF A SYSTEM 3 BUILDING IS APPLICABLE PLEASE DISREGARD ANY TEXT PERTAINING TO RIDGE & KNEE BRACES, THESE BRACES HAVE BEEN REPLACED WITH BOTTOM TRUSS ANGLES & WEB BRACES. PLEASE SEE PREVIOUS PAGES FOR ACTUAL BOLT SIZES FOR THESE BRACE LOCATIONS.

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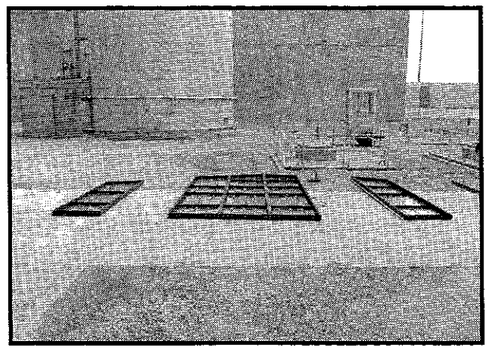

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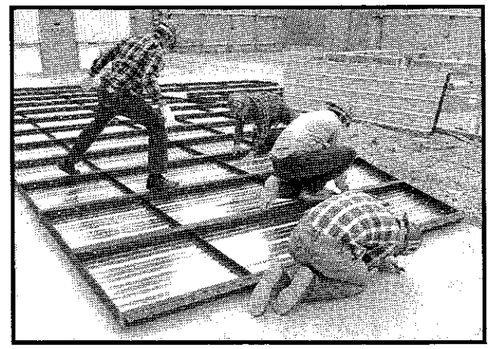

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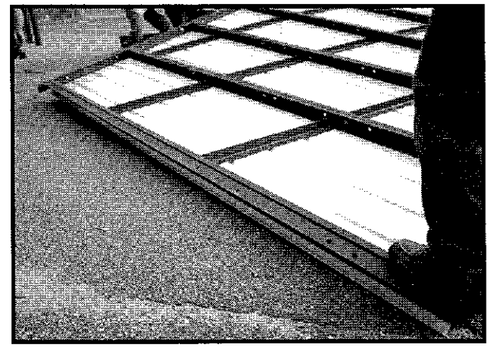

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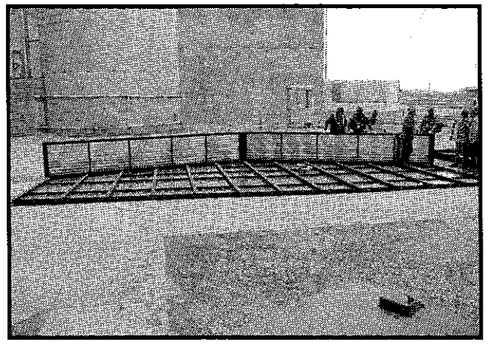

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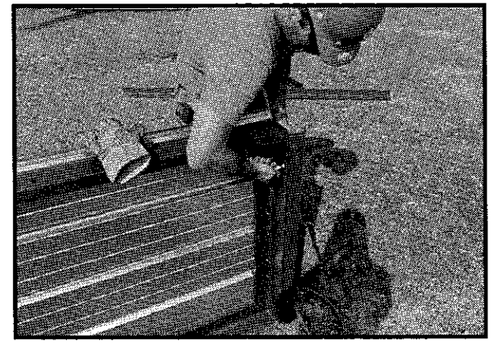

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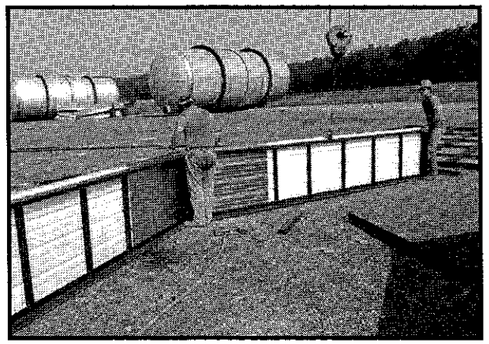

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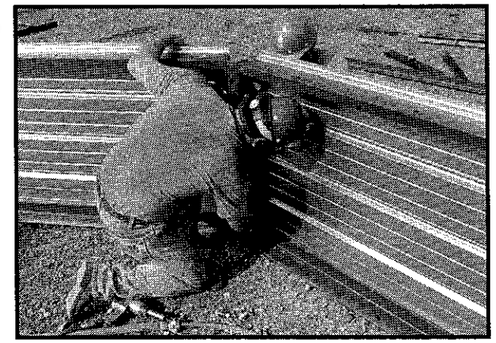

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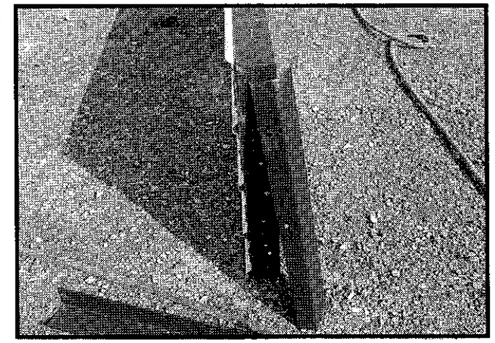

PICTURES 1 & 2

LAYOUT THE GABLE END PANELS MAKING SURE THAT THE SHEETING OVERLAPS NEST PROPERLY ONE PANEL NEXT TO THE OTHER. GABLE PANELS ARE BOLTED TOGETHER WITH 1/2" X 1" BOLTS (PROVIDED). BOLTS ARE REQUIRED IN EACH END HOLE, CENTER HOLE AND AN INTERMEDIATE HOLE ON EITHER SIDE OF THE CENTER HOLE.

PICTURE 3

THE 90 DEG. CORNER ERECTION ANGLES ARE ATTACHED (USING THE SAME BOLT PATTERN) TO THE TWO OUTER SIDES OF THE ENDWALL SECTION THE 90 DEG. GABLE ERECTION ANGLES ARE ATTACHED IN SIMILAR MANNER TO THE OUTER EDGE OF THE GABLE JUNCTION (USE 2 BOLTS PER 3'-0" WIDE GABLE ENDWALL PANEL

PICTURE 4

ROOF PANELS ARE INSTALLED IN A VERTICAL POSITION SQUARELY ON THE FLAT LEG OF THE 90 DEG. CORNER ERECTION ANGLES. BOLTING IS DONE USING A SIMILAR BOLTING PATTERN AS ON THE WALL PANELS. IT IS EXTREMELY IMPORTANT TO NOTE THAT THE SIDE LAP ON THE ROOF & WALL PANELS MUST CONSTANTLY FACE DOWN OR TOWARD THE STARTING END.

