

# Royal Victorian Greenhouse

VI23,34,36,46



Version 2020\_2  
04.17.20

## MOUNTING INSTRUCTIONS

*Note: This is an all-inclusive manual. It shows optional accessories and customizations that may not apply to your greenhouse. Direct any questions to Exaco.*



**[www.exaco.com](http://www.exaco.com)**  
**877-760-8500**

***Please watch our animated assembly  
video on our Exaco Tracing Co  
YouTube Channel.  
Find the link at [www.exaco.com](http://www.exaco.com)***

---

# PRODUCT INFORMATION

Dear customer,

Thank you for buying a Janssens high-quality aluminium greenhouse.

## REMARKS

In this manual, you will find the assembly instructions for all basic/standard-model greenhouses. However, this manual also contains page which apply to optional accessories that may not be included with your kit. *This greenhouse is designed for cultivation of plants/flowers. Therefore leakage, water drops and condensation inside the building are allowed.* The building may only be entered by competent persons during cultivation or maintenance. Aluminium profiles that are not painted may show black stains, these stains are not a production error: they can be easily removed with a aluminium cleaner available at a home improvement store. The rubber strips have been treated with oil/silicone on the interior to facilitate the assembly. The building should be mounted on a solid concrete foundation deep enough to get a solid and frost-free ground. Anchoring of the foundation should be made by the owner or operator and should be checked periodically. During winter, the roof will need to be cleared of snow or supported in a suitable way. The greenhouse should be built in a location protected from strong winds. Protective gear (such as protective gloves) should be used during assembly in order to avoid injuries. One should at all times pay attention to the local building regulations.

## ASSEMBLY ORDER

The assembly procedure is the same for all our greenhouses.

- Sorting of the profiles/extrusions according to the model/size of greenhouse. The aluminum profiles (extrusions) are identified by their cross-section and length.
- Assembly of the complete aluminium framework.
- Leveling of the construction using a level
- Anchoring/securing of the greenhouse to the ground
- Glazing installation

## REQUIRED TOOLS

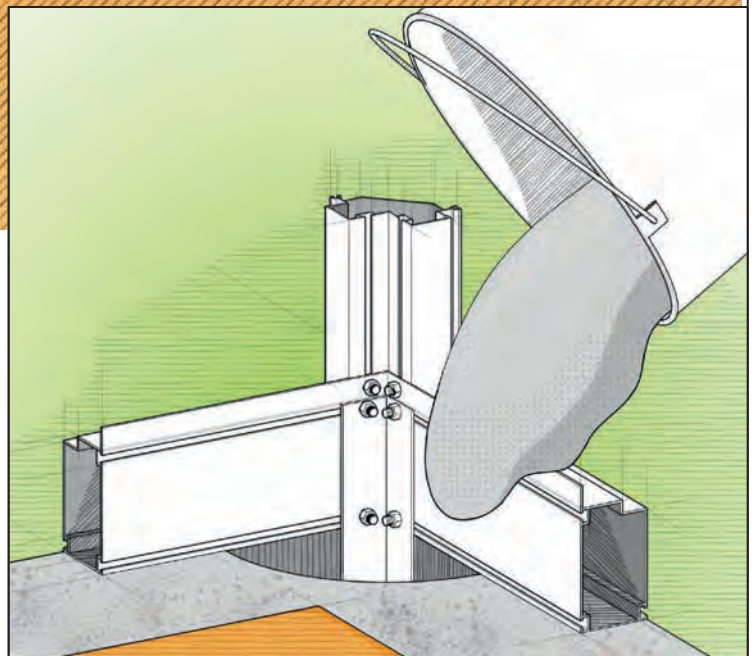
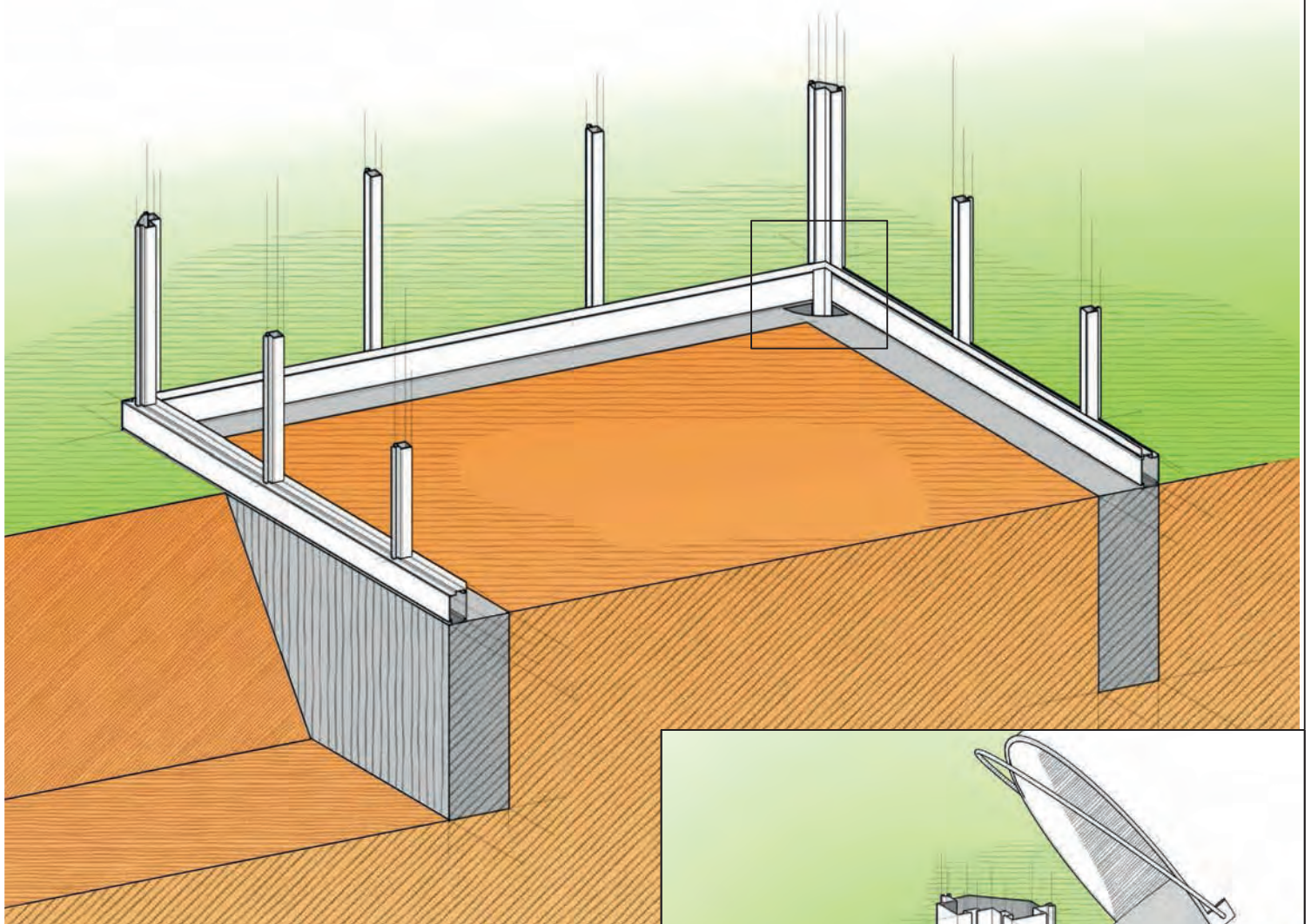
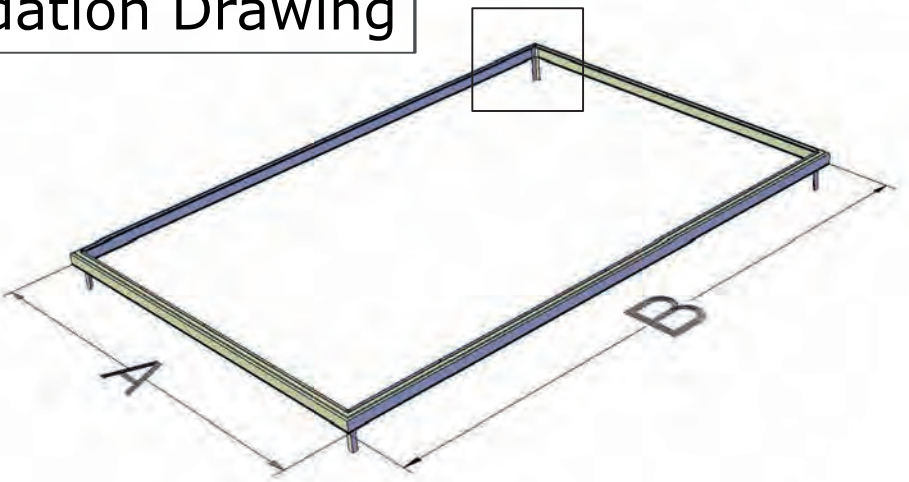
- Metric or Combination Measuring Tape (highly recommended)
- Socket wrench or spanner 10mm
- Level
- Screwdriver
- Drill + drill bit 4.2 mm
- Scissors (to cut the rubber).

We reserve the right to change the construction without prior notice!

**Questions? Need Assembly Support?**  
**Please call Exaco at 877-760-8500, ext. 701 or email**  
**customerservice@exaco.com.**

# Royal Victorian Foundation Drawing

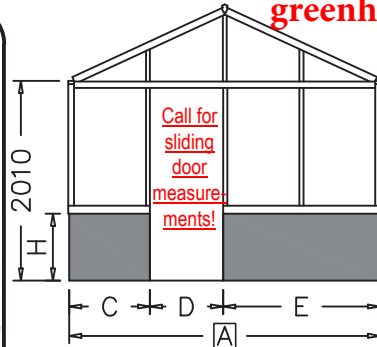
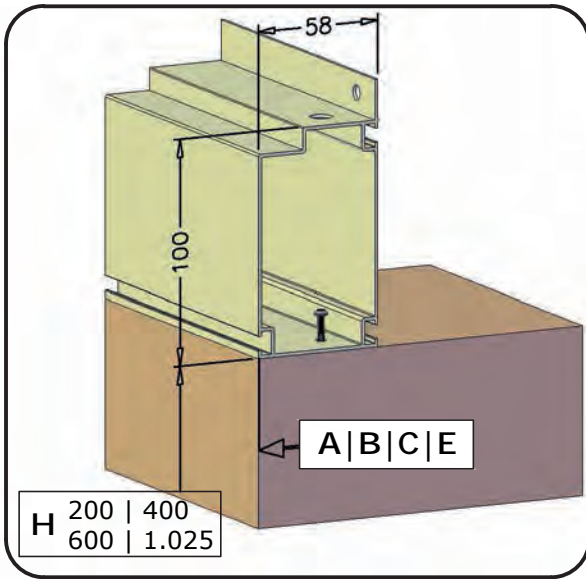
	A	X	B
VI23	2360mm/93"	VI23	3098mm/122"
VI34	3098mm/122"	VI34	4574mm/180"
VI36	3098mm/122"	VI36	6050mm/ 238.2"
VI46	3836mm/151"	VI46	6050mm/ 238.2"



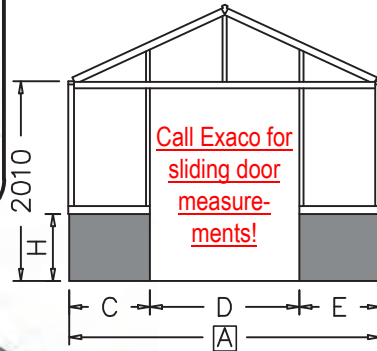
**Note: Do not set concrete in the corners until the entire greenhouse frame is complete, level and square. You may need some play to install the uprights.**

# VI 34,36,46 with Stem Wall

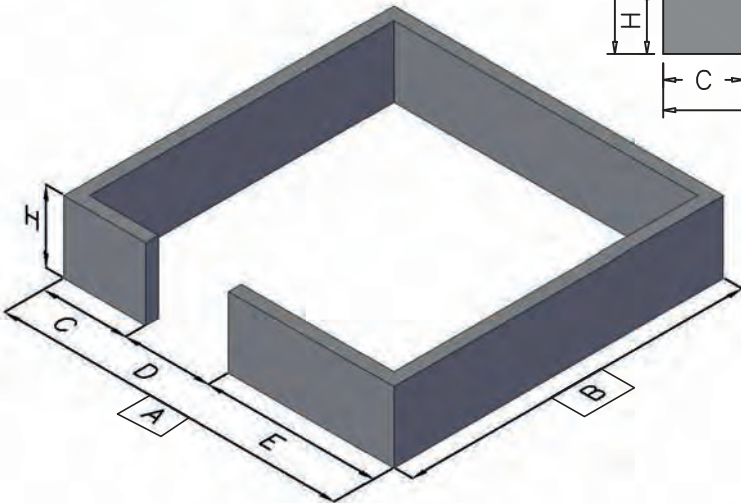
**This page only applies when you have a door extension kit and are placing your greenhouse on a wall. (2020 HDD)**



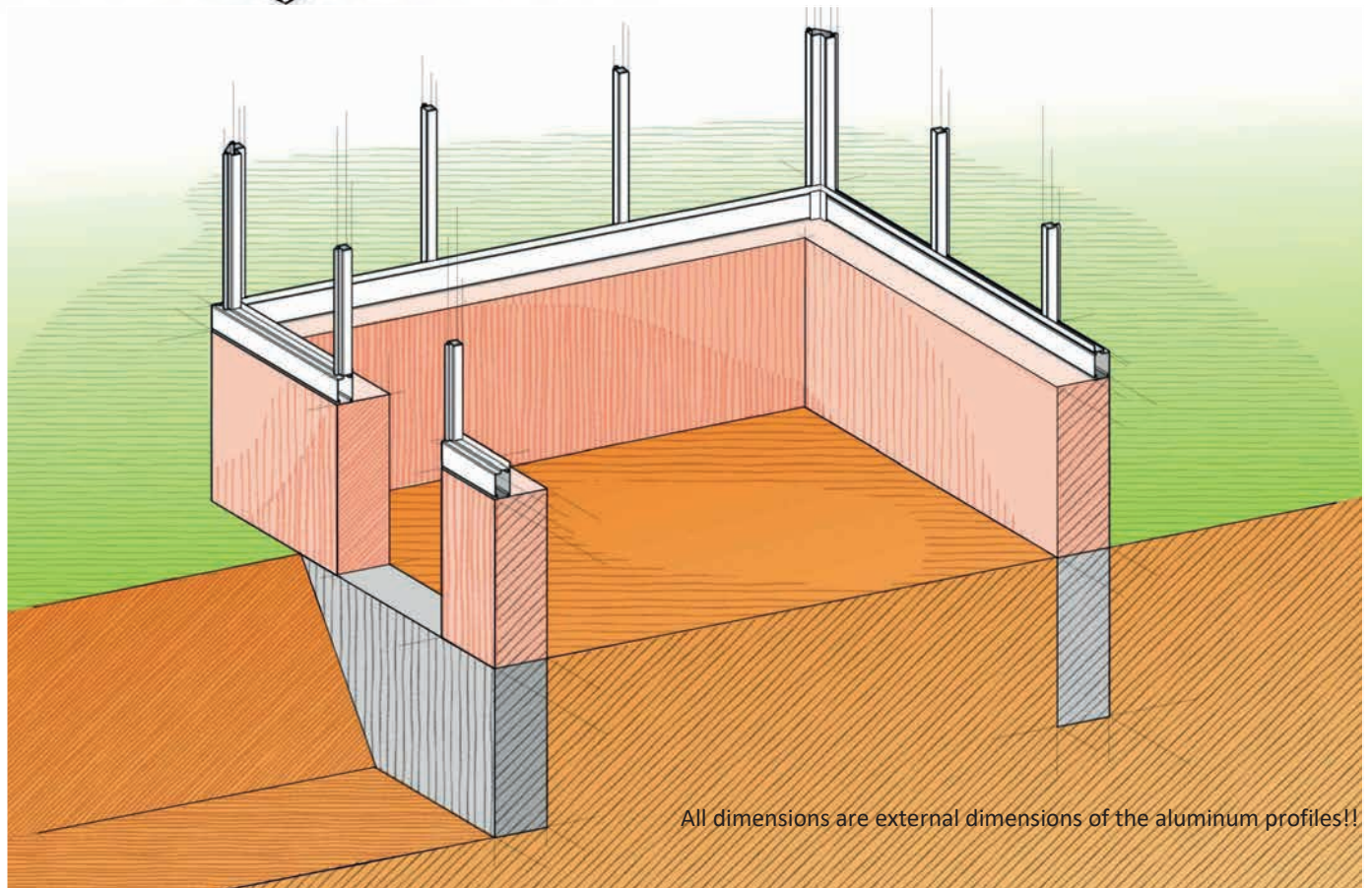
<b>A</b>	= 3.098   3.836
<b>B</b>	= 2.360   3.098   3.836 4.574   5.312   6.050
<b>C</b>	= 829   1.567   2.305
<b>D</b>	= 703 <u>hinged door ONLY!</u>
<b>E</b>	= 829   1.567   2.305
<b>!!! A = C + D + E !!!</b>	



<b>A</b>	= 3.098   3.836
<b>B</b>	= 2.360   3.098   3.836 4.574   5.312   6.050
<b>C</b>	= 829   1.567   2.305
<b>D</b>	= 1.441 <u>hinged door ONLY!</u>
<b>E</b>	= 829   1.567   2.305
<b>!!! A = C + D + E !!!</b>	

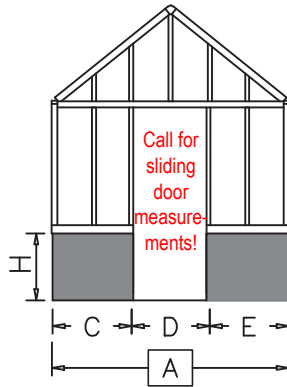
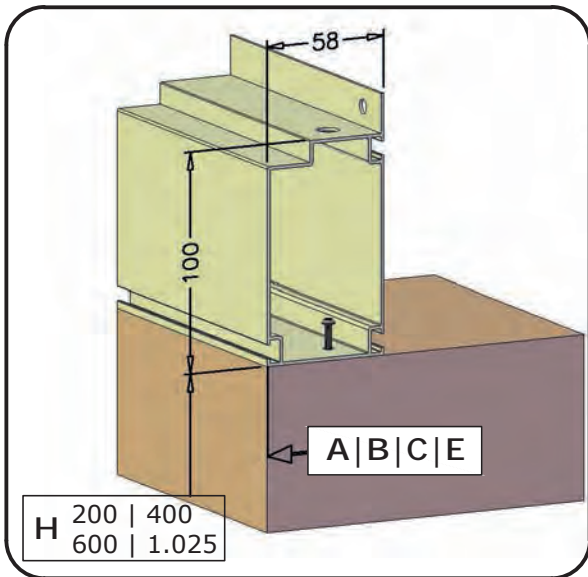


*Divide millimeters by 25.4 to get inches, or use Google.*  
**Please note - Customizable: Door/s can be placed on any side in any bay/s, so your A measurement could be your gable end OR your long wall. Use the above measurements in conjunction with the measurements from the previous page.**



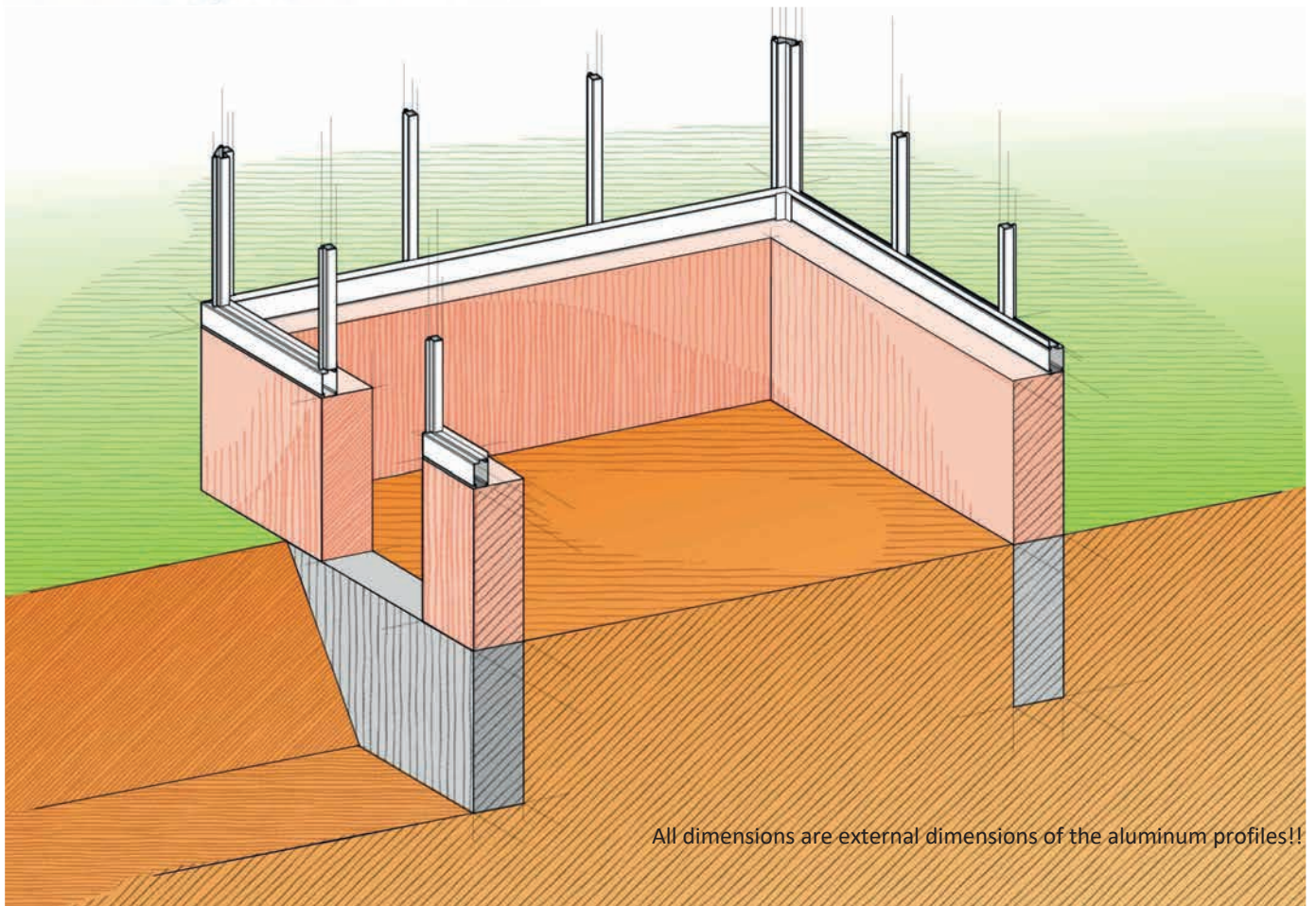
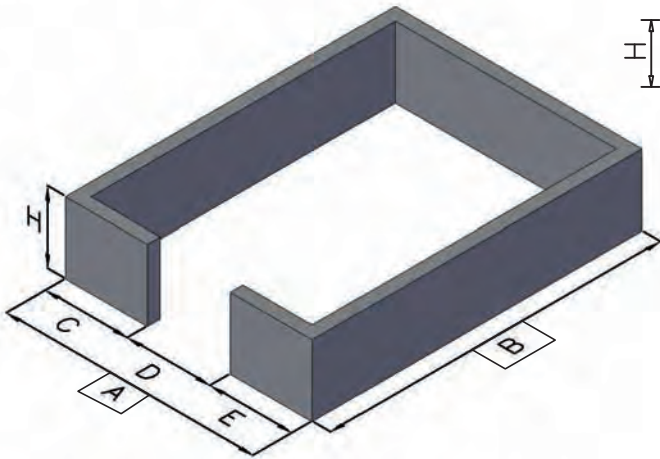
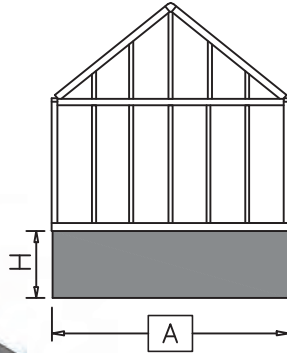
All dimensions are external dimensions of the aluminum profiles!!

# VI 23 on Stem Wall- One door on Gable (shown with narrow panes)



- A** = 2.360
- B** = 2.360 | 3.098 | 3.836  
4.574 | 5.312 | 6.050
- C** = 829
- D** = 703 hinged door ONLY!
- E** = 829

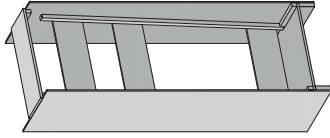
!!! **A** = C + D + E !!!



All dimensions are external dimensions of the aluminum profiles!!

## PALLET

WEIGHT:	MASTER
M23	384 kg
M24	485 kg
M34	567 kg
M36	676 kg
DIMENSIONS:	
800 x 900 x 2300 mm	

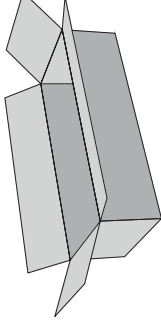















## PACKING LIST Royal Victorian ("HELIOS MASTER")

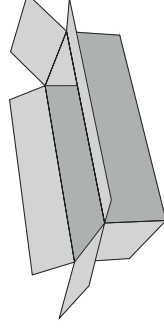
Identify Parts by extrusion shape (cross-section) and length. If you don't have one yet, we highly recommend a metric or combination tape measure!

## COLLI A (HELIOS)

WEIGHT:	19 kg
M23/M24	25 kg
M34/M36	
DIMENSIONS:	
250 x 150 x 3200 mm M23/M24	
4700 mm M34/M36	

















ITEM	M23 / M24	M34 / M36
 PRO6120 foundation profile	2360 mm 2 pc	3098 mm 2 pc
 B19_1030 round tube Ø19		1030 mm 2 pc
 L40X40GATFUND	400 mm 4 pc	400 mm 4 pc
 PRO20229 horizontal gable prof.	2244 mm 2 pc	2982 mm 2 pc
 PRO21214 wind bracings roof	2543 mm 4 pc	2757 mm 4 pc
 PRO1456 glazing bar	547 mm 2 pc	703 mm 2 pc
 PRO1456 glazing bar 90 / 65		396 mm 2 pc
 PRO1456 glazing bar 65 / 90		396 mm 2 pc
 E400330 halfmoon glazingrubber	1 pc	20 ltn 1 pc
 SAPAKHELIOS PVC gable pieces	1 pc	1 pc
 bolt M6x50 DIN933 A2		4+4+2 pc
 Nut M6		16 pc
 L2G		16 pc
		10 pc



## COLLI B (HELIOS)

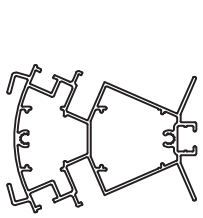
WEIGHT:	26 kg
M23	39 kg
M24/M34	52 kg
M36	
DIMENSIONS:	
250 x 150 x 3200 mm M23	
4700 mm M24/M34	
6250 mm M36	

ITEM	M23	M24 / M34	M36
 PRO6120 foundation profile	3098 mm 2 pc	4574 mm 2 pc	6050 mm 2 pc
 PRO20227 gutter profile	3098 mm 2 pc	4574 mm 2 pc	6050 mm 2 pc
 PRO6760 ridge profile	3098 mm 1 pc	4574 mm 1 pc	6050 mm 1 pc
 ZAK_BOUT	2 pc	3 pc	3 pc
 nut cap M6			50 pc
 nut M6			50 pc
bolt M6x12 DIN933 A2			50 pc

ITEM	M23	M24	M34	M36
 LAMELLEN + ZAKIE_LABEL	1 pc	1 pc	1 pc	1 pc
 ESD_183_ZS	1 pc	1 pc	1 pc	1 pc
 DAKR_HEL	2 pc	3 pc	3 pc	4 pc
 PRO6578 corner profile	4 pc	4 pc	1830 mm	4 pc
 PRO1456 glazing bar gable	8 pc	12 pc	1830 mm	14 pc
 PRO6918 endbar roof	4 pc	4 pc	1630 mm	4 pc
 PRO1456 glazing bar roof	6 pc	10 pc	1630 mm	10 pc
 PRO10980 round tube Ø40	2 pc	2 pc	1900 mm	2 pc
PRO21214 wind bracings gabel	8 pc	8 pc	1975 mm	8 pc
PRO1748 rubber 12m/rol	5 pc	6 pc	7 pc	8 pc
ZAK_H	1 pc	1 pc	1 pc	1 pc
screw 4.8x38 DIN7504 N A2				2 pc
bolt M6x25 DIN933 A2				4 pc
screw 4.8x19 DIN7504 M A2				10 pc
glasholder				32 pc
PVC Ø40 90°				2 pc
PVC gutter pieces				2 + 2 pc

# Key to Profile (Extrusion) Placement

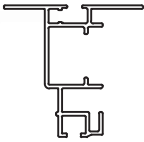
Note: Model pictured in entire manual is VI34 - your size/layout may vary.



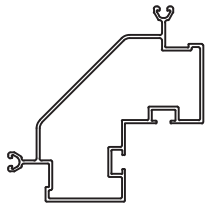
PRO6760



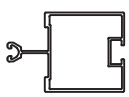
Ø 19



PRO20229



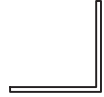
PRO6578



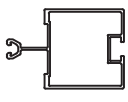
PRO1456



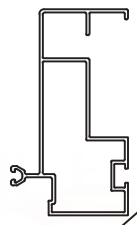
TRE



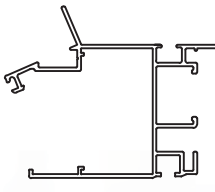
PRO210



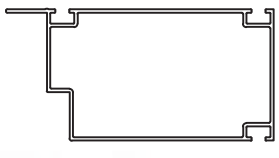
PRO1456



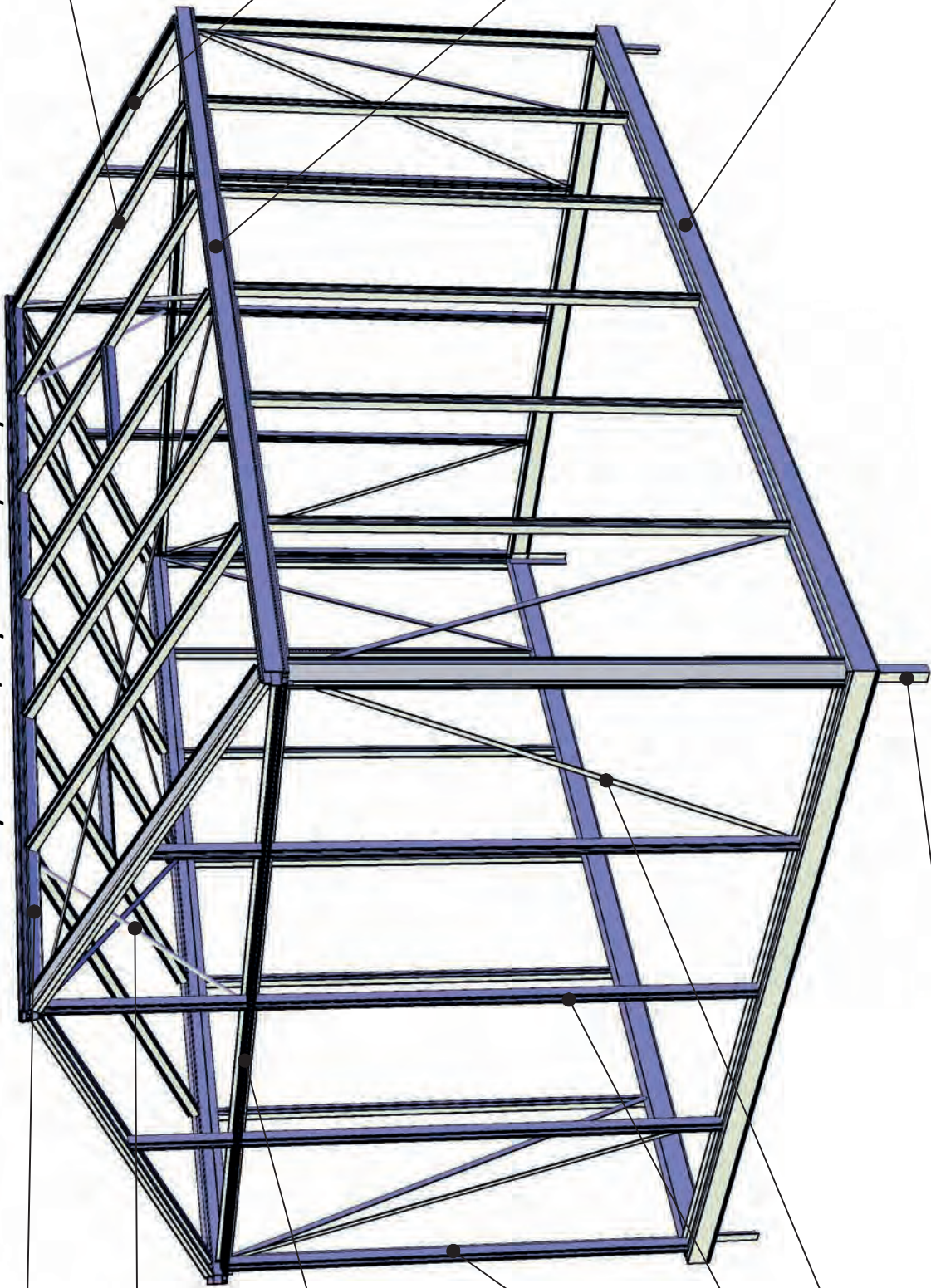
PRO6918

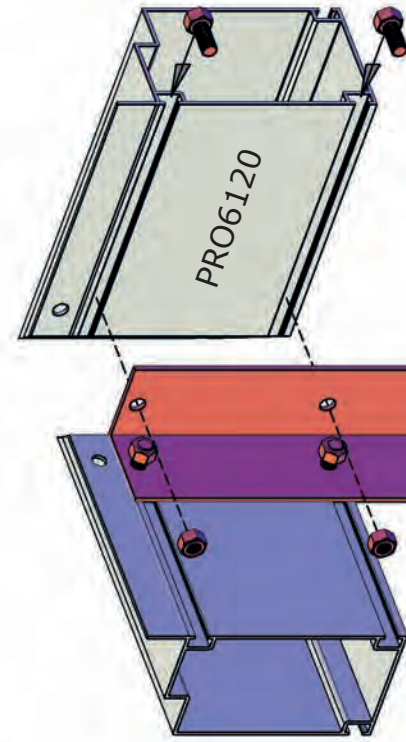
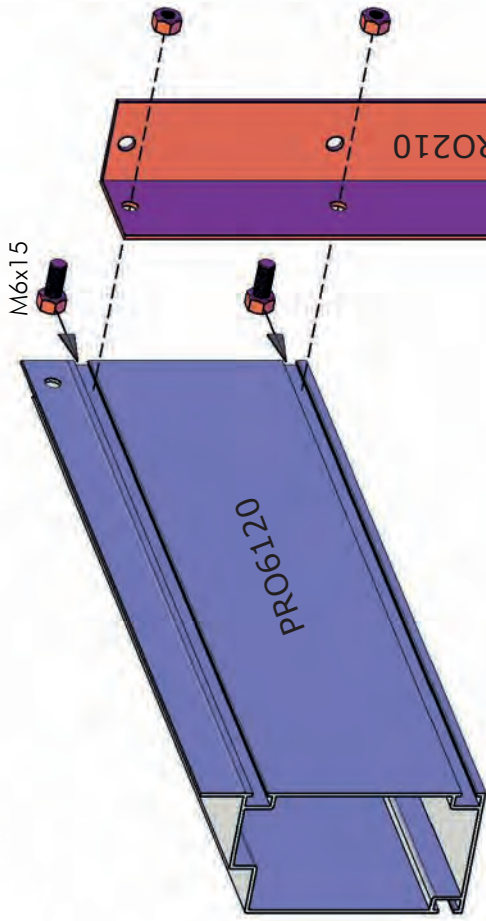


PRO20227

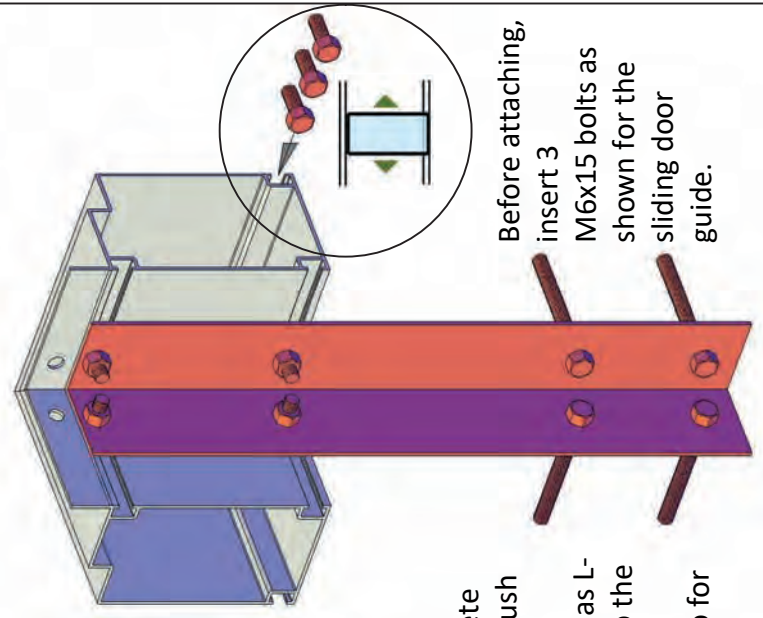
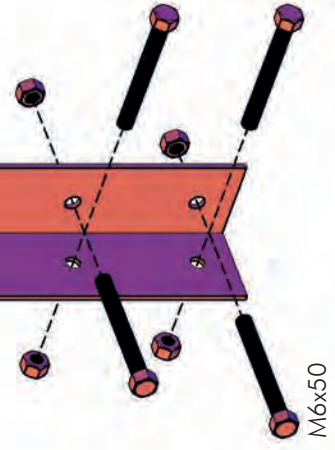


PRO6120



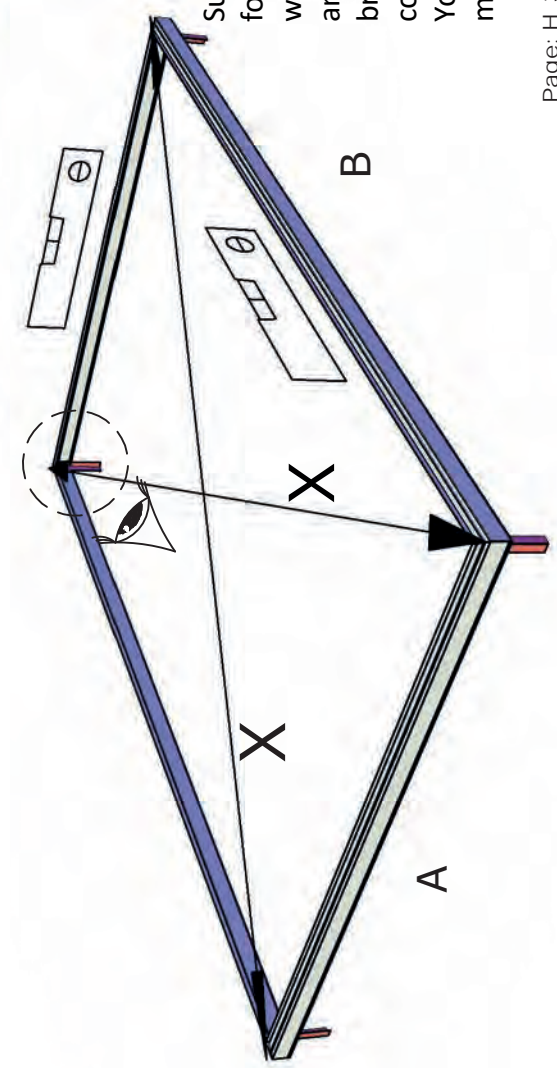


Note: When assembling the foundation in this step, only hand-tighten the nuts. The corners may need to be slightly loose to attach the corner uprights (PRO6578).



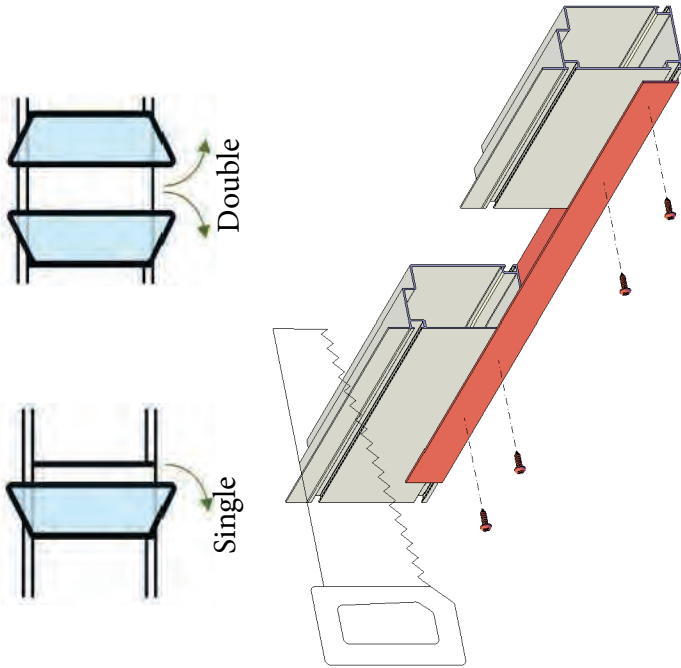
Suggestion: If installed on a concrete foundation you may cut PRO210 flush with the bottom of PRO6120. To anchor, use cut off PRO210 pieces as L-brackets to secure the PRO6120 to the concrete foundation. Please see YouTube animated assembly video for more information.

Before attaching, insert 3 M6x15 bolts as shown for the sliding door guide.

