BOCA 'U' – SERIES STAIRWAY ASSEMBLY INSTRUCTIONS
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1a) MOUNTING TOP ANGLE TO BUILDING STRUCTURE

NOTE
IF MOUNTING TO BUILDING STRUCTURE, REAR SURFACE OF ANGLE MUST BE IN A PERPENDICULAR LINE, FLUSH WITH THE OUTER EDGE OF MEZZANINE PLATFORM TO GAIN FULL ADVANTAGE OF THE TOP STAIR TREAD DEPTH. A MINIMUM OF TWO (2) FASTENERS MUST BE INSTALLED IN EACH ANGLE. IF ANGLE IS TO BE FASTENED TO THE WALL, ANCHORS MUST BE FURNISHED BY OTHERS. DO NOT TIGHTEN FASTENERS UNTIL STAIRWAY IS COMPLETELY ASSEMBLED. TO MOUNT STAIRWAY TO EQUIPTO MEZZANINE SEE MEZZANINE INSTRUCTIONS.

1b) MOUNTING TOP ANGLE TO V-GRIP UPRIGHT

1c) MOUNTING TOP ANGLE TO IRON GRIP UPRIGHT
1d) MOUNTING TOP ANGLE TO SLOTTED ANGLE

1e) MOUNTING TOP ANGLE TO GRATING

ASSEMBLE HANGER BRACKET TO GRATING PANEL
(HARDWARE AND HANGER BRACKETS NOT INCLUDED WITH STAIRWAY)

ASSEMBLE TOP ANGLE TO HANGER BRACKET
2a) Assemble Riser Panel to Top Angle

NOTE
Afte the top angles are in place, lift top end of the riser panel into position with the vertical surface of the riser panel to the inside of the top angle and the slotted top flange to the outside. Repeat this procedure with the opposite riser panel. During this assembly the bottom ends of the risers are to rest on the floor. Do not tighten bolts at this point.

- #13188 Hex Head Bolt 3/8"-16 x 3/4"
- #13191 Hex Nut 3/8"-16
- #13182 Spring Lockwasher 3/8"

(2 per top angle)

2b) Mounting Riser Panel to Floor Angle

NOTE
With the riser panel fastened to the top angle, raise lower end of the riser panel from the floor and fasten the floor angle in place. Tighten bolts securely. Stairway is to be anchored to the floor but not until stairway is completely assembled. Floor anchors are to be furnished by others.

- #13188 Hex Head Bolt 3/8"-16 x 3/4"
- #13191 Hex Nut 3/8"-16
- #13182 Spring Lockwasher 3/8"

(2 per floor angle)
3a) STAIR TREAD AND SUPPORT ANGLE ASSEMBLY

#13152 HEX HEAD BOLT
5/16" -18 X 5/8"
#13051 LOCKNUT 5/16
(2 PER ANGLE)

NOTE
TIGHTEN BOLTS SECURELY.

3b) FASTENING STAIR TREAD ASSEMBLY TO RISER

#13188 HEX BOLT

NOTE
STAIR TREAD NOT SHOWN FOR CLARITY. BOLT TREAD SUPPORT ANGLE TO HOLE 1 IN THE RISER PANEL. LEVEL TREAD SUPPORT ANGLE AND BOLT THE OTHER END OF ANGLE IN THIS POSITION. DO NOT TIGHTEN TREADS UNTIL ALL STAIR TREADS ARE IN PLACE.

#13188 HEX HEAD BOLT 3/8"-16 x 3/4"
#13191 HEX NUT 3/8" -16
#13182 SPRING LOCKWASHER 3/8"
(2 PER SUPPORT ANGLE)
SWAY BRACE ASSEMBLY

FOR U9 THROUGH U11 STAIRWAYS

BRACE

#6444 - 36" WIDE StAIRWAY
#6479 - 48" WIDE StAIRWAY
(NOT REQUIRED FOR U5–8 STAIRWAYS)

NOTE

BOLT ONE PAIR OF BRACES IN THE SECOND AND FOURTH HOLE FROM THE TOP. TIGHTEN BOLTS SECURELY.

