INSTALLATION MANUAL

Econo Plus Spiral Stair

Illustrations are general and may not match your specific stair design.
CALIFORNIA PROPOSITION 65
RAW WOOD PRODUCT EXPOSURE

WARNING: Drilling, sawing, sanding or machining wood products can expose you to wood dust, a substance known to the State of California to cause cancer. Avoid inhaling wood dust or use a dust mask or other safeguards for personal protection. For more information go to www.P65Warnings.ca.gov/wood

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WARNING: This product can expose you to chemicals including formaldehyde, ethylbenzene, Illium dioxde, cumene, carbon black, silica and wood dust, which are known to the State of California to cause cancer, and toluene, which is known to the State of California to cause birth defects or other reproductive harm. For more information go to www.P65Warnings.ca.gov
IMPORTANT MESSAGE

On behalf of everyone at Salter Spiral Stair, we would like to thank you for your purchase of one of our products. This product is designed and manufactured in the USA. This stair comes with an Installation Manual. It is important that you read and fully understand this manual prior to installation. Following the steps exactly as specified in the manual will ease installation and reduce the amount of time necessary to complete the process. Keep this manual even after the installation process has been completed. Understand how to use tools that may be required during the installation process. Observe all safety warnings called out in this manual. Make sure those who may install this product for you understand this manual as well as you do.

Salter Spiral Stair
105 GP Clement Drive
Collegeville, PA 19426

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NOTICE !!!

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Your safety and the safety of others is involved.

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<td>A</td>
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<td>D</td>
<td>1/4&quot; Flat Washer</td>
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<td>E</td>
<td>1/4&quot; Lock Washer</td>
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<td>F</td>
<td>1/4&quot;-20 Hex Nut</td>
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<td>G</td>
<td>1/4&quot;-20 x 1-1/2&quot; Carriage Bolt</td>
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<td>1/4&quot;-20 x 3/4&quot; Carriage Bolt</td>
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<td>I</td>
<td>#10 x 3/4&quot; SQ. Drive D&amp;T</td>
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<tr>
<td>R</td>
<td>#12-1&quot; Baluster Screw</td>
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<td>S</td>
<td>1/4&quot;-20x1&quot; Tube Connector Screw</td>
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<td>T</td>
<td>Tube Connector</td>
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</table>
Center Column Assembly

1. Starting with a single threaded column section (5), screw a threaded coupler (6) into the threaded end of the column section until approximately 1" of the connector remains exposed.
2. Screw a double threaded column section (7) onto the exposed half of the threaded coupler from step 1. Tighten until there are no gaps between the column pieces.
3. Screw another threaded coupler (6) into the threaded end of the assembly.

NOTE: Additional double threaded column sections (7) may be included depending on the height of the stair being installed. Repeat steps 2 and 3 to join the additional sections.

4. Screw the final single threaded column section (5) onto the assembly. Tighten all of the sections of threaded column and ensure that there are no gaps between the column sections.
5. Cut the length of the center column assembly to approximately 10" longer than the floor to floor dimension.

⚠️ WARNING ⚠️ The column sections must be fully tightened. Failure to tighten the sections of the column together could make the stair unstable and result in serious injury or death.
Platform and Base Installation

1. While all treads and platform are on the ground, partially thread set screws (A) into each tread and platform sleeve.
2. Partially thread set screws (A) into the baseplate (1). Insert the center column assembly into the baseplate until fully seated. Attach the baseplate (1) to the center column assembly with set screws (A).
3. Determine the number of 1/8" spacers per rise using the following simple calculations:
   a. Add number of treads and platforms = ______
   b. Measure the floor to floor height in inches = ______
   c. Divide 3b by 3a = ______ (This is your riser height)
      NOTE: Riser height is usually between 8 1/2" and 9 1/2".
4. The bottom tread has a hub that measures 5.75" in height. The remaining treads have a hub that measures 8.5" in height.
5. The total number of spacers needed can be determined below.
   a. Floor to floor measurement from 3b in inches = ______
   b. Count the # of treads (not including the bottom tread) = ______
   c. Multiply 5b by 8.5 = ______
   d. Add 16.25 to 5c = ______
   e. Subtract 5d from 5a = ______
   f. Divide 5e by .125 = ______
   g. Stairs with Wood Tread Covers = Subtract 6 from 5f = _____.
      This is the total number of spacers needed for your stair.
   h. For stairs without Wood Tread Covers - Place 6 of the spacers counted out in 5f onto the center column assembly.
6. The remaining spacers from 5g or 5f must be evenly distributed in between the treads of the stair.
   a. Divide remaining number of spacers (5g or 5h) by 3a = ______
   b. The whole number is the number of spacers for each rise. ______
      EXAMPLE: If 5h is 48.5 and 3a = 12, the result is 48.5/12 = 4.0417. The whole number would be 4.
   c. Multiply 3a by 6b = ______
   d. Subtract 6c from 5g/5h = ______
      NOTE: This is the remaining number of spacers that must be added throughout the entire stair to meet the floor to floor height. Do not add all of the spacers calculated in 6d to only one rise. Add only one spacer per rise.
7. Place the number of spacers determined in 6b onto the center column assembly.
8. Place the bottom tread (18) onto the center column assembly. Measure the rise from the floor to the top surface of the tread. If your stair has wood tread covers, the measurement should be 0.75" shorter than the rise height.

