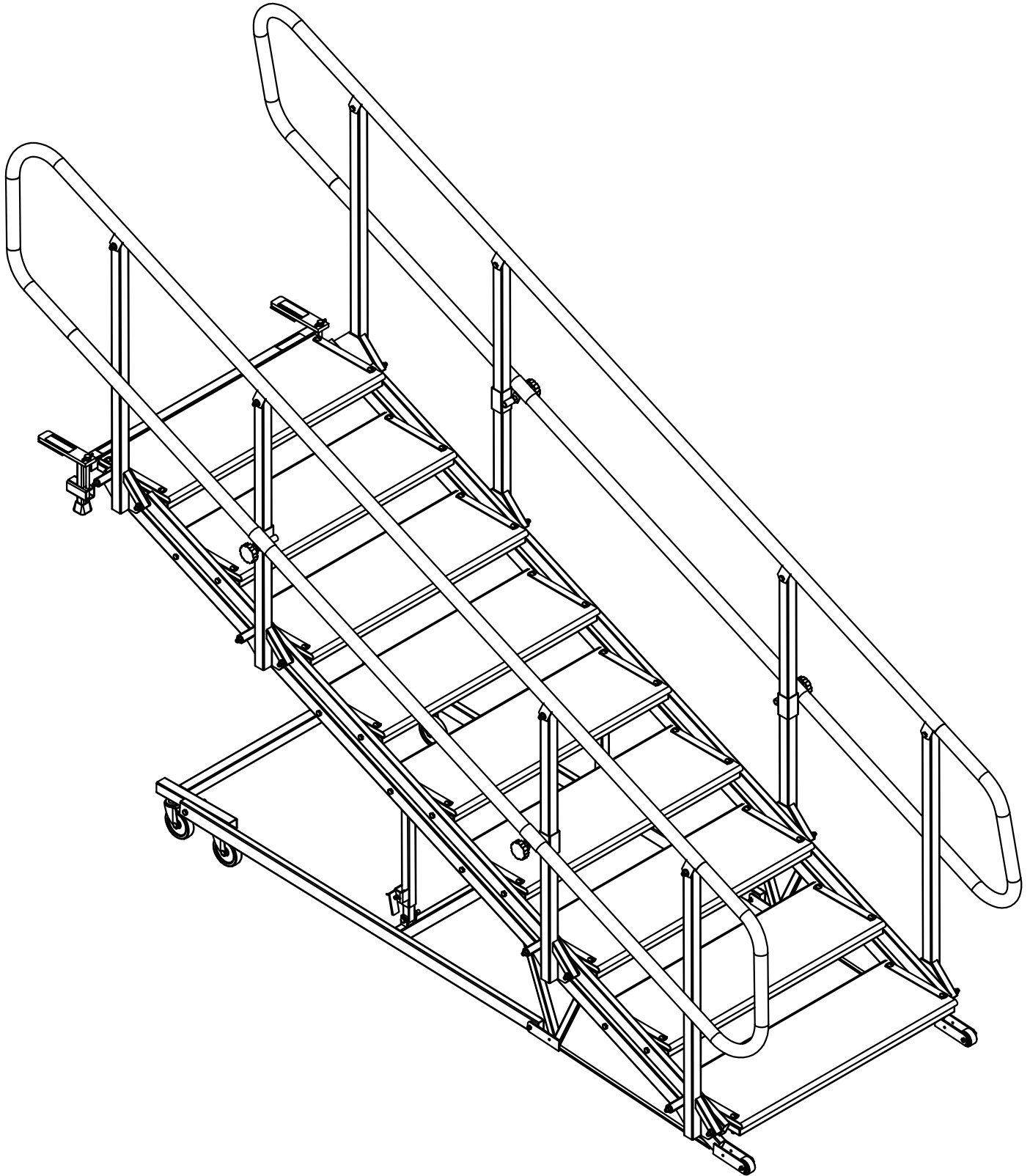


ASSEMBLY INSTRUCTIONS and PARTS LIST for SAS11LXX SERIES UNIVERSAL STEPS



SICO AMERICA INCORPORATED