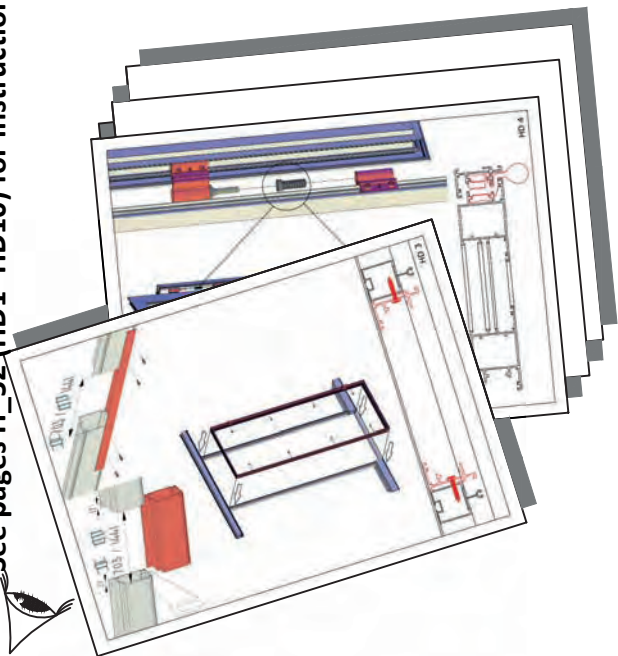




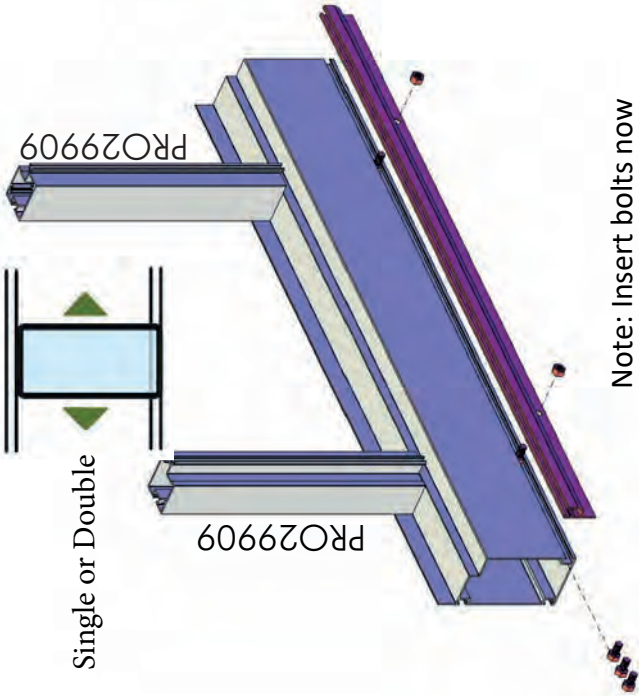
Upgrade OPTION: HINGED DOOR



See pages H\_52 (HD1 - HD10) for instructions

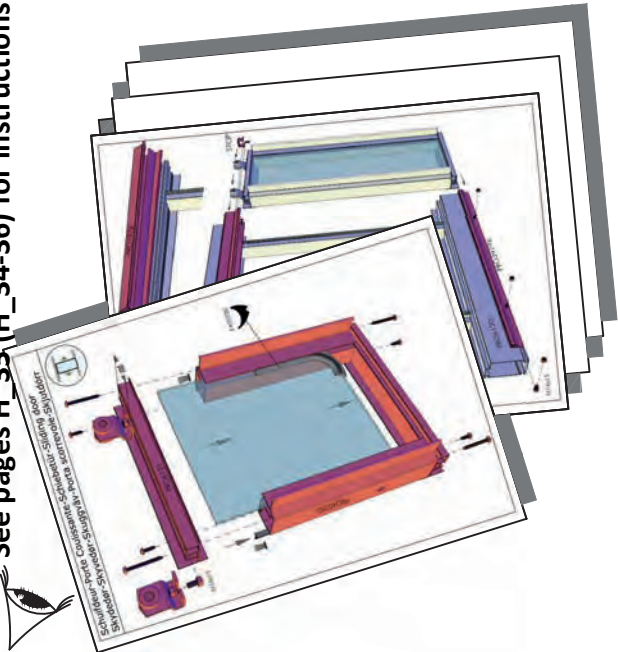


Standard OPTION: SLIDING DOOR

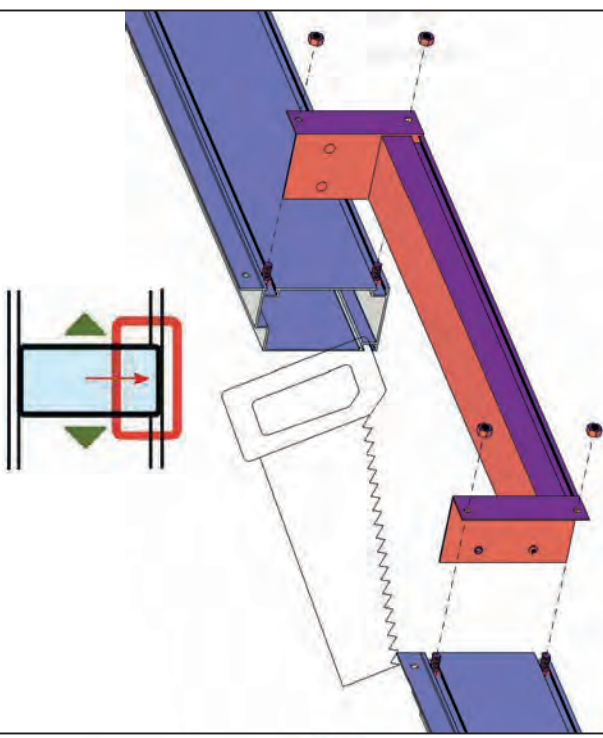


Note: Insert bolts now

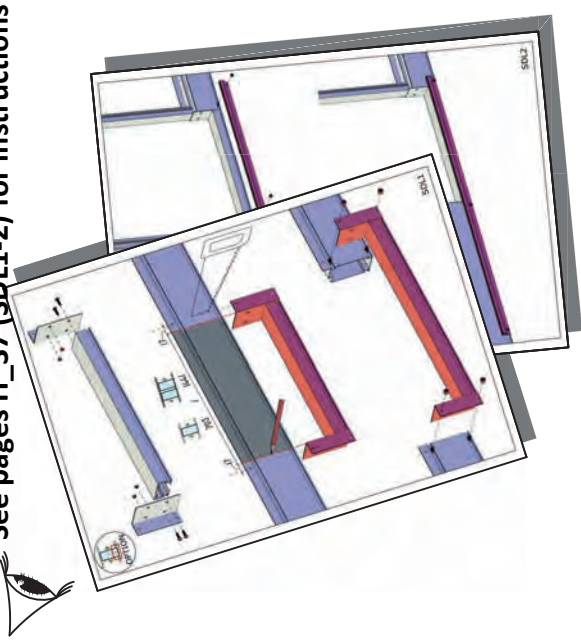
See pages H\_35 (H\_34-36) for instructions



Upgrade OPTION for Sliding Door: LOW THRESHOLD

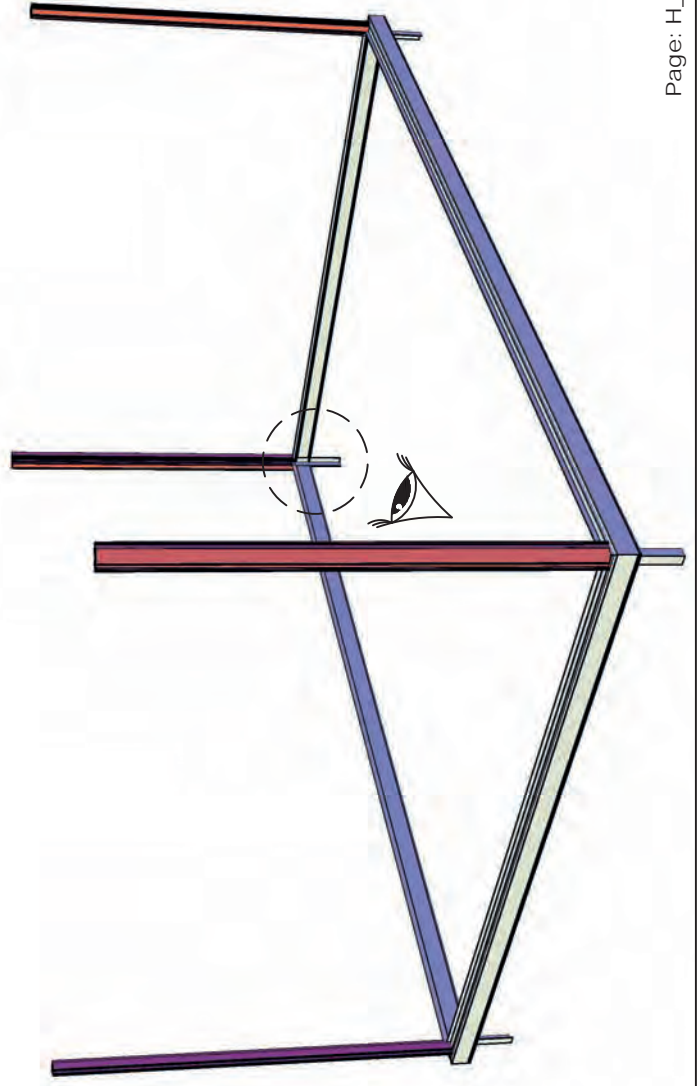
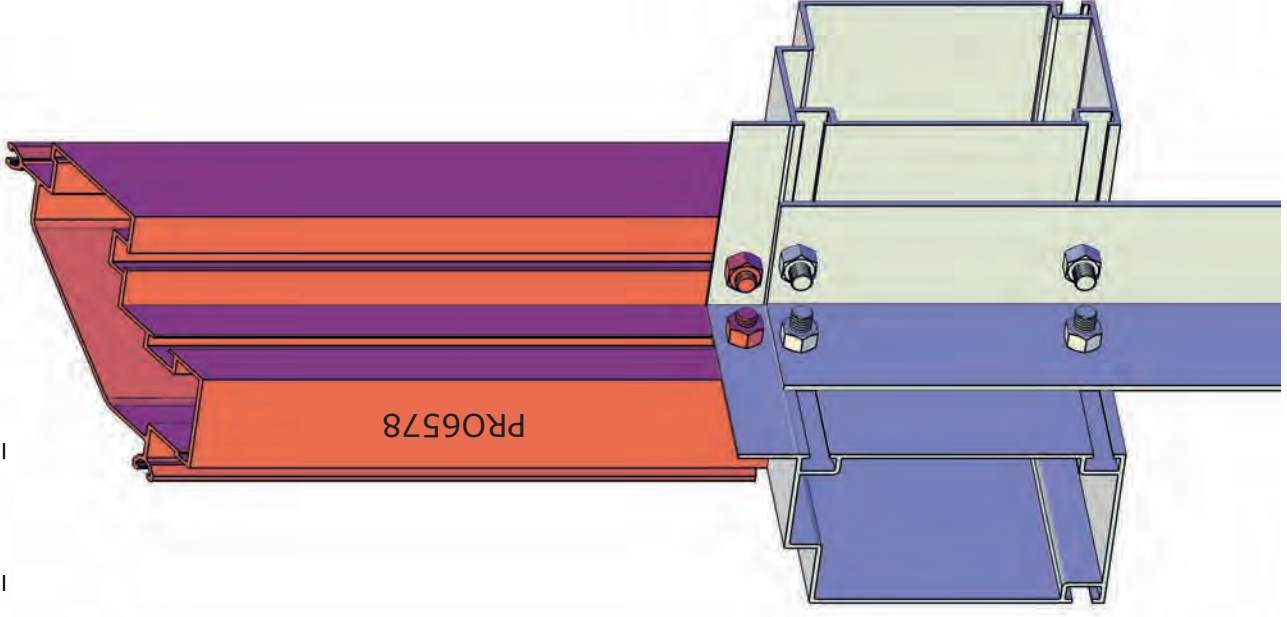
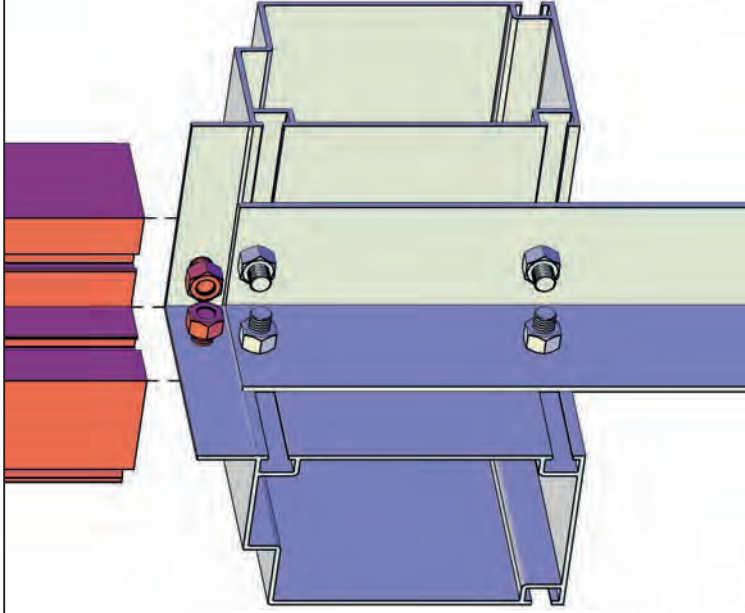
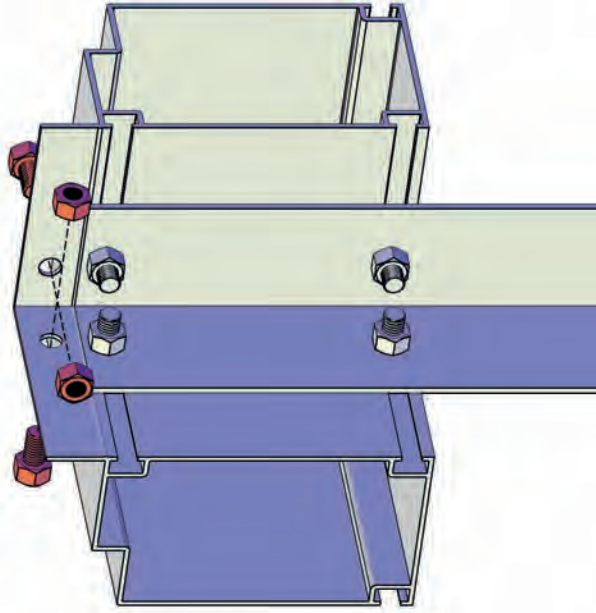


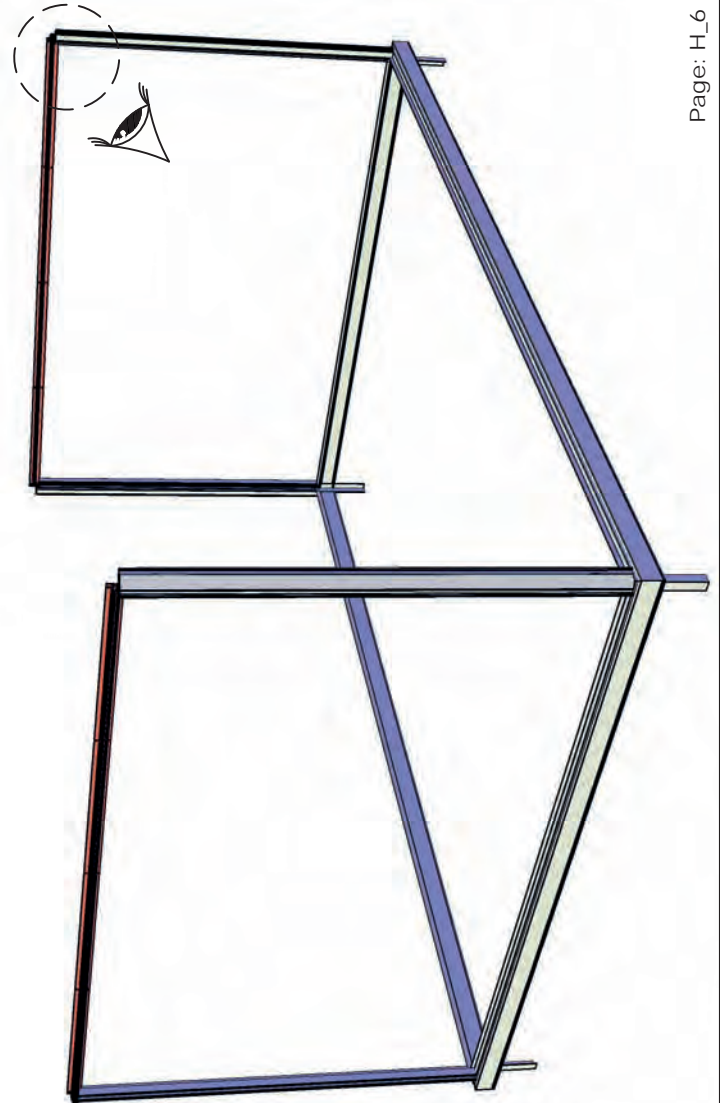
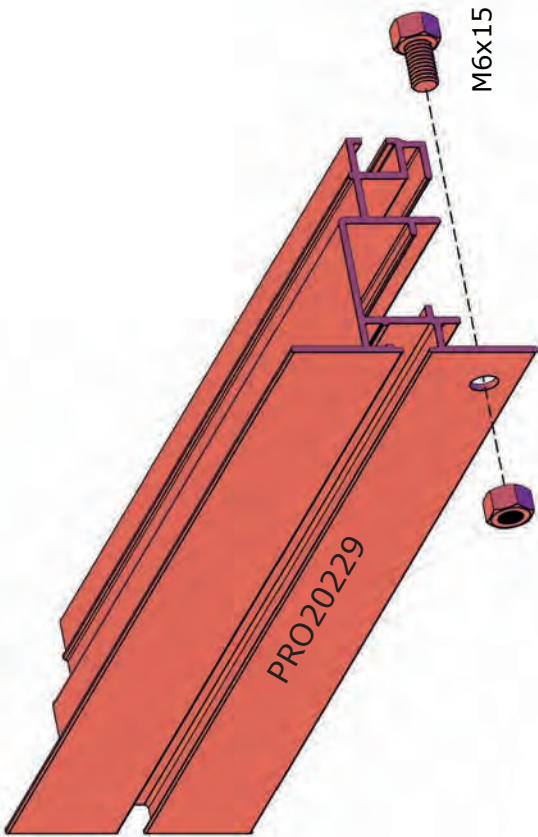
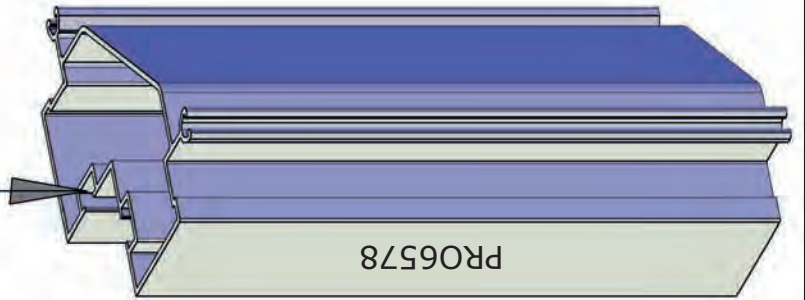
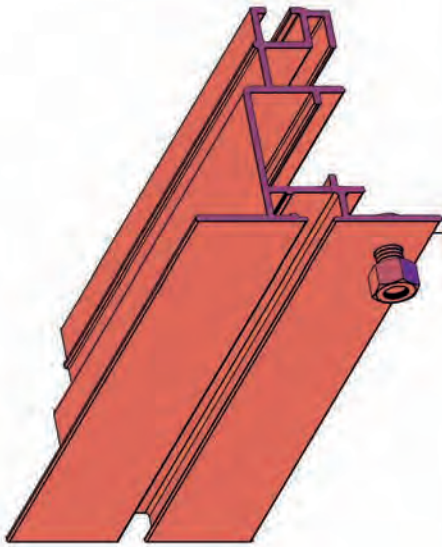
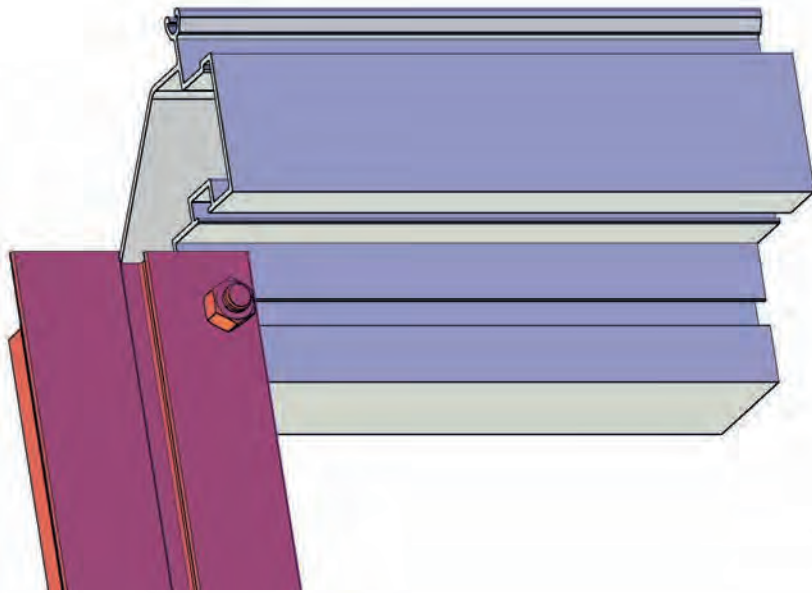
See pages H\_37 (SDL1-2) for instructions



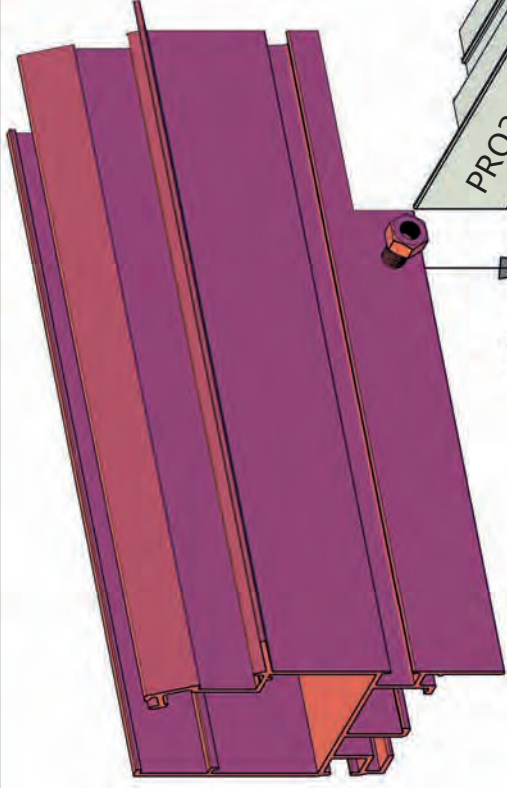
Optional: Insert a bolt into each corner post channel for where the top shelf and/or Seed Tray will be located. See page H\_62 and H\_63 for location information.

M6x15



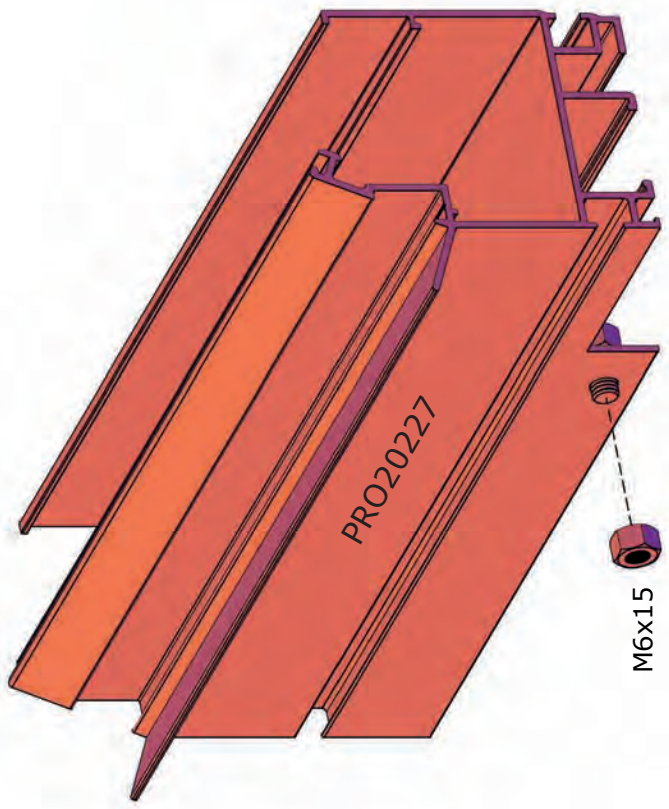
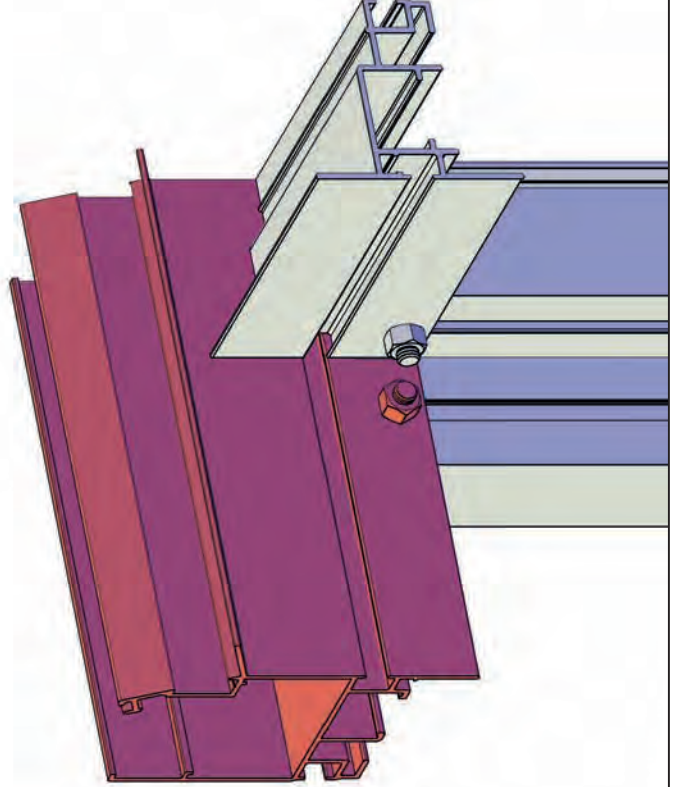


OPTIONAL: If you purchased shade curtains, insert the slider loops into the gutter profile channel before this assembly step. See page H\_64 for more information.



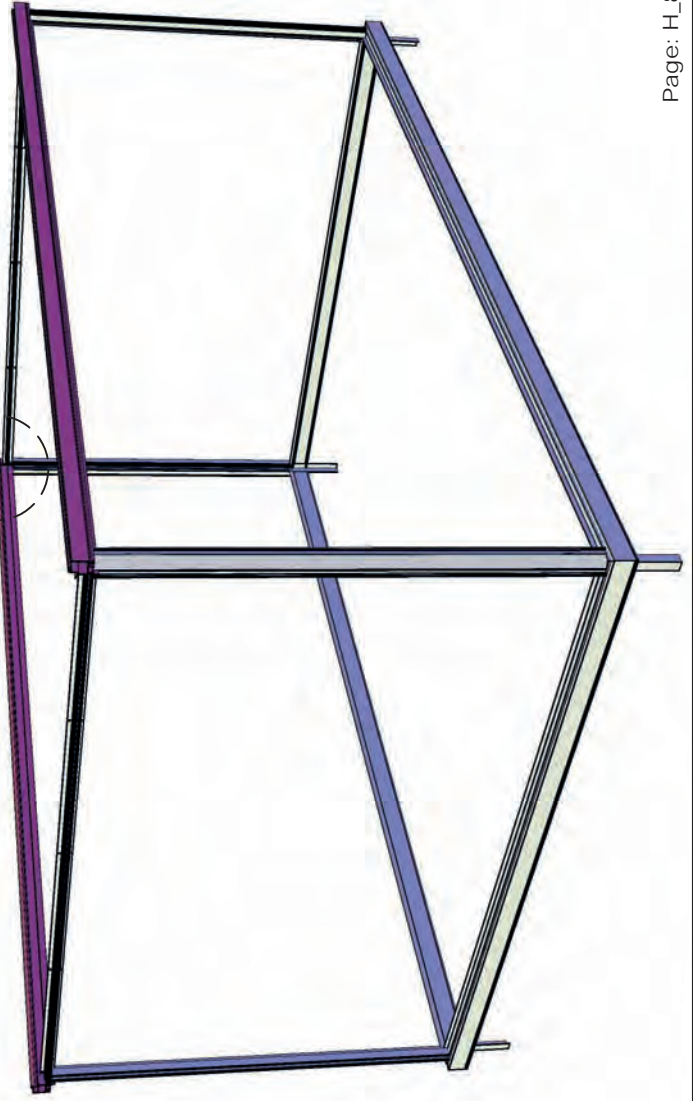
PRO20229

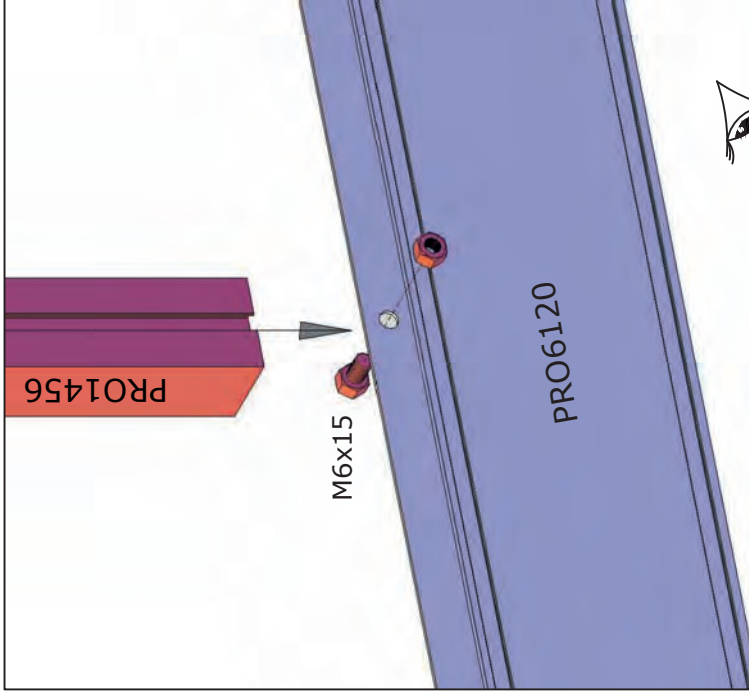
PRO6578



PRO20227

M6x15





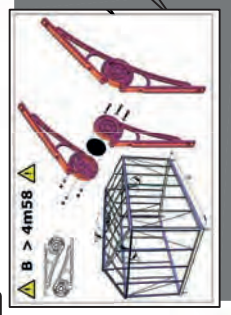
PRO1456

M6x15

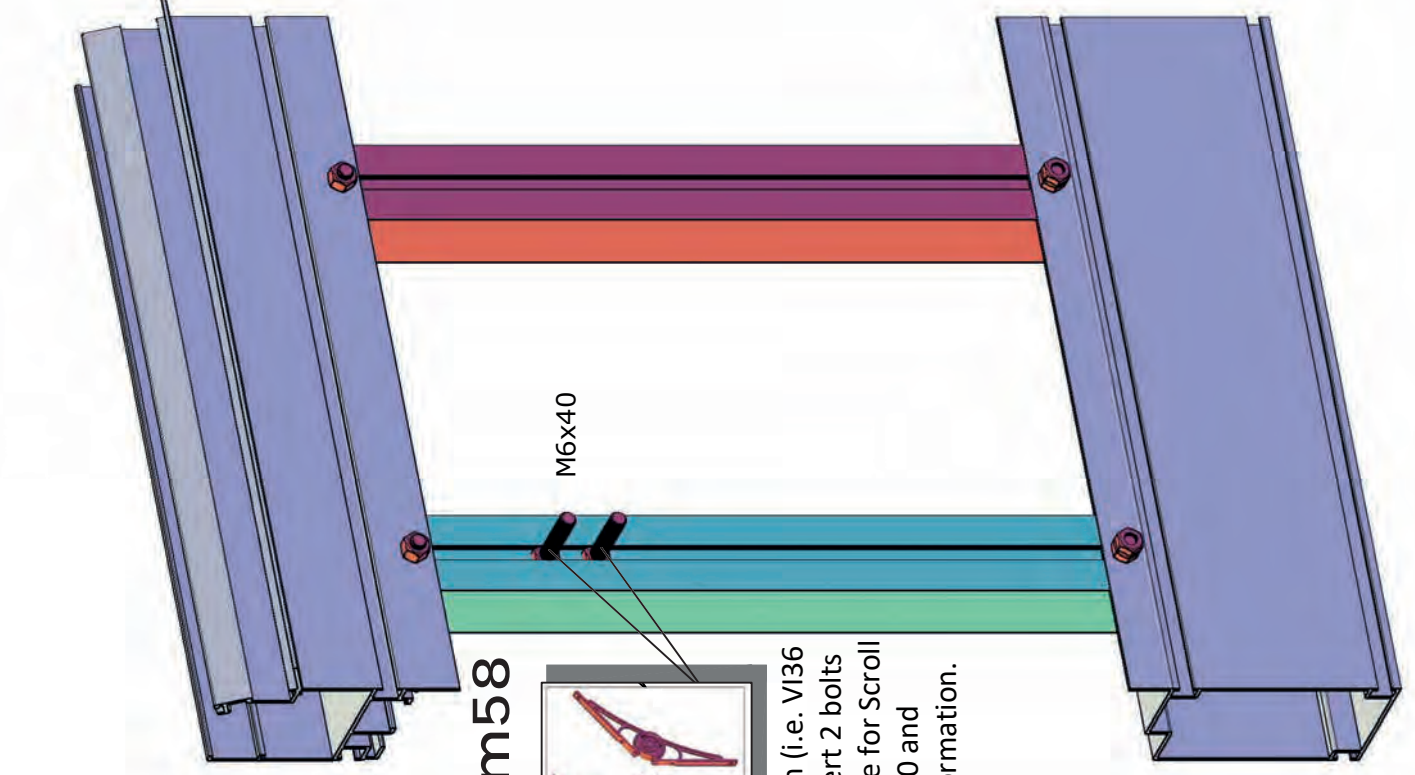
PRO6120



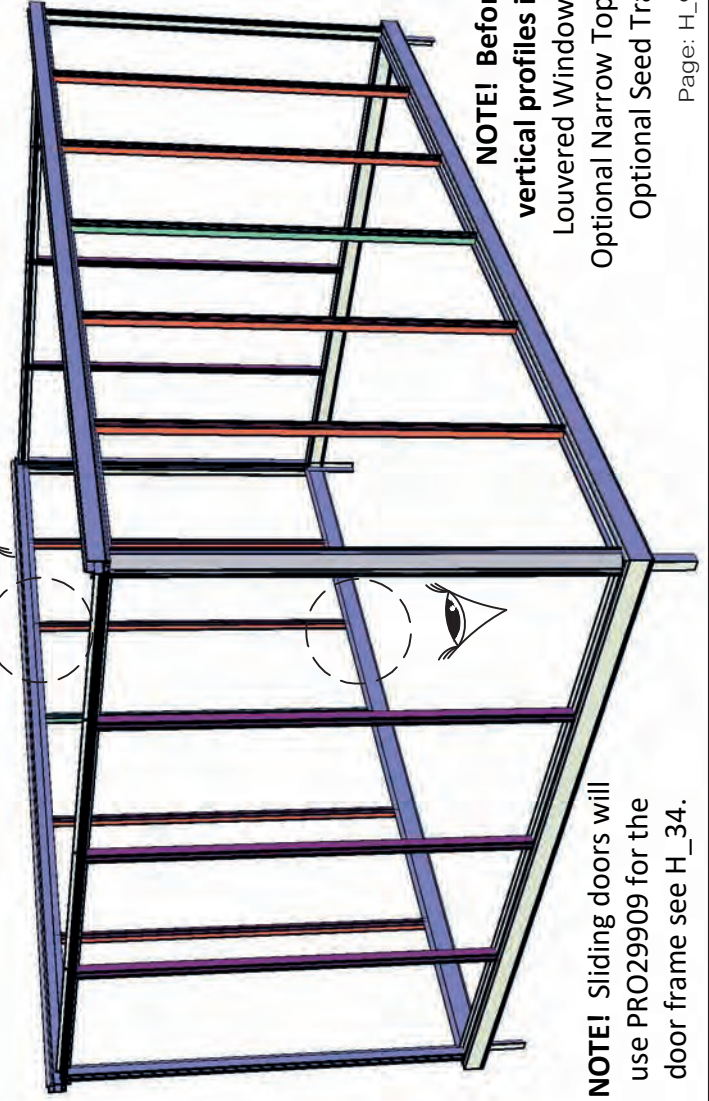
**B > 4m58**



If length > 4580mm (i.e. V136 and V146) then insert 2 bolts in the center profile for Scroll Supports - see H\_20 and H\_21 for more information.

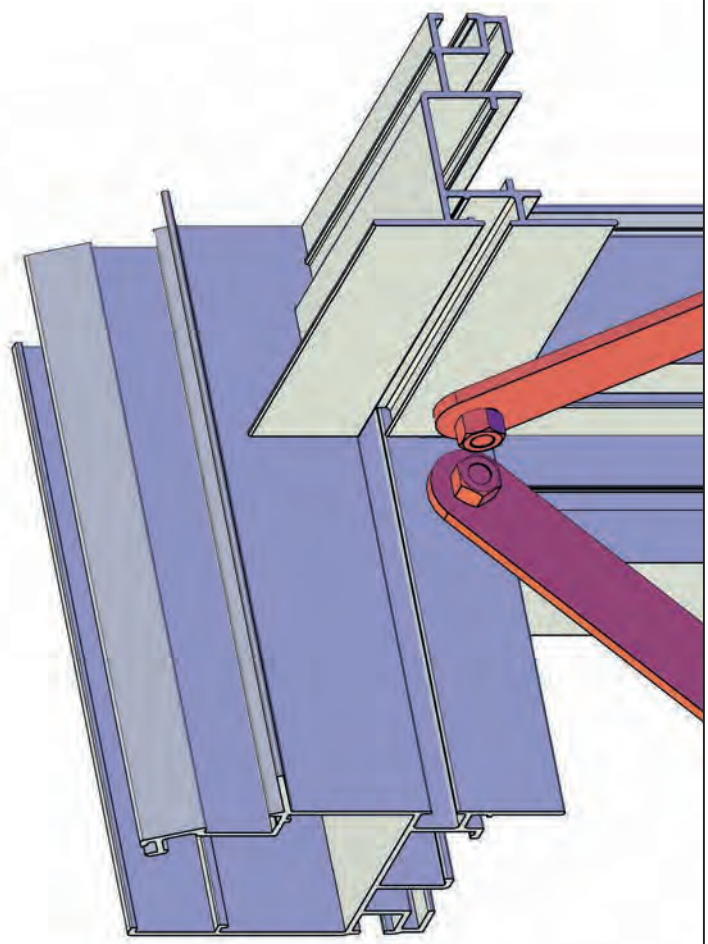
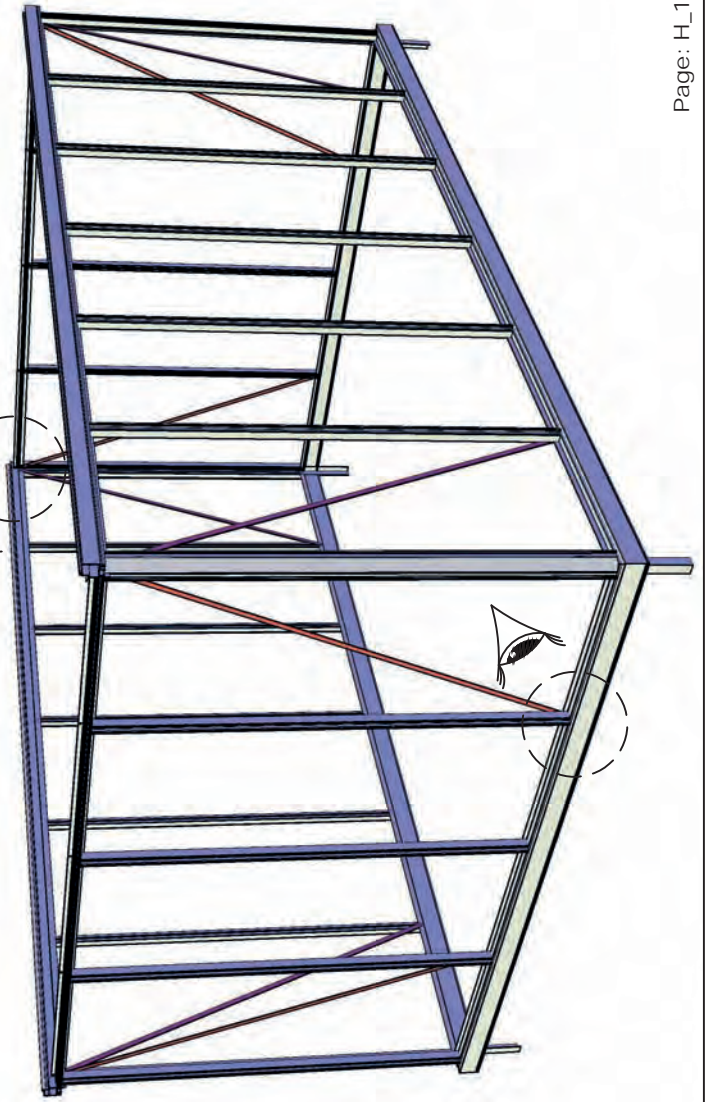
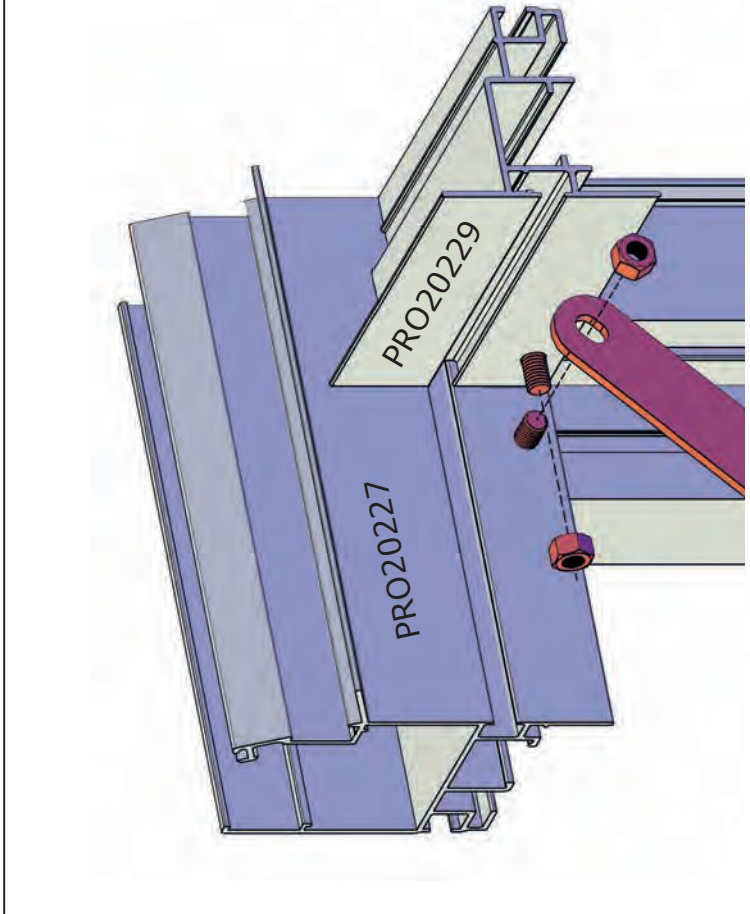
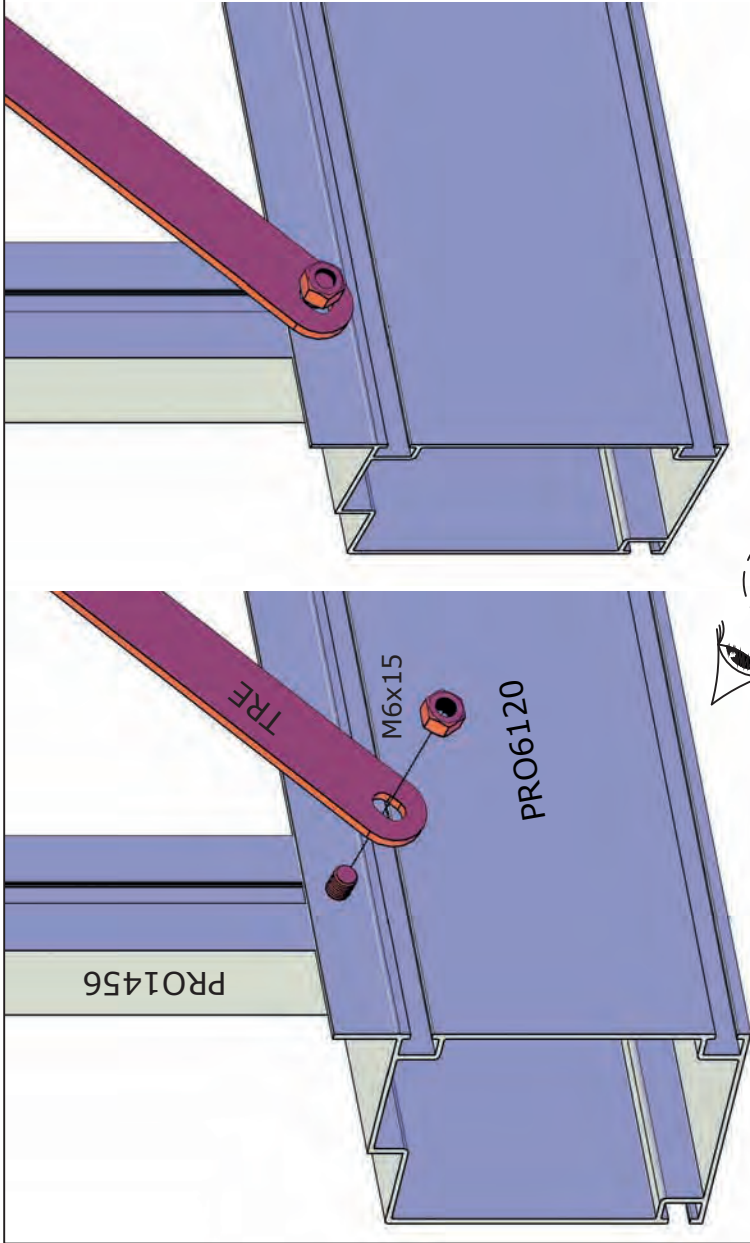