PICTURES 5 THRU 9

ROOF SECTIONS ARE SUB-ASSEMBLED ON THE GROUND BY THE BUILDING, SIX(6) LINEAL FEET OF ROOF AT A TIME. TWO(2) ROOF PANELS ARE SET VERTICALLY AT THE CORRECT ANGLE AND CONNECTED AT THE RIDGE WITH THE RIDGE ANGLE. THE EAVE ANGLES ARE THEN ATTACHED TO THE EAVE END OF EACH ROOF PANEL. BOTH EAVE AND RIDGE ANGLES ARE INSTALLED USING 1/2" X 1" BOLTS PROVIDED.

IMPORTANT NOTE:

IF A ROLL-UP EQUIPMENT DOOR IS REQUIRED IN THIS ENDWALL, DO NOT INSTALL THE DOOR OR IT'S ACCESSORIES UNTIL THE ENDWALL STRUCTURE IS COMPLETED AND ANCHORED INTO PLACE.

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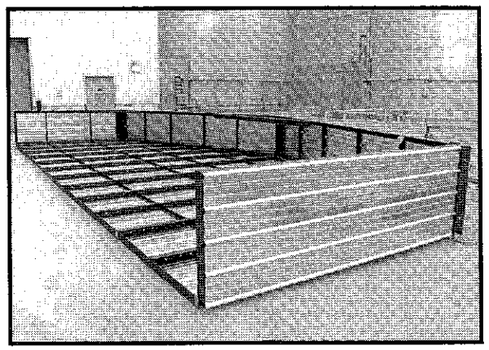

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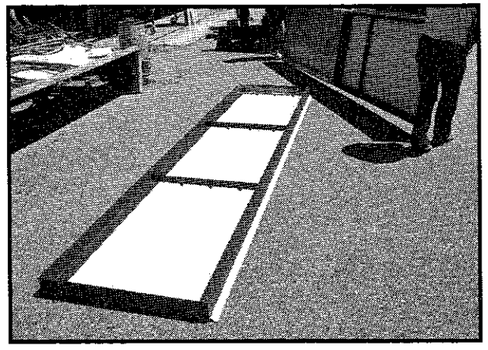

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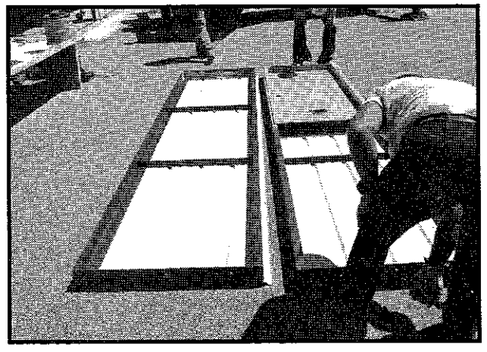

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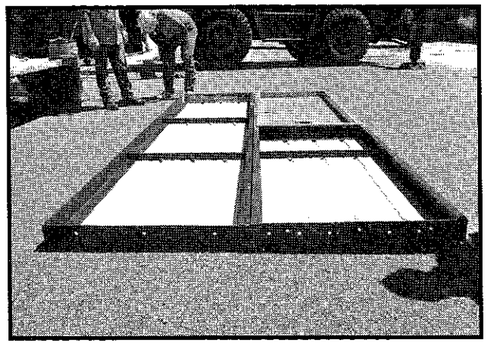

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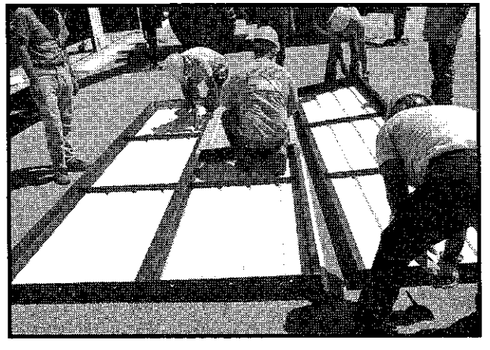

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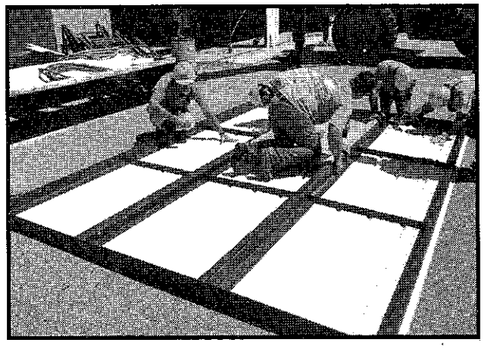

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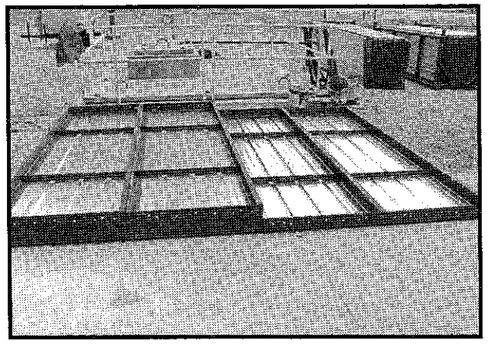

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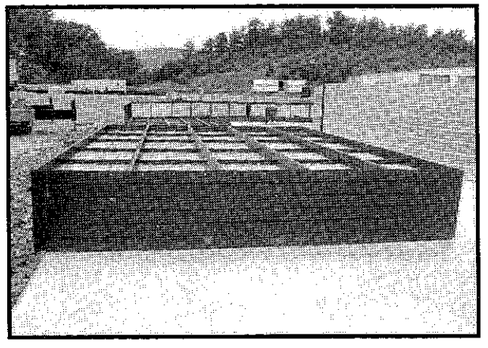

PICTURE 10

THE FIRST SIDEWALL PANELS (ONE EACH SIDE) ARE INSTALLED IN A VERTICAL POSITION SQUARELY ON THE FLAT LEG OF THE 90 DEG. CORNER ERECTION ANGLES WITH THE BOLTING PATTERN THE SAME AS ON THE ENDWALL. TEMPORARILY INSTALL THE RIDGE BRACE AND TWO KNEE BRACES TO ADD STABILITY TO THE SECTION FOR LIFTING.