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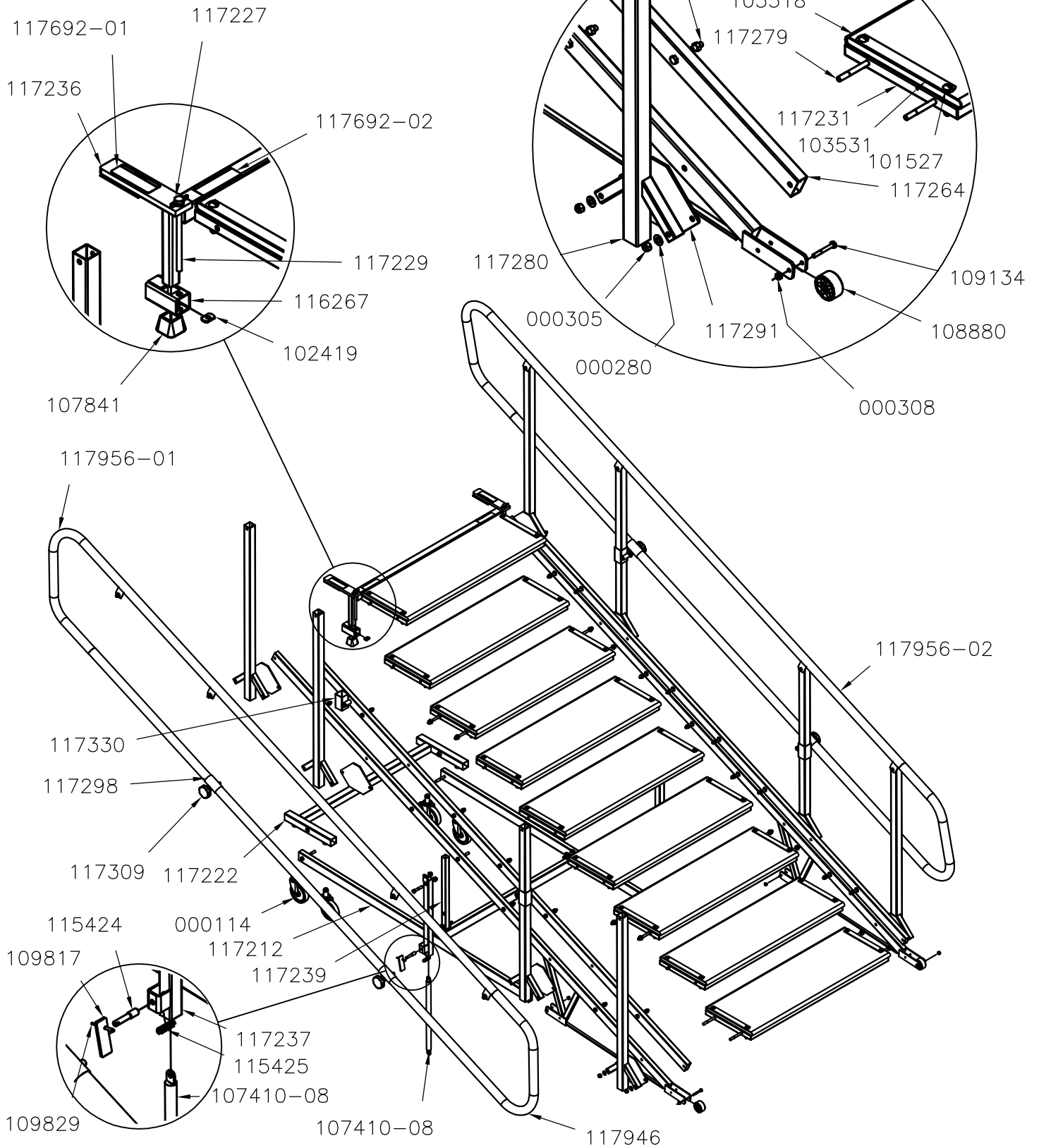
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ASSEMBLY INSTRUCTIONS

