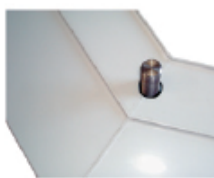


Variable Bay Pole Fitting Guide

- 1) Drill a Ø20mm hole through the cill on the centreline of the weld. For 70mm systems, this hole will be approximately 37mm from the inside corner of the welded cill. For 65mm systems, this hole will be at 34.5mm. A larger hole will give more tolerance on site for the fitter.



- 2) Unthread the nut and the capstain from the jack base. Position the base on the brickwork and pass the M16 studding up through the hole in the cill. Ensure that the jack is level and true and resting on a sound substrate. If you chip out old mortar in the area of the base, then the 8mm base thickness can be recessed. Any packing must be done with shims made from metal. You must fix the cill to the brickwork either side of the jack base - within 150mm of the cill centreline.



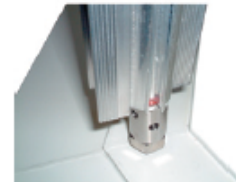
- 3) It is important to make a good watertight seal between the M16 thread and the cill - use an appropriate silicone sealant. Wind the nut and the capstain down on the base and position the fibrewasher supplied as shown.



- 4) Cut the baypole to length - ensure that the cut is straight and true. For a 30mm cill, the formula is **opening** size (brick to brick) - 100mm. If the cill is higher, adjust accordingly. Locate the baypole on top of the fibrewasher as shown.



- 5) You should now locate the top spreaderplate into the hole in the baypole with the fibrewasher in between. You can now begin to 'jack' the pole using an x-head screwdriver in the capstain at the bottom. You should jack about 5mm until the bay starts to take load. Do not over tighten, simply 'take the weight'. You must ensure that the pole is vertical in both planes and that the top spreaderplate is located onto a suitable surface. Packing with metal shims may be required at the head - depending on substrate and its condition.



- 6) The aluminium frame adapter should normally be fixed to the frames. Cut the aluminium frame adapter c.100mm shorter than the frame height and position it min 80mm from the bottom of the frame. There are 2 vee groves extruded to mark the centreline position for the screws. The heads of the screws to the inside must finish flush with the aluminium or else they may interfere with the interface with the baypole extrusion. Aluminium frame adapters with 2 location pips are designed to position centrally to the frame width, the variant with the one pip is designed to position against the inside frame leg (ie. aluminium finishes virtually flush with the frame edge). If you have a rebated plasterline, projecting tiles etc, then



you **should not** fix the aluminium to the last frame to be installed at this stage as you will need to shuffle the frame into position before fixing through the frame into the adapter.

continued over .../

Pioneer Trading Company Essex Limited

Unit 1-3 Red Barns, Warners Farm, Howe Street, Great Waltham, Chelmsford, Essex, CM3 1BN Tel: 01245 362236 Fax: 01245 362421



Our Products bear the BSI Kitemark. This is your assurance that samples are regularly subjected to rigorous, independent testing to ensure that they comply with stringent standards for safety, product performance, or reliability. In addition, the Kitemark also means that the quality systems of the factory where our products are made, are systematically assessed. The Kitemark is therefore Pioneer's commitment towards maintaining the highest possible standards.



Website: www.pioneertradingcompany.co.uk Email: sales@pioneer-trading-company.co.uk

Registered Office: 52B Ashingdon Road, Rochford, Essex, SS4 1RD - Company Reg. No. 5987735 VAT No: 916 2640 33

7) Where rebates and projections are not an issue, you can now begin to fit the frames. Locate the 'ball' on the aluminium adapter (frameside) into the 'socket' on the baypole extrusion. The frame will need to be perpendicular to the baypole extrusion in order to locate the ball into the socket. By pressing the frame tight up against the baypole, you can now rotate the frame around, as shown, to butt the cill upstand. As you do so, depending on your bay angle, the aluminium extrusions will 'interlock' stopping the frame from falling out. If you have not fixed the aluminium to the frame due to obstacles described in 4) above, then you must shuffle the frame into position behind any rebates, rotate the aluminium adapter into the baypole and then fix



through the frame rebate, into the adapter and into the baypole. If you fit the internal PVCu trim before drilling, then it will ensure that the pole is centralised while you drill.



11) Cut the internal trim to size and clip into position. This will centralise the assembly and assist before you screw fix the baypole to the frames. The trim should locate neatly on top of the window board or cill upstand. Before clipping into position, you have an option to run a bead of sealant into the 'cups' along the edge of the extrusion for additional weatherability.



12) When all frames are fixed into position, you must then ensure that they are secured to the baypole. You should drill and fix at max 250mm centres and this can be done with a screw through the frame or from the outside through the vee grooves at the base of the aluminium legs projecting from the baypole. This fixing is especially important for load bearing situations. There should always be a minimum of 3 fixings. You can silicone around the jack detail at the base to ensure good weatherability and no leaks before moving on to fit the external cover.



8) Fix down through the frame into the cill, with the frame tight against the cill upstand. Follow your normal fixing guidelines in terms of screw types and fixing centres.



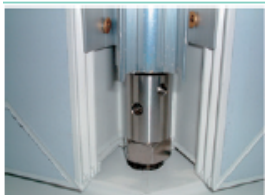
13) When all fixings are in position, cut the outer trim to size and clip it into position. You can also run a bead of sealant along the edges if you wish - prior to fitting. Protective tape is supplied and this should be removed within a day or two of the installation. Finish the installation as normal.



9) Repeat 7) and 8) for the adjacent frames and hence fit the entire bay.



10) With the adjacent frames in position, you should make a final check of the baypole jack and lock out the locknut onto the capstain.



Pioneer Trading Company Essex Limited

Unit 1-3 Red Barns, Warners Farm, Howe Street, Great Waltham, Chelmsford, Essex, CM3 1BN Tel: 01245 362236 Fax: 01245 362421



Our Products bear the BSI Kitemark. This is your assurance that samples are regularly subjected to rigorous, independent testing to ensure that they comply with stringent standards for safety, product performance, or reliability. In addition, the Kitemark also means that the quality systems of the factory where our products are made, are systematically assessed. The Kitemark is therefore Pioneer's commitment towards maintaining the highest possible standards.



Website: www.pioneertradingcompany.co.uk Email: sales@pioneer-trading-company.co.uk

Registered Office: 52B Ashingdon Road, Rochford, Essex, SS4 1RD - Company Reg. No. 5987735 VAT No: 916 2640 33