PICTURES 11 THRU 14

THE REMAINING SIDEWALL PANELS ARE SUB-ASSEMBLED IN 12' OR 15' SECTIONS FLAT ON THE GROUND. PANELS ARE LAYED OUT AND BOLTED TOGETHER IN THE SAME MANNER AS THE GABLE ENDWALL PANELS WERE PREVIOUSLY, USING 1/2" X 1" BOLTS PROVIDED.

PICTURES 15 THRU 18

SIDEWALL SECTIONS CAN BE BUILT ON TOP OF EACH OTHER AND STACKED IF SPACE IS LIMITED AROUND THE BUILDING PERIMETER.

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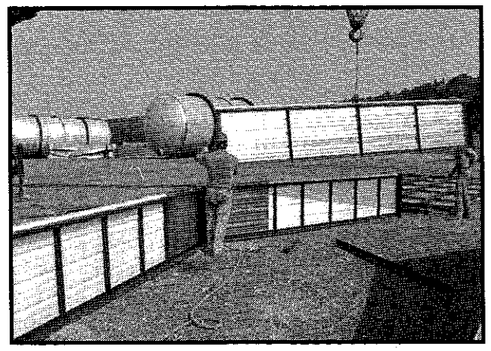

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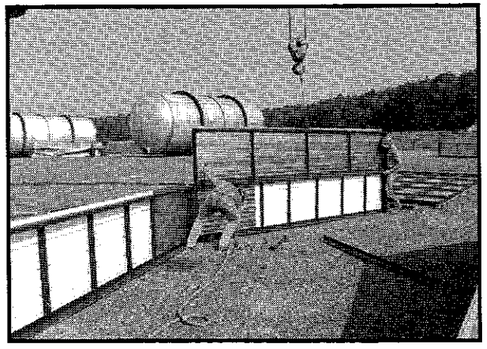

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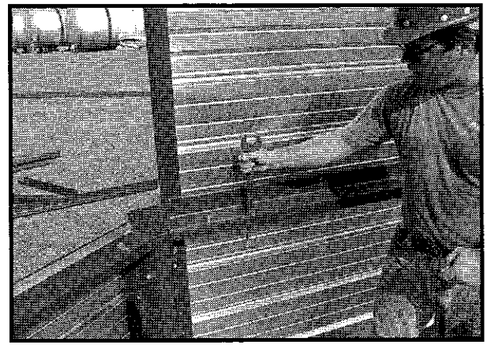

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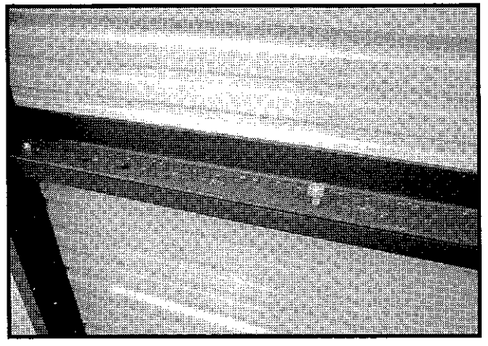

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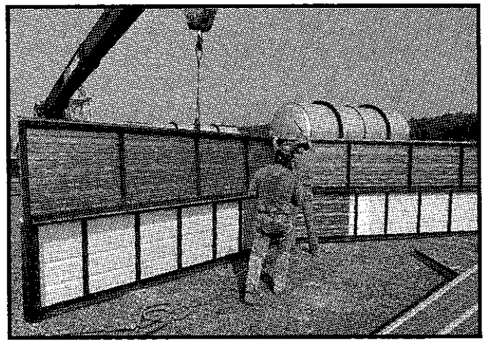

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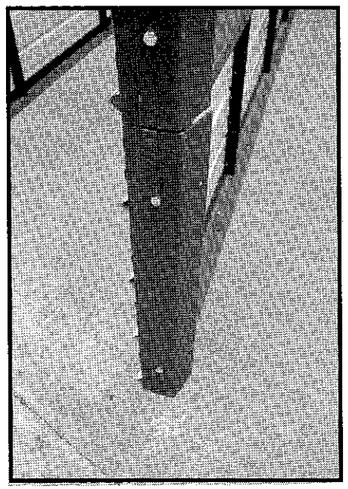

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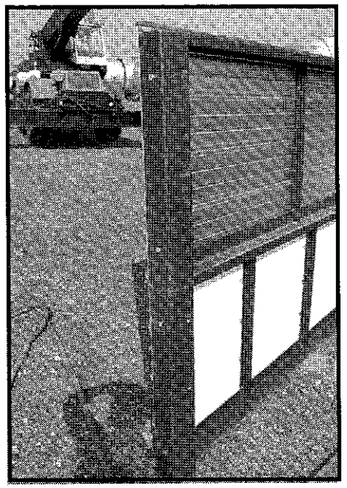

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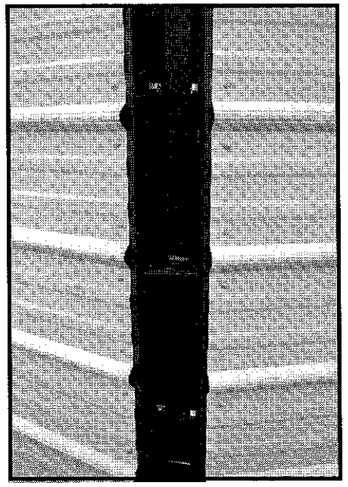

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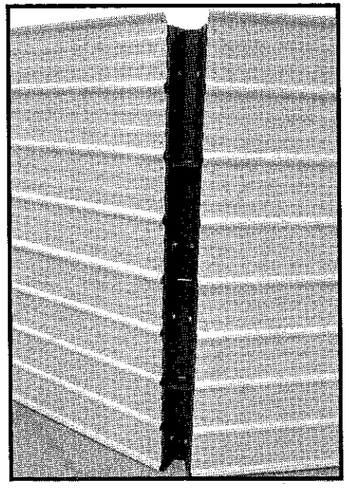

PICTURES 19 THRU 28

CONTINUE TO BUILD THE ROOF SECTION BY STACKING A SECOND SET OF ROOF PANELS ON TOP OF THE FIRST SET AND BOLTING THEM TOGETHER AT THEIR HORIZONTAL JUNCTION. ATTACH THE EAVE AND RIDGE ANGLES IN THE SAME MANNER AS BEFORE. RIDGE BRACE AND KNEE BRACE BOLTS (5/8" X 1 3/4") SHOULD BE PRE-INSTALLED IN THEIR PROPER HOLE LOCATIONS AT THIS TIME AND BEFORE TIGHTENING THE 1/2" X 1" BOLTS.