EXPLODED ASSEMBLY

000305 - 100807



ASSEMBLY INSTRUCTIONS

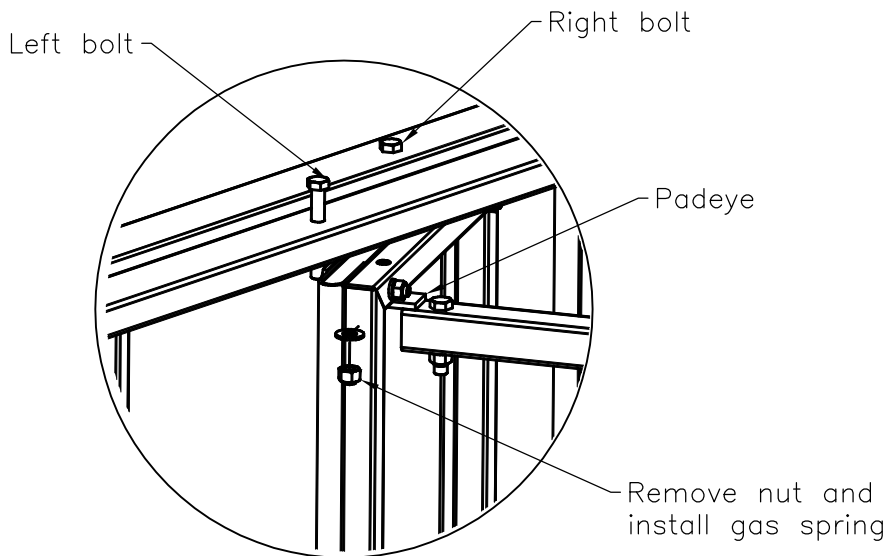
DESCRIBE PARTS BEING ASSEMBLED

PART NUMBER	DESCRIPTION	QTY	PART NUMBER	DESCRIPTION	QTY
000114	CASTER 4 SWIVEL	4	115424	LOCK PIN TRI HEIGHT	2
000245	SCR C HH .38-24x2.00	2	115425	SPRING COMPRESSION	2
000256	SCR C HH .38-24x2.5	10	116267	CLAMP TUBE	2
000280	WASHER 3/8 SAE	66	117212	WLD LIFT FRAME 9	1
000305	NUT STOP .38-24	50	117222	WLD CASTER BEAM	1
000308	NUT STOP .25-20	4	117227	.38 THUMB SCREW HEAD	2
000317	NUT .31-18	36	117229	SCR C SH .38-16x6.00	2
000477	WASHER L SPRING .31	36	117231	WLD STEP FRAME	8
000733	2 IN SAFETY WALK 3" LG	2	117236	WLD TOP STEP	1
000733-02	1 IN SAFETY WALK 1.3" LG	2	117237	WLD OUTER GUARD	2
100807	SCR C HH .38-24x2.75	20	117239	INSIDE TUBE	2
101527	SCR M TH .31-18x2.5	36	117247	WLD LOW STRINGER 9	2
102419	NUT WELD .38-16	5	117264	TOP STRINGER 9	2
103518	CARPETED/VINYL STEPBOARD	9	117279	SCR C HH .38-24x4.00	16
103531	STEP BAR	18	117280	WLD RAIL VERTICAL	8
107410-08	GAS SPRING	2	117284	CONNECTOR PAD	3
107841	GLIDE 1" SQUARE	2	117288	WLD RAIL CONNECTOR	3
108880	2" WHEEL PLAIN STEEL	2	117291	RAIL VERTICAL SPACER	8
109134	SCR C HH .25-20 x 2.00	4	117298	WLD CUT SLEEVE	4
109817	HANDLE LOCK	2	117309	KNOB HAND STEP	4
109829	RIVET BLIND 0.19x0.75	2	117330	WLD NUT SLEEVE	4
111237	SCR C HH .38-24x3.25	2	117692-01	LABEL UPPER CLAMP	2
112822	SERIAL PLATE STAGE	1	117692-02	LABEL UPPER CLAMP	2
114144	SCR C SH .38-16x.75	6	117946	9 STEP RAIL	2
			117956-01	WLD 9 STEP RAIL LH	1
			117956-02	WLD 9 STEP RAIL RH	1