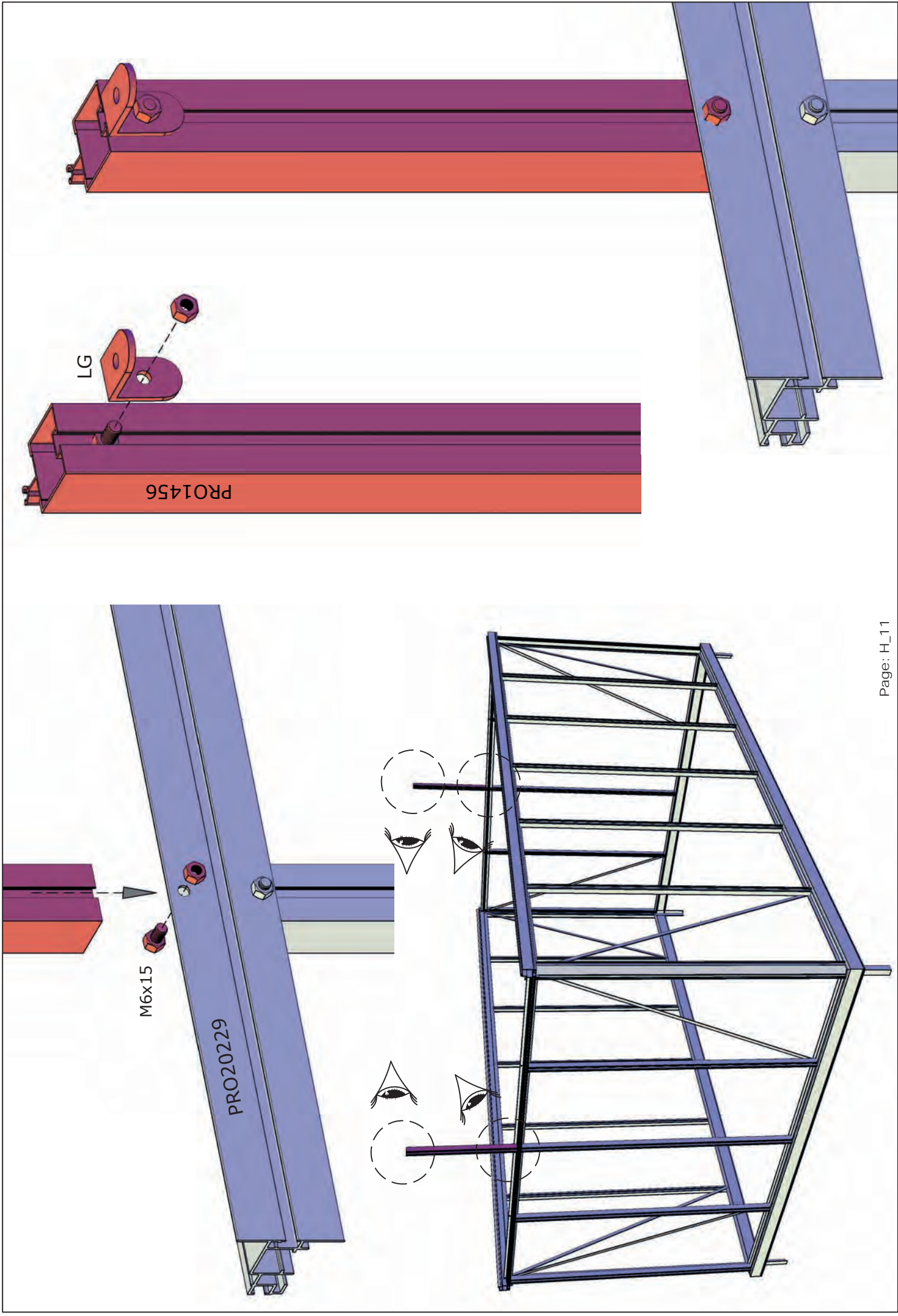
M6x40

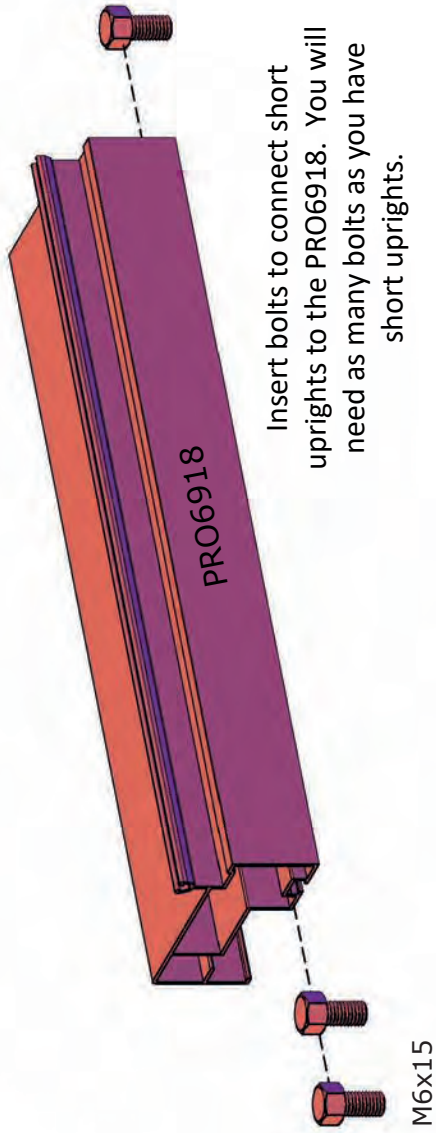


**NOTE!** Sliding doors will use PRO29909 for the door frame see H\_34.

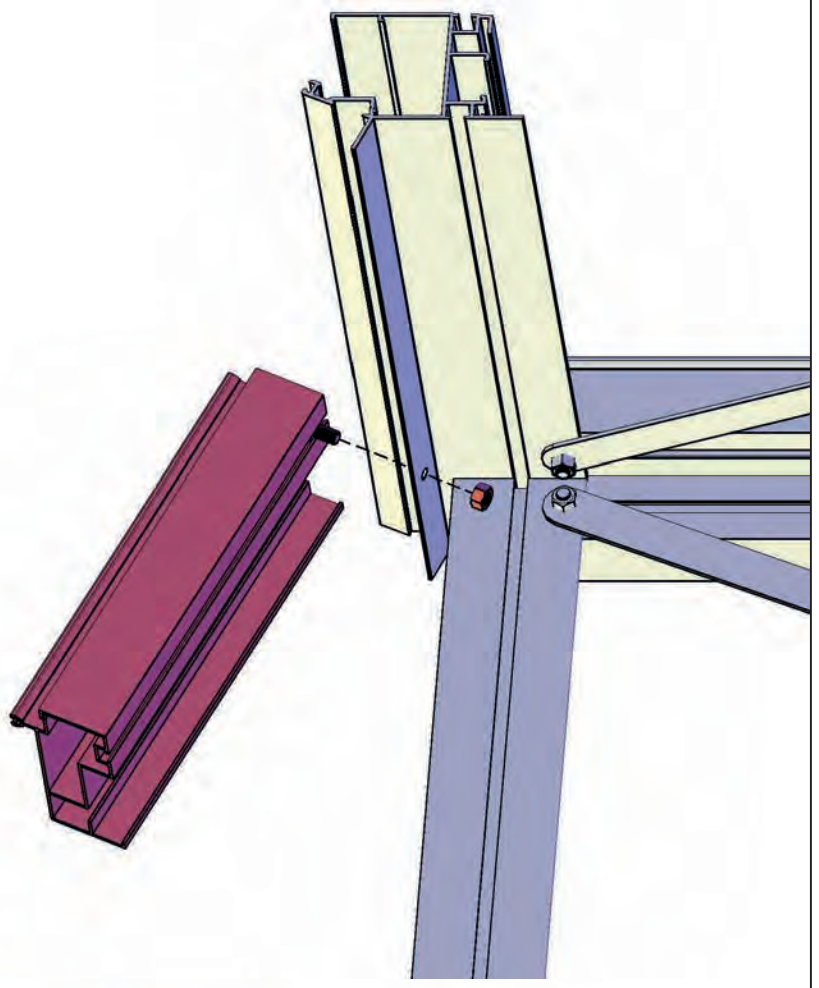
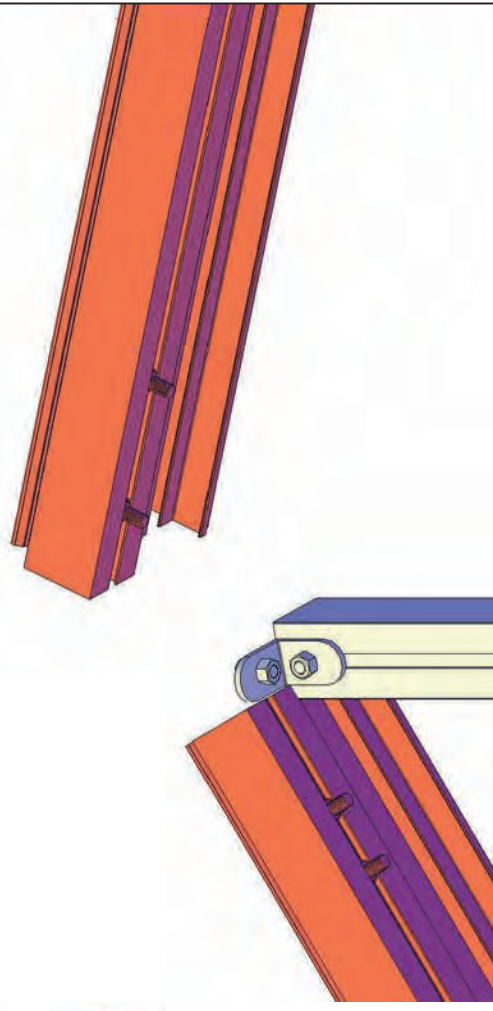
**NOTE! Before securing vertical profiles insert bolts for:**  
 Louvered Window, see p. H\_44-46  
 Optional Narrow Top Shelf, see p. H\_62  
 Optional Seed Tray, see p. H\_63







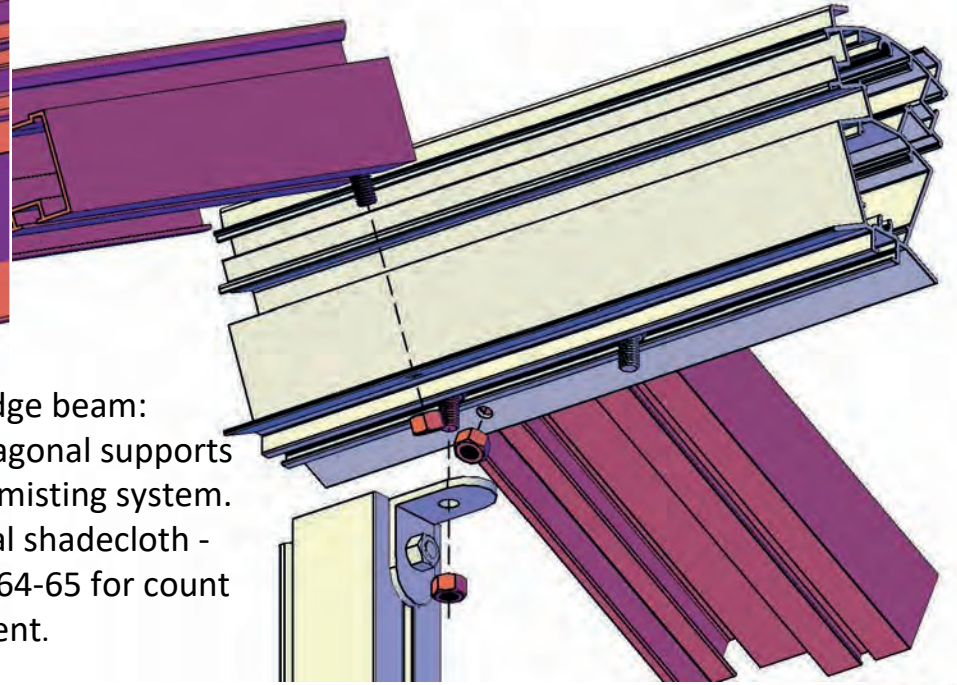
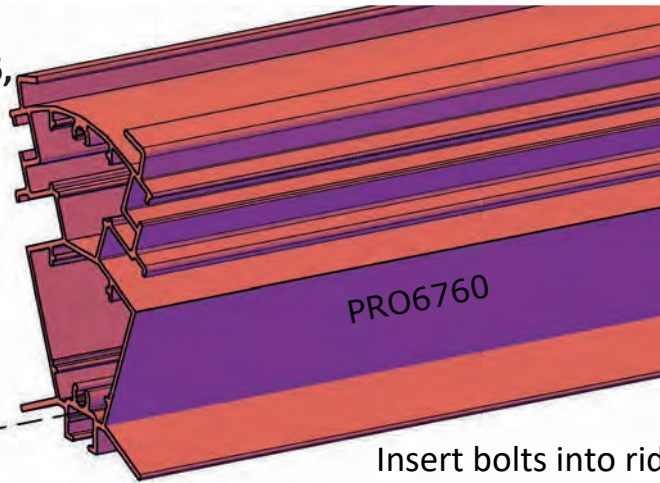
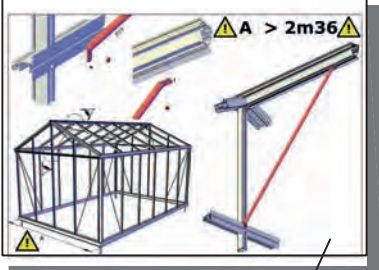
Insert bolts to connect short uprights to the PRO6918. You will need as many bolts as you have short uprights.



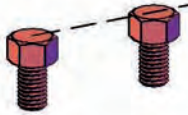




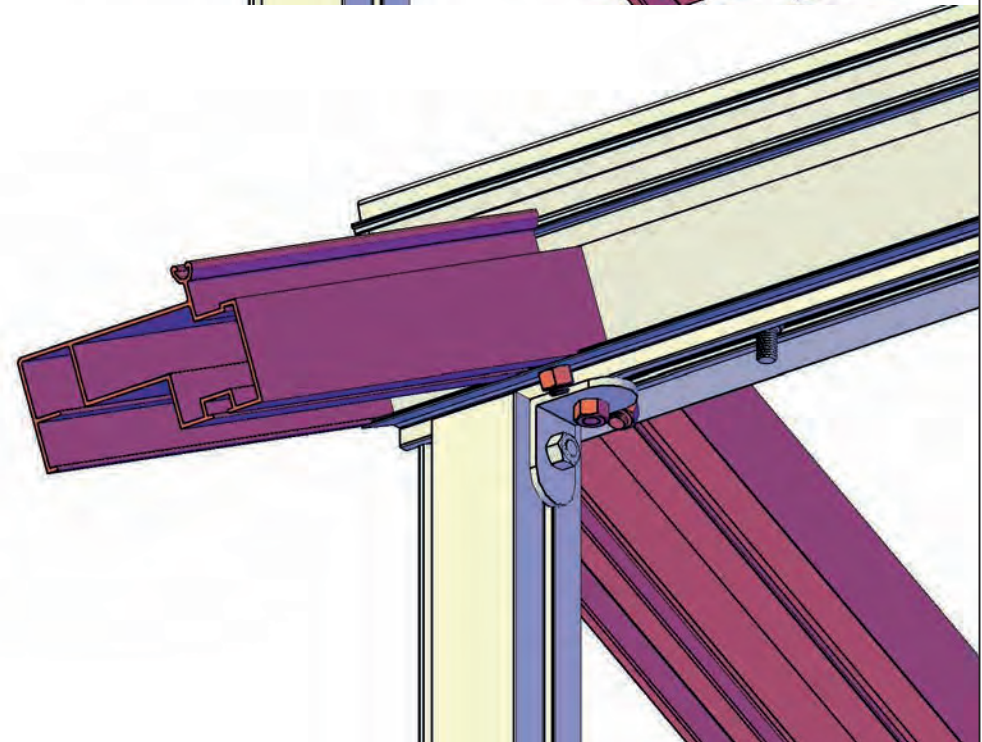
Only for models over  
2360mm (i.e. VI34, 36,  
46) See p. H\_17

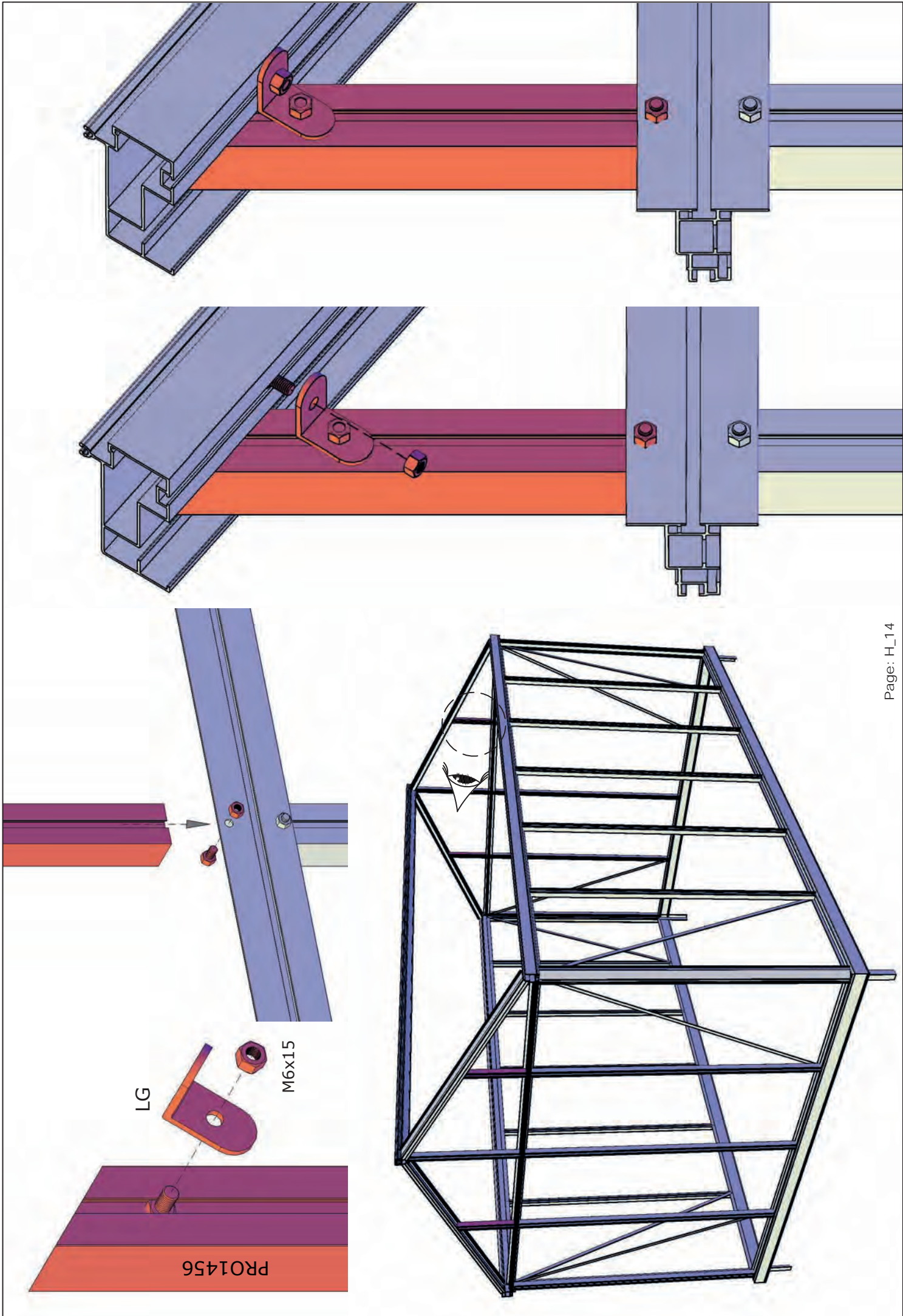


M6x15



Insert bolts into ridge beam:  
2 for L brackets, 2 for diagonal supports  
(except VI23), and 3 for misting system.  
If you have the optional shade cloth -  
insert sliders - see p. H\_64-65 for count  
and placement.



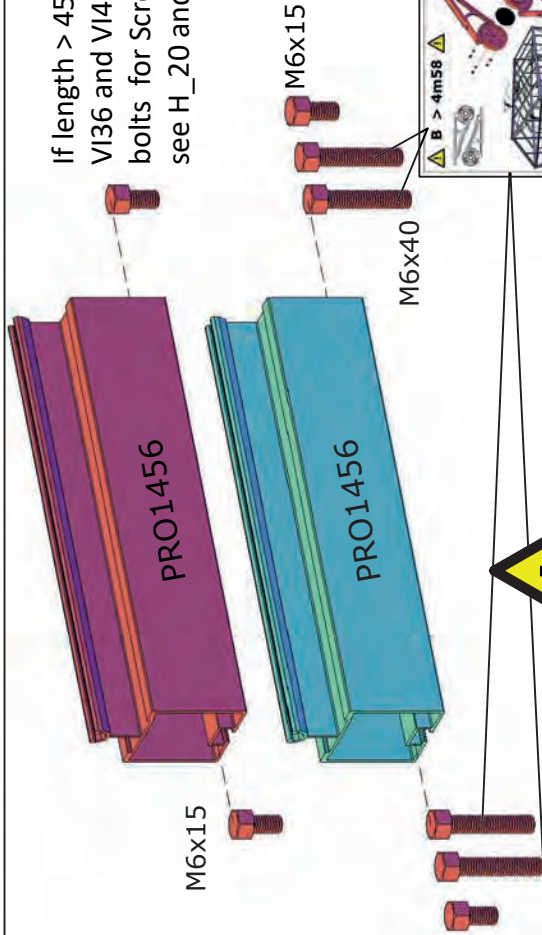


LG

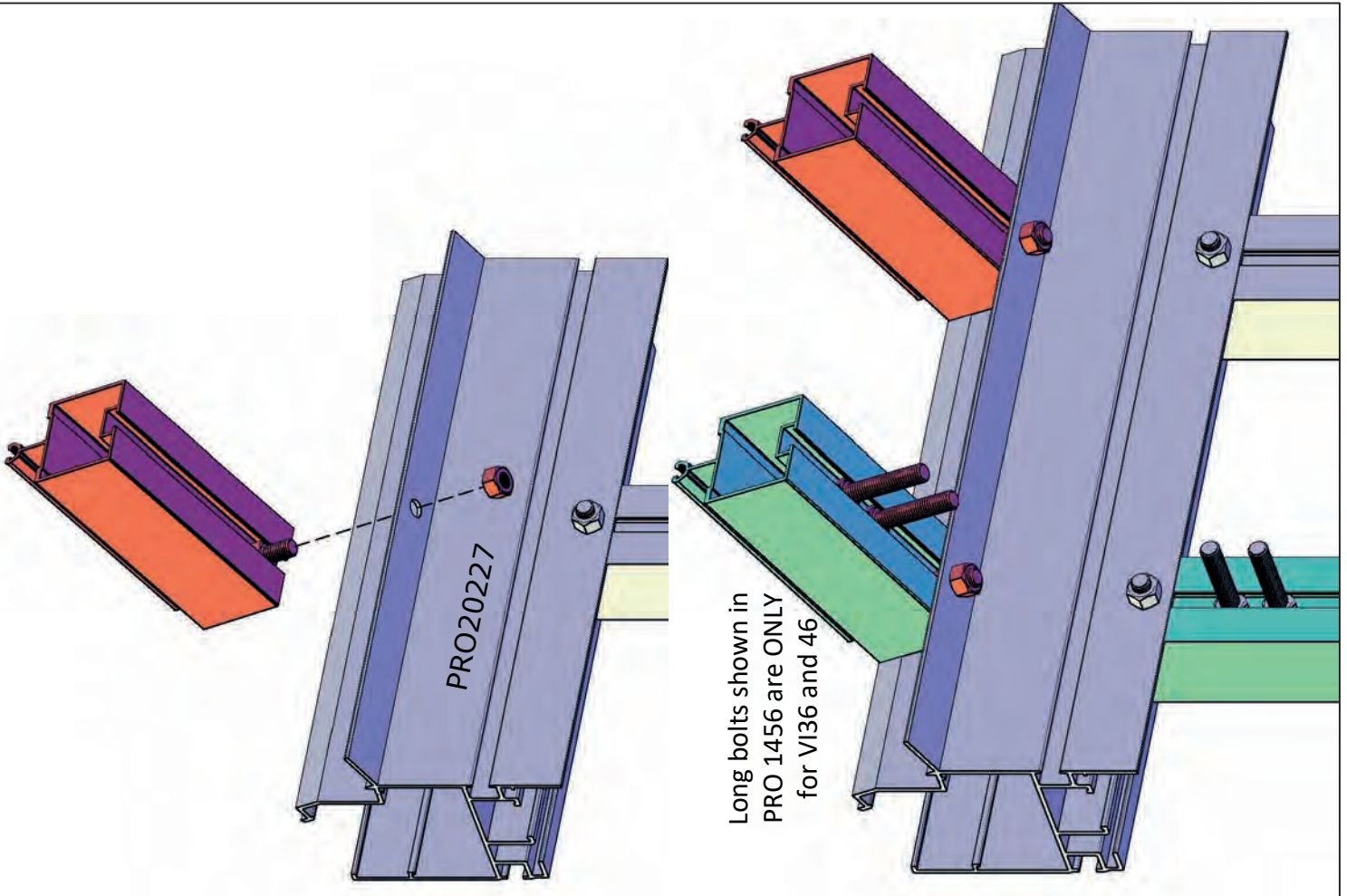
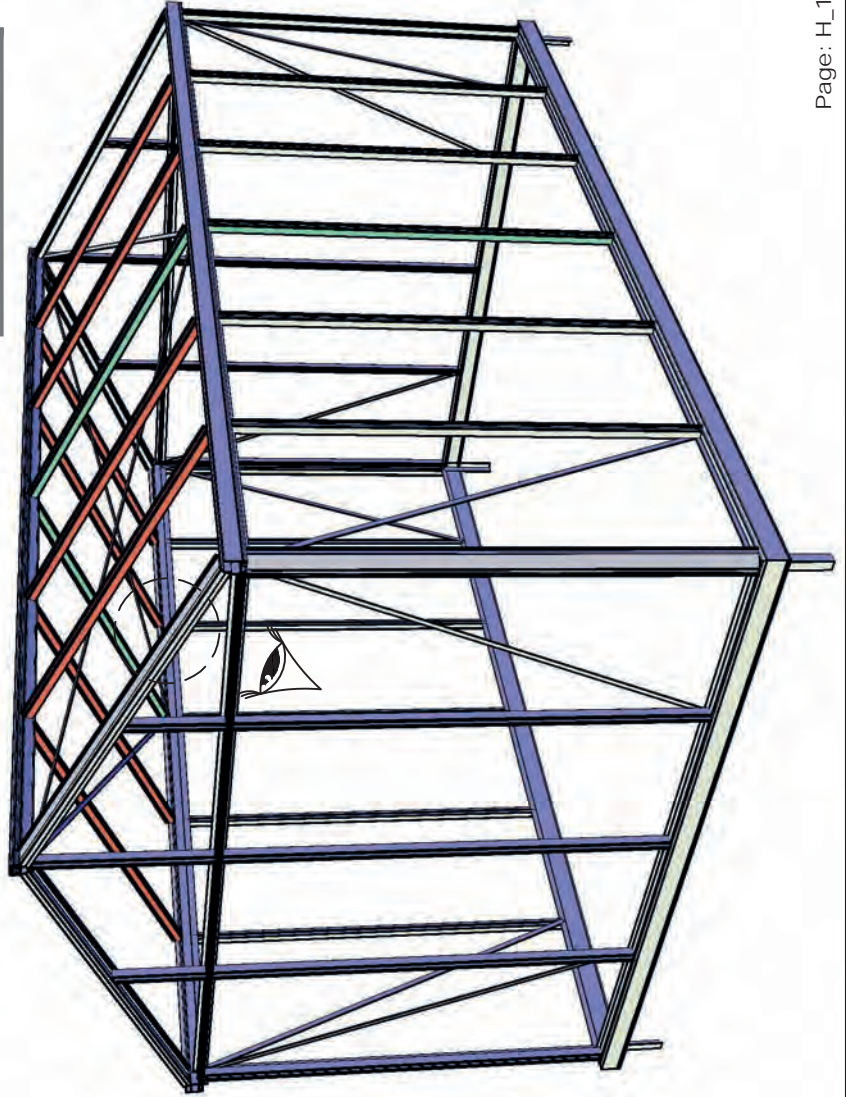
M6x15

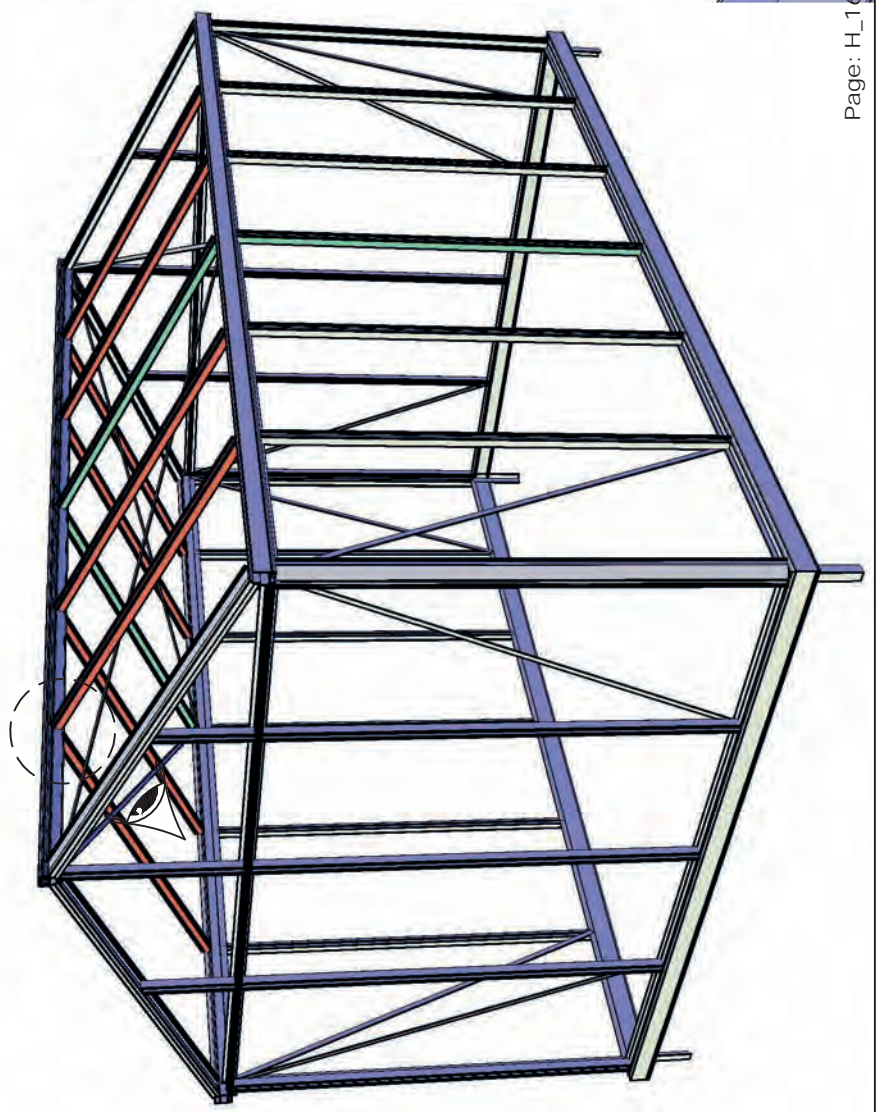
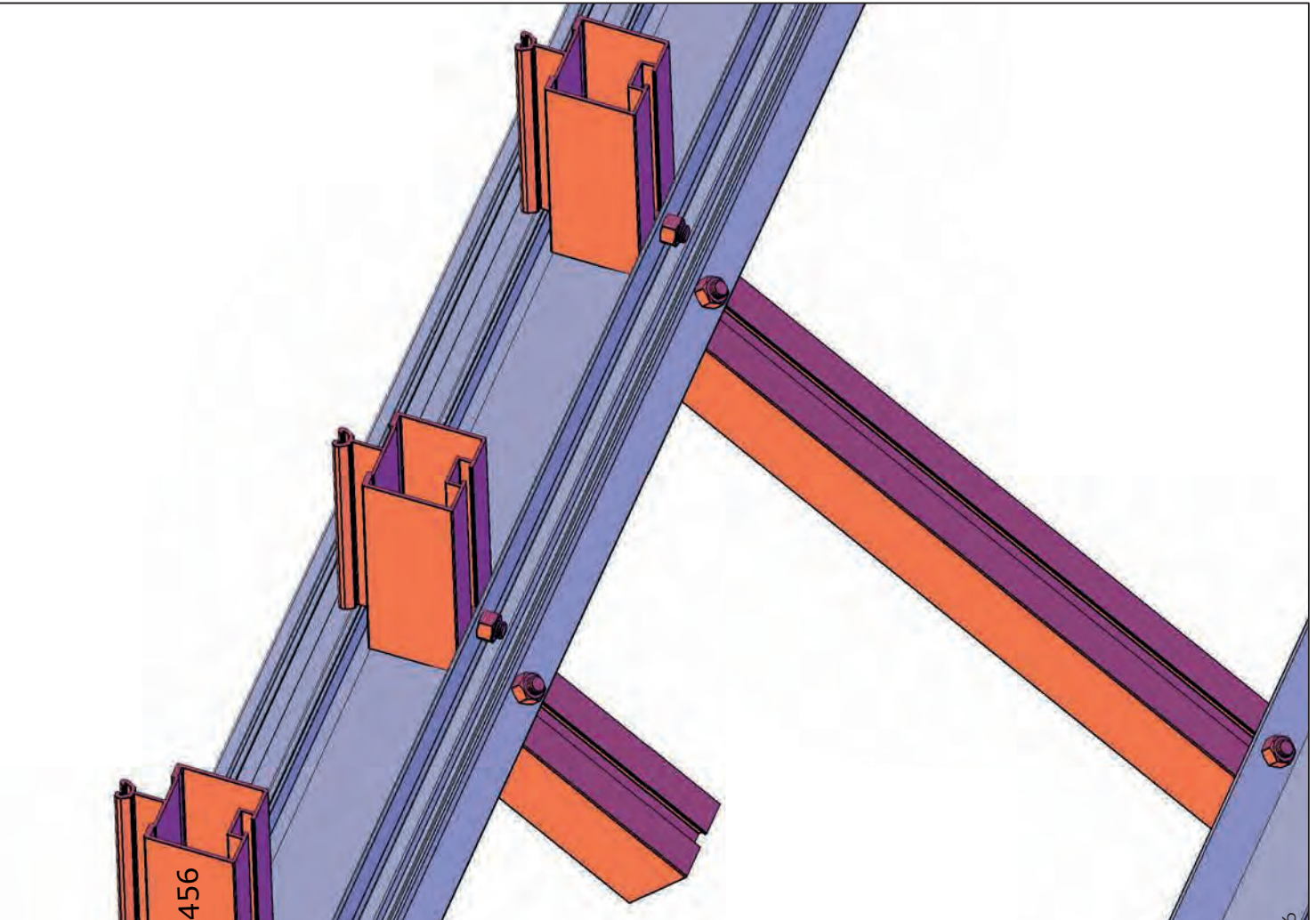
PRO1456

If length > 4580mm (i.e. V136 and V146) then insert bolts for Scroll Supports - see H\_20 and H\_21



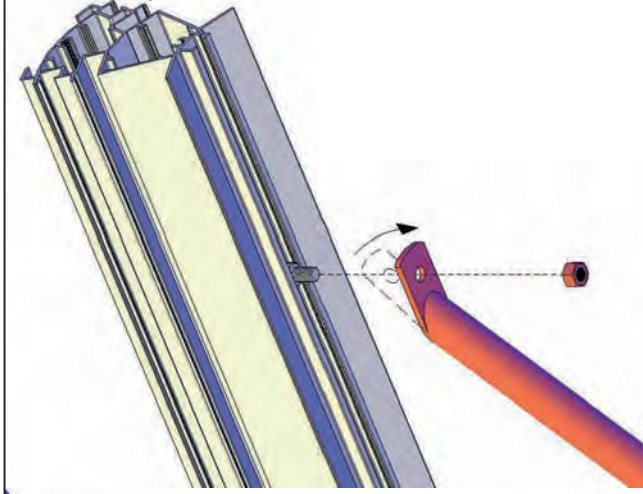
**!** B > 4m58



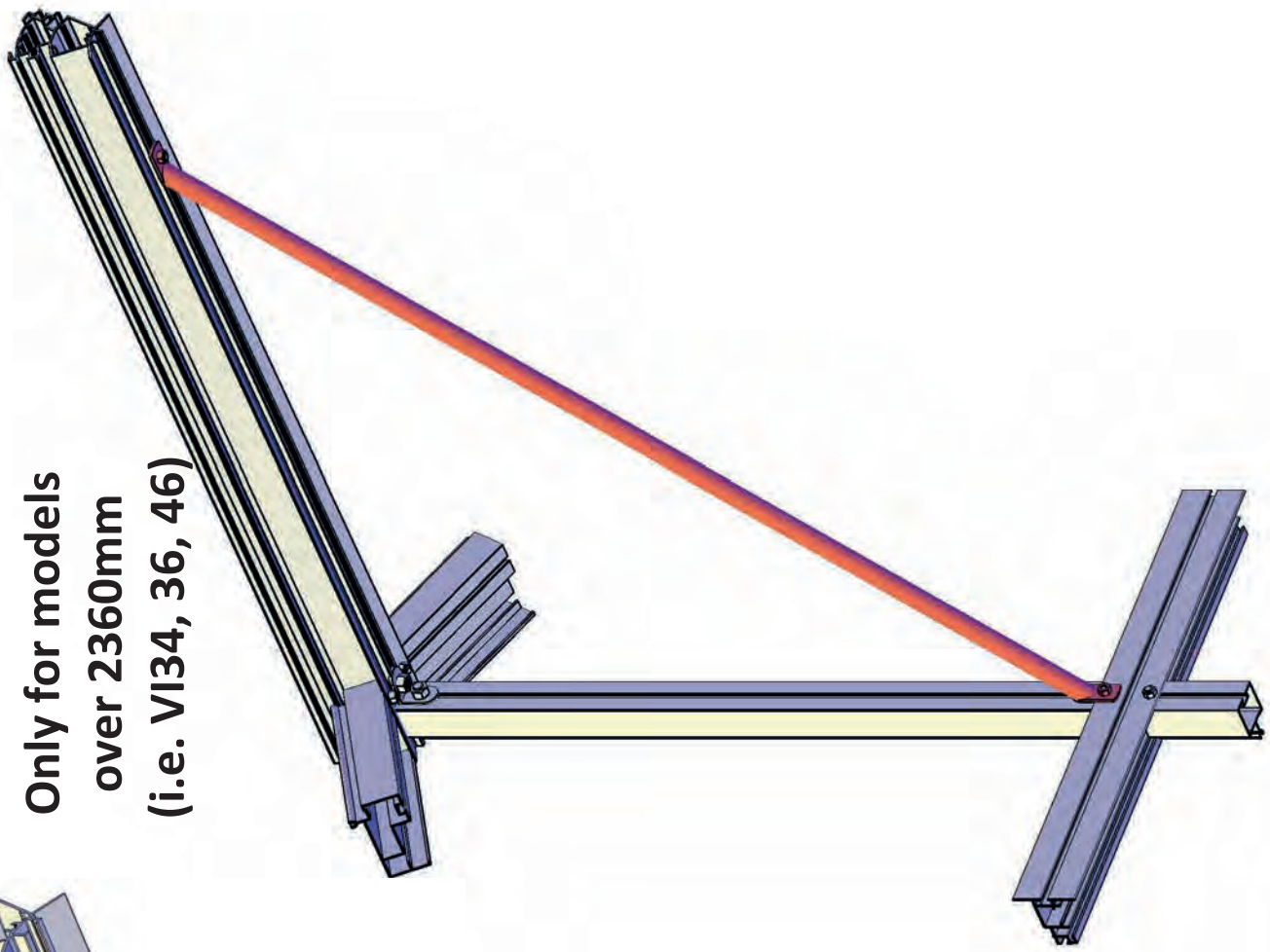
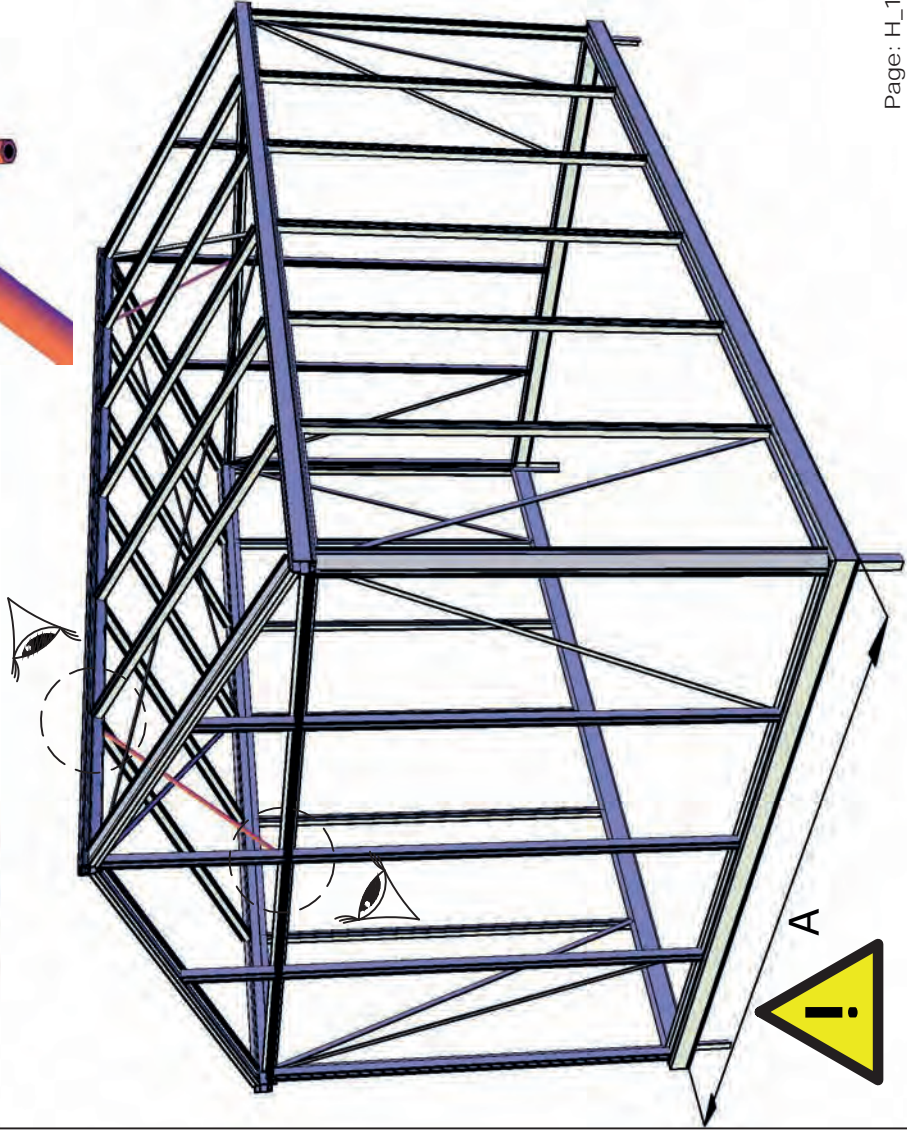
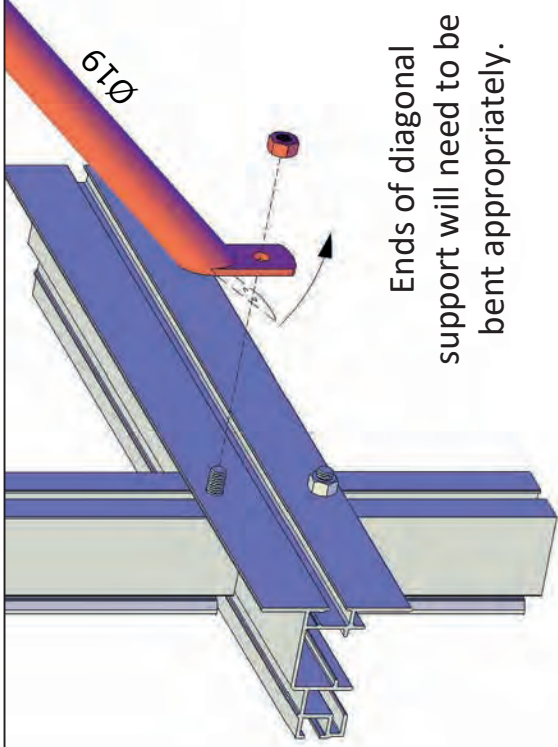