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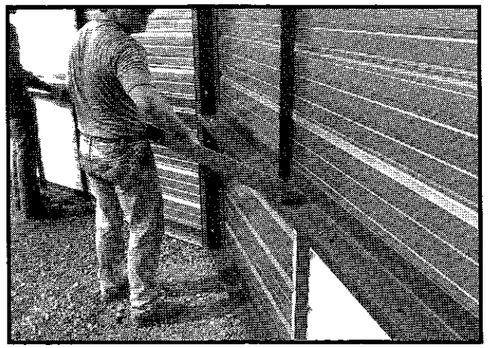

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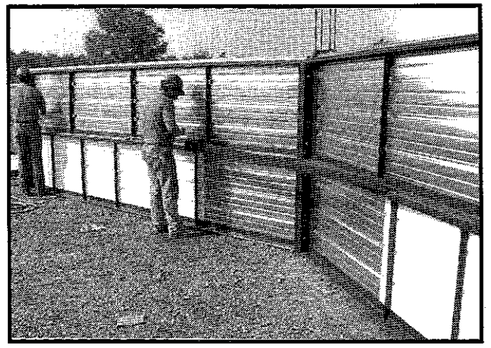

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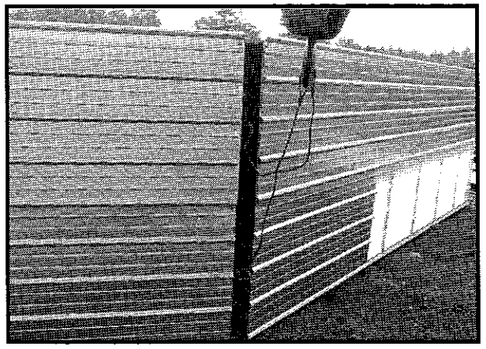

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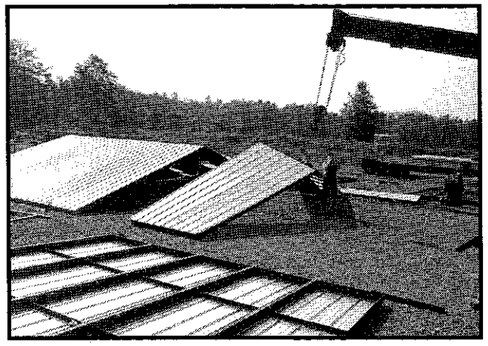

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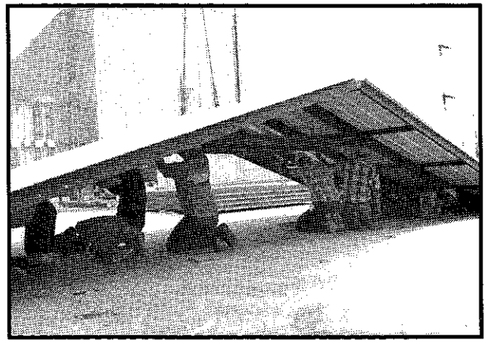

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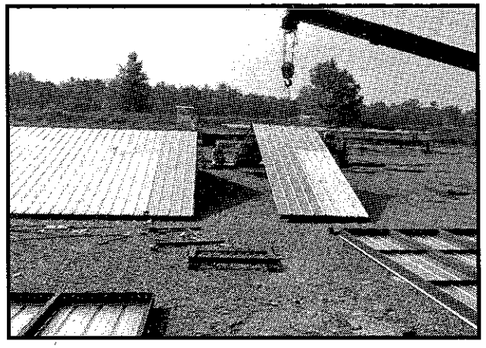

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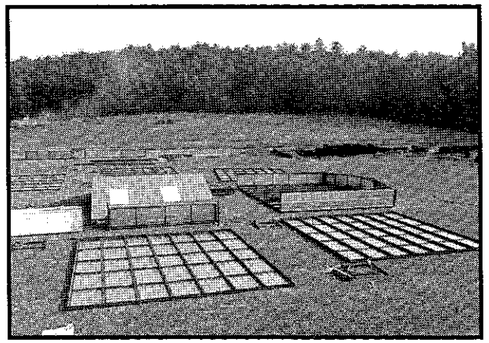

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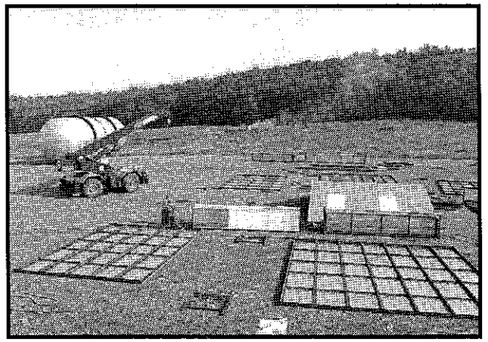

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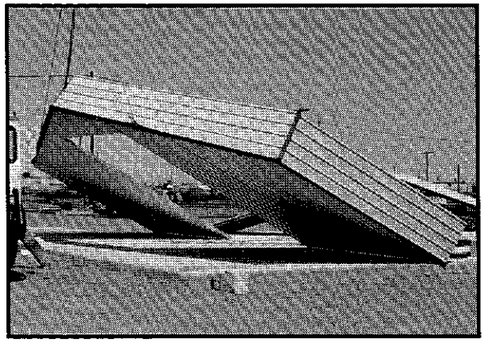

PICTURES 29 & 30

THE RIDGE BRACE SHOULD BE INSTALLED AT THIS TIME BY USING THE 5/8" X 1 3/4" BOLTS. A MOVEMENT OF ONE SIDE OR THE OTHER OF THE SECTION IN OR OUT MAY BE NECESSARY TO ALIGN THE HOLES IN THE BRACE. THESE BOLTS ARE TIGHTENED AT THIS TIME.

PICTURES 31 THRU 34

USING THE PICKING EYES BUILT INTO THE TOP SIDE OF THE RIDGE ANGLE TILT THE SIX(6) FOOT ROOF SECTION OVER 90 DEG. INTO A HORIZONTAL POSITION. CONTINUE BUILDING SIX(6) FOOT ROOF SECTIONS IN THIS MANNER AND TILT THEM UP AND TOGETHER. BY JOINING SIX(6) FOOT SECTIONS 12' OR 18' SECTIONS CAN BE SUB-ASSEMBLED ON THE GROUND RIDGE BRACES MUST BE INSTALLED AFTER SMALLER SIX(6) FOOT SECTIONS HAVE BEEN JOINED

PICTURES 35 & 36

SEVERAL SECTIONS OF DIFFERENT BUILDING COMPONENTS HAVE BEEN SUB-ASSEMBLED ON THE GROUND AND CAN NOW BE LIFTED INTO PLACE MORE EFFICIENTLY WITH THE USE OF A CRANE

PICTURE 37

ATTACHMENT OF A 2-WAY SLING TO THE 90 DEG. GABLE ERECTION ANGLE JUNCTION WILL ENABLE THE CRANE TO TILT THE ENDWALL SECTION INTO PLACE ON THE FOUNDATION.