#13153 HEX BOLT 5/16"–18 x 3/4"
#13051 LOCK NUT 5/16–18
(5 PER PAIR OF BRACES)

FULL SCALE

FOR U13 THROUGH U20 STAIRWAYS

RISER PANELS

(NOTE: REFER TO 061ASY INSTRUCTIONS FOR (2) PIECE CONSTRUCTION)

BRACE

#6444 - 36" WIDE StAIRWAY
#6479 - 48" WIDE StAIRWAY

NOTE

BOLT ONE PAIR OF BRACES IN THE SECOND AND FOURTH HOLE FROM THE TOP AND A SECOND PAIR OF BRACES IN THE SECOND AND FOURTH HOLES FROM THE BOTTOM. TIGHTEN BOLTS SECURELY.

#13153 HEX BOLT 5/16"–18 x 3/4"
#13051 LOCK NUT 5/16–18
(5 PER PAIR OF BRACES)

FULL SCALE
STAIR RAILING ASSEMBLY
RAILING POST ASSEMBLY

NOTE
INSERT POST THRU SLOT IN RISER PANEL SO THAT THE HOLES IN THE TOP OF THE POST ARE FACING TOWARD TOP OF THE STAIRWAY. BOLT POSTS TO RISER PANEL AS SHOWN DO NOT TIGHTEN THESE BOLTS UNTIL COMPLETE RAIL IS ASSEMBLED.

#13007 HEX HEAD BOLT 3/8”-16 x 2 3/4"
#13191 HEX NUT 3/8”-16
#13182 SPRING LOCKWASHER 3/8"
#13187 FLAT WASHER 3/8” (2 PER BOLT)

FULL SCALE

TOP HAND RAIL ASSEMBLY
ASSEMBLE POST BRACKET TO TOP HAND RAILS

#13127 THD. ROLLING SCREW

#15224 POST BRACKET

TOP HAND RAIL

2a) FOR U5 THRU U7 STAIRWAYS

TOP HAND RAIL

NOTE
INSTALL BRACKET SO IT POINTS TOWARD TOP END OF RAIL. TIGHTEN BOLTS SECURELY.

#13127 #8-32 X 7/16 PH. PAN HEAD THRD ROLLING SCREW (2 PER ASSEMBLY)

FULL SCALE
NOTE

BE SURE ALL POST BRACKETS ARE FASTENED SECURELY TO TOP RAIL. LOWER TOP RAIL OVER TOPS OF POSTS WITH BRACKETS INSIDE. FASTEN IN PLACE SECURELY.
2b) FOR U8 THROUGH U11 STAIRWAYS

TOP HAND RAIL ASSEMBLY TO VERTICAL POST

NOTE
ASSEMBLE POST BRACKET TO TOP HAND RAIL IN THE SAME WAY AS SHOWN AT STEP 2a. MAKE SURE ALL BRACKETS ARE TIGHTENED SECURELY TO TOP HAND RAIL AND FASTEN THE RAIL TO POSTS AS SHOWN.
SLEEVE ASSEMBLY INTO TOP HAND RAIL

NOTE

INSERT SLEEVE INTO BOTTOM END OF TOP HAND RAIL AS SHOWN. ALIGN THE UPPER SET OF HOLES IN THE SLEEVE WITH THE HOLES IN THE HAND RAIL. FASTEN IN PLACE AND TIGHTEN SECURELY.

#13143 PH. PAN HD SHEET METAL SCREW
#10–24 X 1/2" (4 PER SLEEVE)

BOTTOM HAND RAIL ASSEMBLY TO VERTICAL POST

NOTE

ASSEMBLE POST BRACKET TO BOTTOM HAND RAIL. TIGHTEN THE BRACKET SECURELY. TELESCOPE THE END OF THE BOTTOM RAIL OVER THE SLEEVE EXTENDING FROM TOP HAND RAIL AND AT THE SAME TIME PLACE BOTTOM HAND RAIL POST BRACKET INSIDE POST. TIGHTEN ALL SCREWS SECURELY.