**! A > 2m36 !**

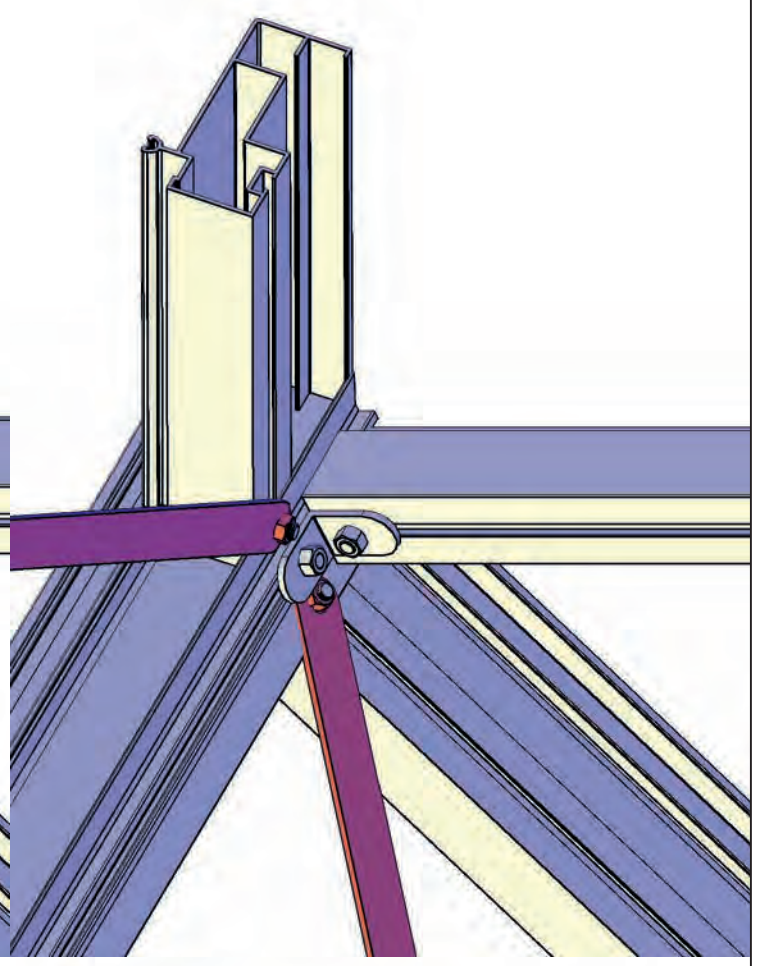
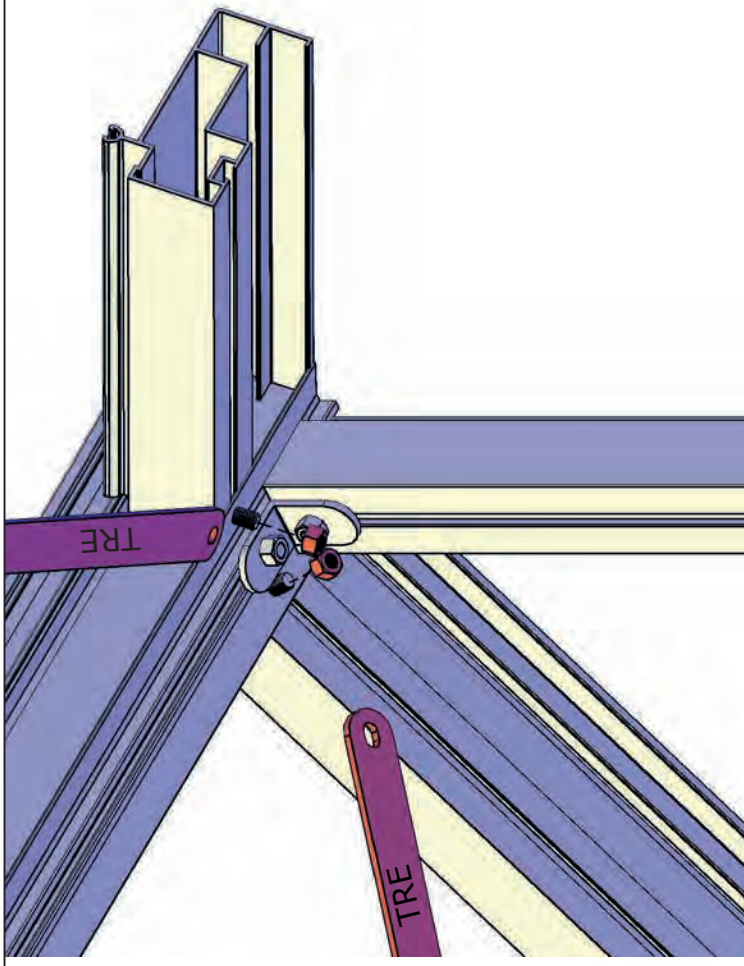
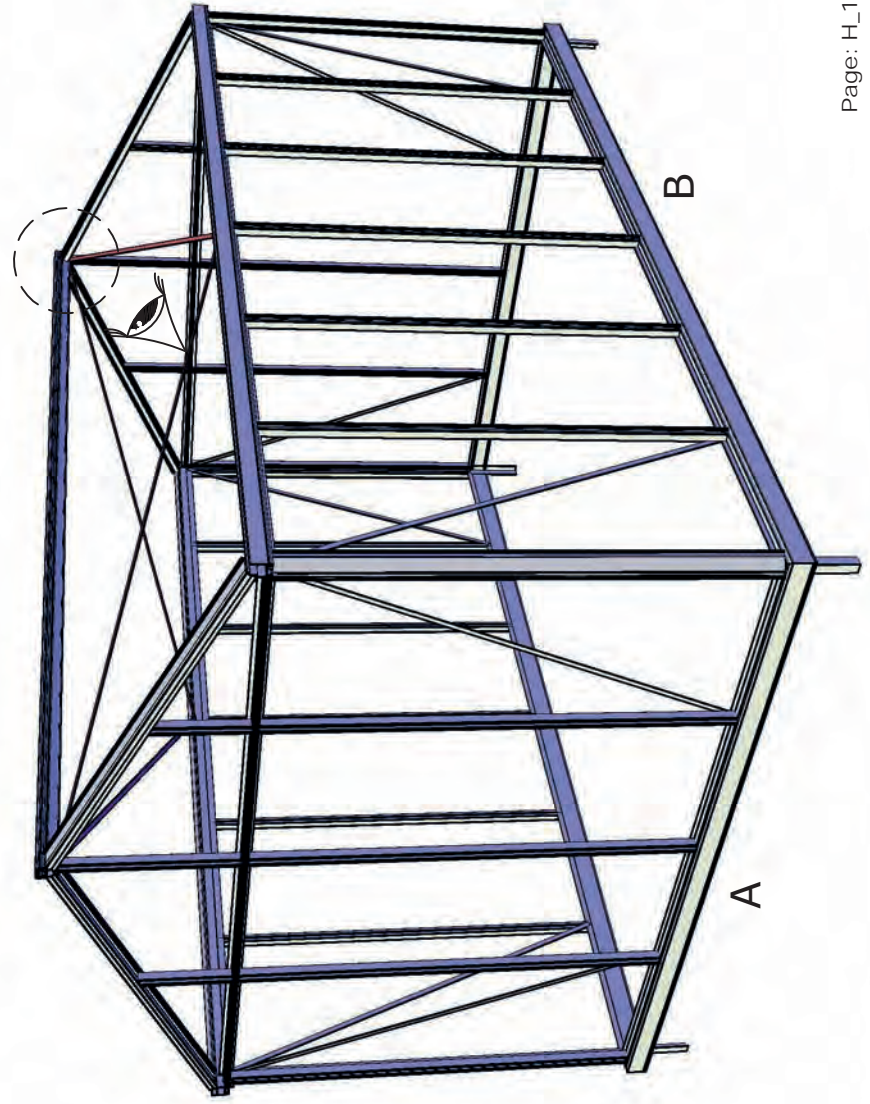
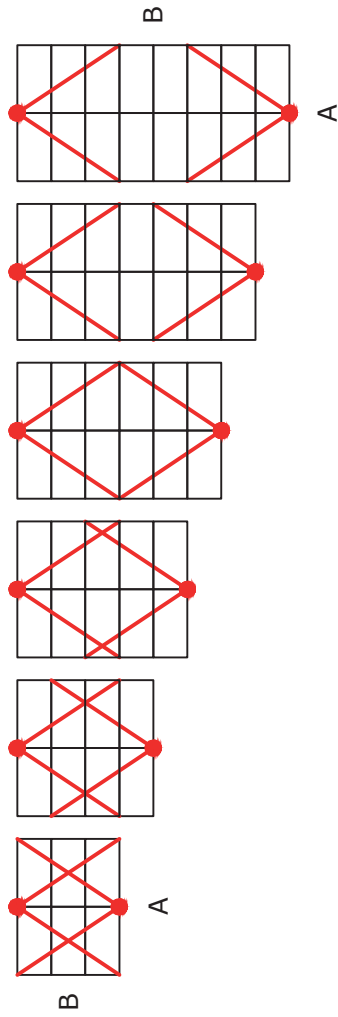
Only for models  
over 2360mm  
(i.e. VI34, 36, 46)



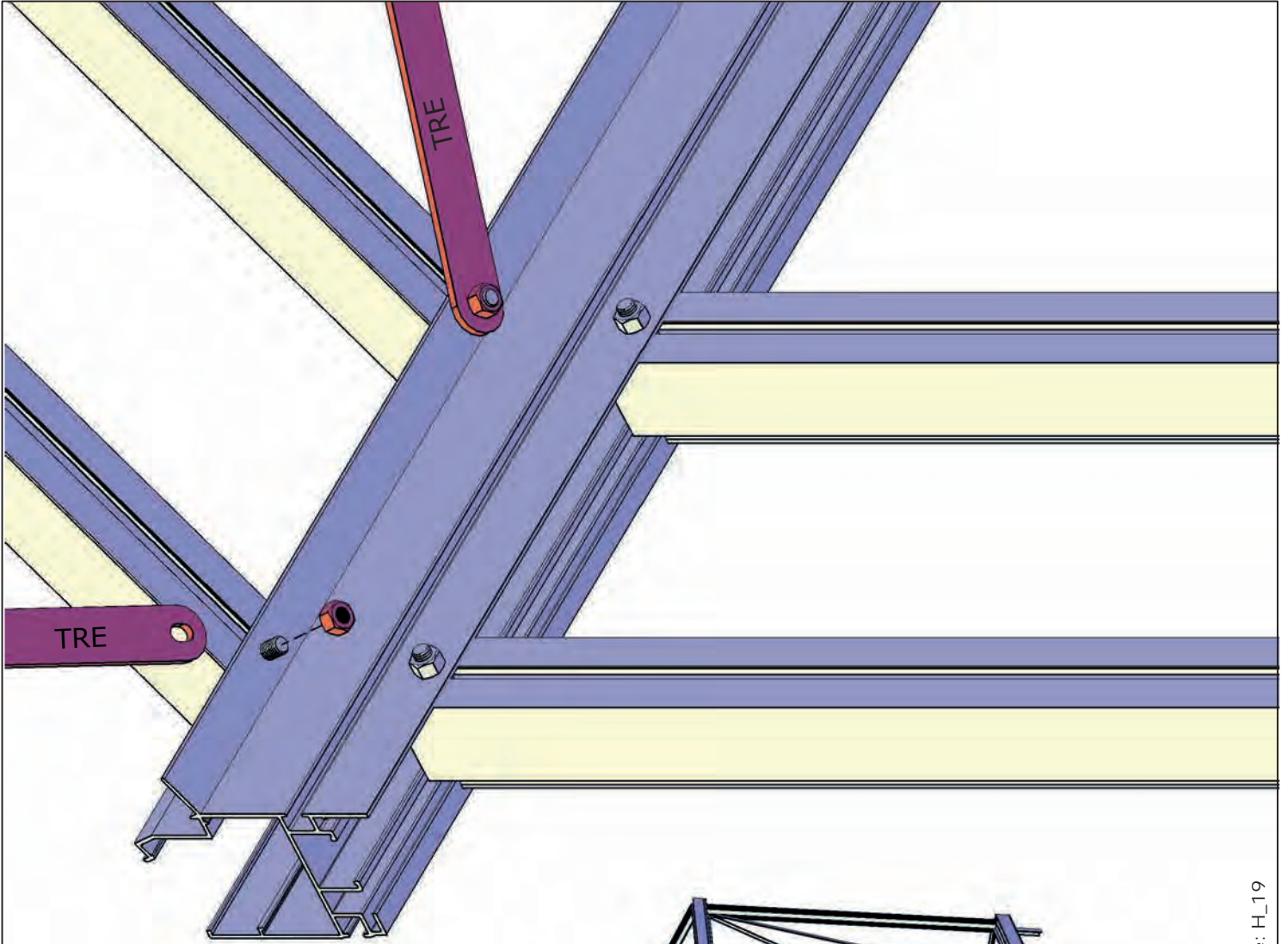
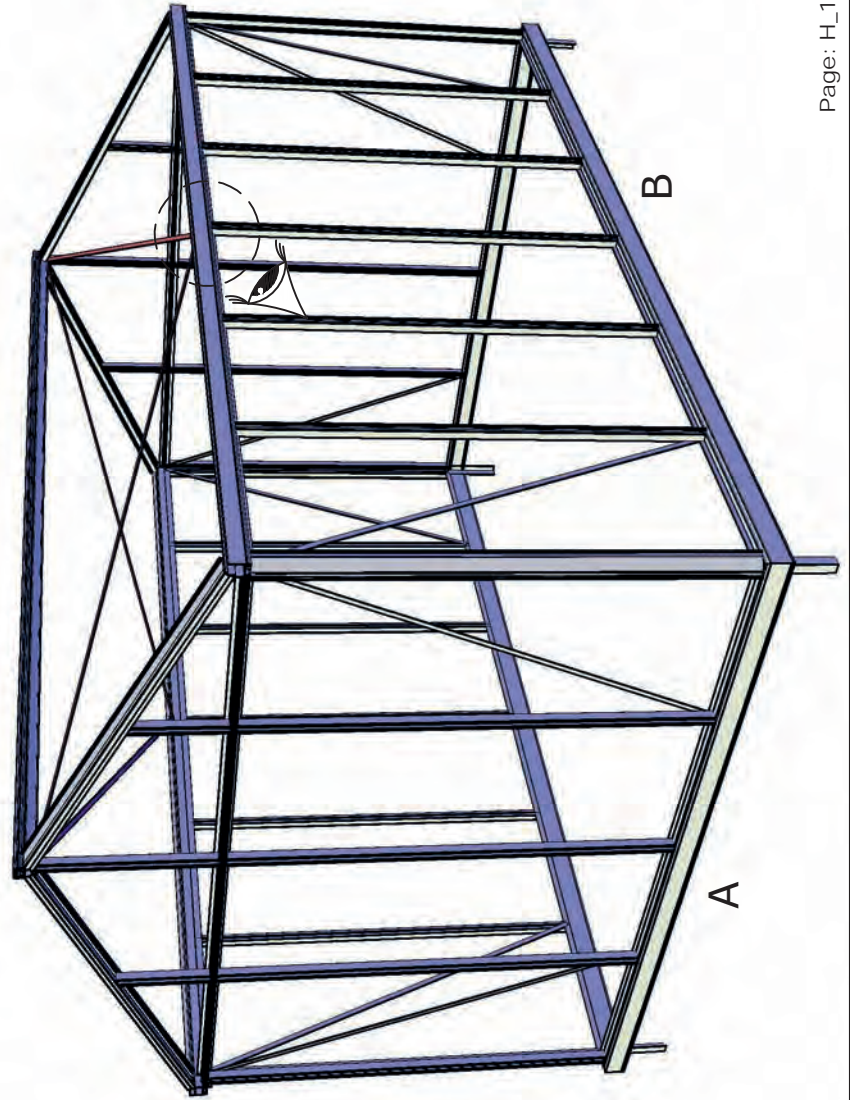
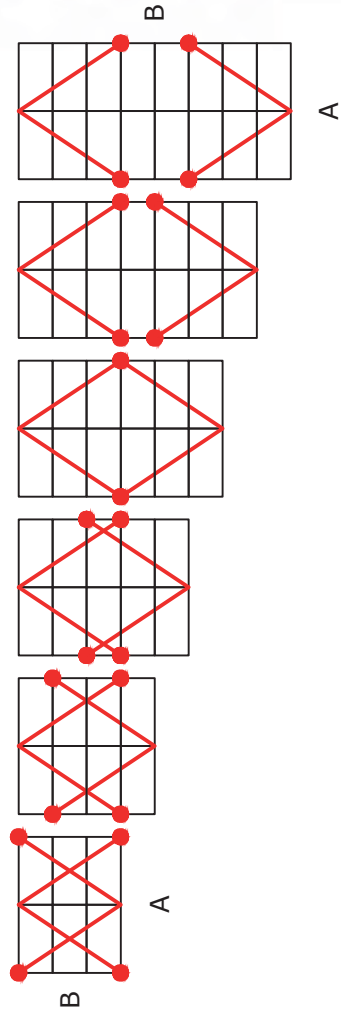
Ends of diagonal  
support will need to be  
bent appropriately.



Placement of Roof Wind Braces (TRE) - View from above  
 Attach first at ridge beam

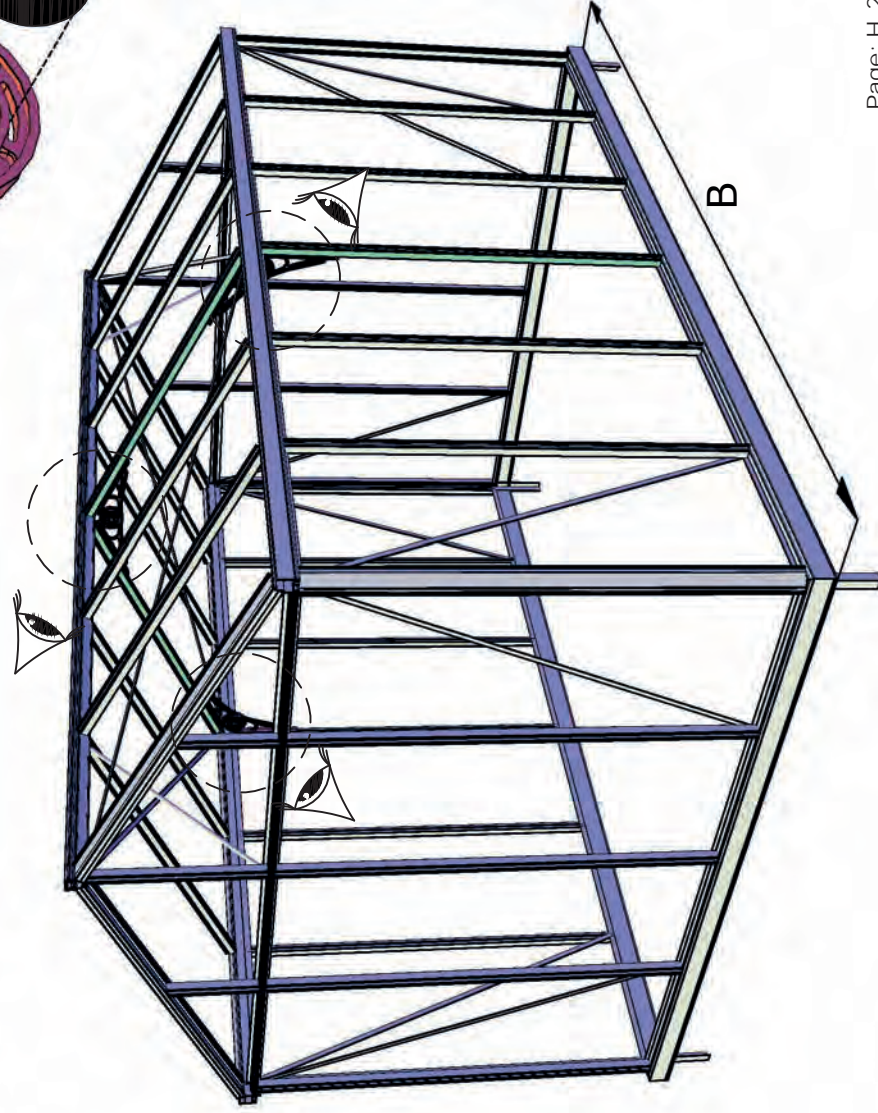
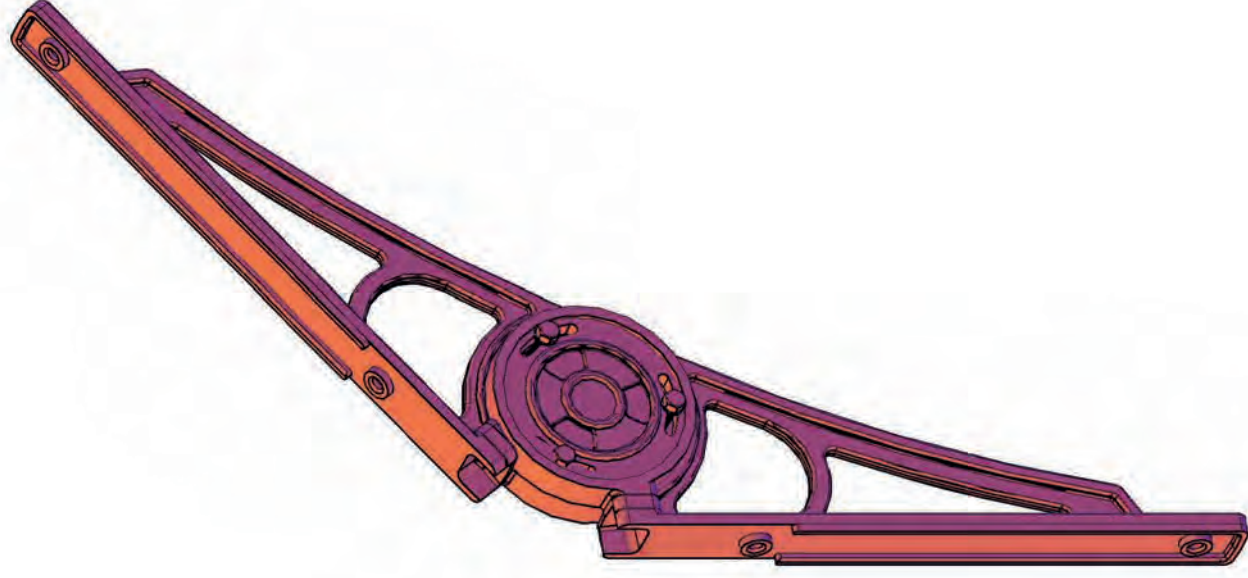
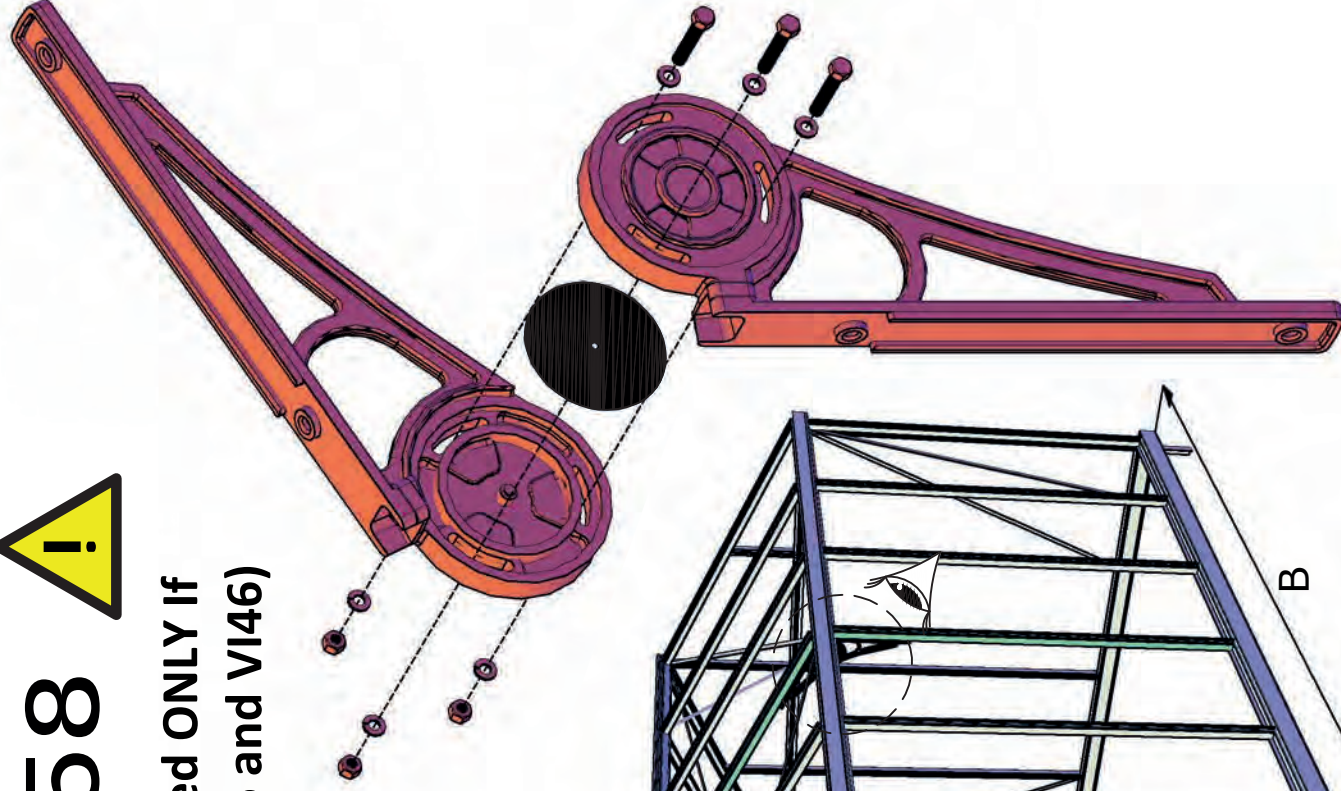
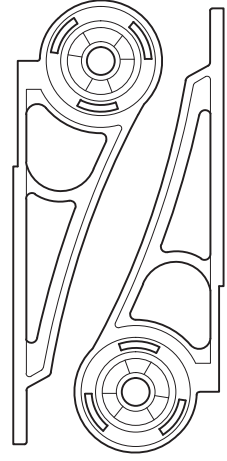


Placement of Roof Wind Braces (TRE) - View from above  
Attachment at gutter profile

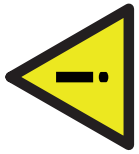


**⚠ B > 4m58 ⚠**

**Scroll Supports are included ONLY if  
length > 4580mm (i.e. V136 and V146)**



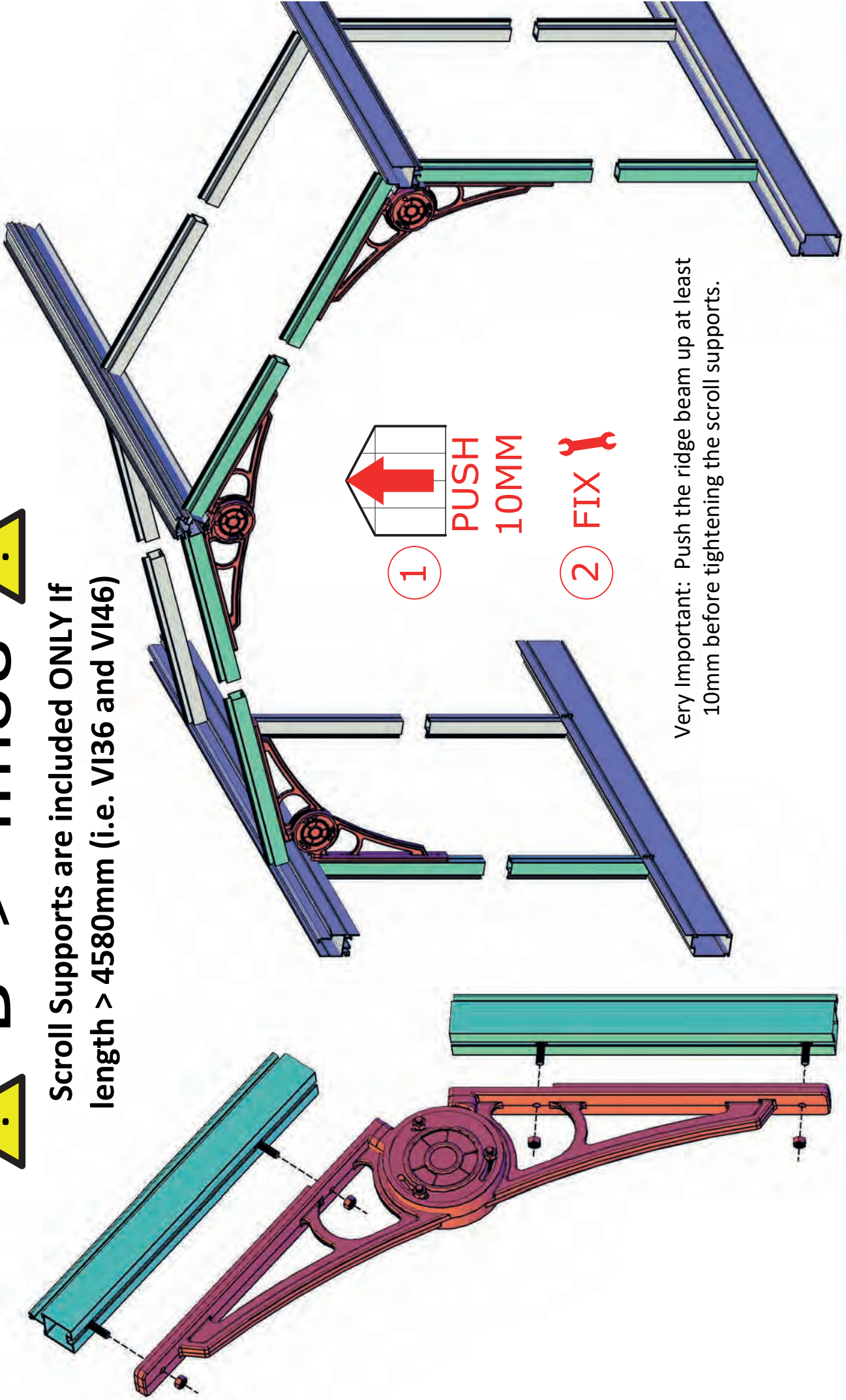




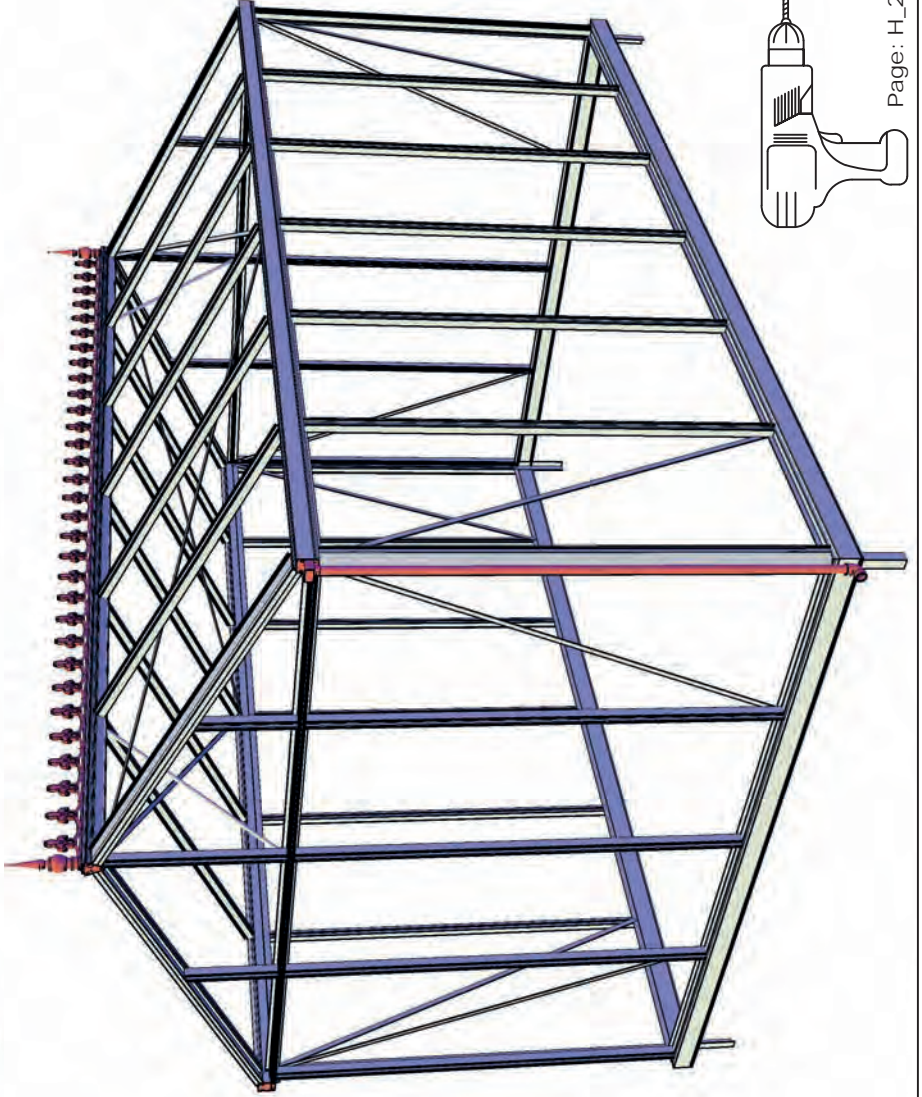
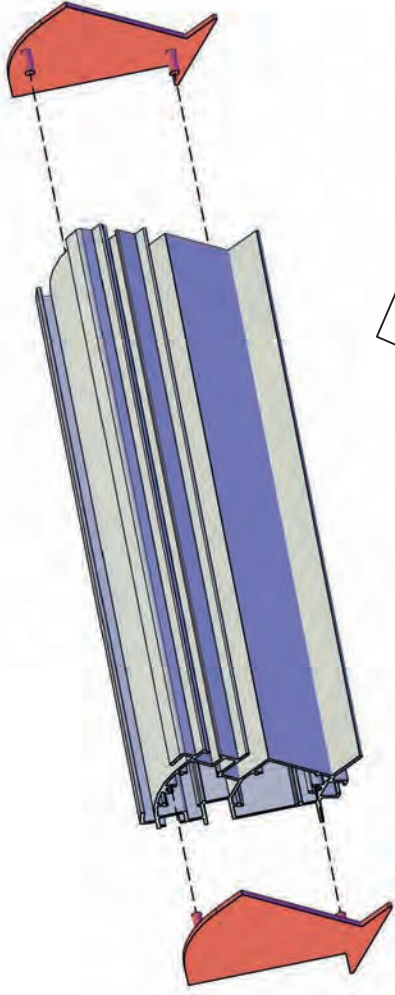
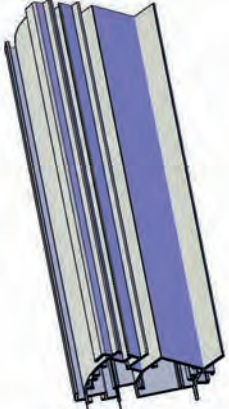
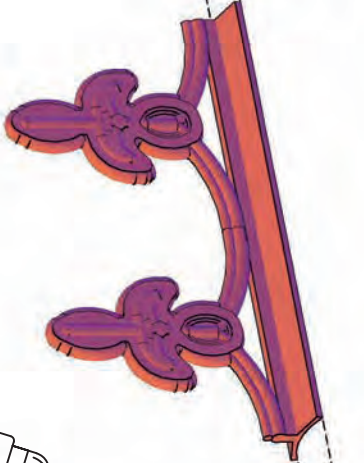
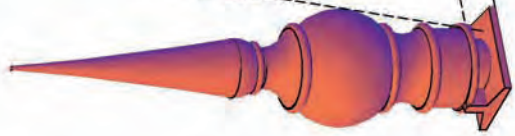
**B > 4m58**



**Scroll Supports are included ONLY If  
length > 4580mm (i.e. V136 and V146)**



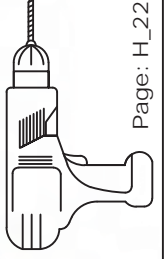
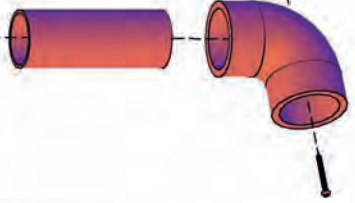
**Very Important: Push the ridge beam up at least  
10mm before tightening the scroll supports.**



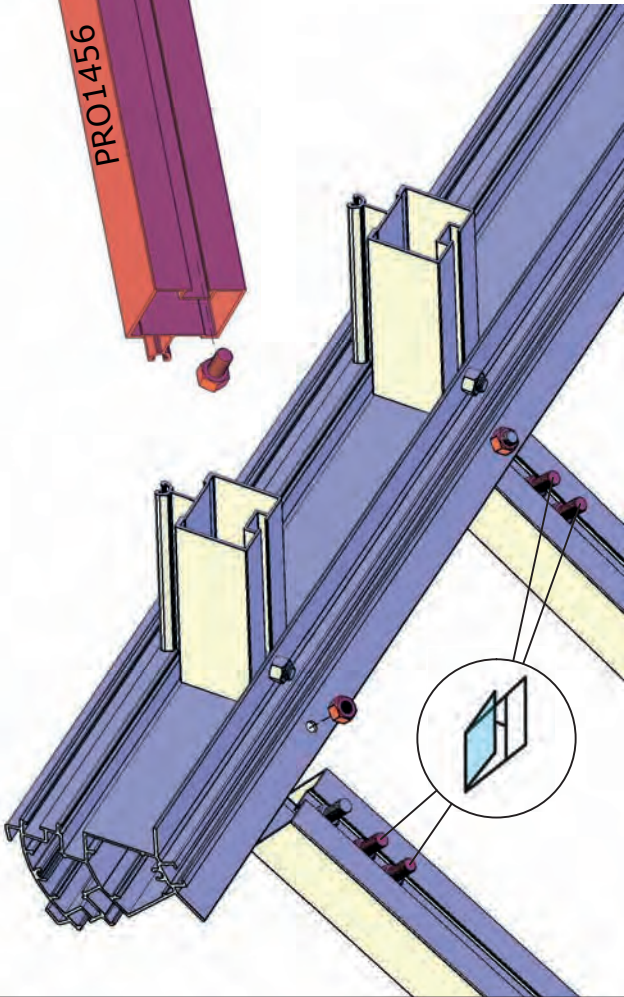
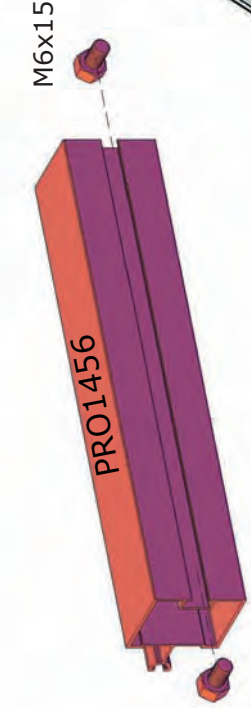
SILICONE

SILICONE

Note: Attach the elbow to the greenhouse base. First, drill a small hole in the back of the elbow and then a small hole in the frame of the greenhouse for the screw to thread into. Run the screw through the hole on the inside of the elbow and into the greenhouse base.

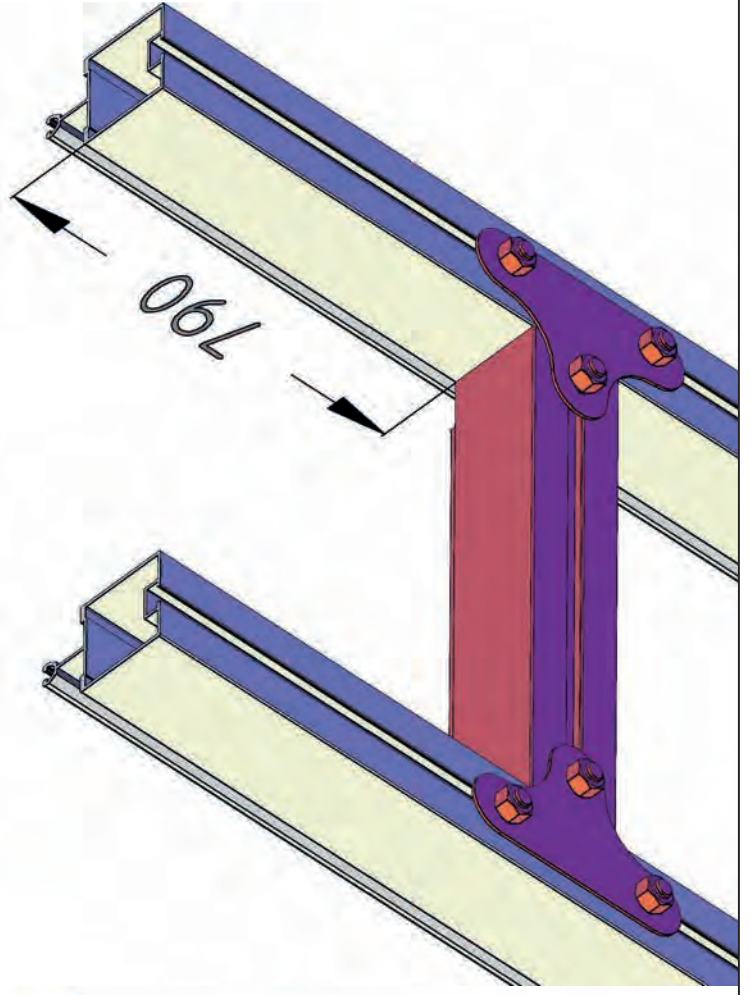
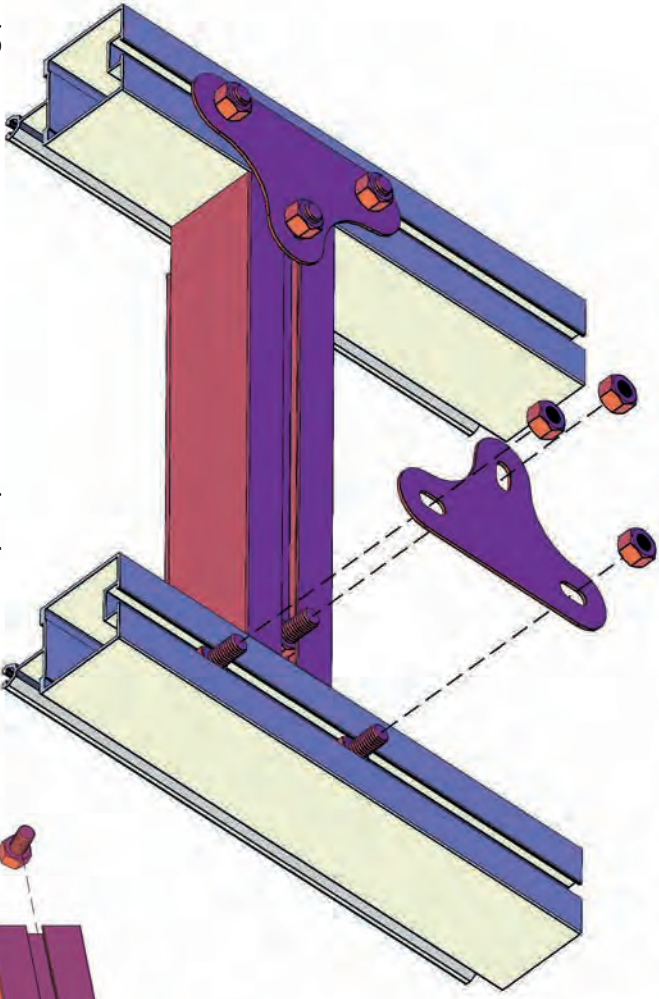


Crossbar for framing roof vent opening. Roof Vents can be installed in any bay. Insert bolts to attach connecting plate.