Hardware
A  B  C

Parts
⑧  ⑨  ⑩

Tools
you calculated in 3b. If you do not have wood tread covers, the measurement should be equal to the rise height calculated in 3b.

9. Place the number of spacers determined in 6b onto the center column assembly.

10. Place a tread (8) over the center column assembly.

11. Measure the rise from the top surface of the bottom tread to the top surface of the next tread. The measurement should be equal to the rise height calculated in 3b.

12. Repeat steps 9-11 for the remaining treads and platform.

NOTE: Remember to add in the extra spacers calculated in 6e during the assembly process. This will make sure the top of the platform is located correctly at the end of the assembly process. This additional spacer will cause the measurement to be 1/8" larger than the riser height when included. If you have wood tread and platform covers, the top surface of the platform will be 3/4" shorter than the loft surface.

NOTE: Depending on how the platform is being mounted in your application, 3/8" holes may need to be drilled through the platform edge as needed to install the mounting lag screws. If the platform is being mounted in a corner, make sure that both edges of the platform are secured to the wall.

13. Use 3/8"x3" lag screws (C) and washers (B) to attach the platform to the mounting surface.

**WARNING**

The platform is heavy. Steps 4 through 6 require a minimum of 3 people. One to keep the column steady and 2 people hoist and hold the platform in place. A fourth person may then drill and fasten the platform.
14. Plumb center column assembly and attach base plate to floor with 3/8”x3” lag bolts (C) and washers (B). Lead anchor shields (not supplied) will be needed if installing into concrete.

![Diagram showing assembly process]

**WARNING**

The lag screws securing the base plate to the floor and the platform to the wall must be installed and fully tightened before continuing with the installation process. Failure to do so could cause the stair to be unstable and could result in serious injury or death.

15. Slide the column extension (10) down over the center column assembly and tighten set screws (A).

16. Place the column cap on the top of the column extension.
Tread and Baluster Installation

1. Start installation with the top tread. Place a main baluster (3) in the hole closest to the platform. Move the baluster up or down until the bottom of the baluster is flush with the bottom edge of the tread.

2. Attach this baluster to the tread using the carriage bolt (G), nut (F), washer (D) and lock washer (E).

NOTE: Main Balusters have two holes drilled near the bottom.

3. For stairs that are 60” in diameter, plumb the main baluster and attach to the face of the platform using the top baluster bracket, carriage bolts (H) and SQ Drive D&T screws (I), nut (F), washer (D), and lock washer (E). For stairs that are 42” in diameter, plumb the main baluster and attach to the face of the platform using carriage bolt (G), nut (F), washer (D) and lock washer (E). A ¼” diameter hole must be drilled in the platform at the location of the pre-drilled hole in the baluster.

4. Check that the tread is level and the baluster is plumb. Tighten the 5/16” set screws in the tread hub to lock the top tread to the center column.
5. Spin the next tread into position beneath the tread above. Place a main baluster through the upper tread and into the lower tread. Move up or down until the bottom of the baluster is flush with the bottom edge of the lower tread.

6. Secure the baluster to the lower tread using carriage bolt (G), nut (F), washer (D) and lock washer (E).

7. Fasten the baluster with carriage bolt (G), nut (F), washer (D) and lock washer (E).

8. Check that the tread is level and the baluster is plumb. Tighten the 5/16" set screws in the tread hub to lock the tread to the center column.

9. Repeat steps 6-9 with the remaining treads.
NOTE: The main baluster connecting the bottom tread to the floor must be cut.