THE PICKING PLATES ARE SUPPLIED AND MUST BE ATTACHED USING 5/8" X 1.3/4" BOLTS, WHICH ARE ALSO SUPPLIED. NOTE: DO NOT USE 1/2" DIAMETER BOLTS FOR THIS CONNECTION.

IMPORTANT NOTE:

IF A ROLL-UP EQUIPMENT DOOR IS REQUIRED IN THIS ENDWALL, DO NOT INSTALL THE DOOR OR IT'S ACCESSORIES UNTIL THE ENDWALL STRUCTURE IS COMPLETED AND ANCHORED INTO PLACE.

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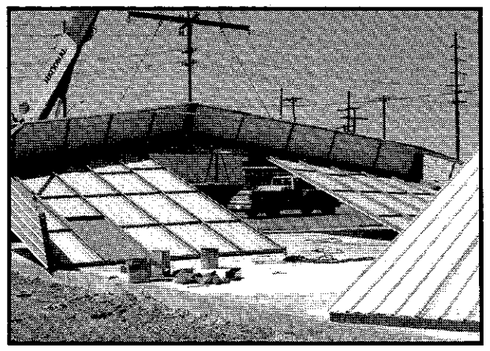

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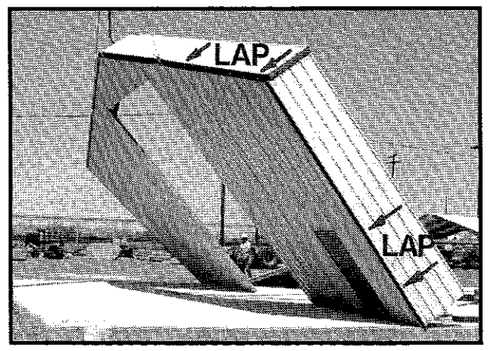

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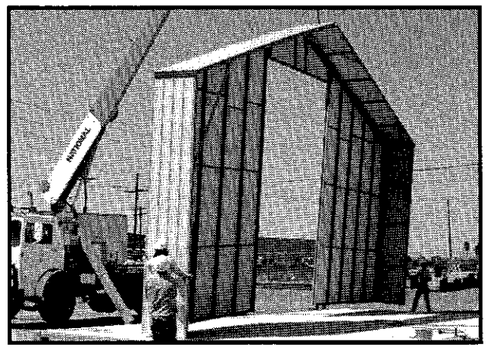

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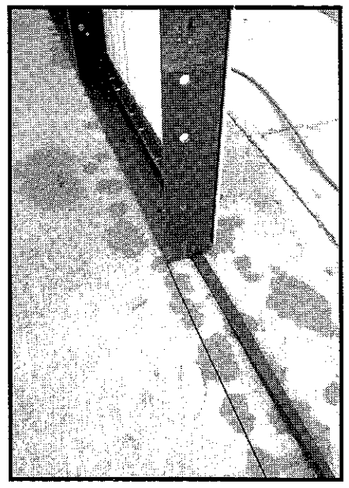

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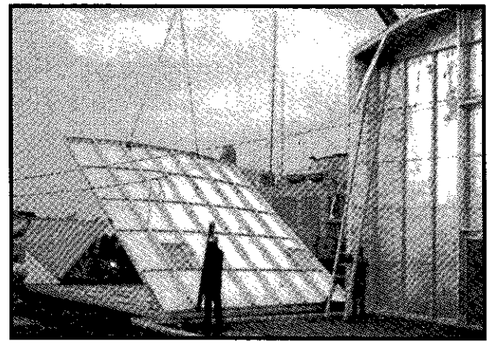

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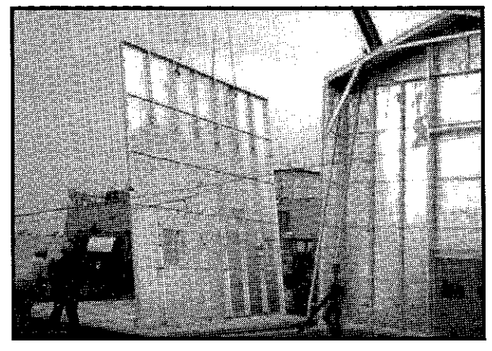

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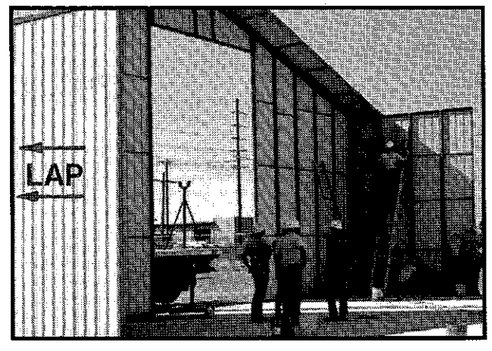

PICTURES 38 THRU 41

THE ENDWALL SECTION CAN BE TEMPORARILY LIFTED TO PERMIT THE POSITIONING OF THE BASE SILL. THEN LOWERED INTO PLACE. A CHALK LINE SHOULD BE SNAPPED TO MARK THE INSIDE DIMENSION OF THE WALL.

PICTURES 42 & 43

HOLES FOR CONCRETE EXPANSION ANCHORS ARE DRILLED INTO THE CONCRETE USING A MASONRY DRILL WITH A 1/2" DIA. BIT. EXISTING HOLES IN THE BASE OF EACH WALL PANEL THROUGH WHICH THE EXPANSION ANCHOR IS DRIVEN AND THEN TIGHTENED, ARE PROVIDED.

PICTURES 44 THRU 46

SIDEWALL SECTIONS ARE LIFTED INTO PLACE USING THE CRANE AND SLING ARRANGEMENT. WALLS ARE THEN LOWERED ONTO THE SILL SEAL STRIP AND ALIGNED WITH THE CHALK LINE. THE WALL SECTIONS ARE THEN BOLTED AT THE VERTICAL JUNCTION WITH THE ENDWALL SECTION USING 1/2" X 1" BOLTS.