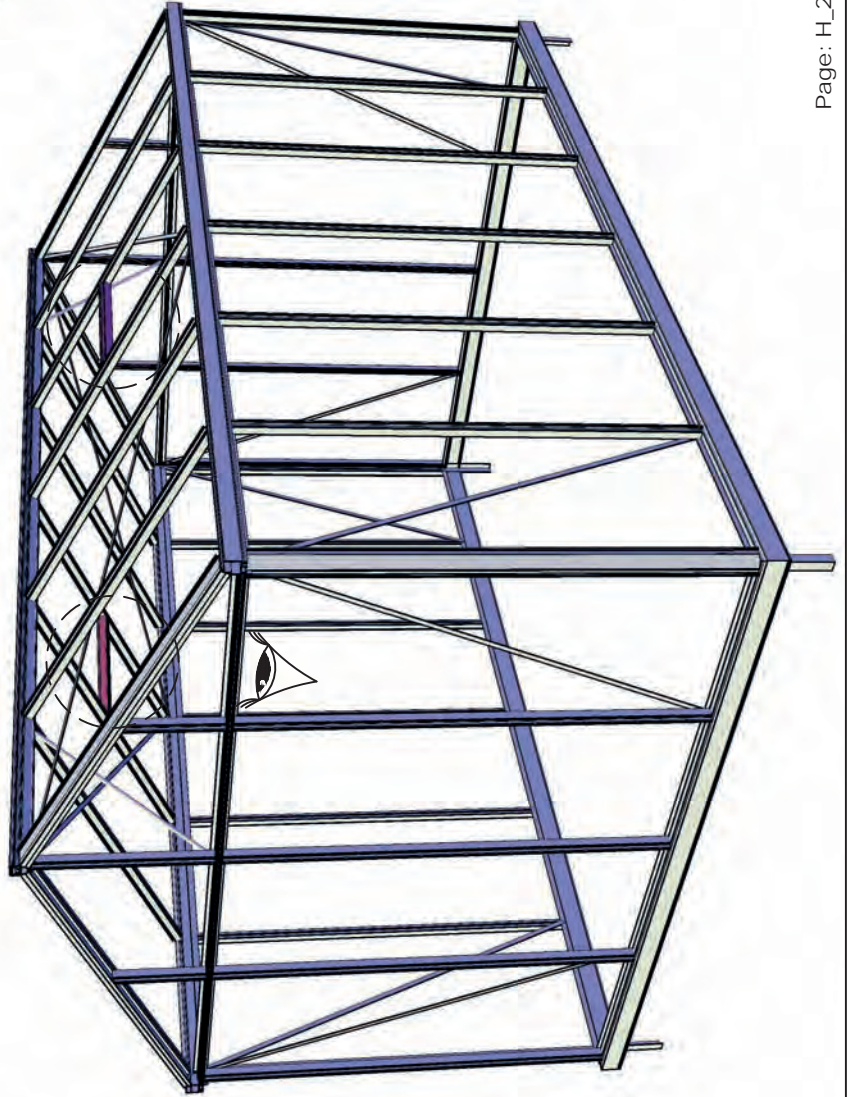


PRO1456

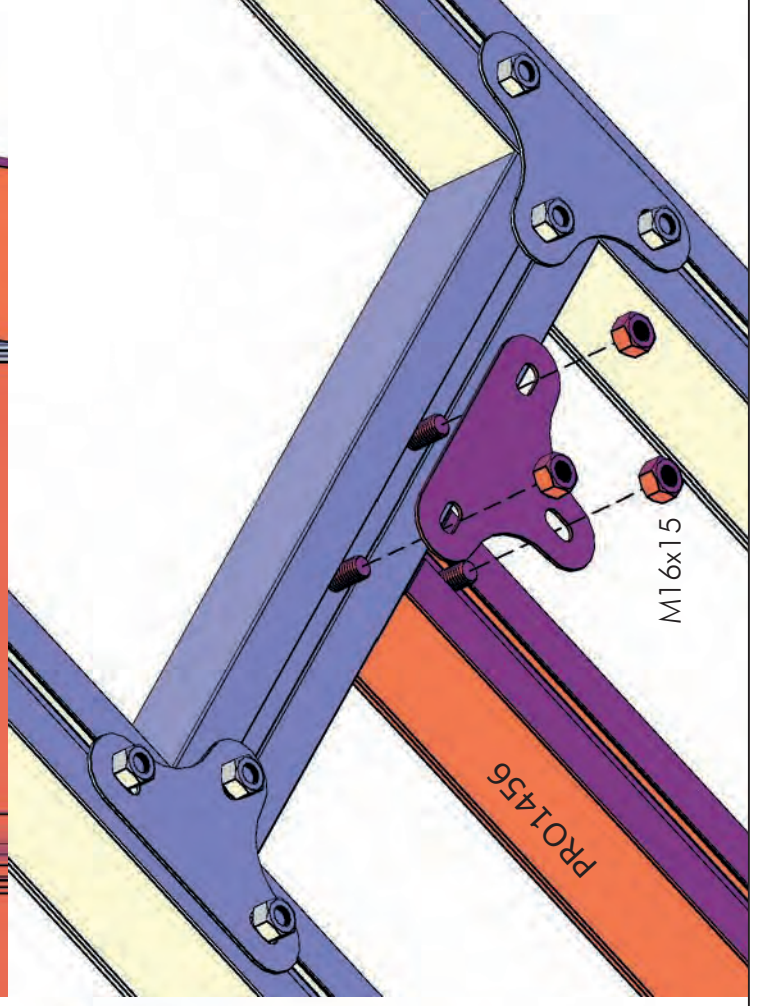
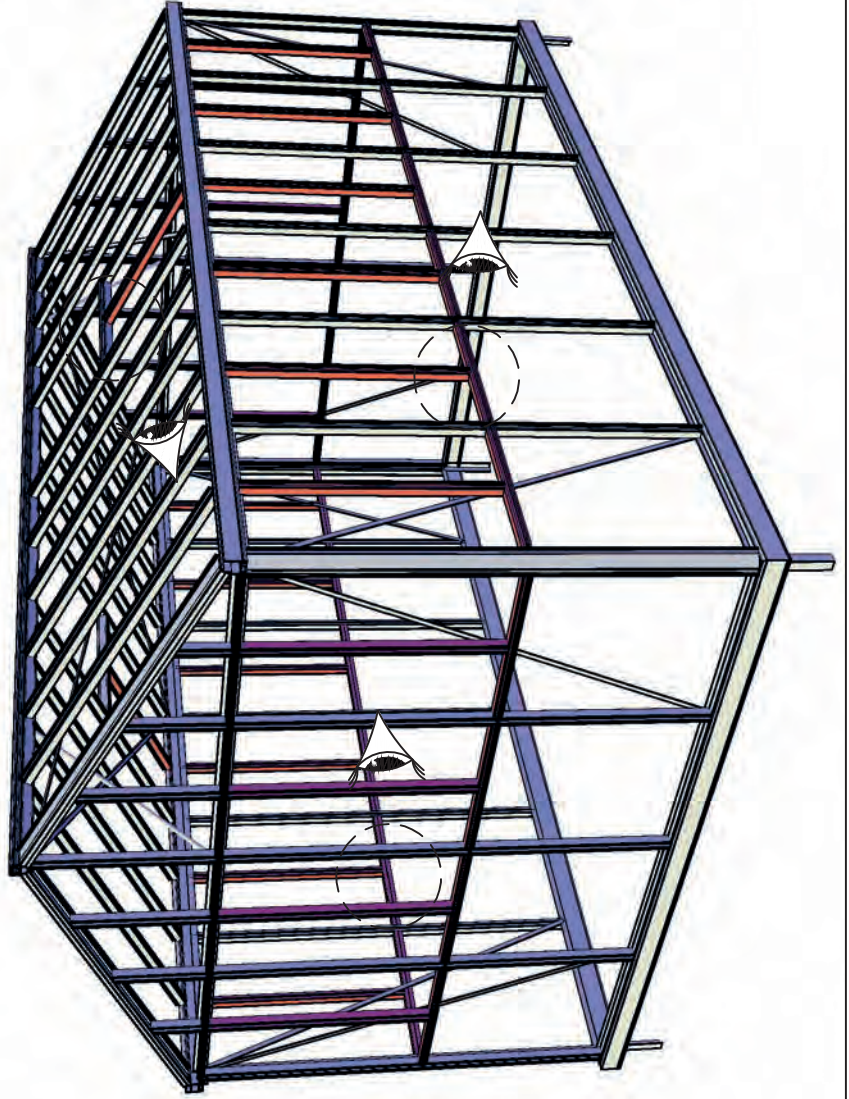
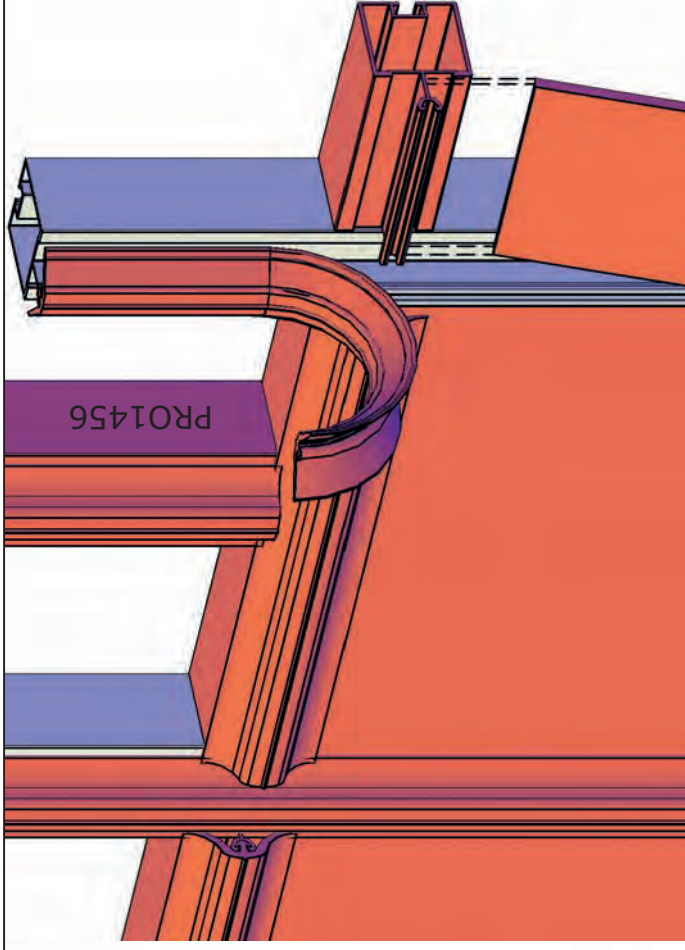
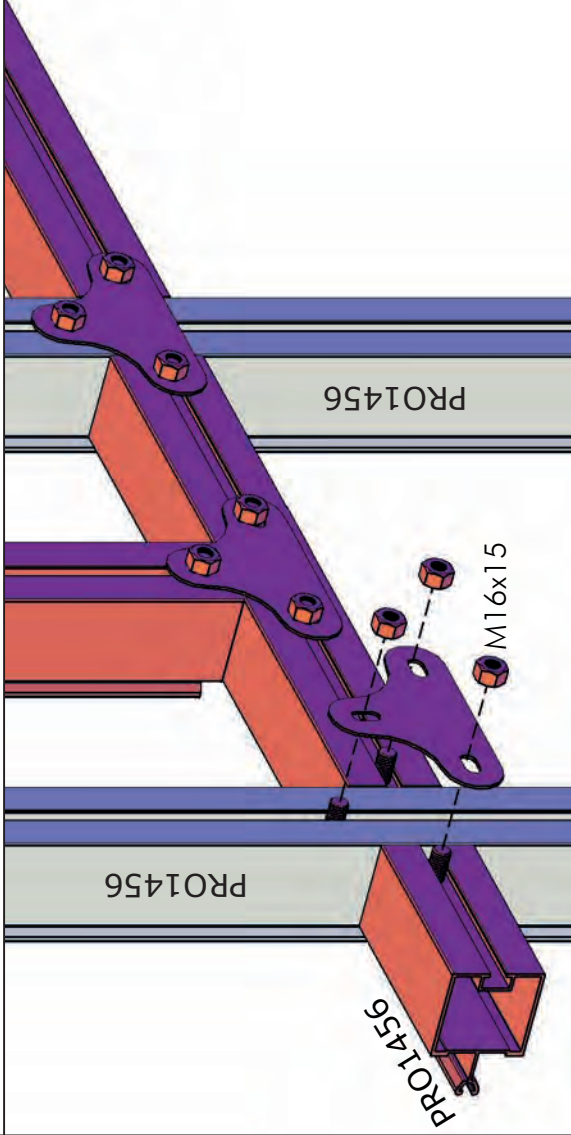
M6x15



190

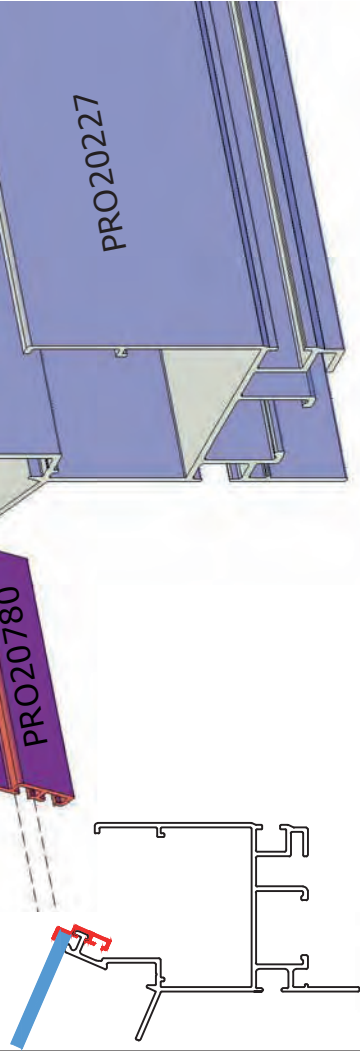


OPTIONAL: THIS PAGE ONLY APPLIES TO 'RETRO' MODEL

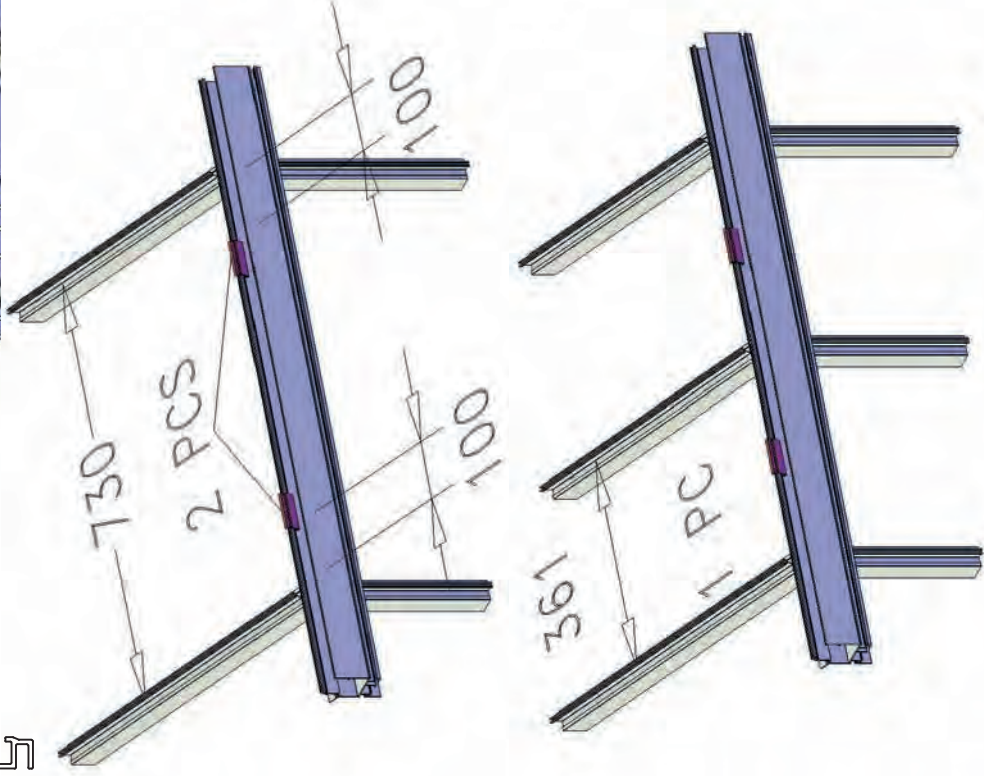
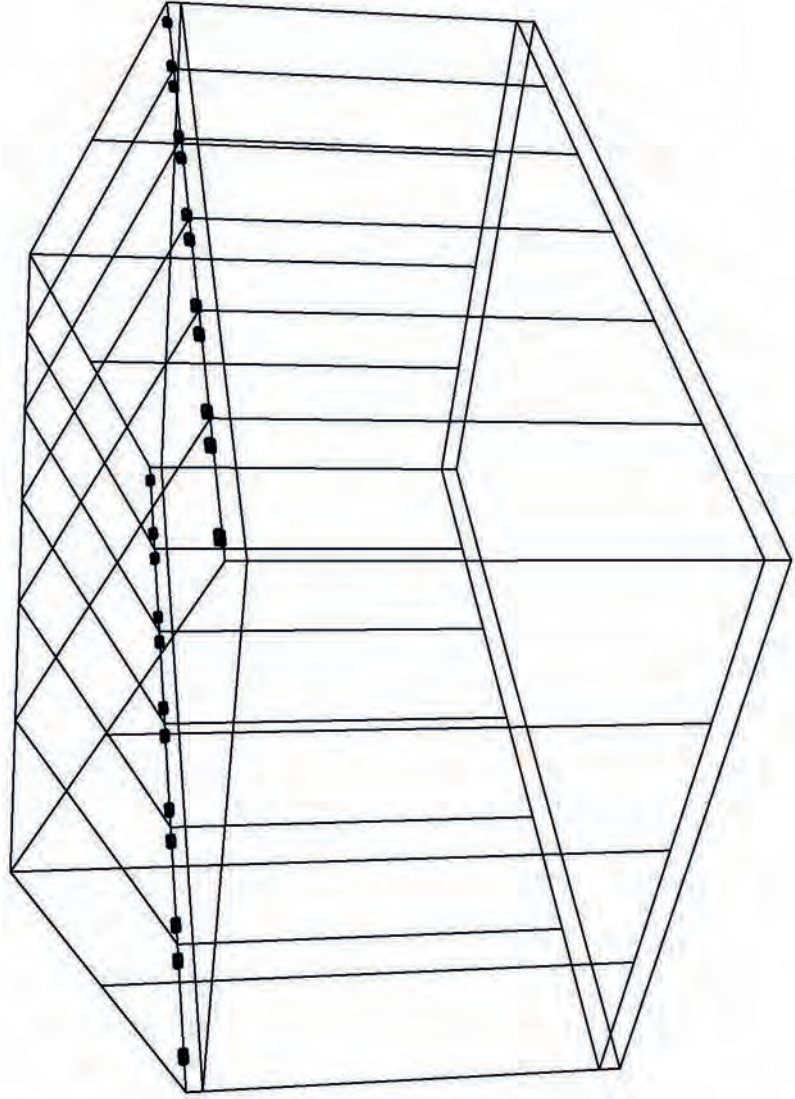


Glazing supports slide onto the gutter profile, space them 100mm or 4 inches from each roof profile.

4mm  
GLASS

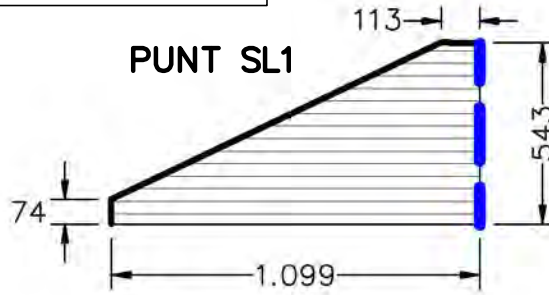
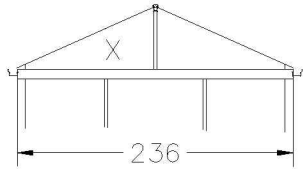


10mm  
POLYCARBONATE

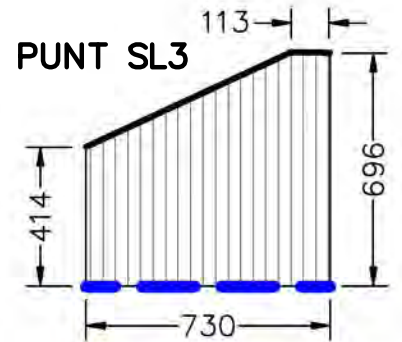
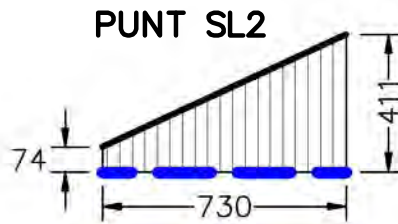
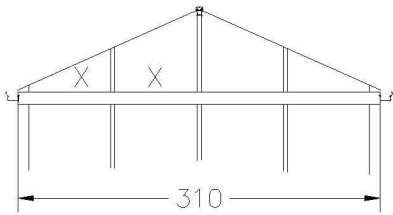


# HELIOS polycarbonate 10mm

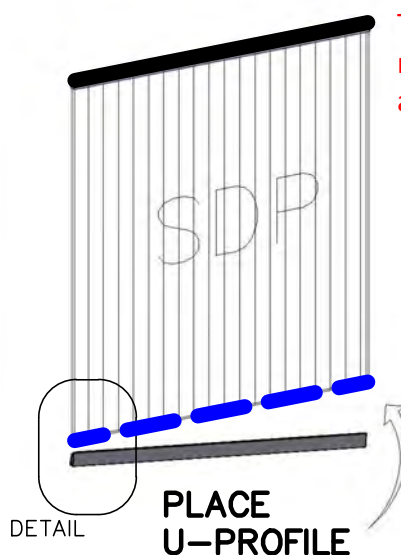
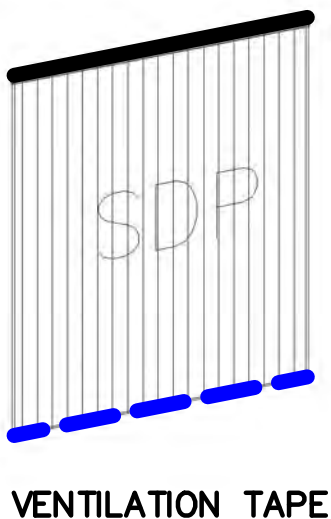
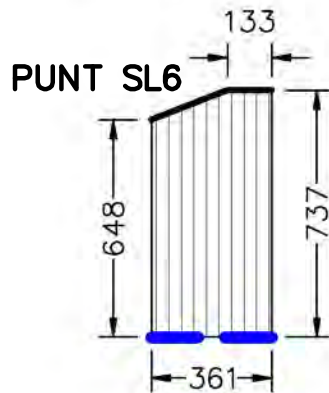
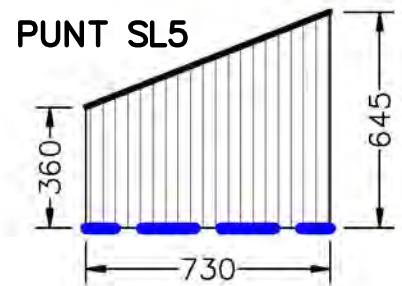
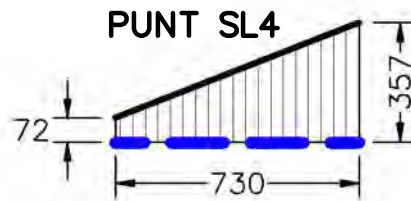
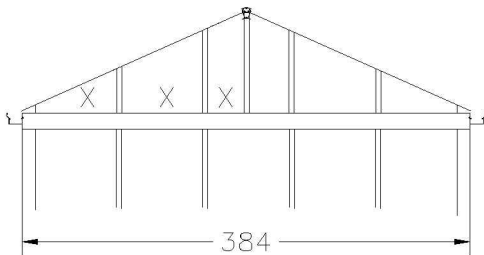
This page is for polycarbonate units only.



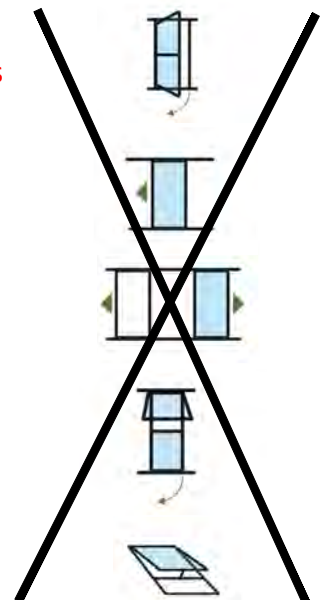
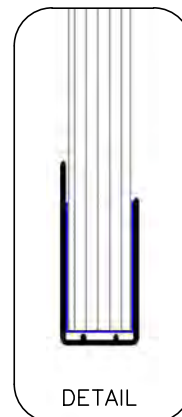
The crescent seal (E400330) is NOT used with polycarbonate. It may be shipped with your unit, but it is only for GLASS panels.

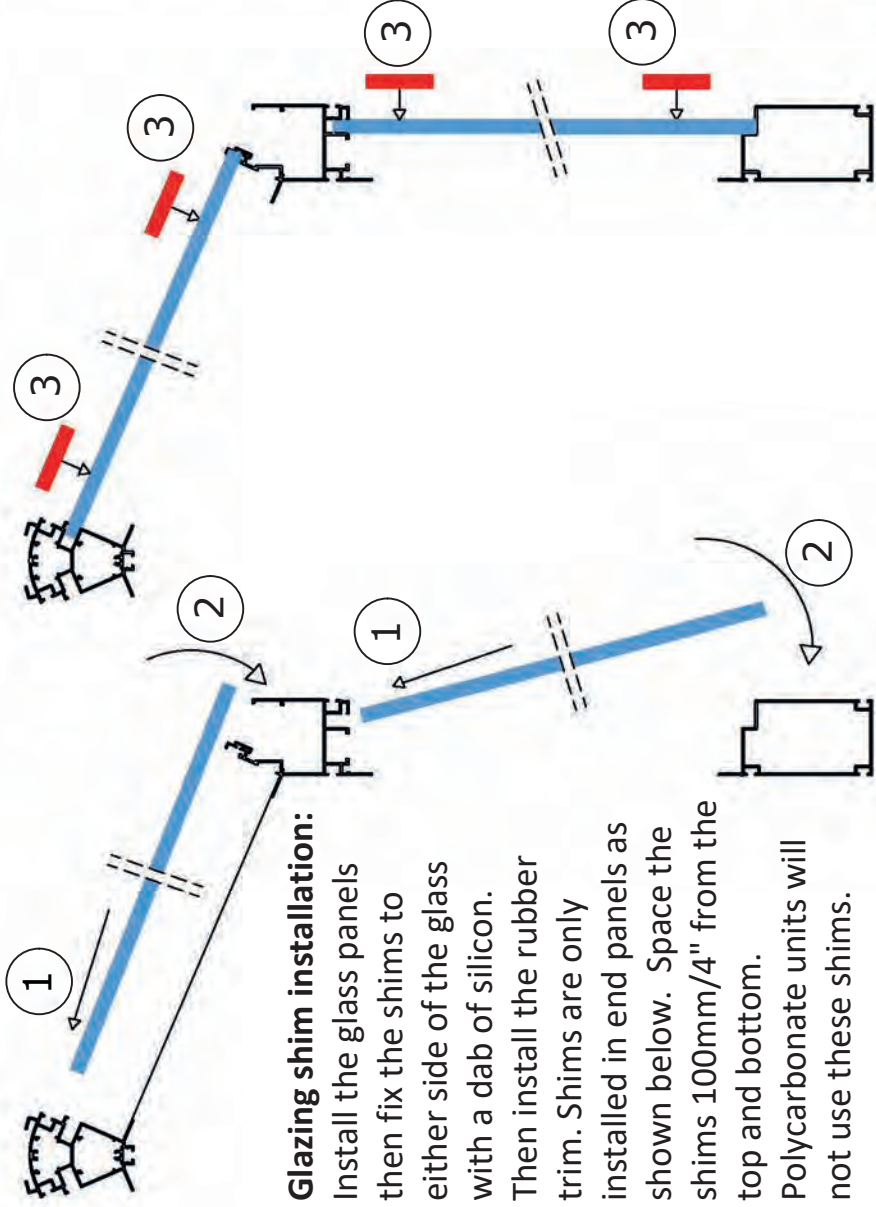


Remove the protective film, but leave the silver sealed tape and ventilation tape on the ends. Ventilation tape indicates the bottom of the panel.



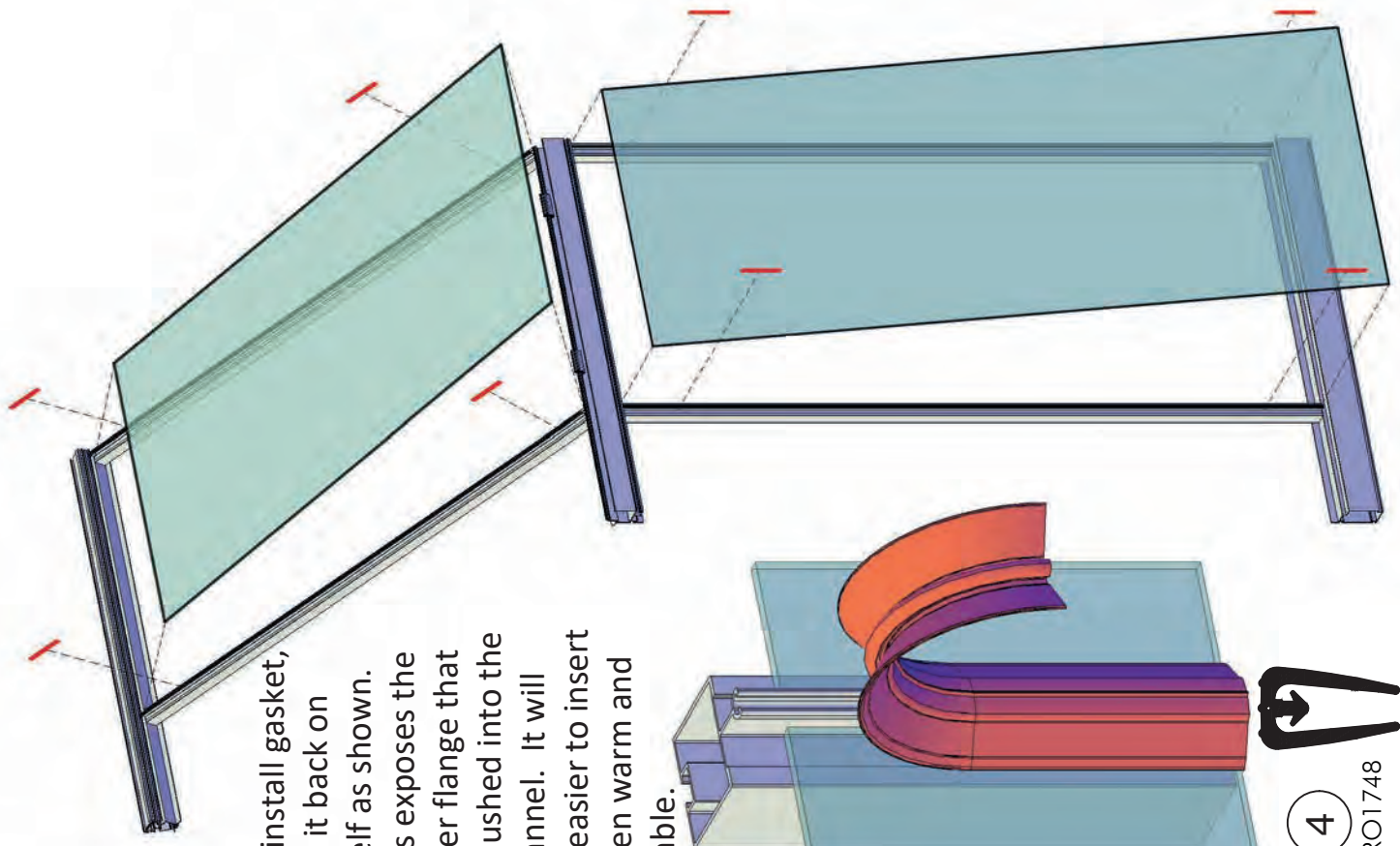
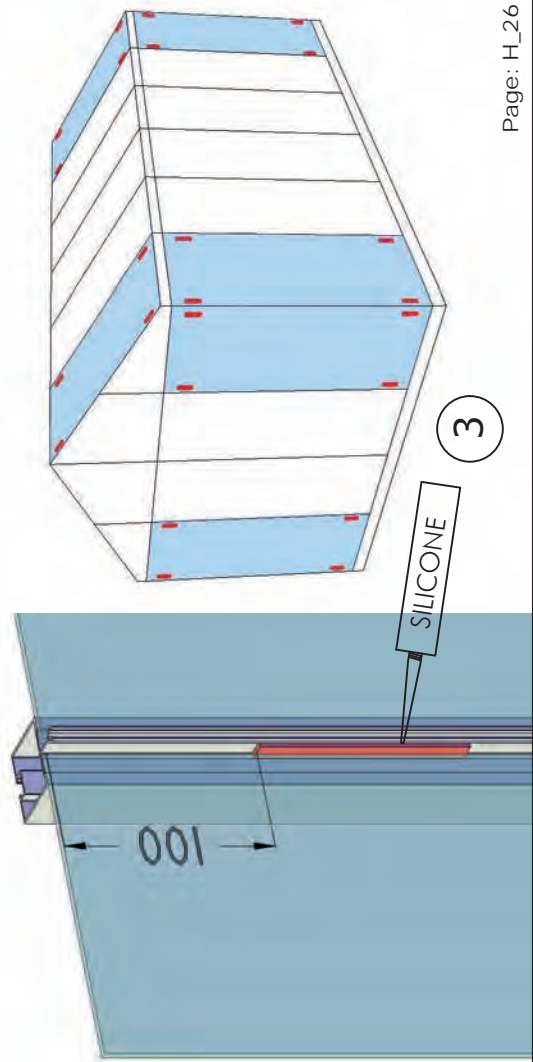
The U-profiles are not used in the doors and windows.





**Glazing shim installation:**

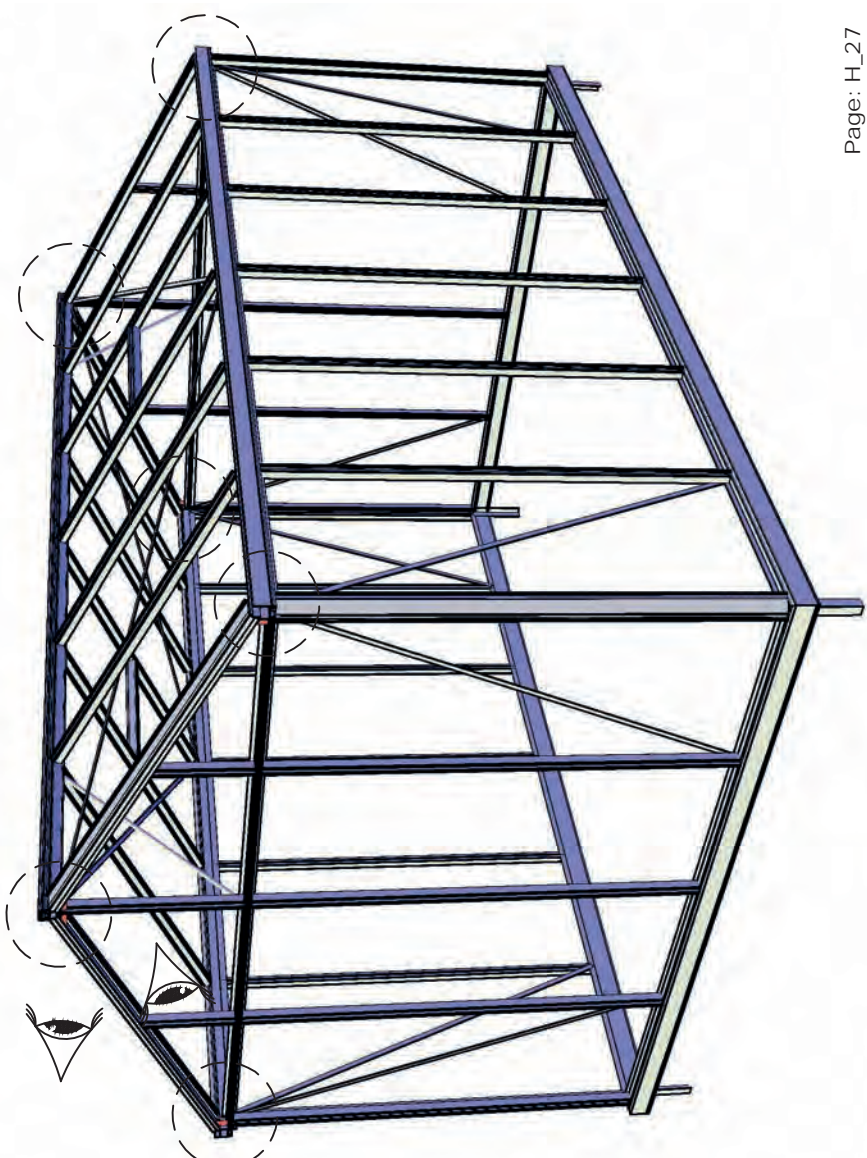
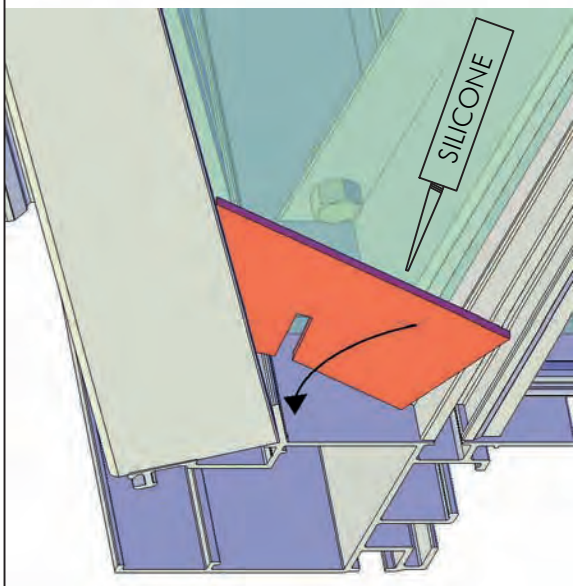
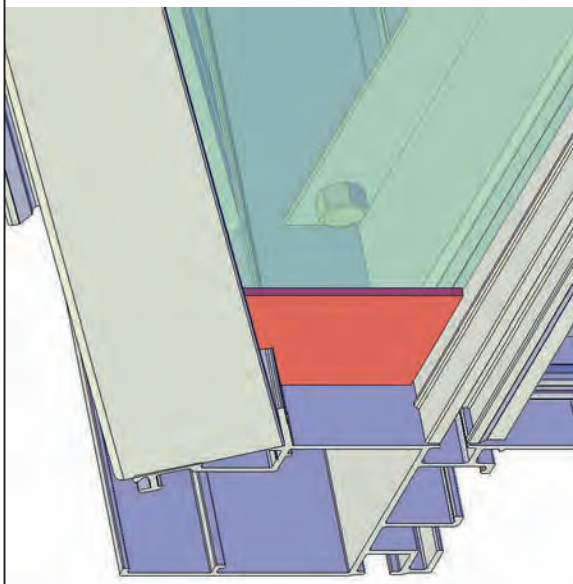
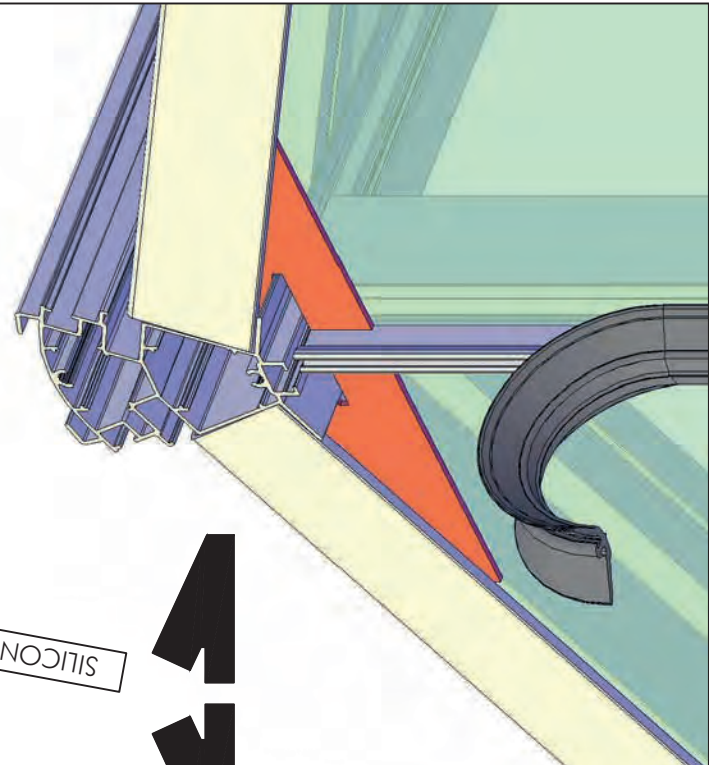
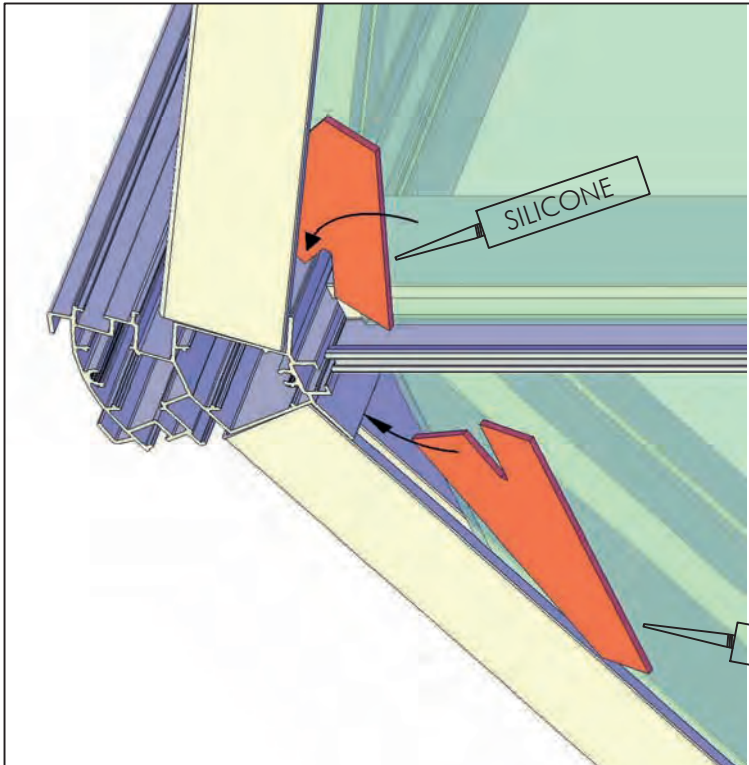
Install the glass panels then fix the shims to either side of the glass with a dab of silicon. Then install the rubber trim. Shims are only installed in end panels as shown below. Space the shims 100mm/4" from the top and bottom. Polycarbonate units will not use these shims.



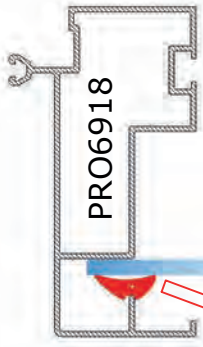
To install gasket, roll it back on itself as shown. This exposes the inner flange that is pushed into the channel. It will be easier to insert when warm and pliable.

4

PRO1748



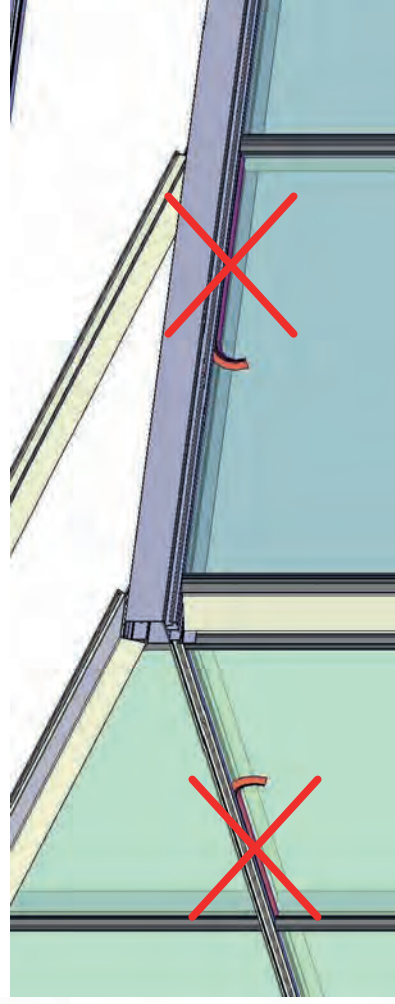
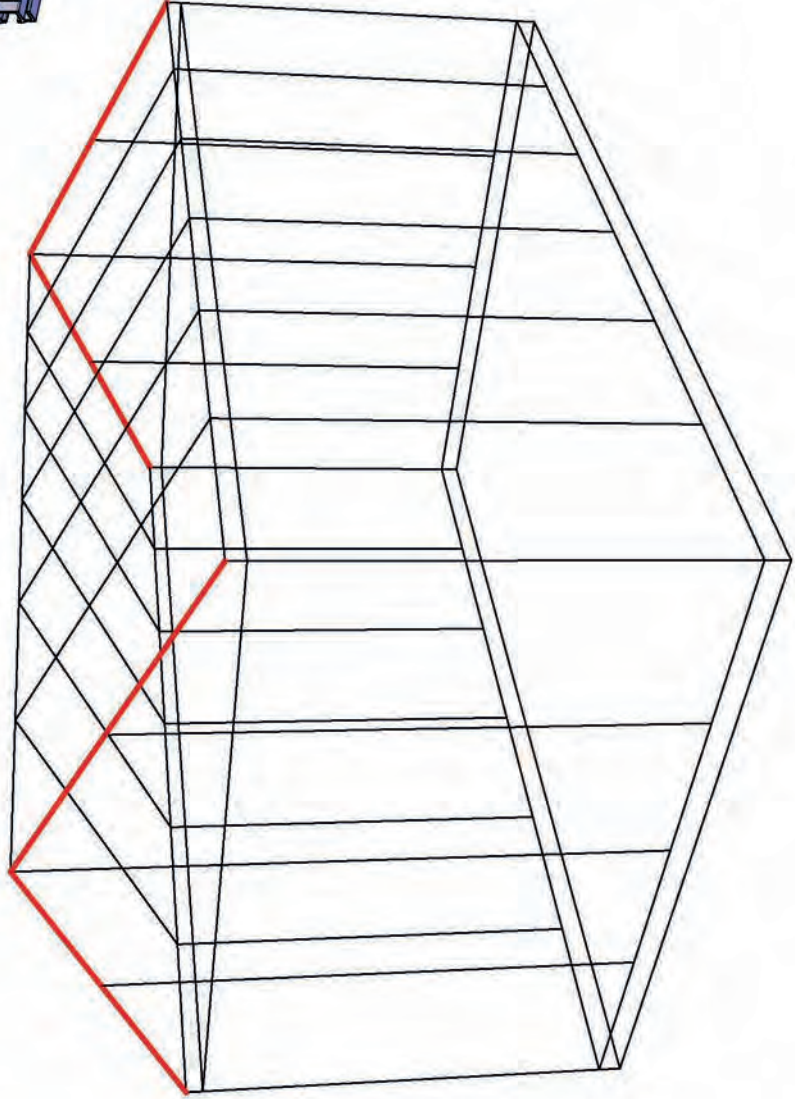
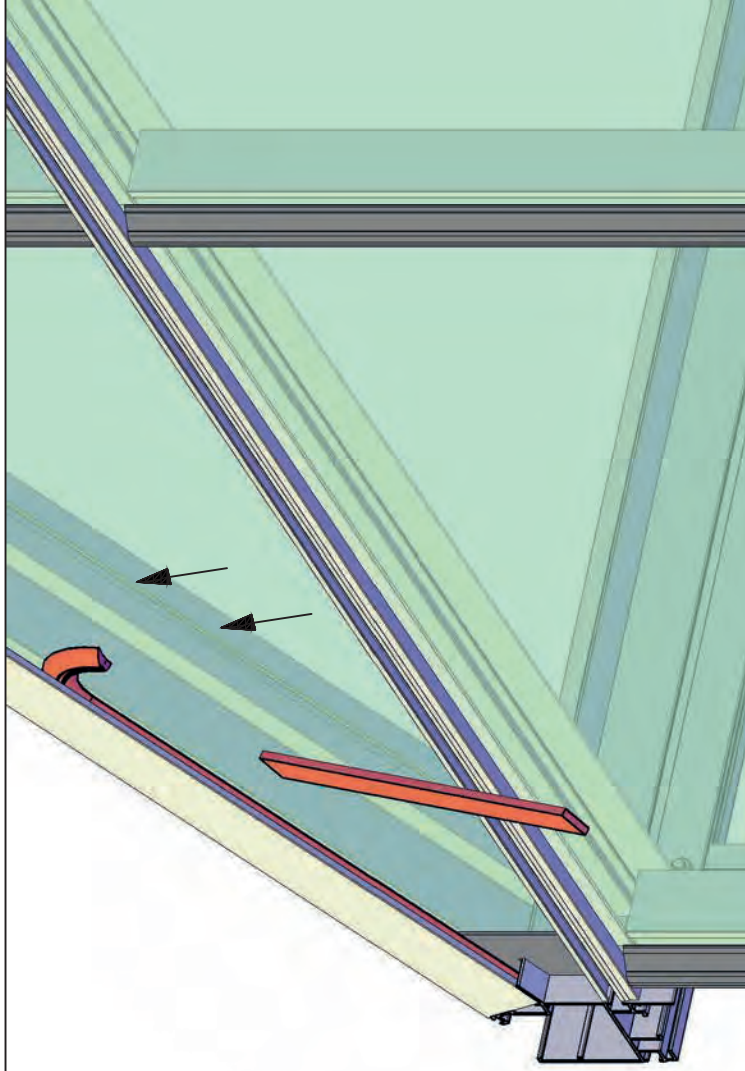




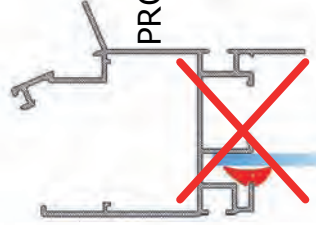
PRO6918



E400330



Crescent seal is only installed in the eaves and roof. Not along side walls.