1. Cut approximately 1 ½" off the bottom of the last main baluster.
2. Place the bottom baluster bracket on the ground below the first tread. Guide the baluster through the hole in the first tread and into the hole of the bottom baluster bracket.
3. Adjust the height of the lower tread to be one riser height below the tread above. Fasten the baluster with carriage bolt (G), nut (F), washer (D) and lock washer (E).
4. Check that the tread is level and the baluster is plumb. Tighten the 5/16" set screws in the tread hub to lock the tread to the center column.
5. Ensure that the baluster remained plumb, then fasten the bottom baluster bracket to the floor using wood screws (U). Masonry fasteners (not supplied) will need to be used if installing into concrete.
1. The handrail is shipped in a coil that is typically between 36” and 48” in diameter. The first step to fitting the handrail is increasing this diameter to the proper coil diameter listed below.

<table>
<thead>
<tr>
<th>Stair Diameter</th>
<th>3’-6”</th>
<th>5’-0”</th>
</tr>
</thead>
<tbody>
<tr>
<td>Coil Diameter</td>
<td>60”</td>
<td>75”</td>
</tr>
</tbody>
</table>

NOTE: The coil diameter should be larger than the stair diameter.

2. On a soft surface such as carpet, position the coil as depicted below. The cut end (1) should be approximately 4”-6” off the ground.
3. Insert a lever (2) into the cut end. A wooden handle (such as a broom handle) makes a suitable lever.
4. Hold the coil in place on the side opposite the cut end. Push the lever down until the coil bends slightly. It may be necessary to brace the coil where it contacts the ground to prevent it from slipping during this process.

5. Rotate the handrail counterclockwise (clockwise for left hand up) approximately 20 degrees.
6. Hold the coil in place on the side opposite the cut end. Push the lever down until the coil bends slightly. It may be necessary to brace the coil where it contacts the ground to prevent it from slipping while forming.
7. Repeat steps 5 and 6 until the cut end is vertical. It should now be long enough to form by hand.
8. Hold the coil in place and pull the unsecured side outward and away from the center of the coil until the coil bends slightly. It may be necessary to brace the coil where it contacts the ground to prevent it from slipping while forming.

9. Continue rotating the coil and forming until the whole coil has been worked through. Measure the coil diameter to determine if more adjustment is needed. If so, repeat the forming process from the beginning.

IMPORTANT: Do not try to bend the handrail into shape on the first pass through the coil. For best results, make small adjustments and repeat the process as needed.
10. Lay the handrail down and find the cut end that contacts the ground. Use the method below to determine the orientation of the handrail.

**LEFT HAND UP**

**RIGHT HAND UP**

NOTE: If the handrail orientation matches the orientation of the stairs being installed, skip to the next step.

11. Stand the handrail up. Push a cut end towards the center of the coil enough to clear the adjacent rail. Pull this cut end through the coil to the other side. The other cut end must be pulled away from the center of the coil and pushed over the adjacent rail.
Pulling the Handrail into a Spiral

1. Determine the end to end length needed based on the diameter of the stair being installed.

<table>
<thead>
<tr>
<th>Stair Diameter</th>
<th>3'-6&quot;</th>
<th>5'-0&quot;</th>
</tr>
</thead>
<tbody>
<tr>
<td>End to End Length</td>
<td>14'</td>
<td>11'</td>
</tr>
</tbody>
</table>

2. With the help of another person, pull the handrail apart to the desired end to end length. Stop periodically to inspect the handrail for any kinks that may be forming.
1. Once the Handrail has been shaped, dry fit the rail to the baluster tips.

   NOTE: The handrail may be slightly kinked on both ends. This is normal and the handrail should be positioned so that these ends can be cut off after installation.

2. Working together with another person, start at the top of the stair and install each screw (R) through the hole in the tip of each main baluster. Push or pull the handrail as needed to match it up with the baluster tip.

   NOTE: To assist in installation, it may be beneficial to use zip ties to hold the handrail onto the baluster tips during the installation process.

   NOTE: If the handrail does not sit flush on the baluster tips, the baluster tips can be bent up or down as needed with an adjustable wrench to better match the angle of the handrail. Place a rag between the wrench and the baluster tip to prevent damage to the finish of the baluster tip.

3. Once the handrail has been attached to all of the main balusters, cut the railing 3" above the top baluster and 3" below the bottom baluster. If your local building code requires a longer length, cut the handrail to meet the code.

4. Use the supplied two-part epoxy to bond the endcaps (13) to the handrail.
Center Baluster Installation

1. Measure each center baluster (4) from tip (at the handrail) to the top of the corresponding tread.

   NOTE: Do not cut all the balusters the same length. Measure each baluster position individually.

2. Using a saw, cut each baluster to the correct length.
3. Insert bolt (S) through the tread and into hex nut (F). Do not fully tighten the hex nut.