#13127 #8–32 X 7/16 PH. PAN HEAD THRHD ROLLING SCREW (2 PER ASSEMBLY)

FULL SCALE

#15420R RAILING POST
FOR U13 THROUGH U20 STAIRWAYS

HAND RAIL ASSEMBLY TO VERTICAL POST

NOTE

ASSEMBLE POST BRACKETS TO TOP HAND RAIL AND ASSEMBLE TOP HAND RAIL TO POSTS AS SHOWN AT STEP 2b. ASSEMBLE SLEEVE INTO BOTTOM END OF TOP HAND RAIL AS SHOWN AT STEP 2b. ASSEMBLE POST BRACKET TO MIDDLE RAIL AS SHOWN AT STEP 2b. TELESCOPE THE END OF THE MIDDLE RAIL OVER THE SLEEVE EXTENDING FROM TOP END RAIL AND AT THE SAME TIME PLACE MIDDLE RAIL POST BRACKET INSIDE THE POST. TIGHTEN ALL SCREWS SECURELY.

#13143 PH. PAN HD
SHEET METAL SCREW
#10-24 X 1/2”
(4 PER SLEEVE)

#13127 #8-32 X 7/16 PH. PAN HEAD THIRD ROLLING SCREW
(2 PER ASSEMBLY)

NOTE

U17 AND U20 STAIRWAY HAND RAILS WILL HAVE 2 MIDDLE SECTIONS
ASSEMBLE BOTTOM HAND RAIL TO VERTICAL POST

NOTE

ASSEMBLE POST BRACKET TO BOTTOM HAND RAIL. TIGHTEN BRACKET SECURELY. ASSEMBLE SLEEVE INTO BOTTOM END OF MIDDLE RAIL AS SHOWN AT STEP 2b. TELESCOPE THE END OF BOTTOM HAND RAIL OVER THE SLEEVE EXTENDING FROM MIDDLE RAIL AND AT THE SAME TIME PLACE BOTTOM HAND RAIL POST BRACKET INSIDE POST. TIGHTEN ALL SCREWS SECURELY.

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#15401T SLEEVE
10" LONG

TOP HAND RAIL

MIDDLE HAND RAIL

#13143 SCREW

BOTTOM HAND RAIL

#15420R RAILING POST

#13143 PH. PAN HD SHEET METAL SCREW
#10–24 X 1/2"
(4 PER SLEEVE)

#13127 8–32 X 7/16 PH. PAN HEAD THRD ROLLING SCREW
(2 PER ASSEMBLY)
NOTE

INSERT ALL BOLTS WITH THE HEAD TOWARD INSIDE STAIRWAY. TIGHTEN ALL BOLTS SECURELY. POST QUANTITIES WILL VARY DEPENDING ON THE STYLE OF STAIRWAY CHOSEN.

NOTE

SEE CHARTS ON PAGE 18–20 FOR TOP AND BOTTOM RAILING LENGTHS AND SEQUENCE OF ASSEMBLY

#15417L COLLAR LEFT HAND

#15417R COLLAR RIGHT HAND

#15475 END RAIL (MIRROR OF TOP)

#911574H SCREW

#15475 END RAIL

#13051 LOCK NUT

#911574H TRUSS HD MACH SCREW
5/16" – 18 X 2 1/2"

#13051 TWIN WHIZZ LOCKNUT
5/16" – 18

(3 PER PAIR OF COLLARS)
INSERT THE SLEEVES INTO THE RAIL ENDS AND SECURE WITH 13143 PAN HEAD SCREWS. SLIDE THE EXTENSIONS ONTO THE SLEEVES AND SECURE WITH 13143 SCREWS.
INSTALL RAILING PLUGS IN BOTH ENDS OF THE LOWER INTERMEDIATE RAIL.
INSTALL POST PLUGS IN VISIBLE BOTTOM ENDS OF THE RAILING POSTS. FIELD CUT THE SLOT COVER AND INSTALL IN THE TOP HAND RAIL ONLY. SLOT COVERS FOR THE EXTENSIONS ARE FACTORY PRE-CUT.
### U5 - U7 Railing Chart

<table>
<thead>
<tr>
<th>STAIRWAY</th>
<th>TOP RAIL</th>
<th>LENGTH</th>
<th>INTER. RAIL</th>
<th>LENGTH</th>
</tr>
</thead>
<tbody>
<tr>
<td>U5</td>
<td>15473UR</td>
<td>64-7/16&quot;</td>
<td>15460UR</td>
<td>45-1/32&quot;</td>
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<tr>
<td>U6</td>
<td>15474UR</td>
<td>77-15/32&quot;</td>
<td>15429UR</td>
<td>58-1/16&quot;</td>
</tr>
<tr>
<td>U7</td>
<td>15470UR</td>
<td>90-1/2&quot;</td>
<td>15459UR</td>
<td>71-3/32&quot;</td>
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</table>