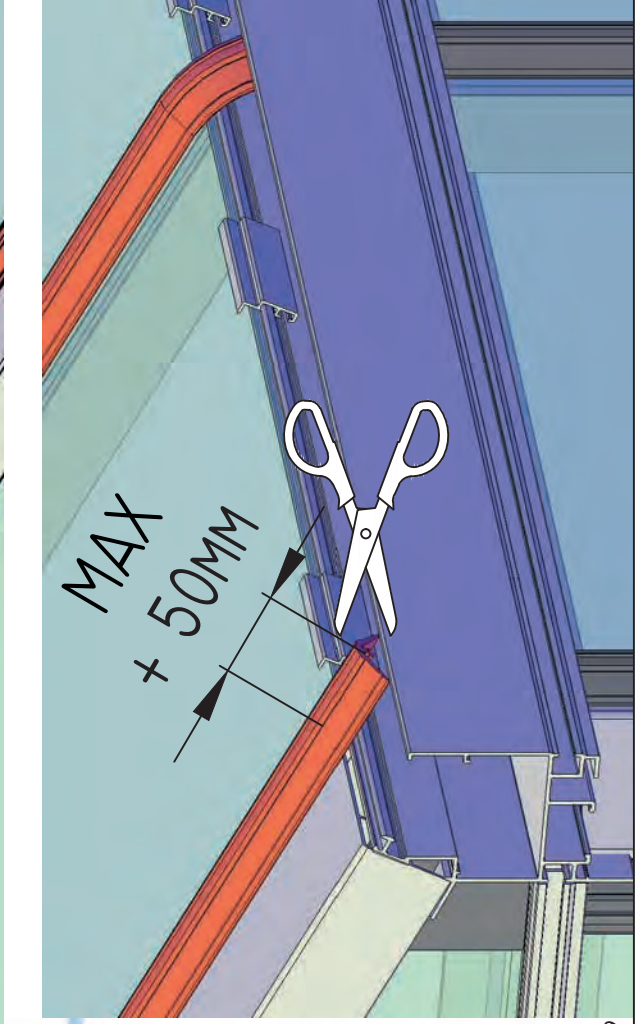
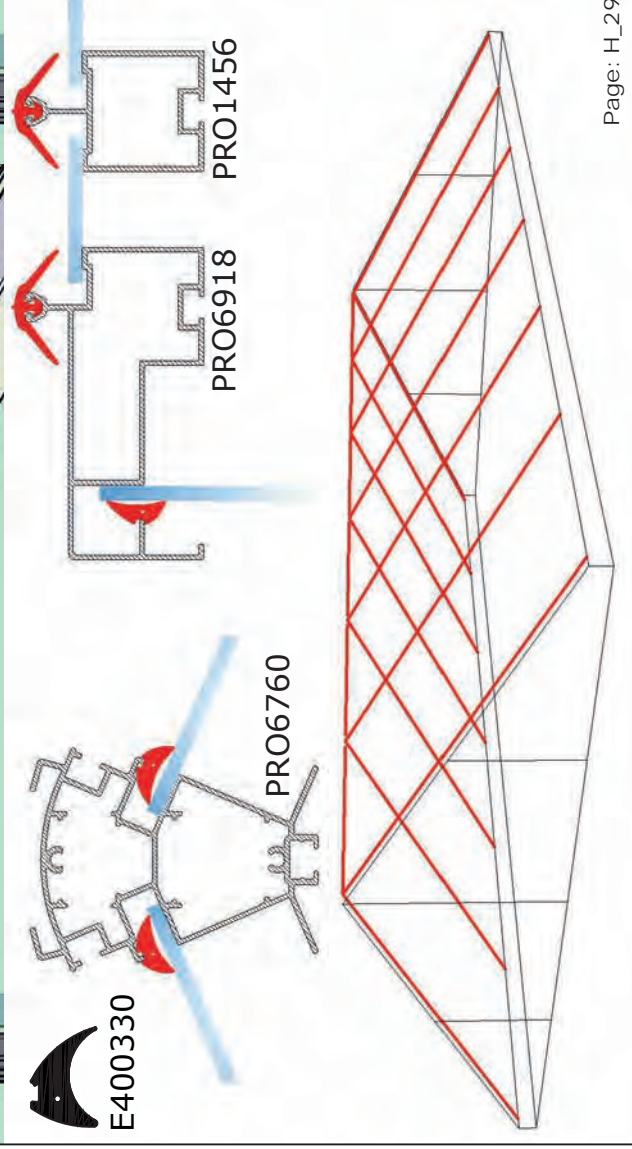
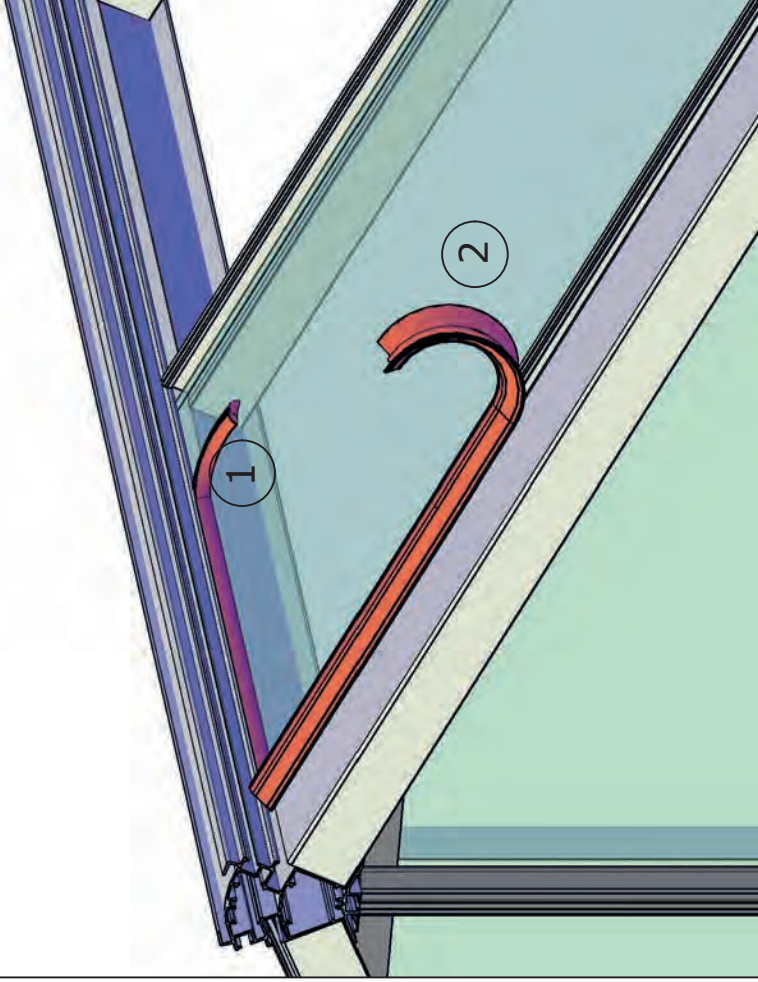


PRO20227



PRO20229

To install heavy gasket, it is easiest to roll it back on itself as shown. This exposes the inner flange that is pushed into the channel. It will be easier to insert when warm and pliable. Install the roof glazing pane by pane, inserting gaskets after each.



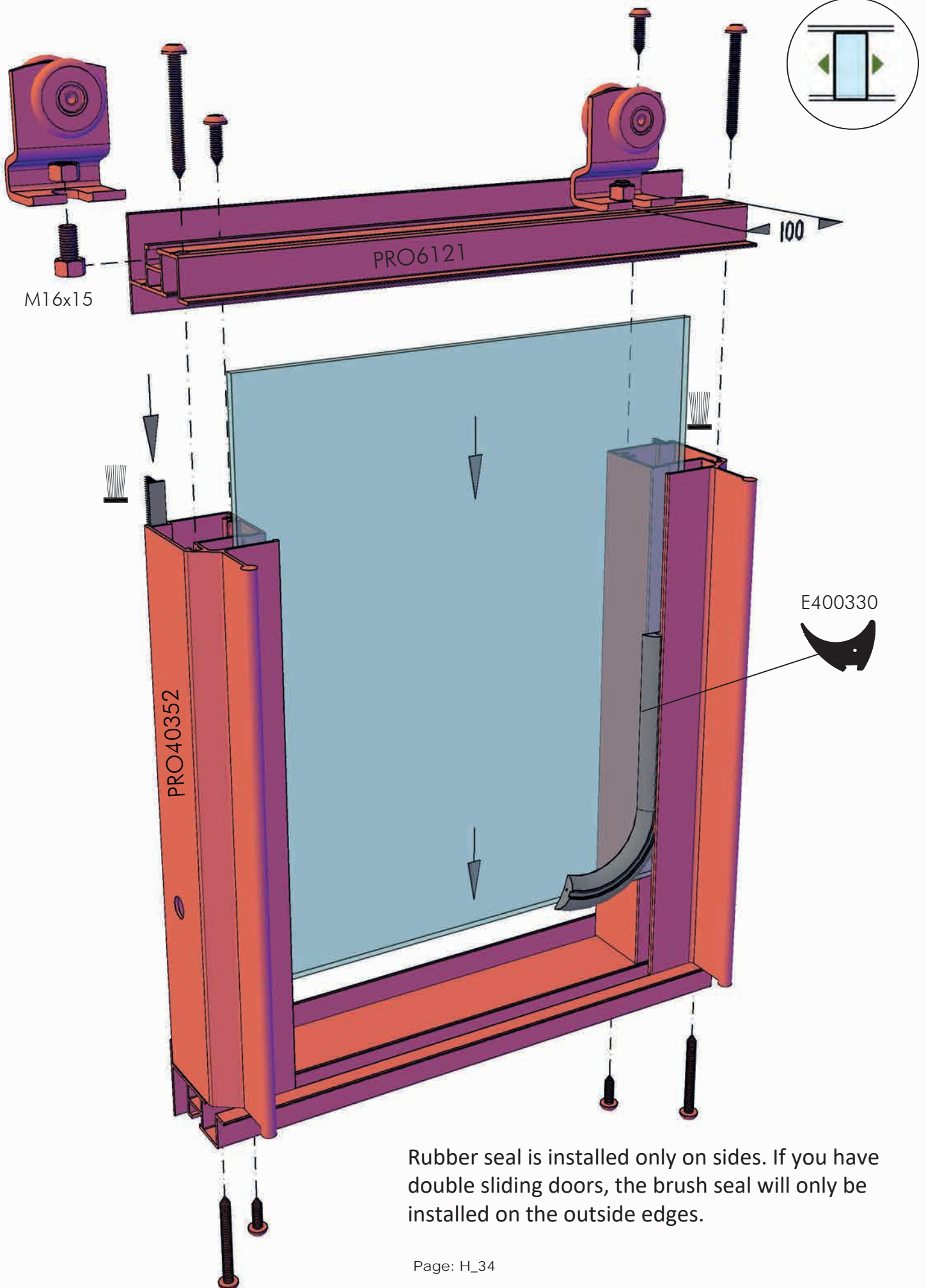
## **ACCESSORIES**

This section contains many of the optional accessories.

You will have some, but likely not all, items seen in this section.

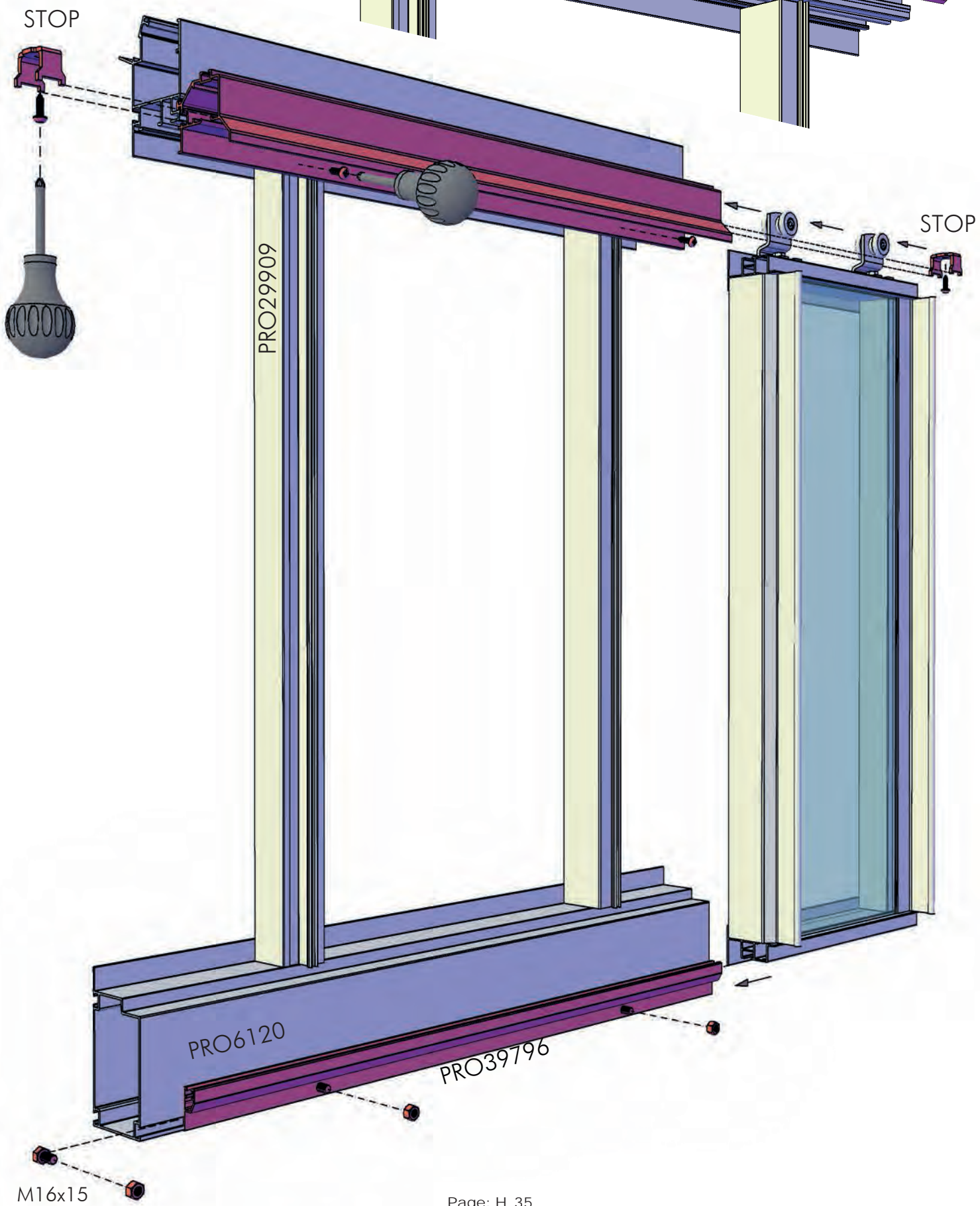
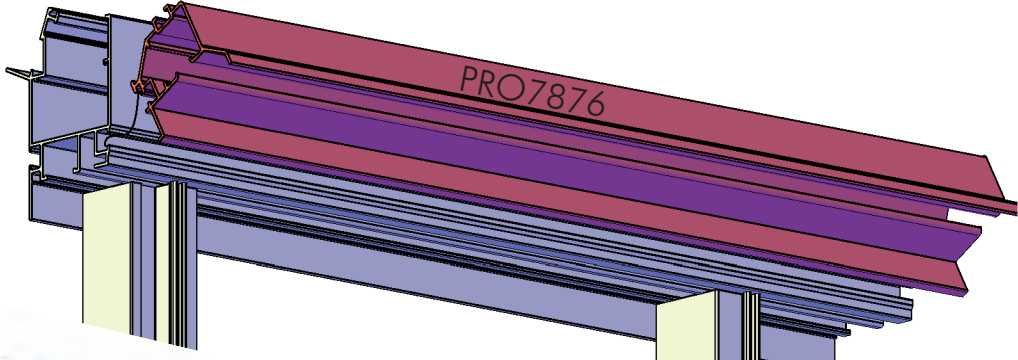
# Sliding door (standard for most models)

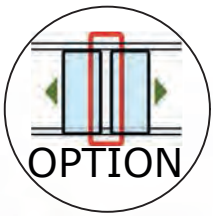
Some models will have double sliding doors.



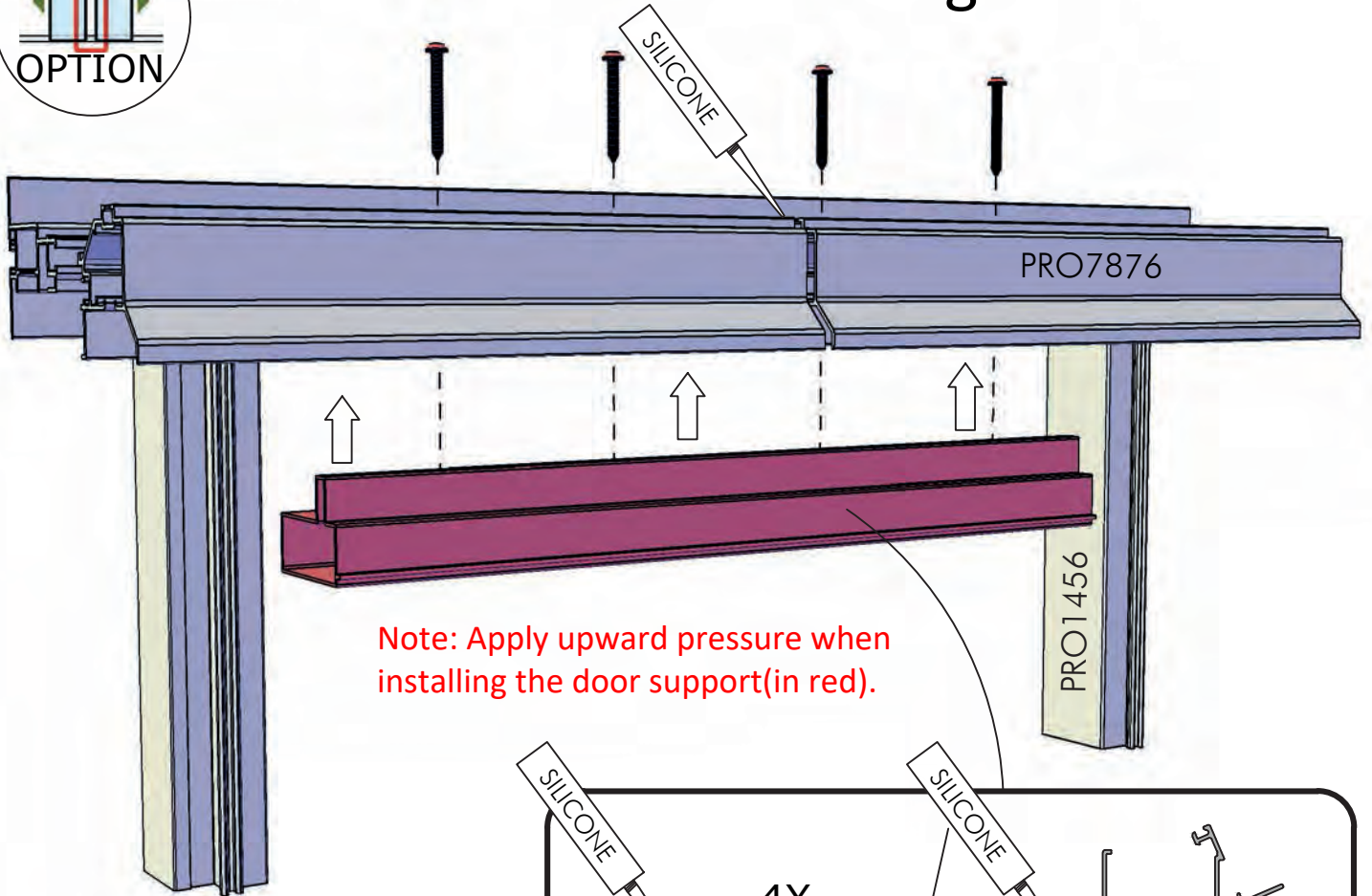
Rubber seal is installed only on sides. If you have double sliding doors, the brush seal will only be installed on the outside edges.

# Sliding Door

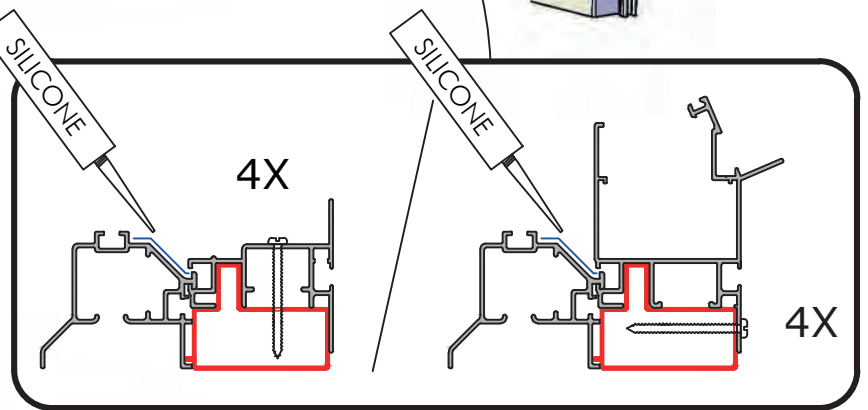




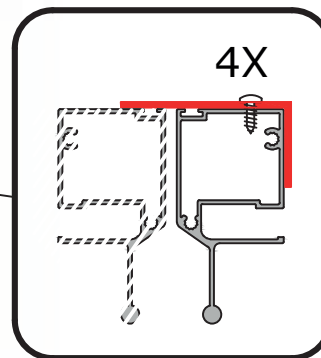
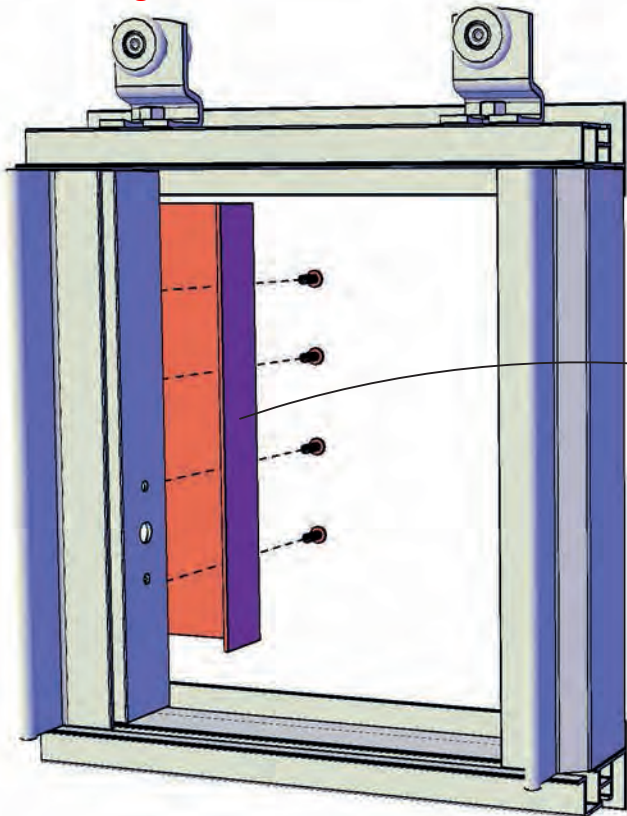
# OPTION: Double Sliding Door



Note: Apply upward pressure when installing the door support(in red).



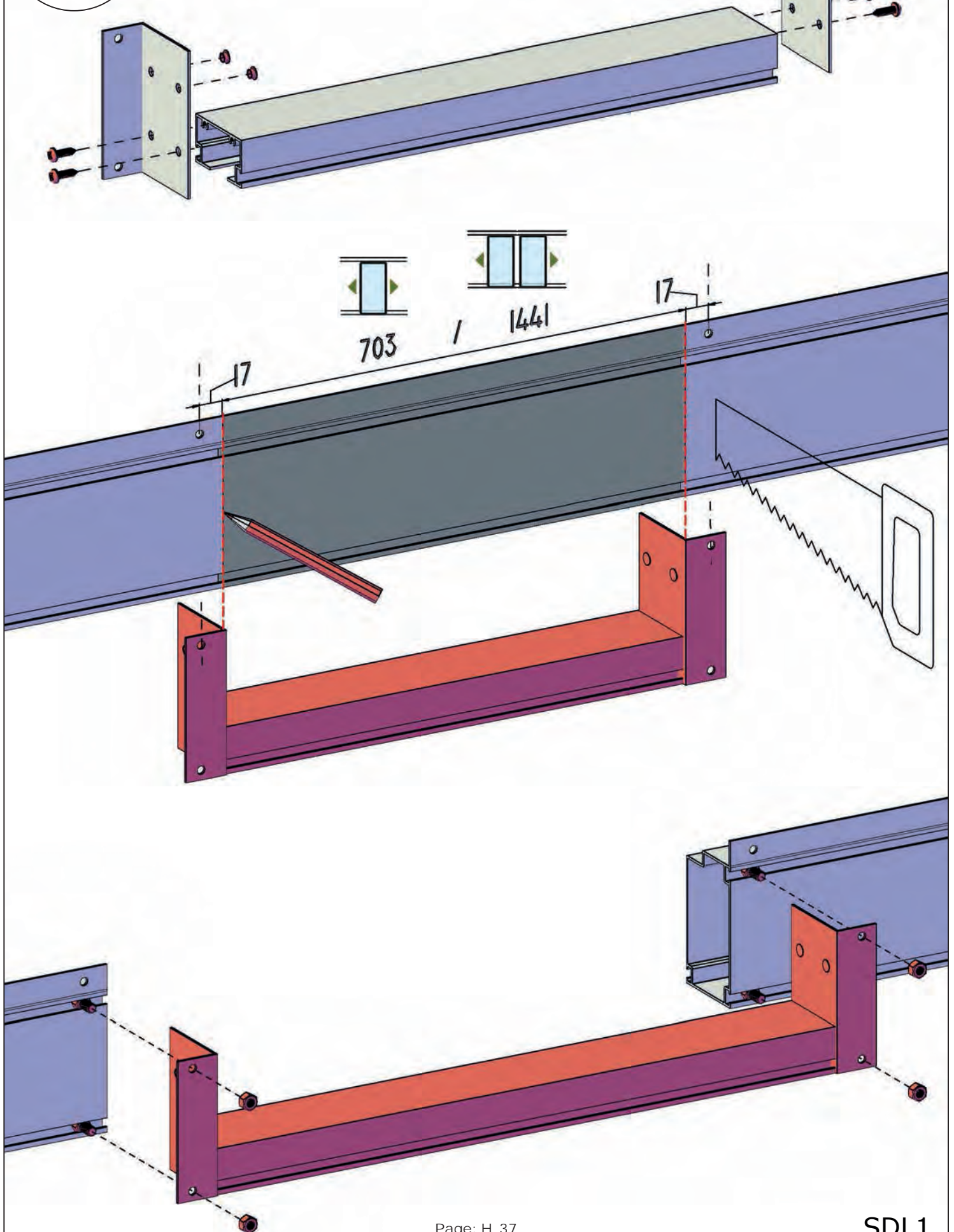
As needed, use washer underneath door hanger to level the door .



Add L bracket to close the gap between the doors where they meet.

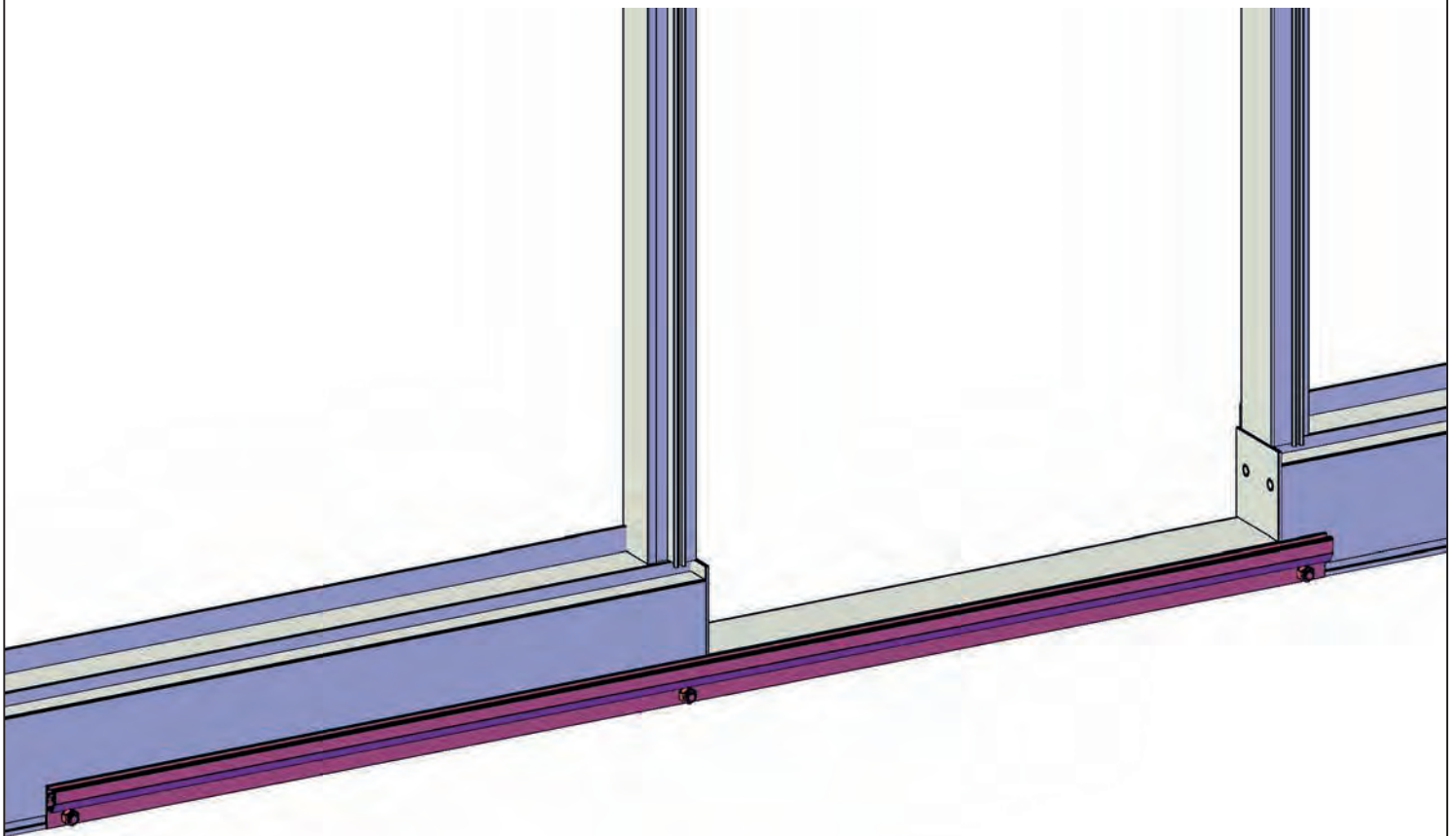
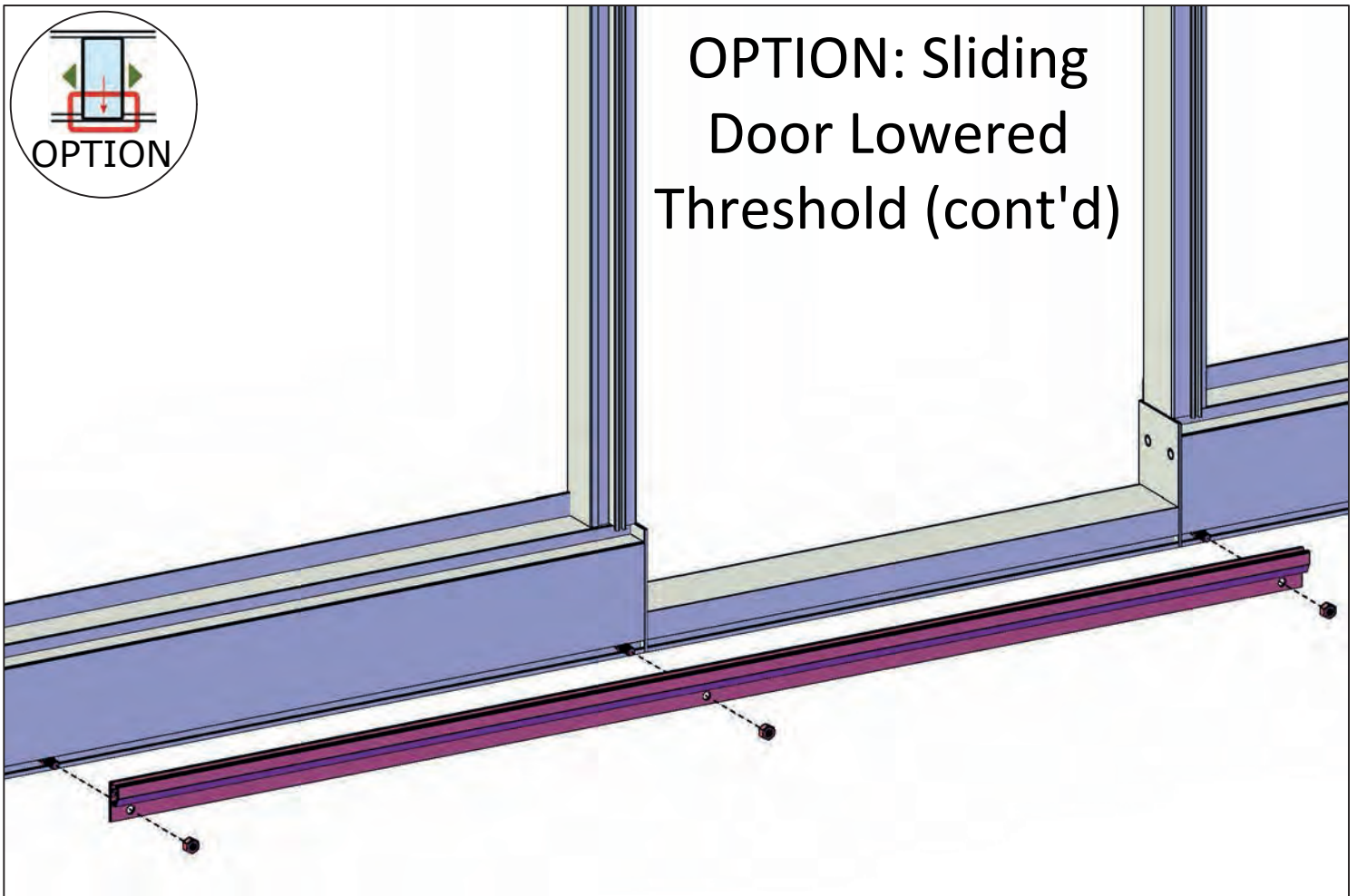


# OPTION: Sliding Door Lowered Threshold



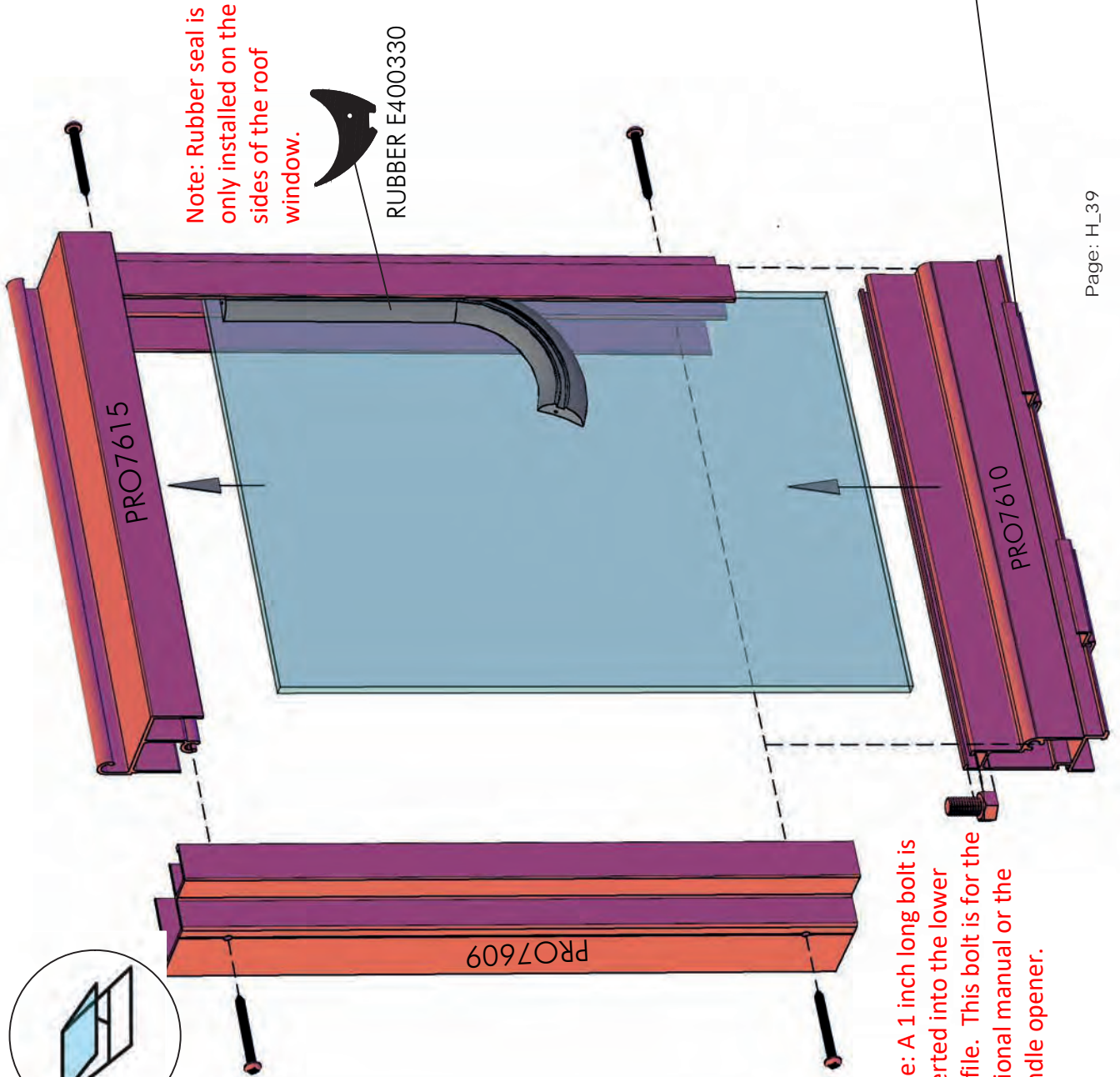
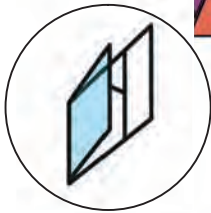


# OPTION: Sliding Door Lowered Threshold (cont'd)





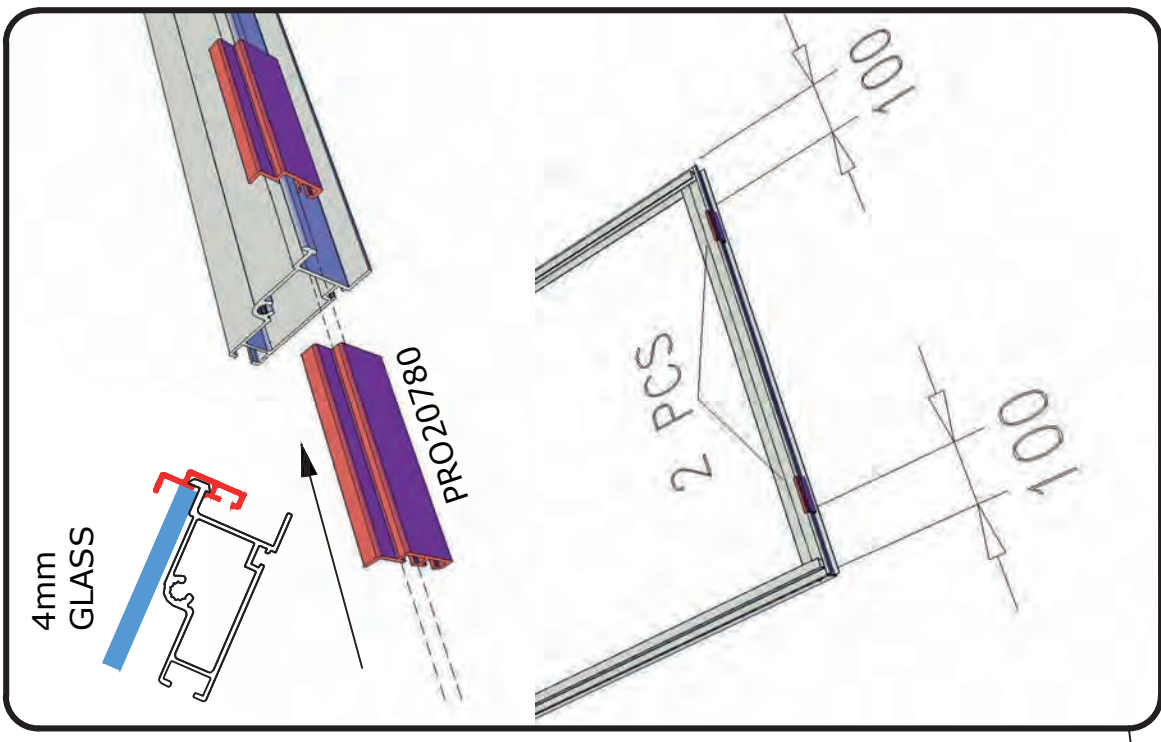
# Roof window - all hardware is in roof window package



Note: Rubber seal is only installed on the sides of the roof window.

RUBBER E400330

Note: A 1 inch long bolt is inserted into the lower profile. This bolt is for the optional manual or the spindle opener.