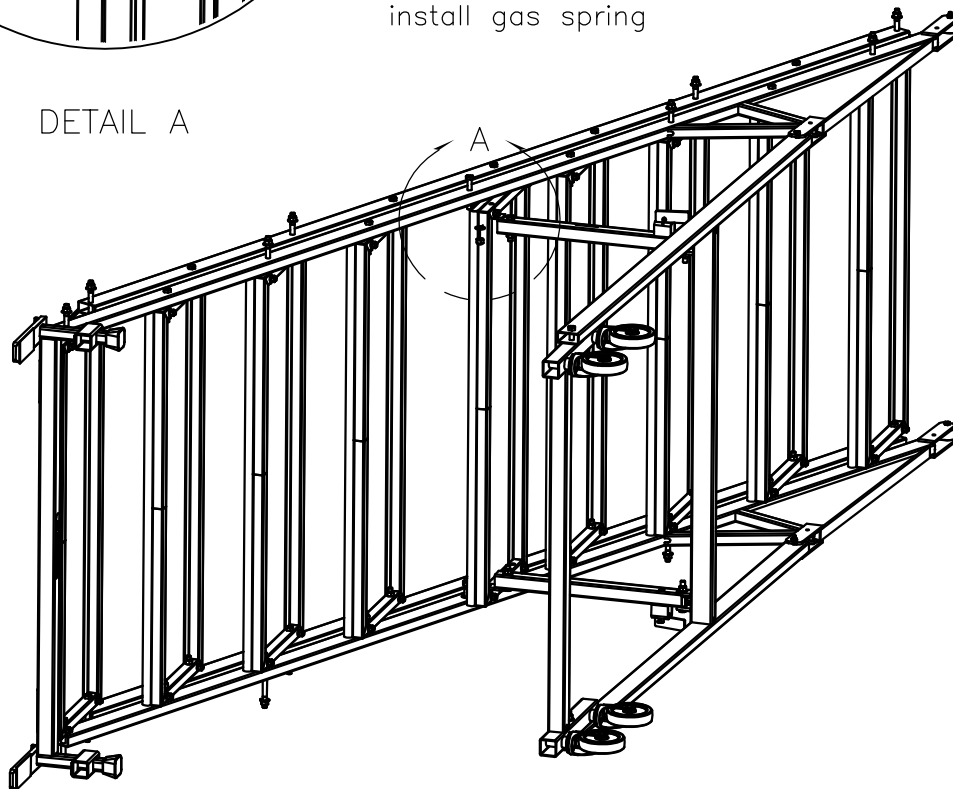
ASSEMBLY INSTRUCTIONS

ATTACHING GAS SPRINGS

1. This is easiest to do with the step lying on its side.
2. Remove the nut from left bolt on the inside of the step frame on the fifth step as shown in Detail A
3. Insert the bolt through the padeye at the free end of the gas spring
4. Replace the nut and tighten.
5. After tightening, the bolt should still turn smoothly in it's hole. If the bolt is over tightened, the step will not rise and lower easily.
6. Repeat on opposite side