4. Thread a tube connector (T) onto the exposed threads of the bolt until it is seated against the hex nut. Make sure the flanges on the tube connector are facing down towards the tread surface. Unscrew the tube connector one revolution to create a gap between the nut and the tube connector.

5. Ensure that the baluster tip is in line with the handrail, then slide the center baluster onto the tube connector.

6. Install screw (R) through the hole in the tip of each center baluster.

7. Tighten the screw that was installed in step 3. This will pull the baluster against the tread and complete the connection.

8. Repeat steps 1-7 for each center baluster.
Platform Rail Installation

1. Place the platform rail onto the platform in the correct location. The platform rail will be approximately 1/4" away from the column and 1/4" away from the end of the platform.
2. Using the holes on the bottom of the platform rail as a template, mark the location of the holes on the top and side surface of the platform.
3. Drill a 1/4" diameter hole in each location.
4. Using bolt (G), nut (F), washer (D) and split washer (E), secure the platform rail to the side of the platform.
5. Using bolt (H), nut (F), washer (D) and split washer (E), secure the platform rail to the top of the platform.

6. If your stair has an extra platform rail, follow steps 1-5 to install the extra platform.

NOTE: The platform rail will be approximately 2" shorter than the extra platform rail. Be sure to install the platform rail first and then the extra platform rail.

**WARNING**

The platform rail(s) must be installed on the platform of the stair. Failure to install the platform rail(s) could result in serious injury or death.
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### Parts & Hardware

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<td>Tread Cover</td>
<td>Platform Cover</td>
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<th>Description</th>
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<td>A</td>
<td>#10-12-3/4 Wood Screw</td>
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WOOD HANDLING AND FINISHING

READ BEFORE STARTING INSTALLATION

WOOD HANDLING

UNFINISHED TREADS AND HANDRAILS ON THE JOB SITE WILL ABSORB MOISTURE FROM THE AIR. THESE MUST BE SEALED WITHIN 1 WEEK TO AVOID ADVERSE AFFECTS ON THE WOOD.

NEARBY PLASTERING, TILE WORK, CEMENT OR BRICKWORK INTRODUCE ENOUGH WATER IN THE IMMEDIATE ENVIRONMENT FOR THE WOOD TO BE AFFECTED.

IF NEEDED, STORE THE WOOD PROVIDED IN A COOL, DRY AND STRUCTURALLY STABLE LOCATION.

WOOD FINISHING

A. SAND ALL WOOD SURFACES BEFORE APPLYING ANY STAIN OR POLYURETHANE. NEARLY ALL PROBLEMS WITH FINISHING OCCUR DUE TO IMPROPER SANDING PRIOR TO STAIN OR POLYURETHANE APPLICATION. TREADS MAY RUB TOGETHER, OR AGAINST OTHER SURFACES DURING HANDLING AND TRANSPORTATION. THIS MAY CREATE "SHINY SPOTS" WHICH PREVENT AN EVEN FINISH. TAKE PRECAUTIONS WHEN TRANSPORTING TREADS.

B. SAND ALL WOOD SURFACES WITH 100 TO 220 GRIT RATING.

C. APPLY A STAIN IF ANY COLOR OTHER THAN THE NATURAL FINISH IS DESIRED.

D. THREE COATS OF SEALER MUST BE APPLIED TO ALL WOOD SURFACES. INADEUATE FINISHING OF ALL SIX SIDES OF A TREAD (WHICH INCLUDES THE BOTTOM) WILL ALLOW MOISTURE TO BE ABSORBED.

E. CHECK WITH YOUR PAINT SPECIALTY DEALER FOR FURTHER INSTRUCTIONS IF NEEDED.
Wood Tread Cover Installation

17. The treads are not pre-drilled to accept the tread covers (1).
18. Drill four ¼” holes in the steel tread top in the approximate location shown below. Do not drill the holes too close to the edge of the tread top. If the holes are too close to the edge of the tread, the wood tread cover could split when installing the screws.

19. Locate the wood tread cover on top of the tread and center it so the reveal is the same on the front and back of the tread.
20. Install the pan head wood screw (A) through the holes drilled in step 2 and into the wood tread cover.
21. Repeat this step for each tread until all the tread covers have been installed.
Wood Platform Cover Installation

1. The platform is not pre-drilled to accept the platform cover (2).
2. Drill four ¼" holes in the steel platform top in the approximate location shown below. Do not drill the holes too close to the edge of the tread top. If the holes are too close to the edge of the platform, the wood platform cover could split when installing the screws.

3. Locate the wood platform cover on top of the platform.
4. Install the pan head wood screws (A) through the holes drilled in step 2 and into the wood platform cover.