4mm GLASS

PRO20780

2 PCS

100

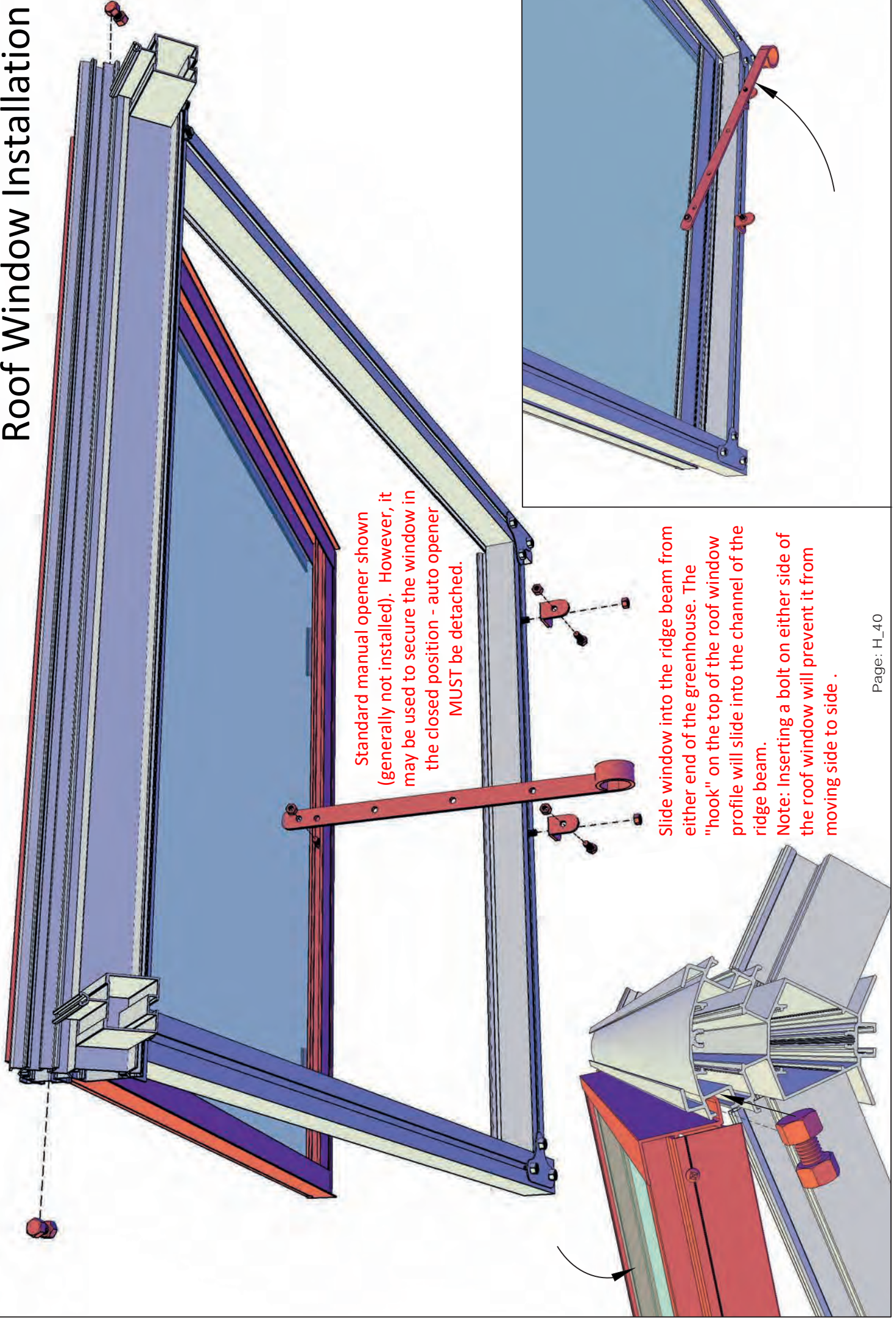
100

# Roof Window Installation

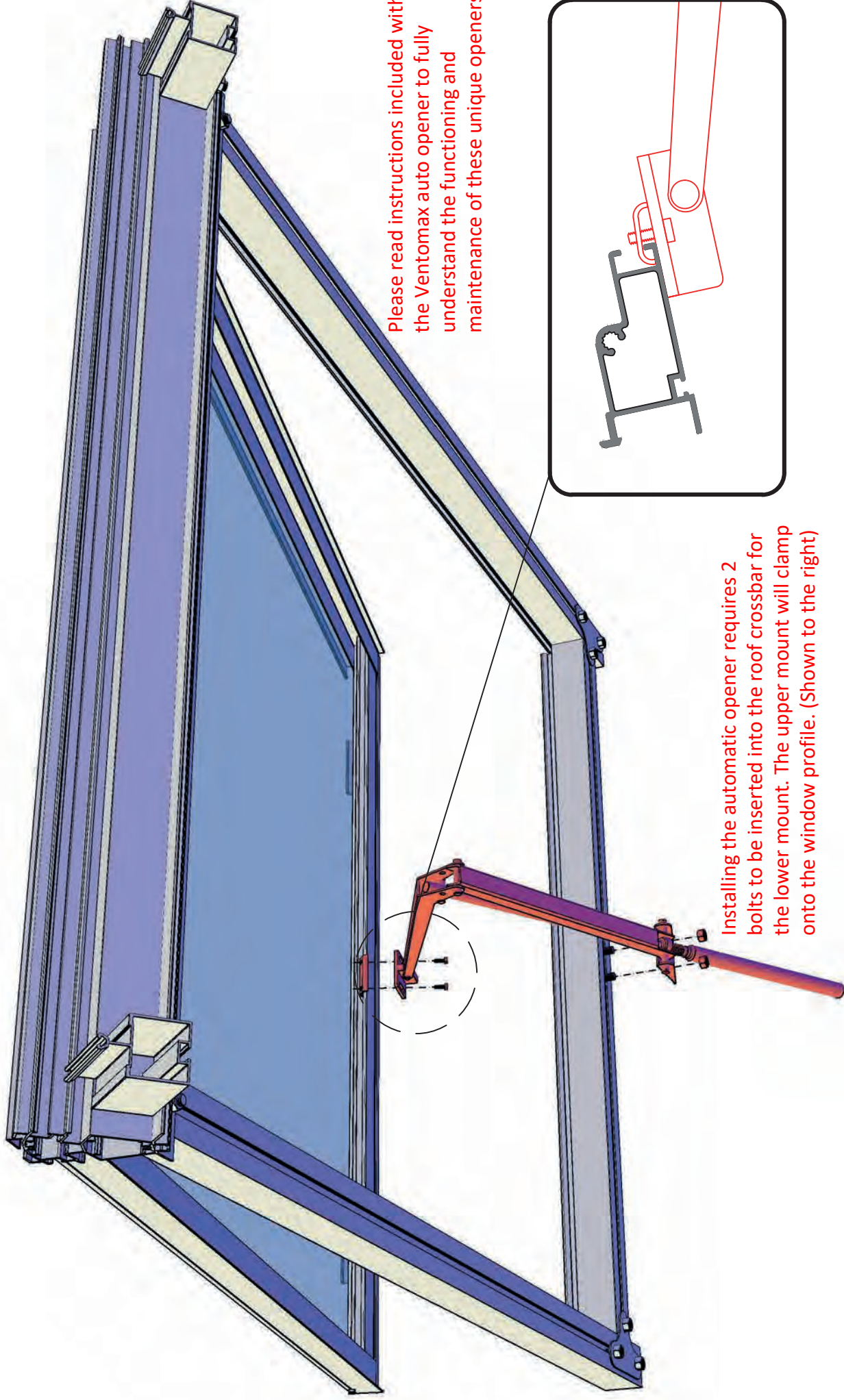
Standard manual opener shown (generally not installed). However, it may be used to secure the window in the closed position - auto opener MUST be detached.

Slide window into the ridge beam from either end of the greenhouse. The "hook" on the top of the roof window profile will slide into the channel of the ridge beam.

Note: Inserting a bolt on either side of the roof window will prevent it from moving side to side .



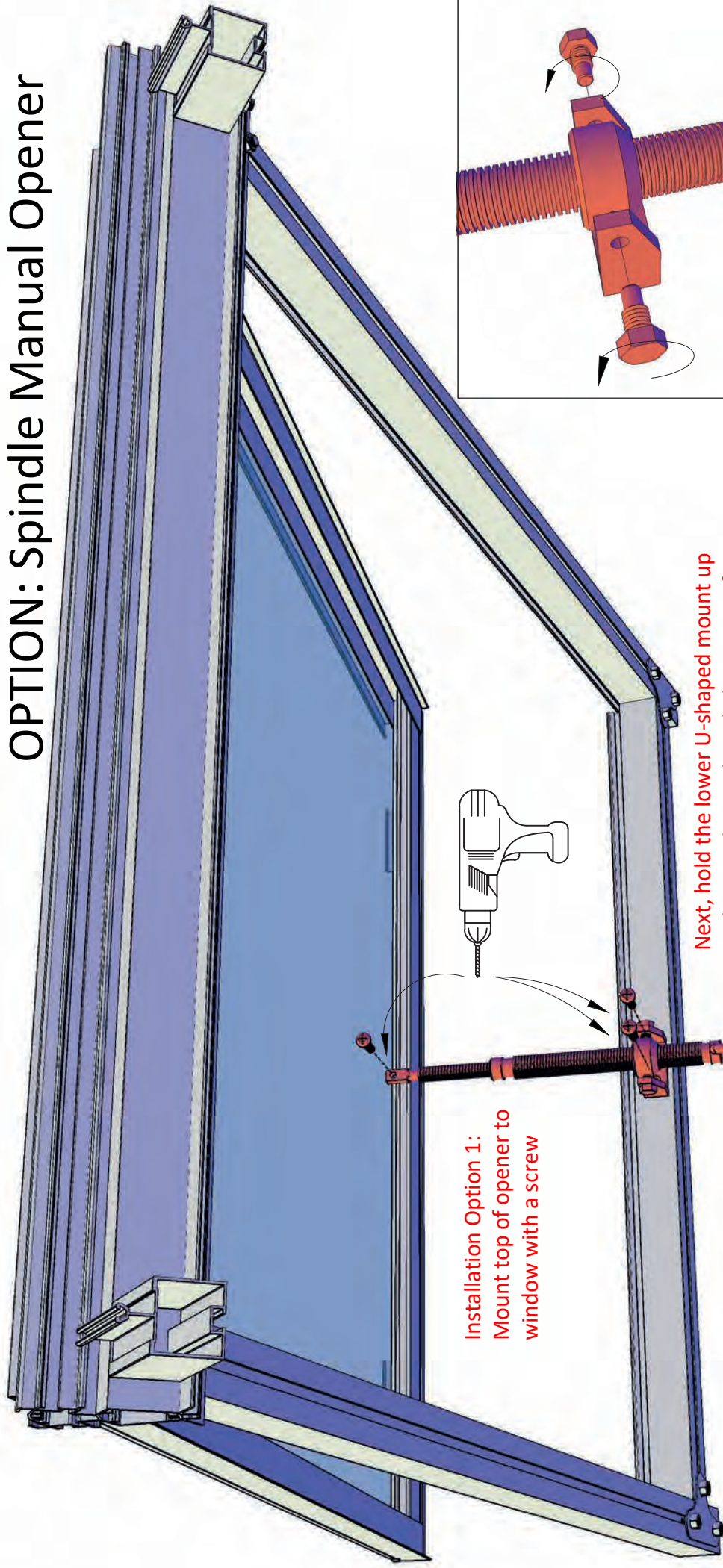
# OPTION: Auto Opener (Ventomax)



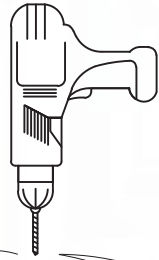
Please read instructions included with the Ventomax auto opener to fully understand the functioning and maintenance of these unique openers.

Installing the automatic opener requires 2 bolts to be inserted into the roof crossbar for the lower mount. The upper mount will clamp onto the window profile. (Shown to the right)

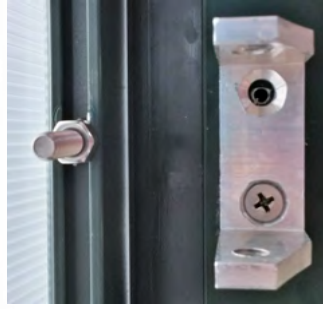
# OPTION: Spindle Manual Opener



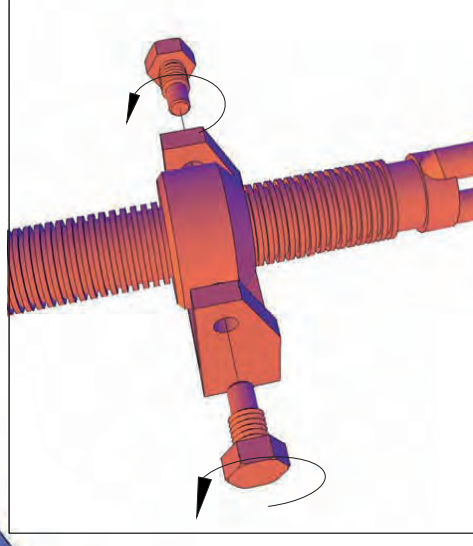
**Installation Option 1:**  
Mount top of opener to window with a screw



**Installation Option 2:** Insert a 1 inch long bolt into lower roof window channel. Slide to the center and lock it in place with a nut as shown below.



Next, hold the lower U-shaped mount up to the crossbar and mark the center of one hole. Using a 1/8" drill bit, drill the first hole, then screw the bracket on, check for level - then mark and drill the second hole. Slide the brass part of the opener over the bolt in the window channel. Use the supplied nylock nut to secure the opener on the top mounting bolt. Finally thread the large side bolts into the U-shaped mount and the opener is installed.

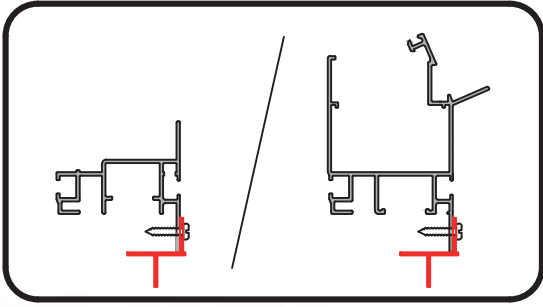


# Louvre vent

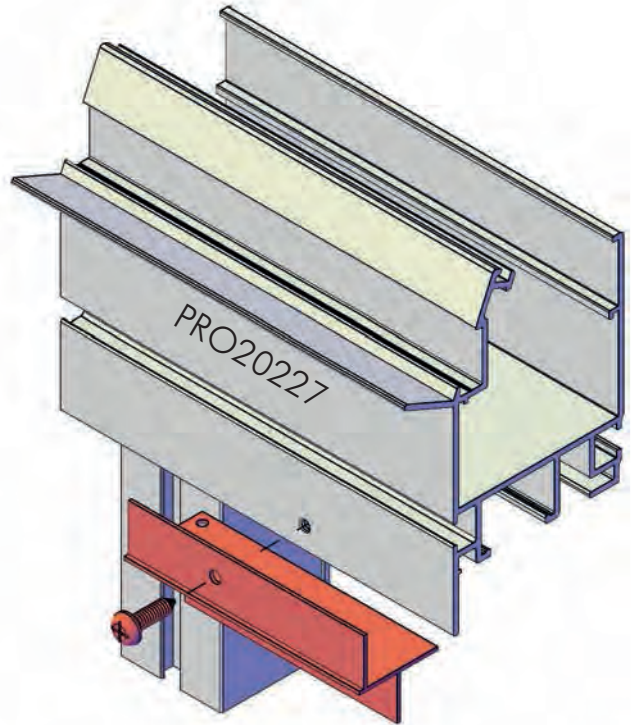
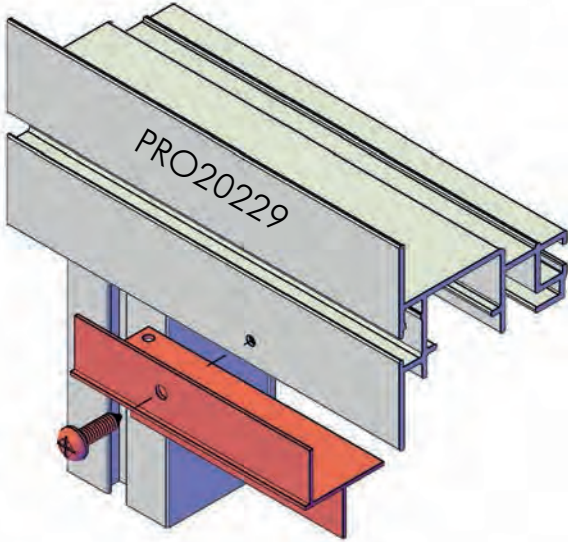


If your model is equipped with the louvre vent automatic opener please refer to the Installation and Care manual packaged with the opener. You will need to remove the manual opener following the directions.

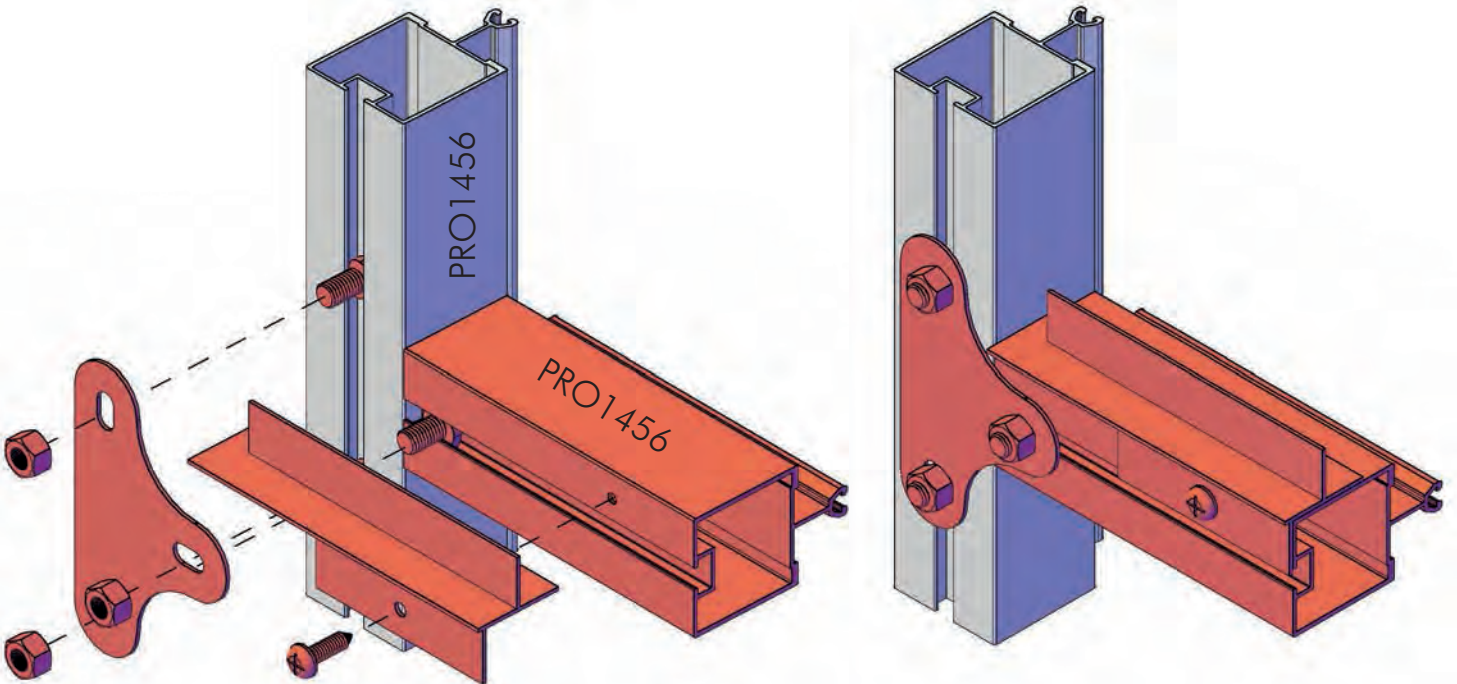
1



# Louvre Vent (Cont'd)

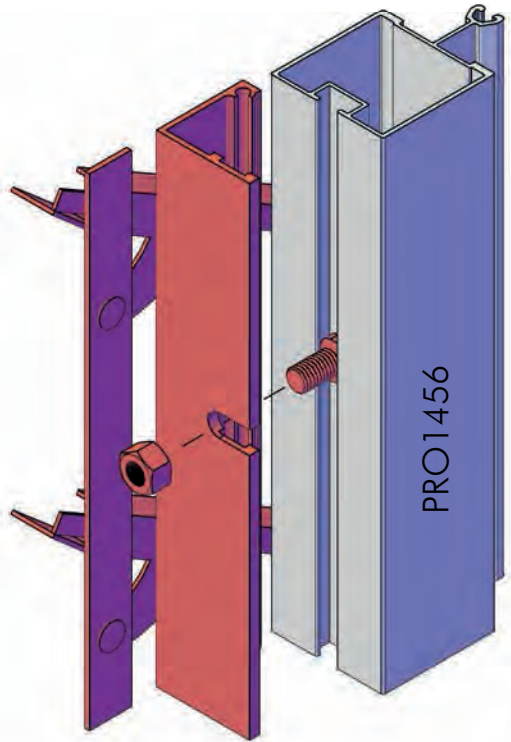


2



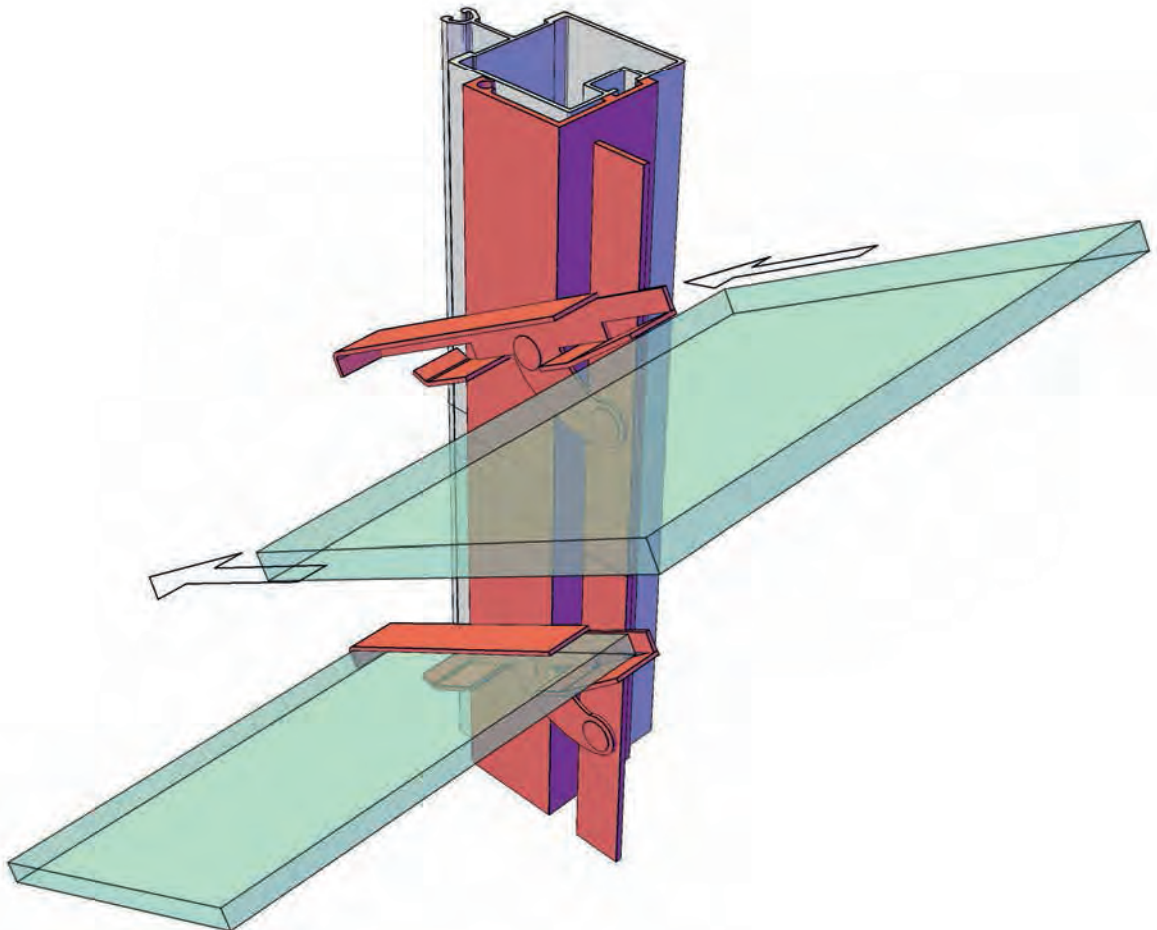
3

# Louvre Vent (Cont'd)

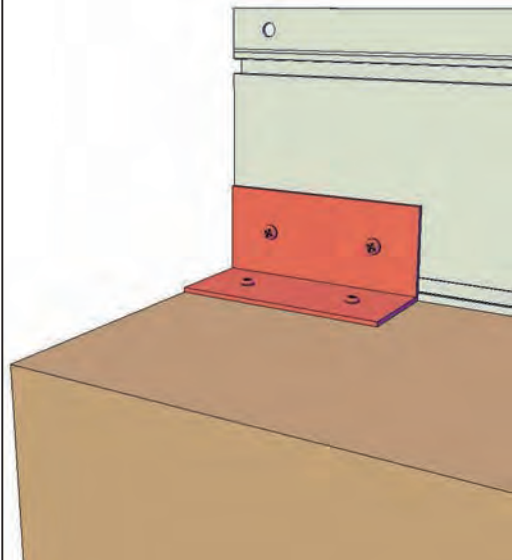
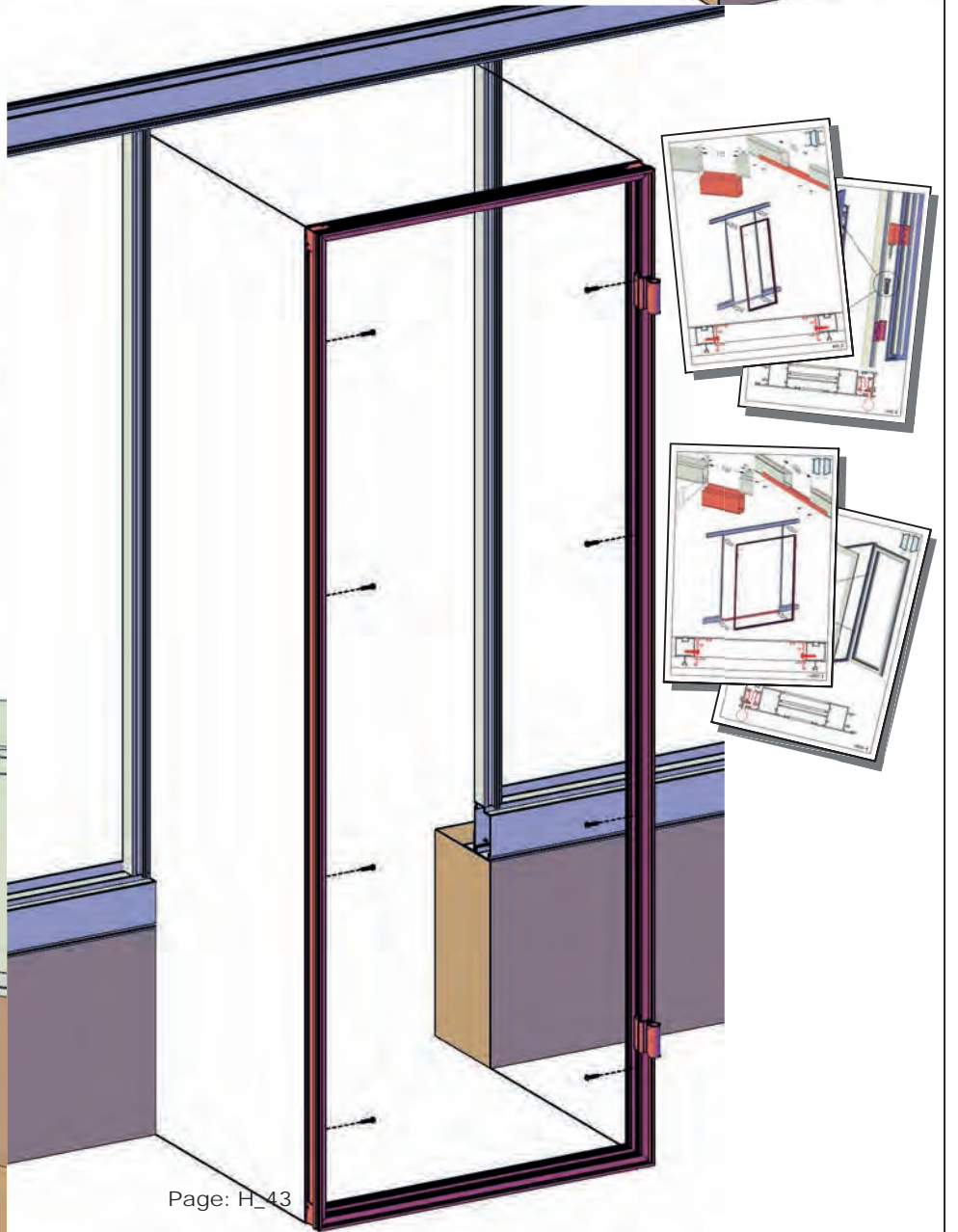
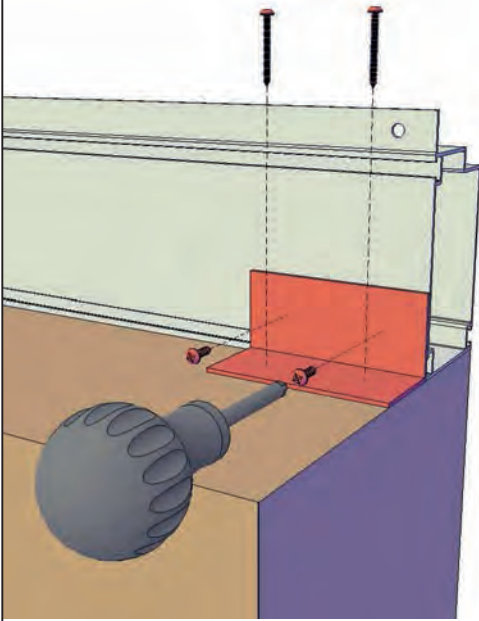
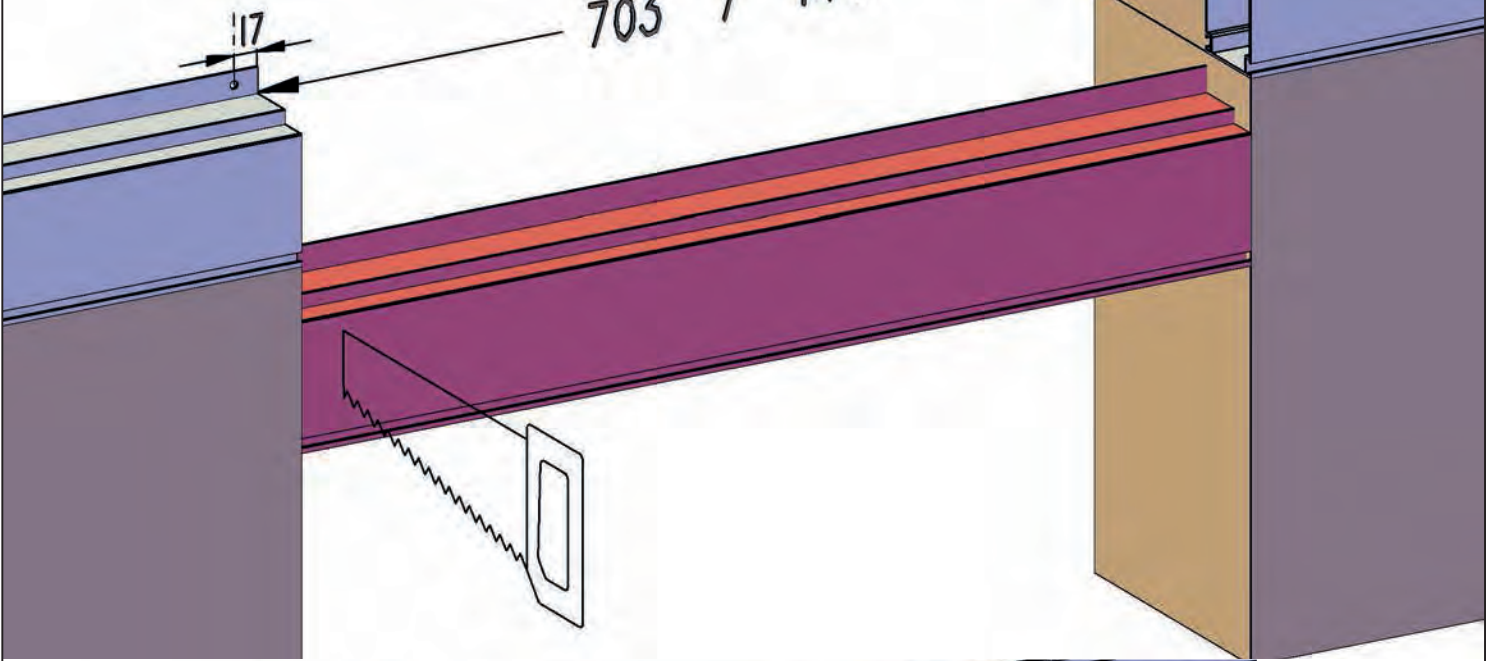
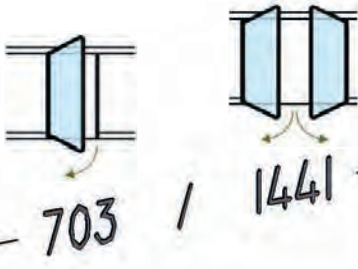


4X

4

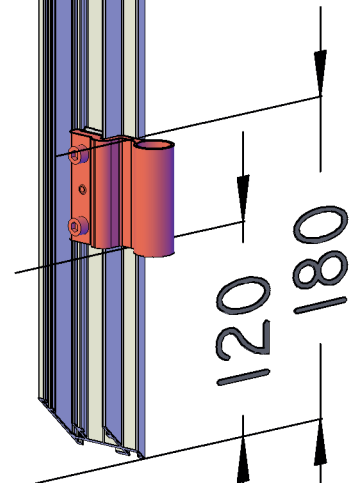
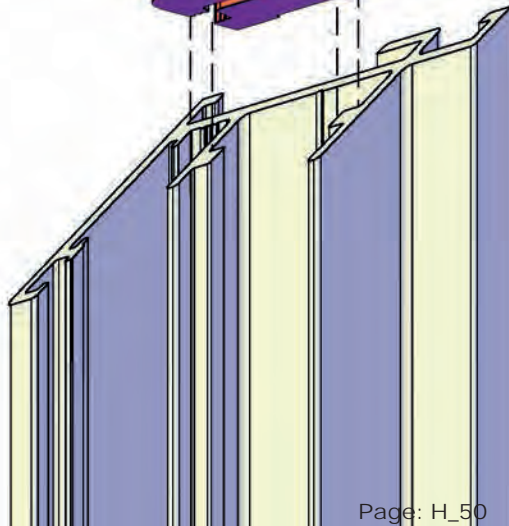
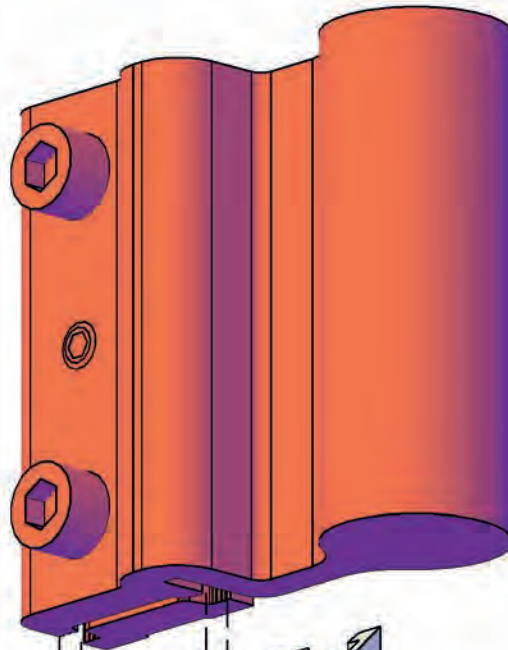
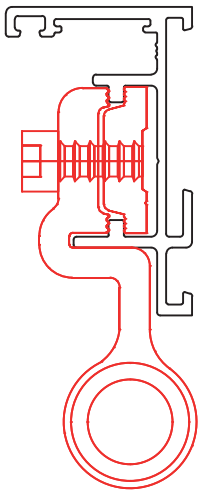
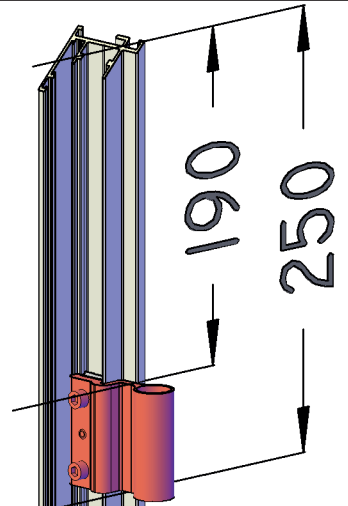
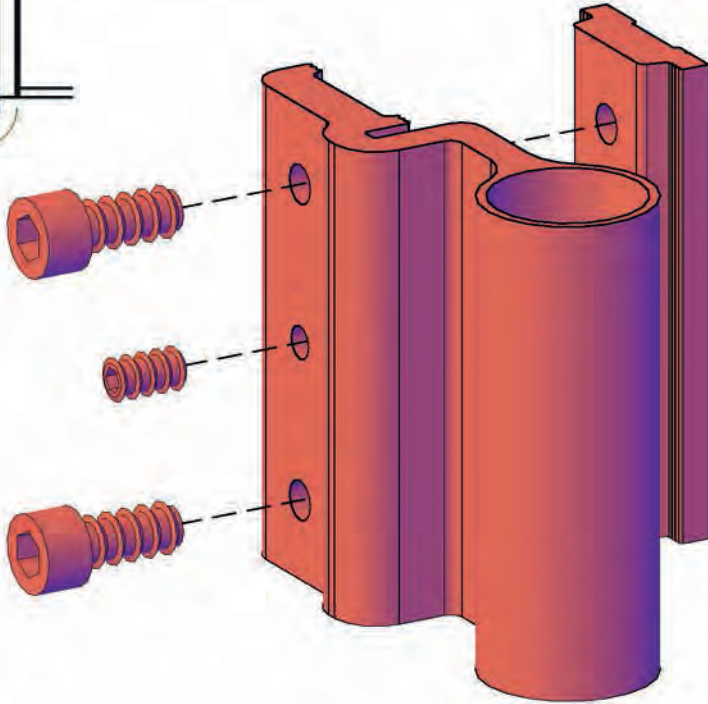
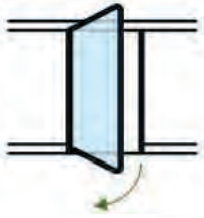


# OPTION: 2020 Hinged Door



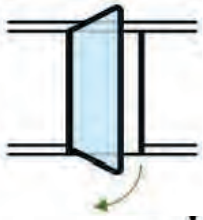


# OPTION: 2020 Hinged Door



HD 1

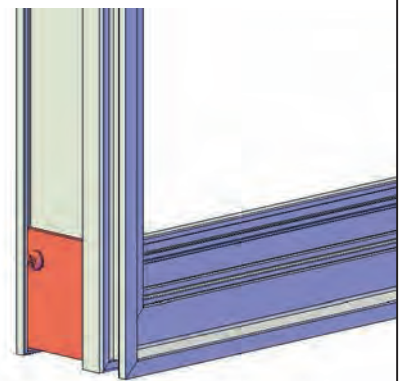
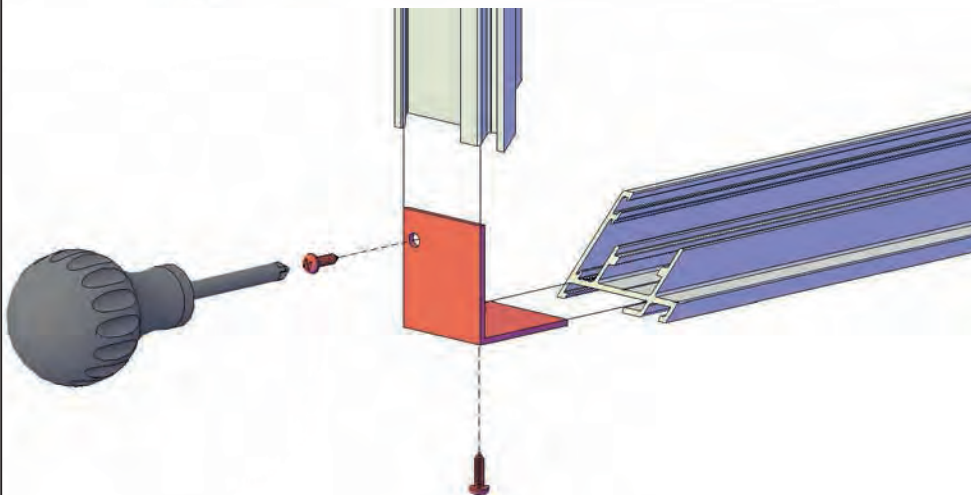
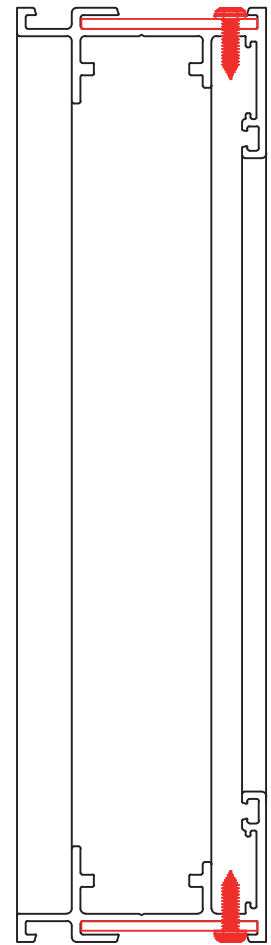
# OPTION: 2020 Hinged Door

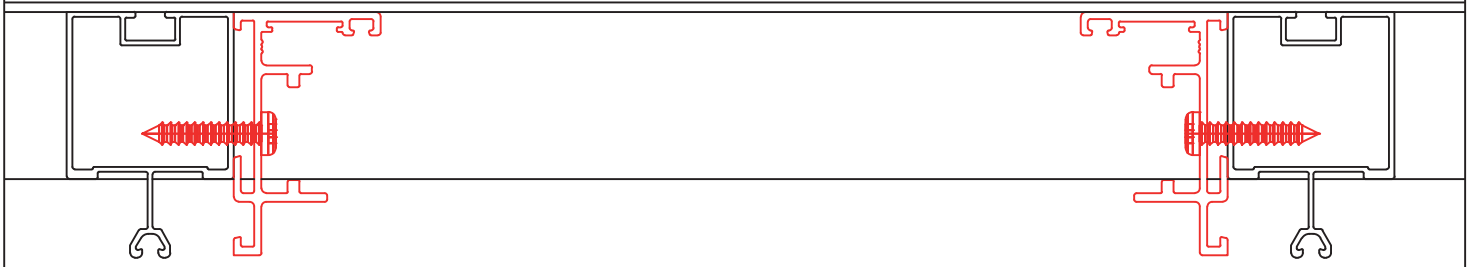
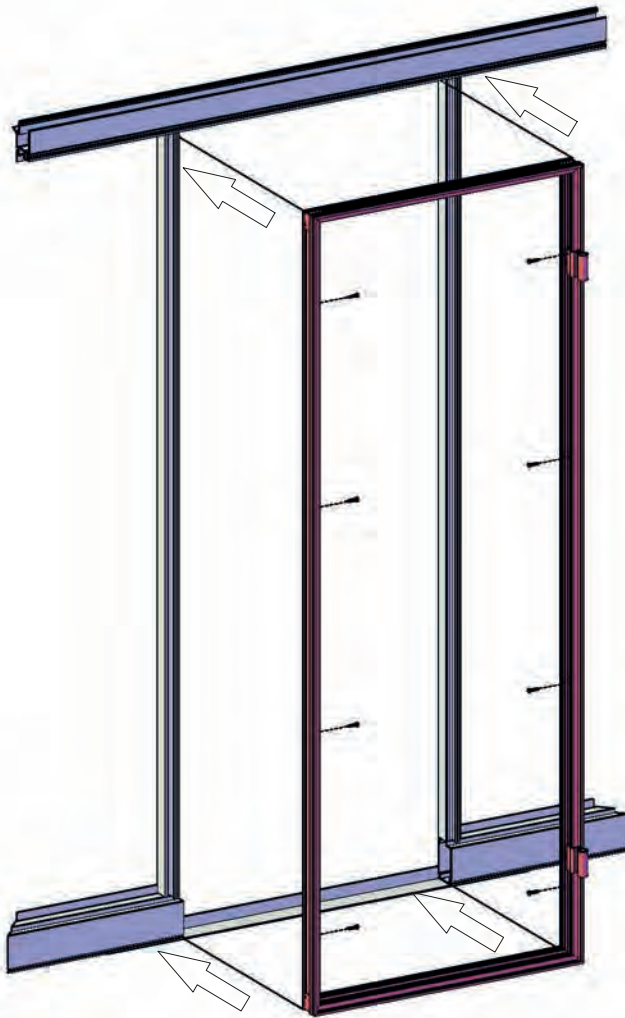
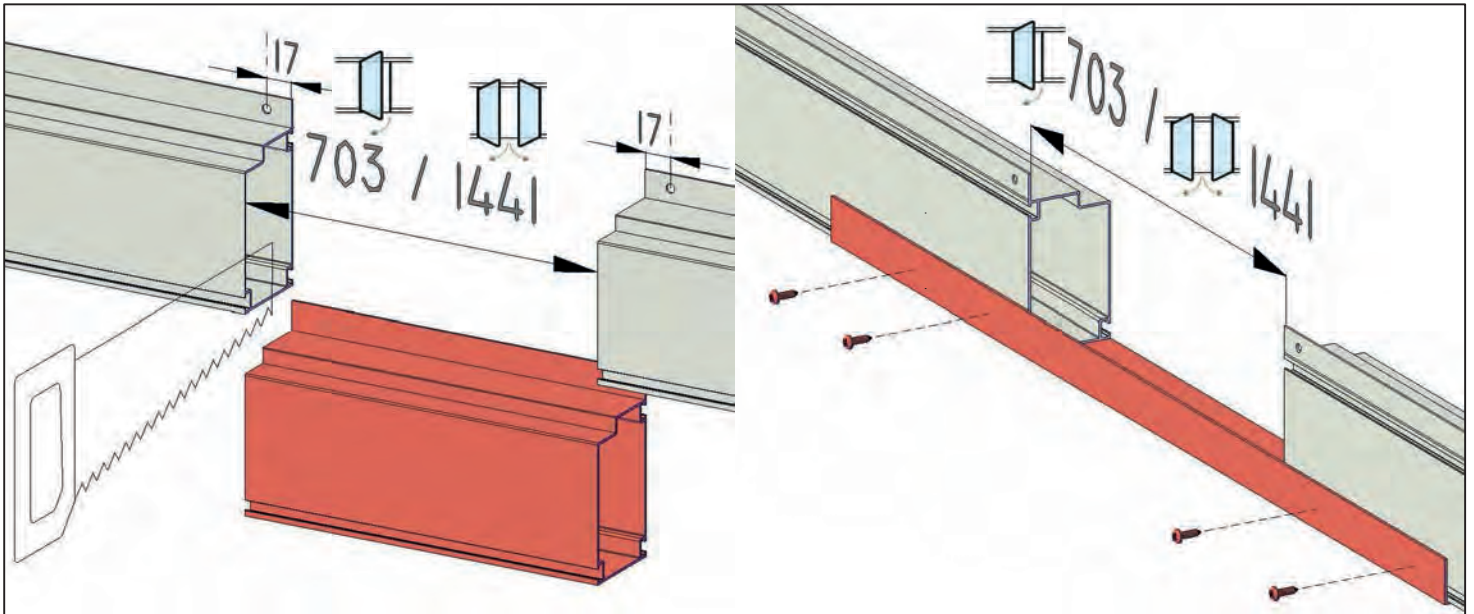