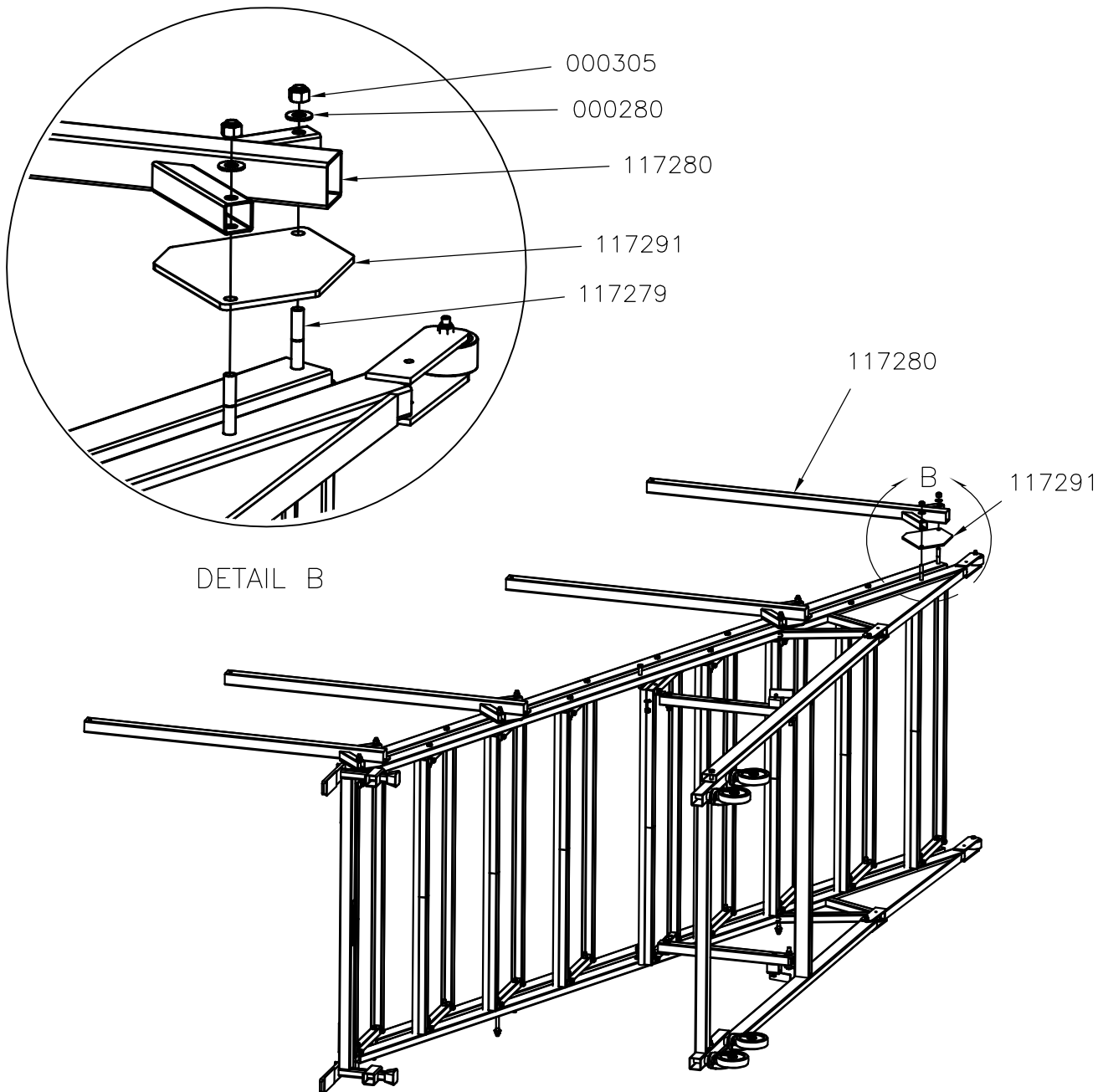
DETAIL A



ASSEMBLY INSTRUCTIONS

ATTACHING HANDRAIL VERTICALS

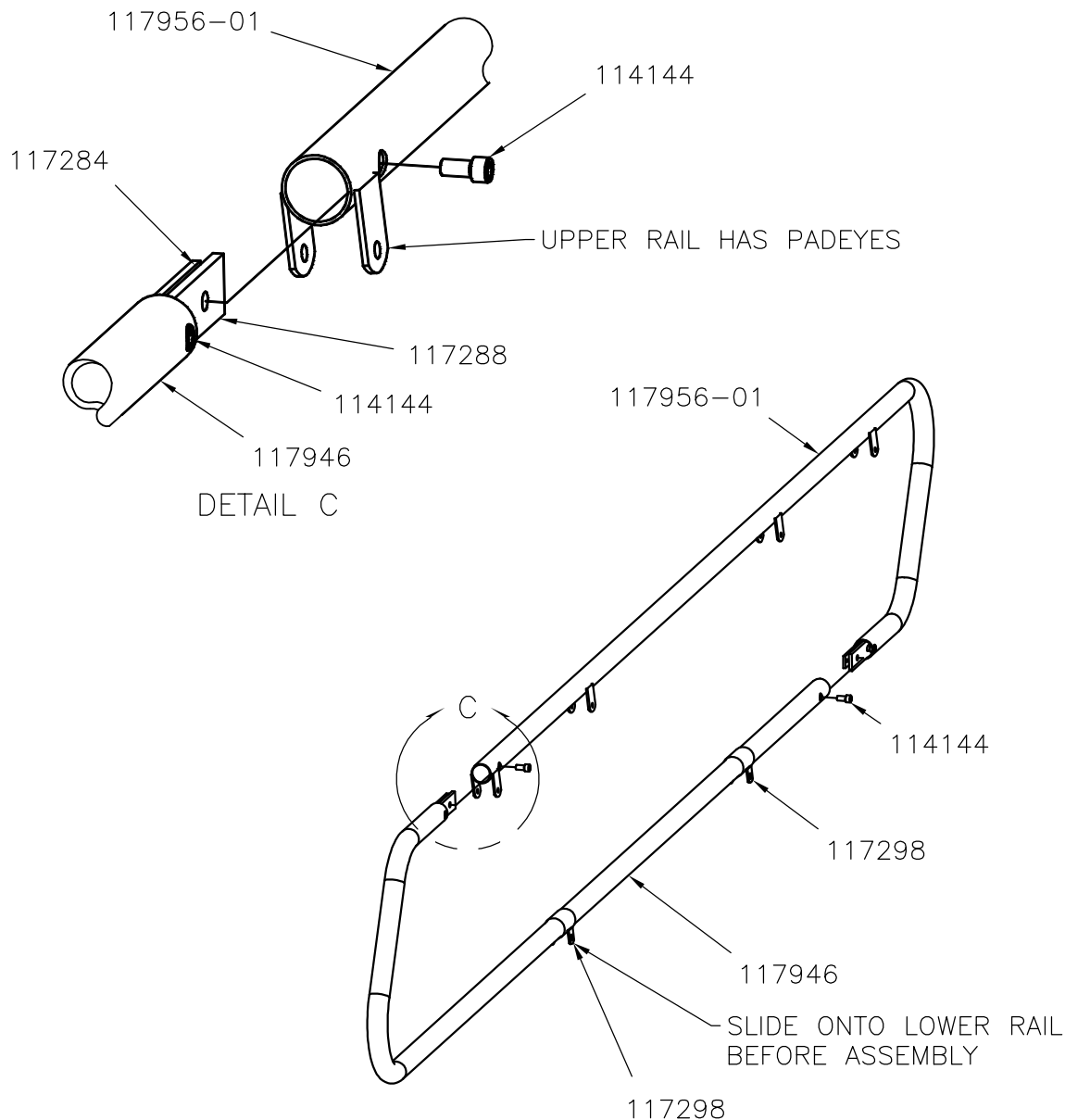
1. This may be done with the step lying on its side or on its casters.
2. Remove the nut and washer from the bottom step. Ensure that the bolts remain in position.
3. Position a plastic spacer (117291) with the textured side facing out over the bolts.
4. Position the handrail vertical (117281) over the exposed bolts.
5. Replace the nut and tighten.
6. After tightening, the bolt should still turn smoothly in its hole. If the bolt is over tightened, the step will not rise and lower easily.
7. Repeat for verticals on each side of steps 1,3,7,9



ASSEMBLY INSTRUCTIONS

ASSEMBLING HANDRAIL SECTION

1. Assemble the handrails by removing the exposed hex head cap screw (114144) from each of the couplers.
2. Slide two clamping sleeves (117298) over the bottom tube
3. Slide the rails together over the exposed coupling parts.
4. Insert the cap screw into the open hole in the rail.
5. If the holes do not align, slightly loosen the installed screw and adjust the location of the coupling as needed.
6. Tighten both cap screws fully, repeat for other rail.



ASSEMBLY INSTRUCTIONS

INSTALLING HANDRAIL

1. Place the handrails on top of the verticals so that when the padeyes are in place, the lower rail is on the outside of the vertical as shown.
2. Attach each rail with four 2 1/2" bolts (000256) washers (000280) and nuts (000305). (Detail E)
3. Do not overtighten these bolts. When tightened a wrench placed on the bolt head should be able to smoothly turn the bolt. If it is too tight the step will not articulate.
3. Fasten the clamping sleeves (117298) to the vertical sleeves (117330) using the hand knobs (117309) (Detail F)