IMPORTANT NOTE:

AT THIS TIME THE ROLL-UP EQUIPMENT DOOR AND ACCESSORIES MAY BE INSTALLED AT THE CUSTOMERS CONVENIENCE. OTHERWISE THE DOOR AND ACCESSORIES MUST BE INSTALLED AFTER THE BUILDING HAS BEEN COMPLETED AND ANCHORED INTO PLACE.

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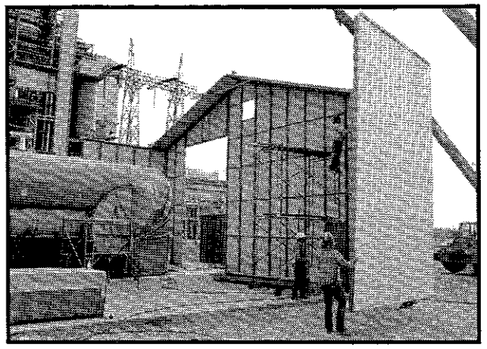

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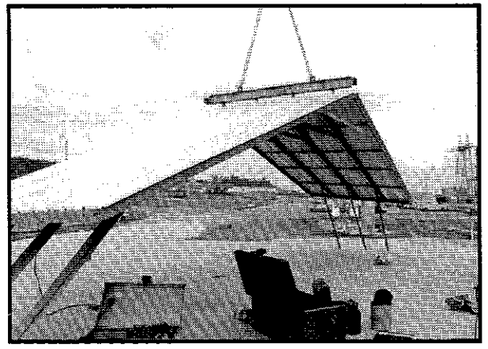
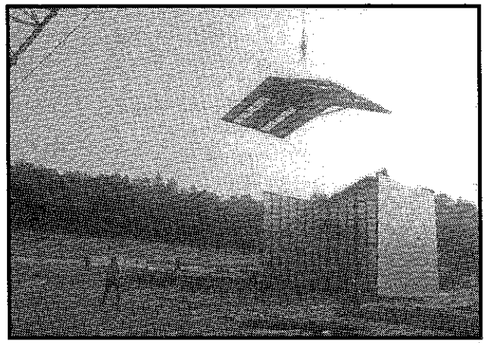


SPREADER BEAM IS NOT REQUIRED. USE TWO POINT PICK AT RIDGE.

50



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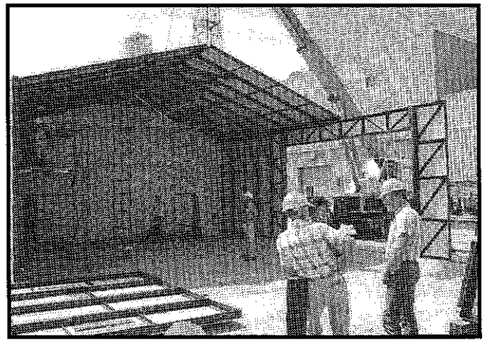

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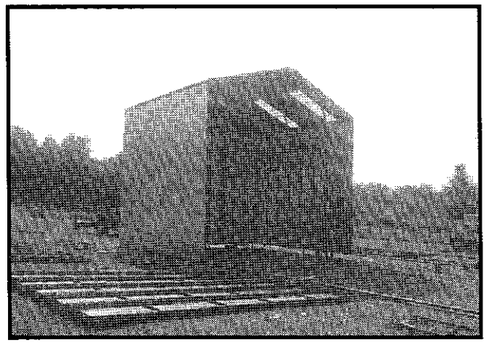

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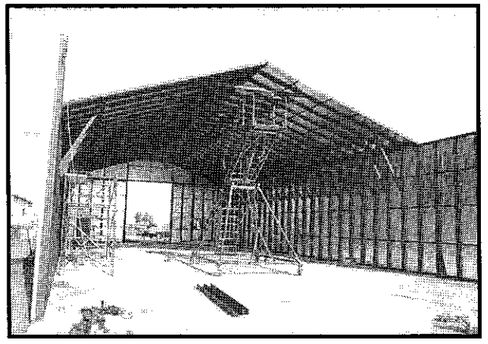

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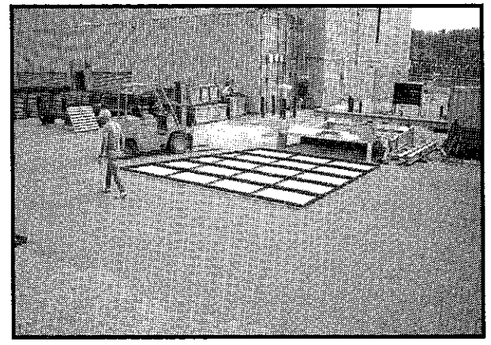

PICTURES 47 THRU 48

ONE 15' OR 18' WALL SECTION IS PLACED ON EITHER SIDE. ANCHORED INTO THE FOUNDATION AND BOLTED VERTICALLY.

PICTURES 49 THRU 52

AT THIS TIME ROOF SECTIONS ARE LIFTED INTO PLACE AND ATTACHED TO THE PREVIOUS ROOF PANELS. 2-WAY SLINGS ARE ATTACHED TO THE LIFTING EYES PROVIDED IN THE UPPER SIDE OF THE RIDGE ANGLE ENABLING THE CRANE TO SET THE ROOF SECTION ON THE WALL SECTIONS THAT ARE IN PLACE CREW MEMBERS THEN BOLT THE ROOF SECTIONS AT THE EAVE POINTS AND ALSO TO THE PREVIOUS ROOF SECTION KNEE BRACES CAN BE ATTACHED TO THE UNDERSIDE OF THE ROOF AT GROUND LEVEL THEN FLOWN WITH THE ROOF SECTION OR CAN BE INSTALLED AFTER THE ROOF SECTION IS IN PLACE THE CRANE IS USED TO LIFT OR LOWER THE ROOF SECTION WHEN INSTALLING THE KNEE BRACES. THEREFORE DO NOT DISCONNECT THE CRANE UNTIL ALL KNEE BRACES HAVE BEEN INSTALLED. SCAFFOLD OR OTHER PERSONNEL HOISTS ARE NEEDED AT THIS TIME.

PICTURES 53 & 54

CONTINUE INSTALLATION OF WALL & ROOF SECTIONS THROUGH OUT THE FULL LENGTH OF THE BUILDING.

PICTURE 55

THE FINAL ENDWALL WILL BE SUB-ASSEMBLED IN 2 HALVES ON THE GROUND AND MADE READY FOR INSTALLATION SIMILAR TO A SIDEWALL SECTION.