### U8 - U11 Railing Chart

<table>
<thead>
<tr>
<th>STAIRWAY</th>
<th>'A'</th>
<th>LENGTH</th>
<th>'B'</th>
<th>LENGTH</th>
<th>'C'</th>
<th>LENGTH</th>
<th>'D'</th>
<th>LENGTH</th>
</tr>
</thead>
<tbody>
<tr>
<td>U8</td>
<td>15471UR</td>
<td>49-31/32&quot;</td>
<td>15471LR</td>
<td>53-9/16&quot;</td>
<td>15471UL</td>
<td>32&quot;</td>
<td>15472UL</td>
<td>48-23/32&quot;</td>
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<tr>
<td>U9</td>
<td>15457UR</td>
<td>63&quot;</td>
<td>15471LR</td>
<td>53-9/16&quot;</td>
<td>15460UR</td>
<td>45-1/32&quot;</td>
<td>15472UL</td>
<td>48-23/32&quot;</td>
</tr>
<tr>
<td>U11</td>
<td>15468UR</td>
<td>76-1/32&quot;</td>
<td>15457LR</td>
<td>66-19/32&quot;</td>
<td>15429UR</td>
<td>58-1/16&quot;</td>
<td>15460UR</td>
<td>61-3/4&quot;</td>
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</table>
## U13 - U15 Railing Chart

### Table

<table>
<thead>
<tr>
<th>Stairway</th>
<th>'A'</th>
<th>Length</th>
<th>'B'</th>
<th>Length</th>
<th>'C'</th>
<th>Length</th>
</tr>
</thead>
<tbody>
<tr>
<td>U13</td>
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<td>15447MR</td>
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<td>15471LR</td>
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<tr>
<td>U15</td>
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<td>15457MR</td>
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<td>15457LR</td>
<td>66-19/32&quot;</td>
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</tbody>
</table>

### Table

<table>
<thead>
<tr>
<th>Stairway</th>
<th>'D'</th>
<th>Length</th>
<th>'E'</th>
<th>Length</th>
</tr>
</thead>
<tbody>
<tr>
<td>U13</td>
<td>15460UR</td>
<td>45-1/32&quot;</td>
<td>15472UL</td>
<td>48-23/32&quot;</td>
</tr>
<tr>
<td>U15</td>
<td>15460UR</td>
<td>45-1/32&quot;</td>
<td>15460LR</td>
<td>61-3/4&quot;</td>
</tr>
</tbody>
</table>
# U17 – U20 Railing Chart

## Dimensions

- **Top Rail 'A'**
- **Top Rail 'B'**
- **Top Rail 'C'**
- **Intermediate Rail 'D'**
- **Intermediate Rail 'E'**

## Stairway 'A' Lengths

<table>
<thead>
<tr>
<th>Stairway</th>
<th>'A'</th>
<th>'B'</th>
<th>'C'</th>
<th>'D'</th>
<th>'E'</th>
</tr>
</thead>
<tbody>
<tr>
<td>U17</td>
<td>15457UR</td>
<td>15447MR</td>
<td>15471LR</td>
<td>63&quot;</td>
<td>52–5/32&quot;</td>
</tr>
<tr>
<td>U20</td>
<td>15457UR</td>
<td>15457MR</td>
<td>15457LR</td>
<td>63&quot;</td>
<td>65–5/32&quot;</td>
</tr>
</tbody>
</table>

## Stairway 'D' Lengths

<table>
<thead>
<tr>
<th>Stairway</th>
<th>'D'</th>
<th>'E'</th>
<th>'F'</th>
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</thead>
<tbody>
<tr>
<td>U17</td>
<td>15460UR</td>
<td>15472UL</td>
<td>45–1/32&quot;</td>
</tr>
<tr>
<td>U20</td>
<td>15460UR</td>
<td>15460LR</td>
<td>61–3/4&quot;</td>
</tr>
</tbody>
</table>