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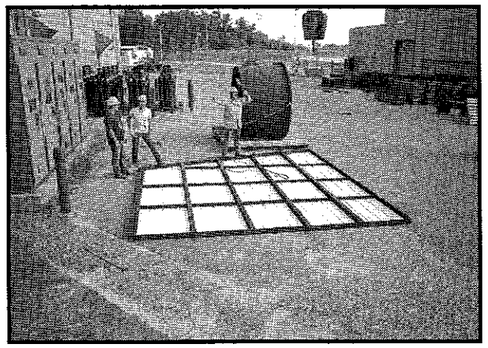

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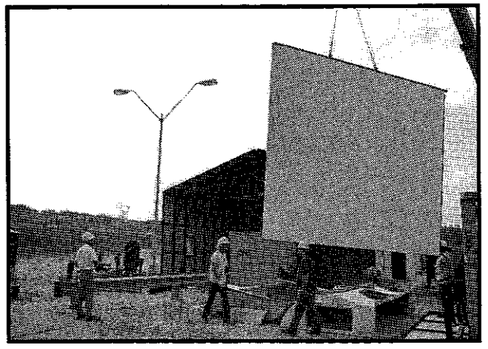

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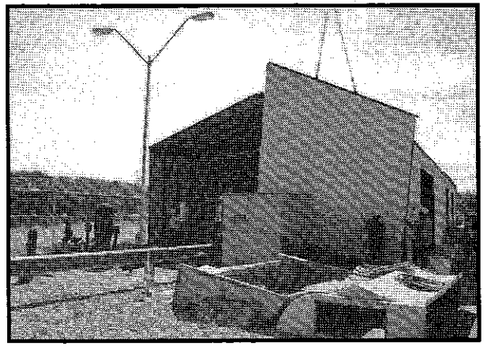

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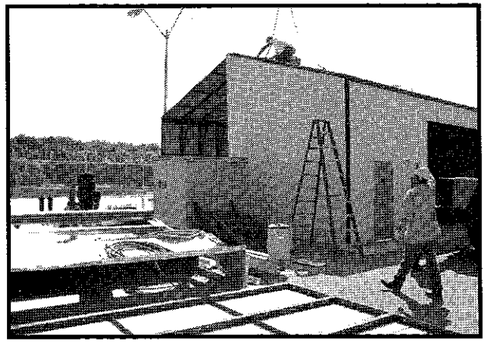

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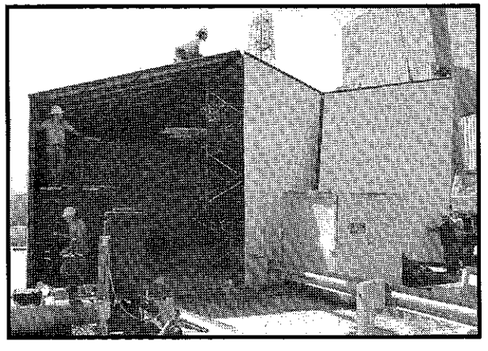

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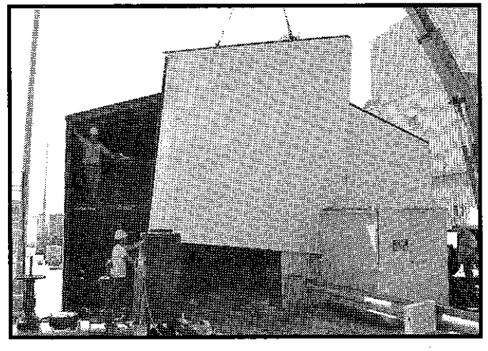

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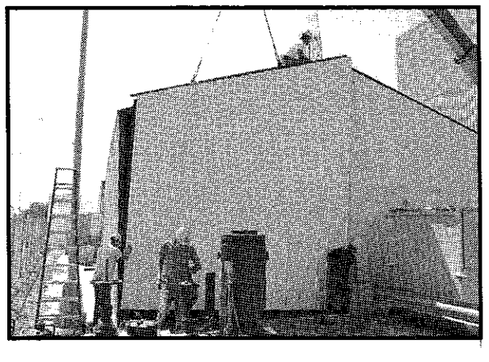

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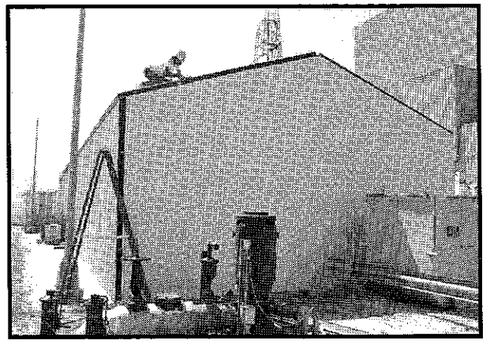

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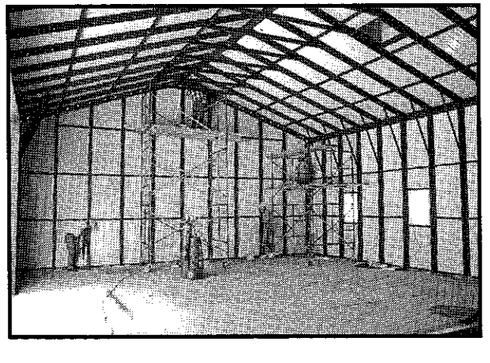

PICTURES 56 THRU 64

THE FINAL ENDWALL SECTIONS ARE THEN LIFTED INTO PLACE AND ATTACHED TO THE NOW EXISTING STRUCTURE AT THE 90 DEG. GABLE AND CORNER ERECTION ANGLES

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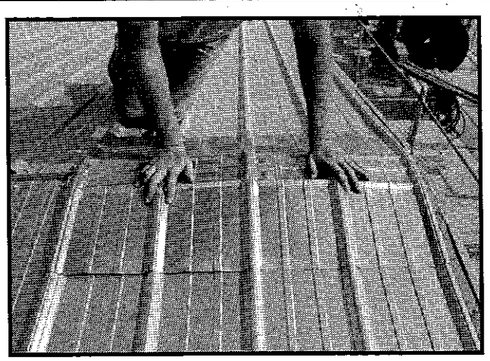

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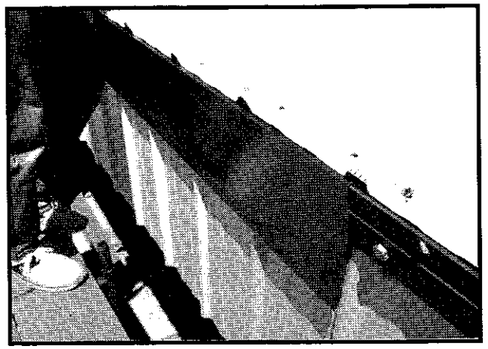

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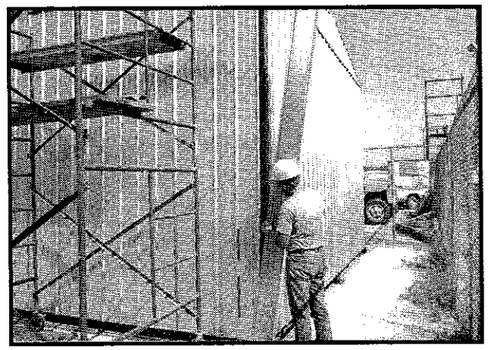

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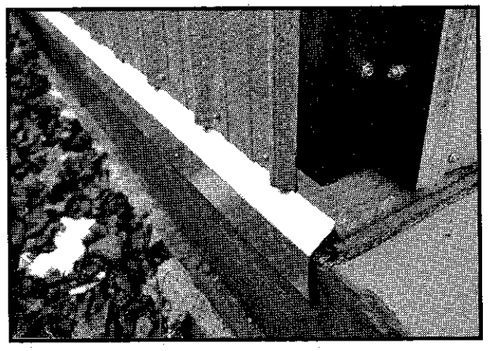

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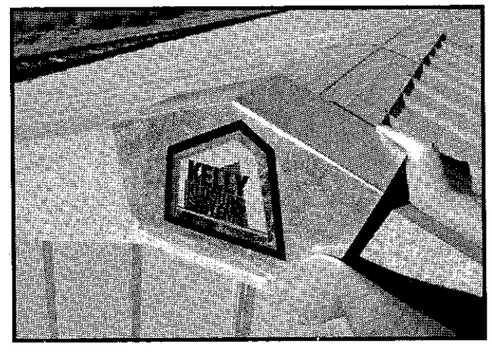

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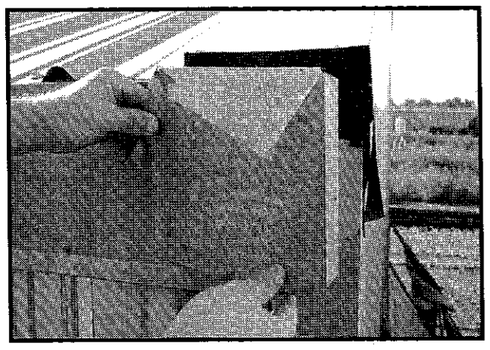

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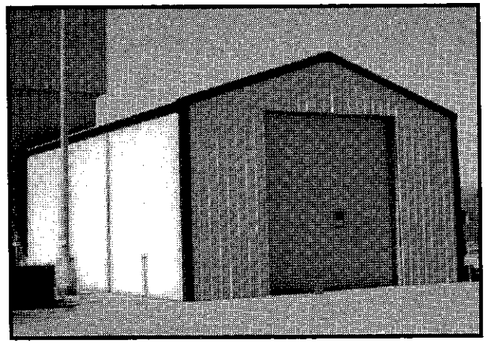

PICTURES 65 THRU 71

THE WEATHER PROTECTION IS INSTALLED NEXT WEATHER PROTECTION CONSISTS OF THE FOLLOWING ITEMS:

- *PICTURE 65 - RIDGE CAP*

  RIDGE CAPS ARE SUPPLIED IN 3'-0" LENGTHS. THEY ARE ATTACHED AT THE PEAK OF THE ROOF PANELS WITH SHEET METAL SCREWS SUPPLIED. CAULKING IS RECOMMENDED AT EACH 3'-0" OVERLAP.

- *PICTURE 66 - EAVE FLASHING*

  EAVE FLASHING IS SUPPLIED IN 10'-0" LENGTHS AND IS INSTALLED WITH THE UPPER LEG INSERTED UNDER THE ROOF PANEL SHEETING. THE LOWER LEG IS ATTACHED TO THE WALL PANEL SHEETING WITH SHEET METAL SCREWS SUPPLIED.

- *PICTURE 67 - CORNER CAP*

  CORNER CAPS ARE SUPPLIED IN 10'-0" LENGTHS AND ARE POSITIONED AROUND THE 90 DEG. CORNERS OF THE BUILDING AND ATTACHED WITH SHEET METAL SCREWS SUPPLIED.

- *PICTURE 68 - DOOR FLASHING*

  PERSONNEL DOOR FLASHING IS SUPPLIED TO FINISH OUT THE PERIMETER OF THE DOOR PANEL. THIS TRIM INCLUDES THE HORIZONTAL DRIP LEDGE WHICH IS INSTALLED ABOVE THE DOOR. THIS DOOR FLASHING IS INSTALLED UNDER THE WALL PANEL SHEETING AND SCREWED TO THE SHEETING WITH SHEET METAL SCREWS PROVIDED.

- *PICTURE 69 - BASE FLASHING*

  BASE FLASHING IS SUPPLIED IN 10'-0" LENGTHS AND IS INSTALLED WITH THE UPPER LEG INSERTED BEHIND THE BOTTOM END OF THE WALL PANEL SHEETING. FOR CONCRETE CURBS THE LOWER LEG EXTENDS DOWN AND ALONG THE OUTSIDE OF THE CONCRETE CURB (AS SHOWN ON THIS PAGE)

  PLEASE NOTE: FOR EXISTING SLAB CONDITION PLEASE REFER TO BASE FLASHING ISOMETRIC & SECTION ON SHEET ENTITLED "BASE FLASHING ISOMETRIC"

- *PICTURE 70 - GABLE CAP*

  THE GABLE CAP IS DESIGNED TO SET ON THE ROOF AT THE PEAK OF EACH GABLE END. IT IS ATTACHED TO THE GABLE CORNER CAPS WITH SHEET METAL SCREWS SUPPLIED.

- *PICTURE 71 - CORNER END CAP*

  THE CORNER END CAP IS DESIGNED TO PLUG OFF THE OPENING AT THE LOWER END OF THE GABLE CORNER CAP WHERE IT MEETS THE EAVE FLASHING & THE CORNER CAP. THE CORNER END CAP IS ATTACHED AT THIS POINT WITH SHEET METAL SCREWS SUPPLIED.

PICTURE 72

A COMPLETED KELLY KLOSURE SYSTEM "2" BUILDING.

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