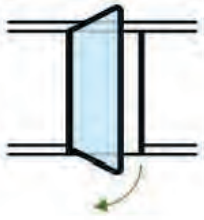
Single Door



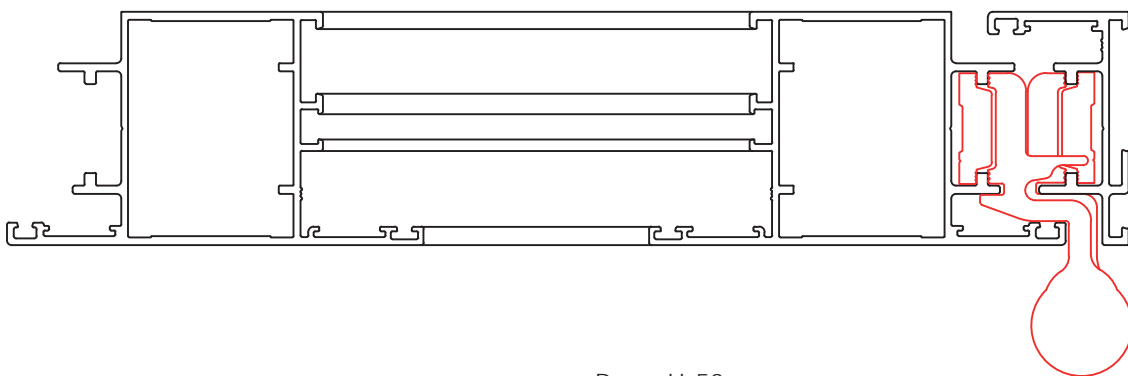
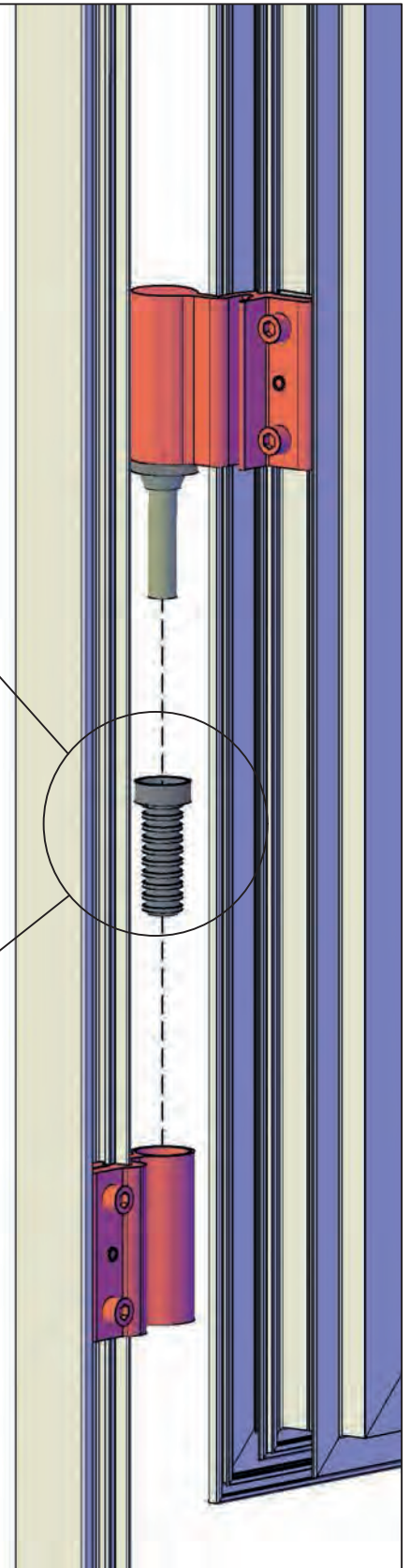
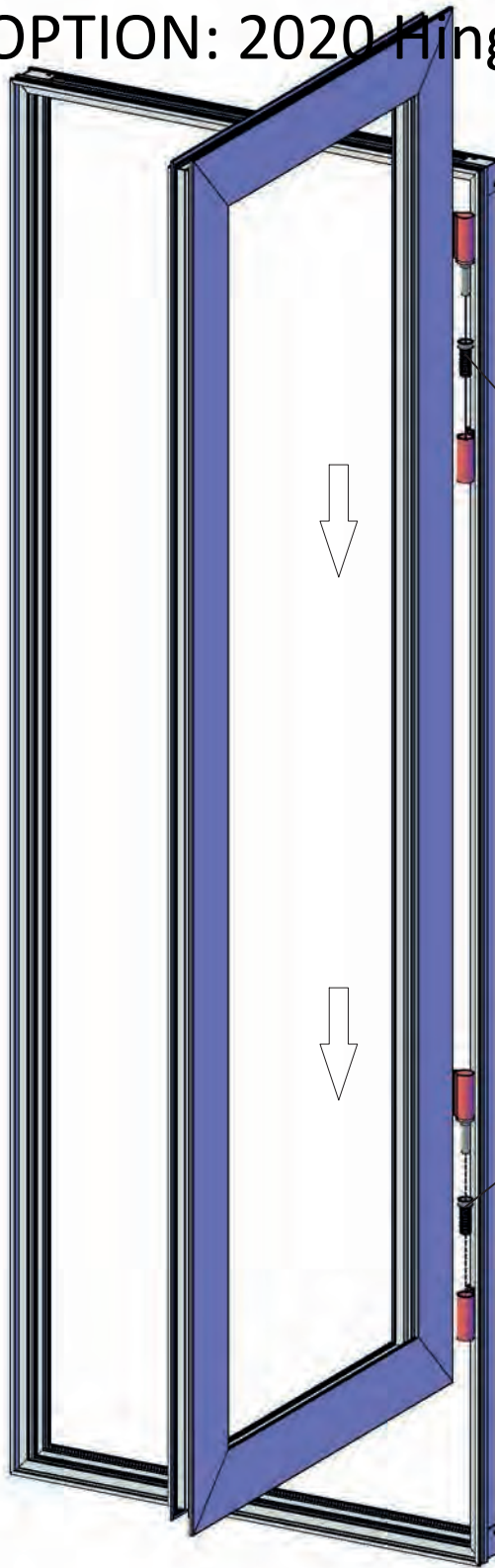
	ITEM	PC.	L
	L 40X40	4 PC	36 MM
	PRO6280	2 PC	703 MM
	PRO6280	2 PC	1.441 MM
	PRO6280	2 PC	1.930 MM
	4,2 x 13	8 PC	

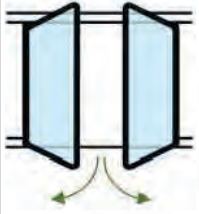




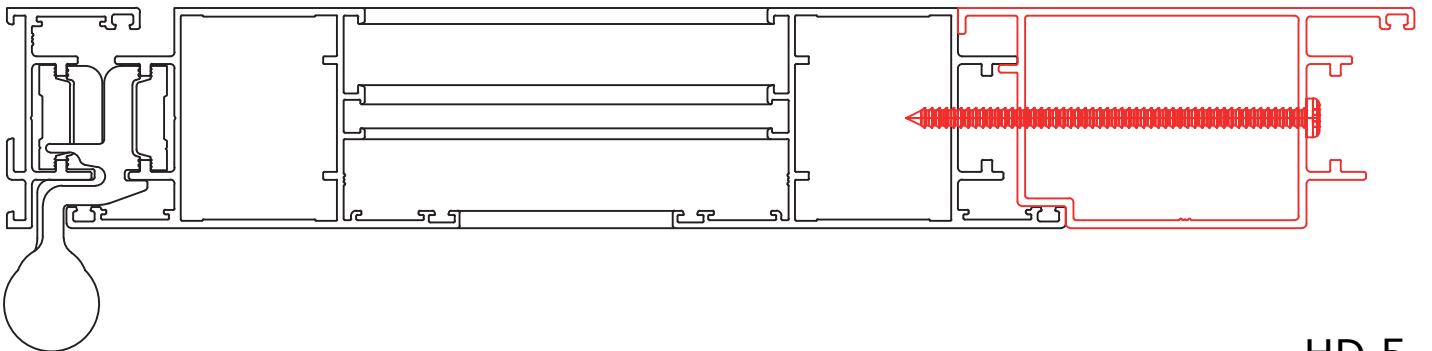


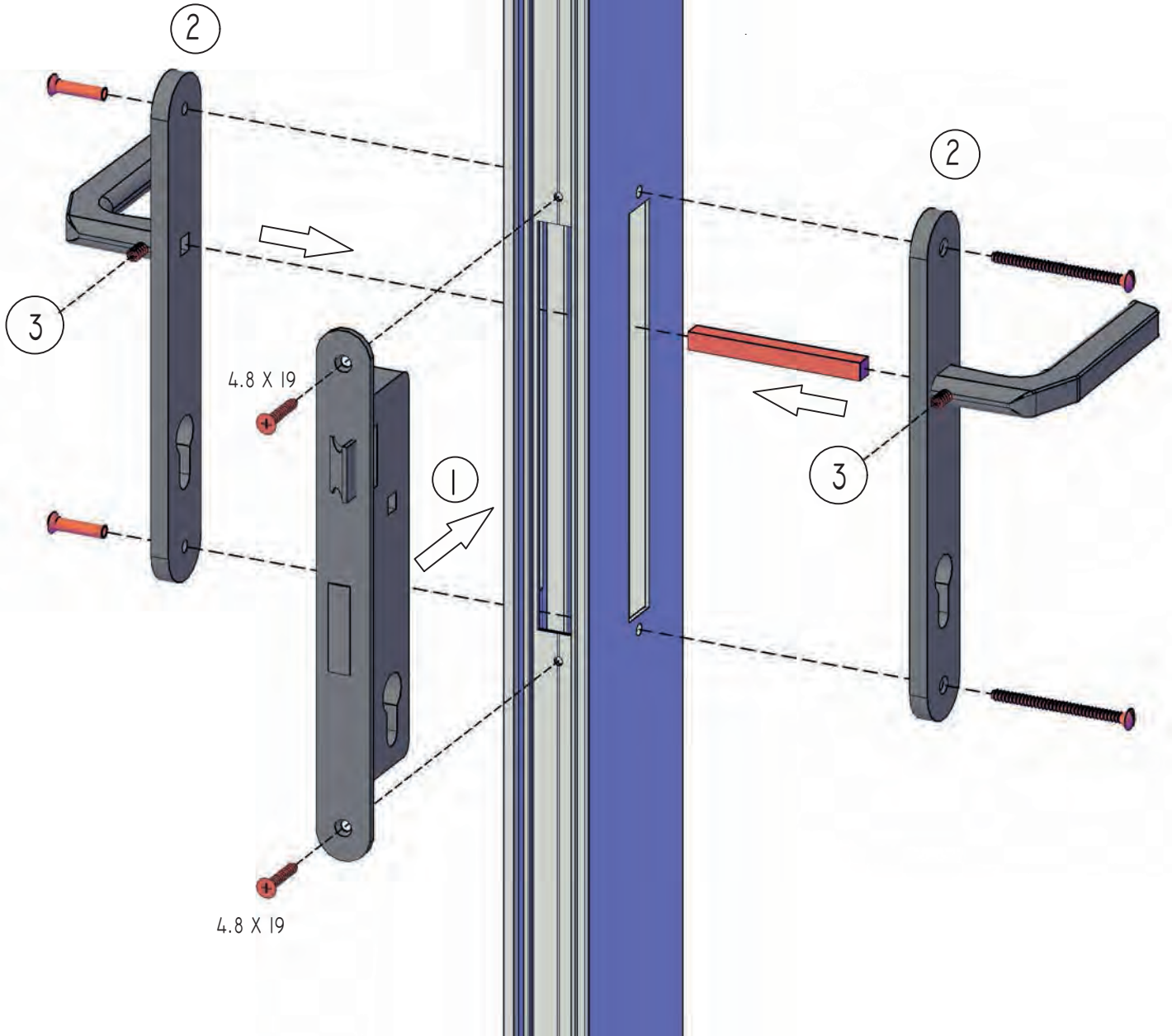
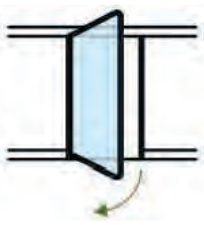
# OPTION: 2020 Hinged Door

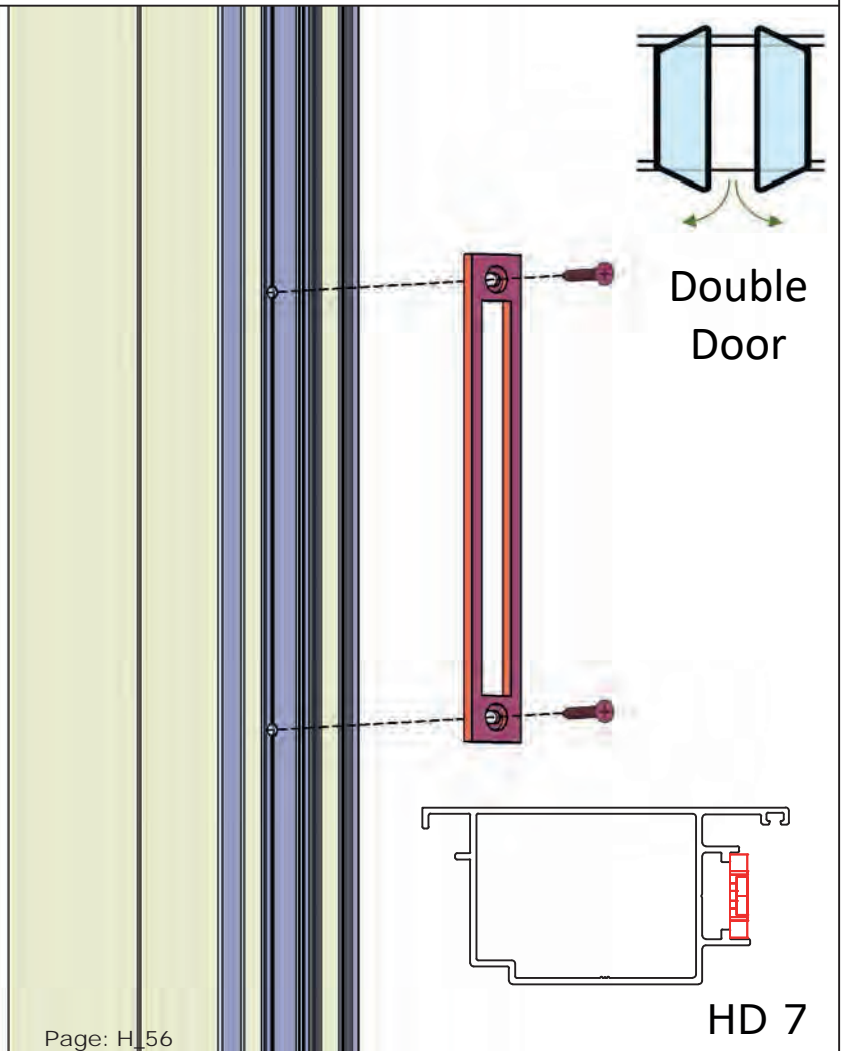
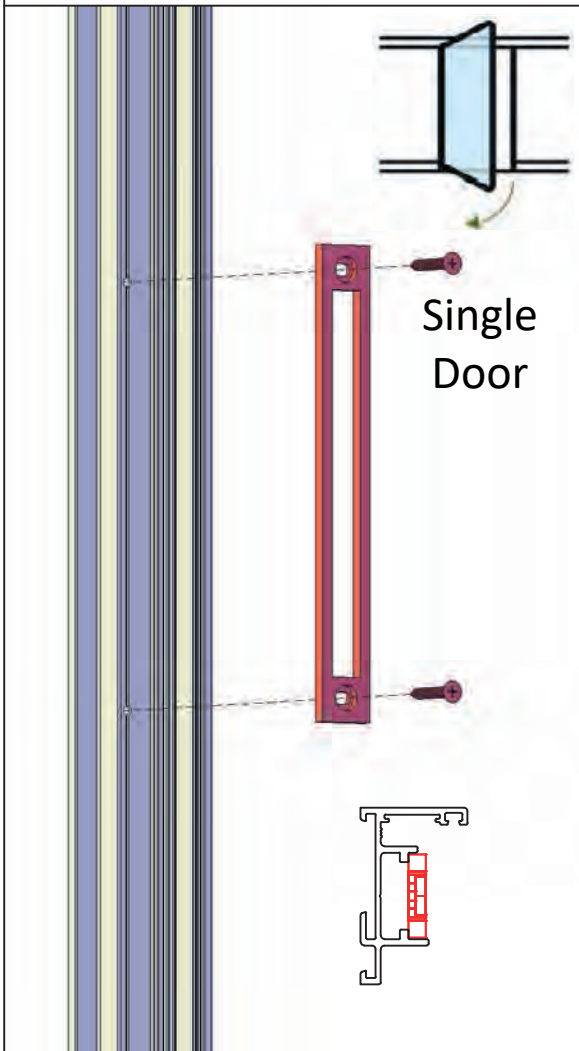
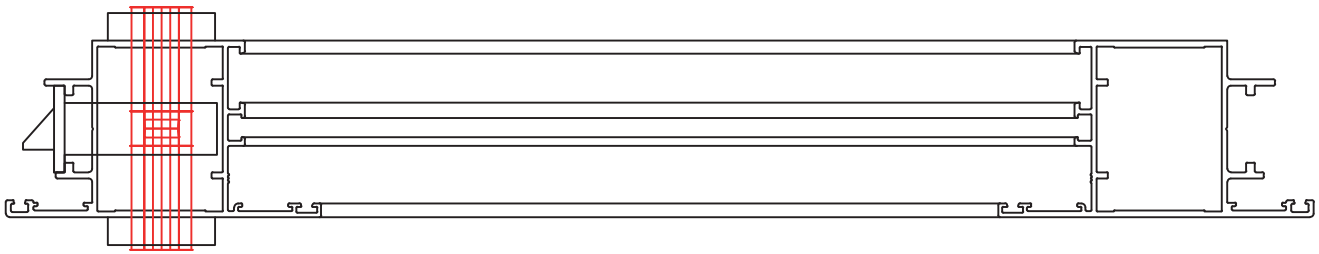
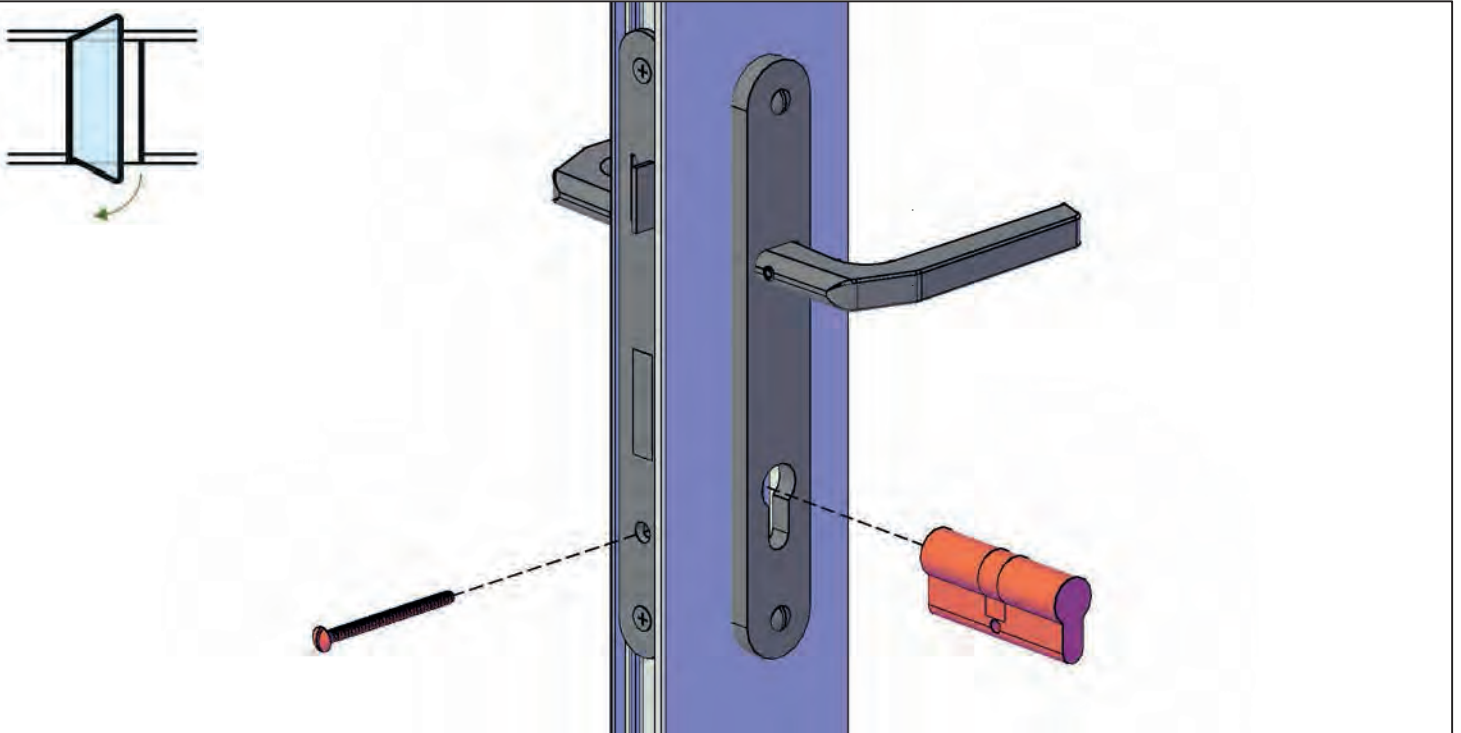


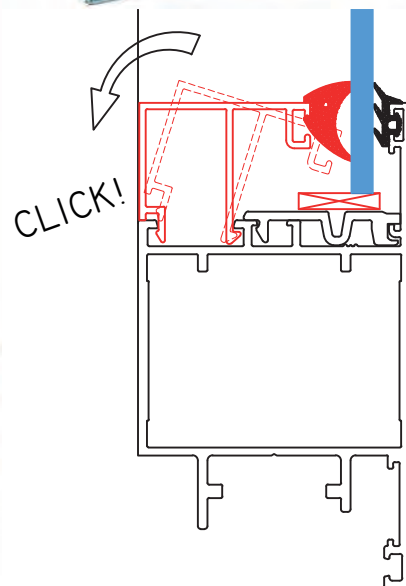
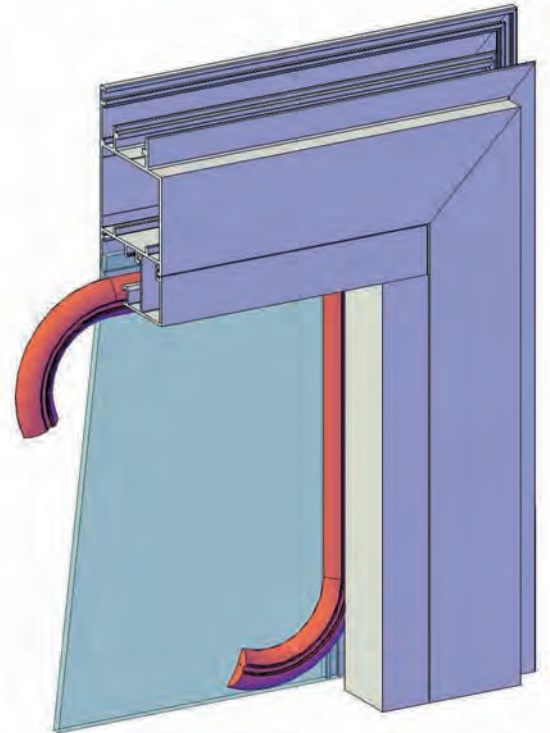
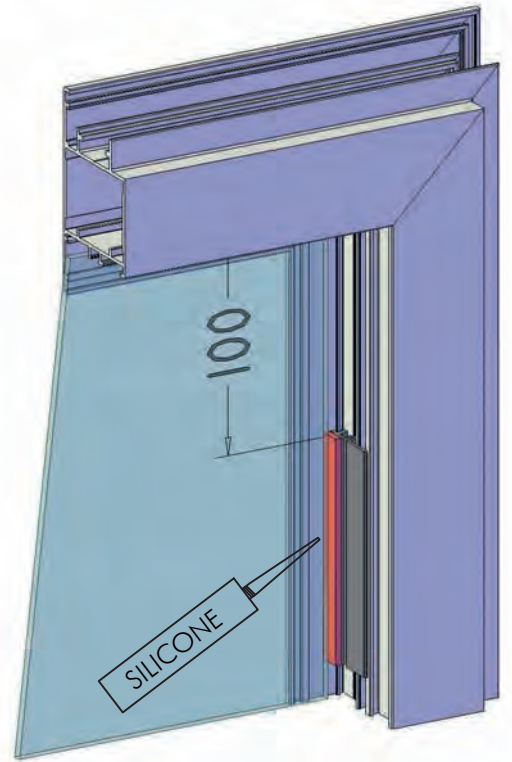
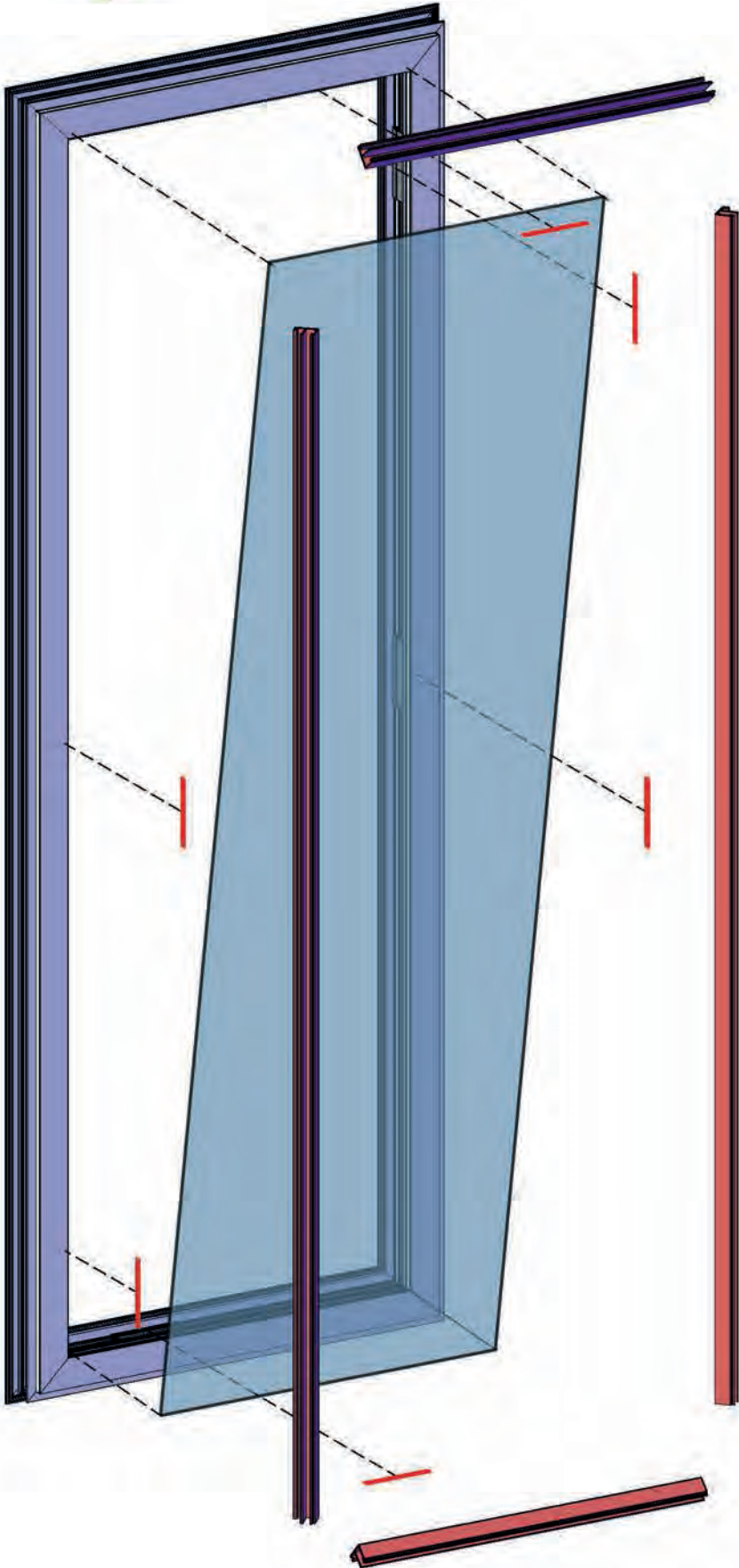
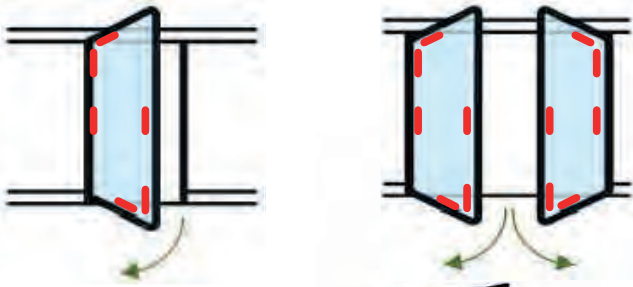


Double Door

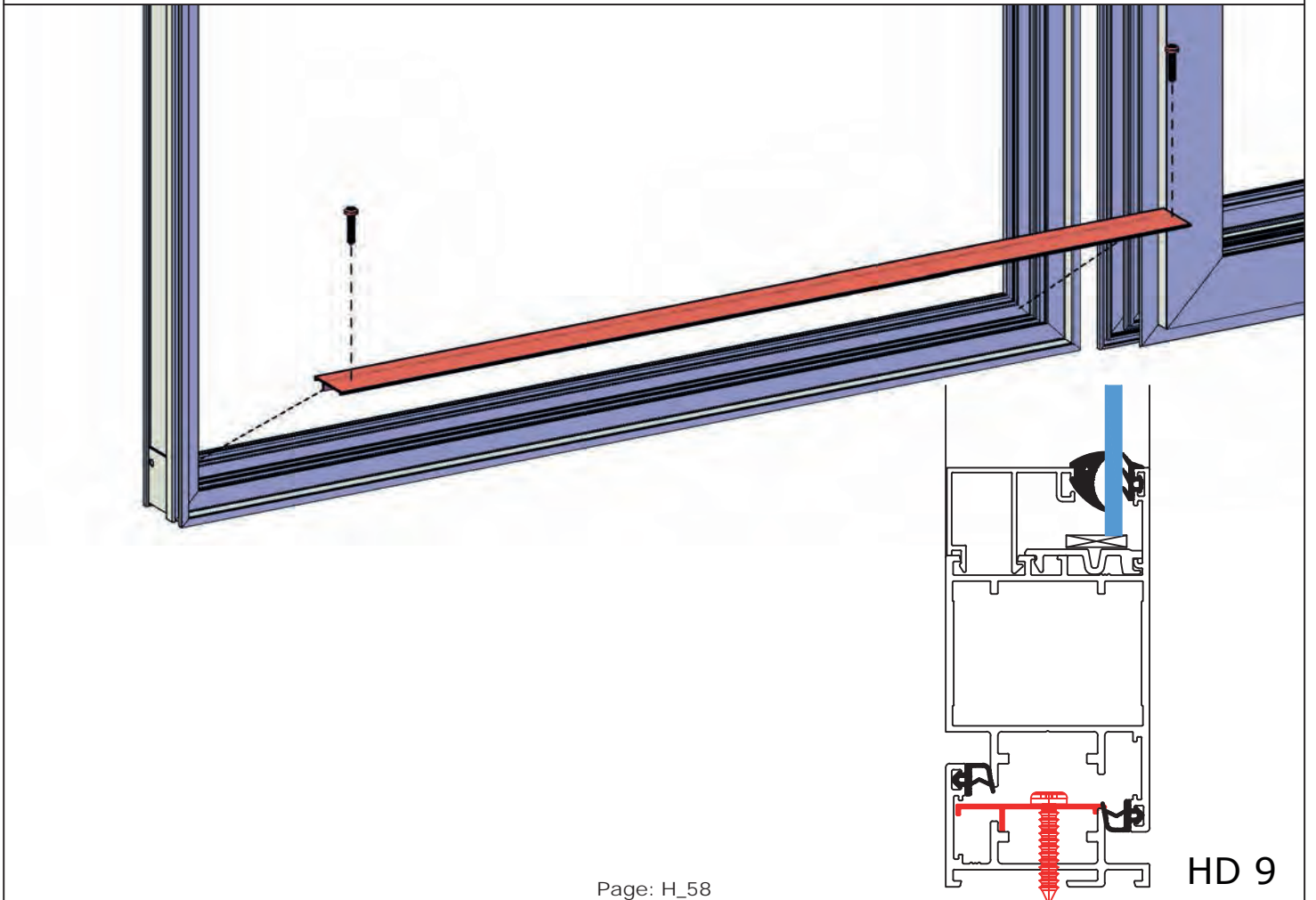
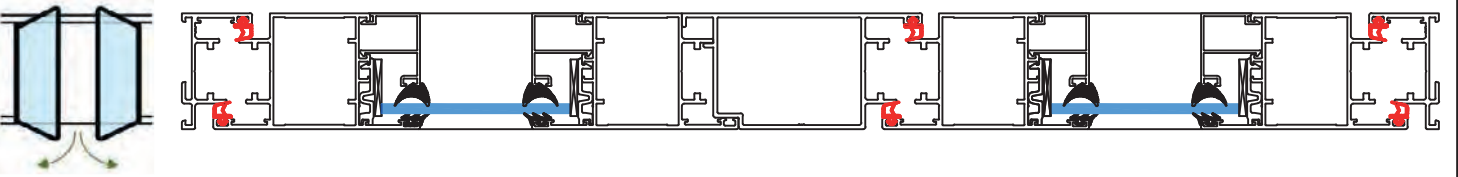
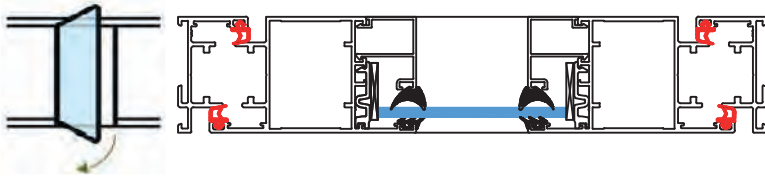
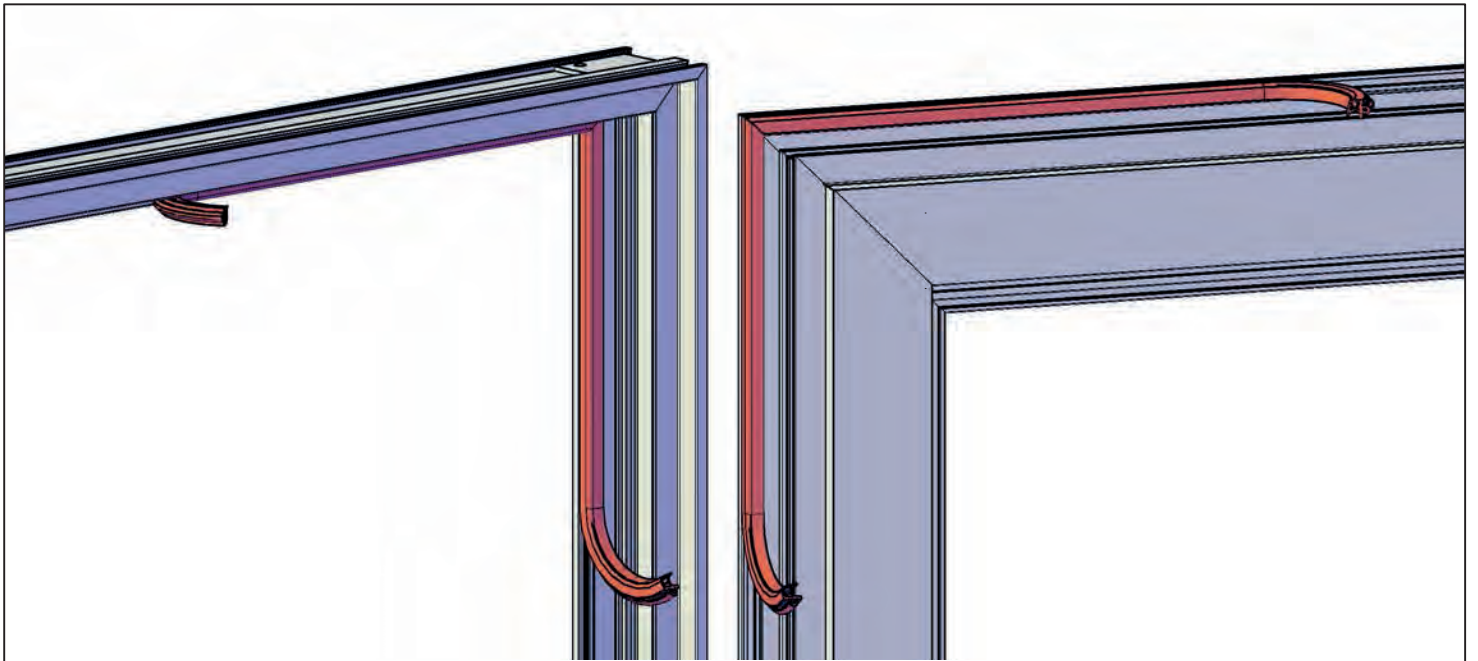


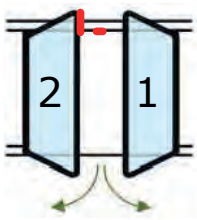




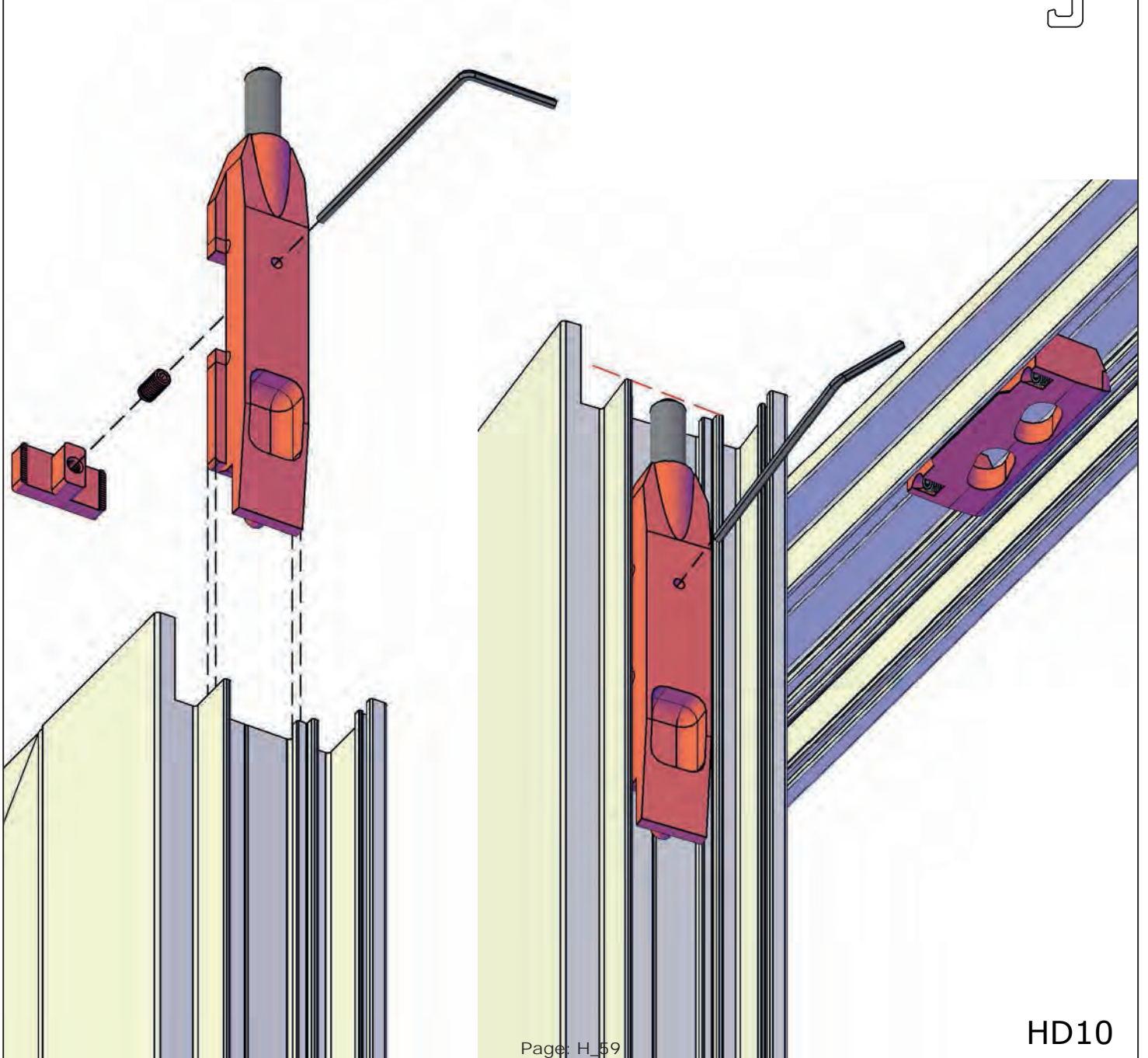
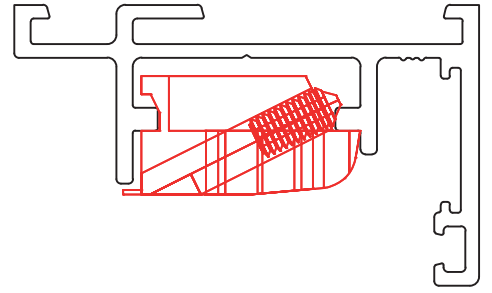
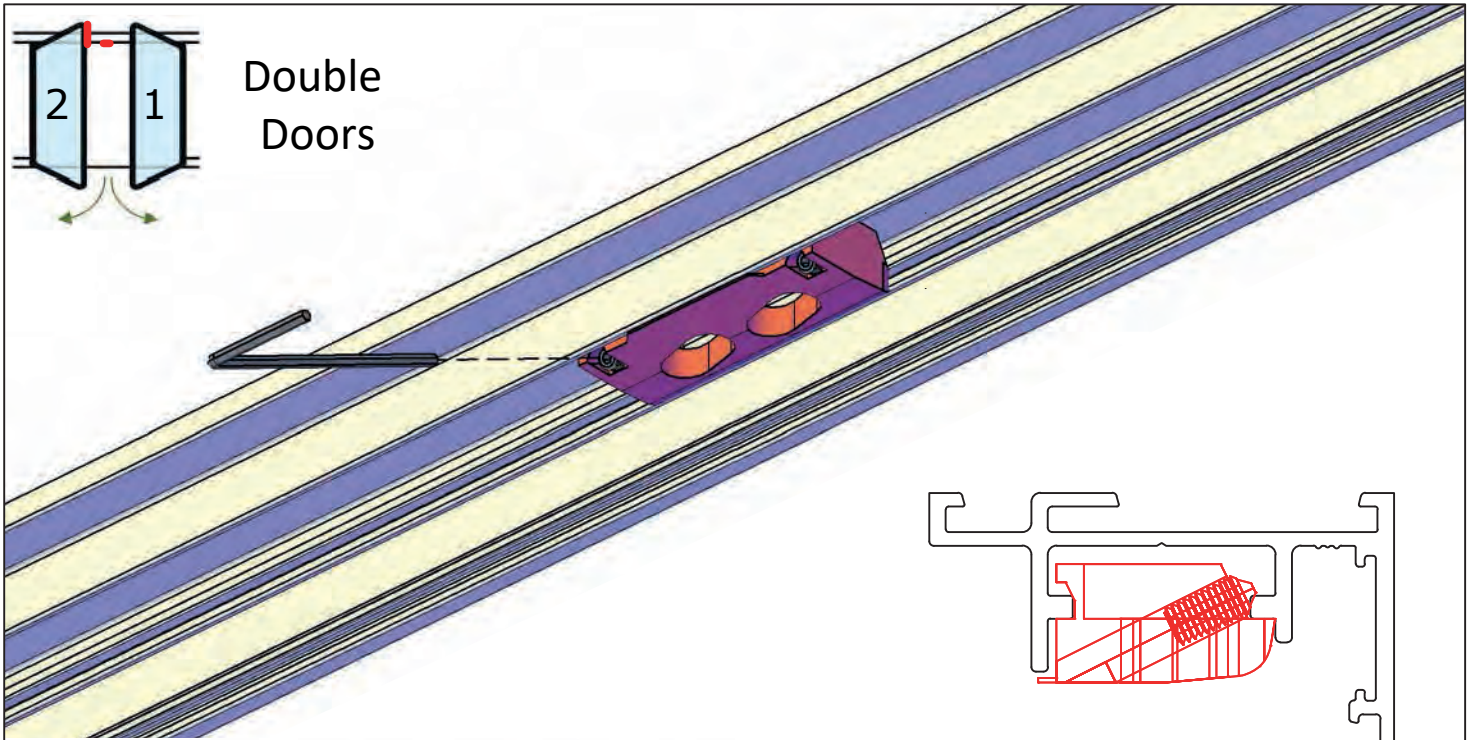




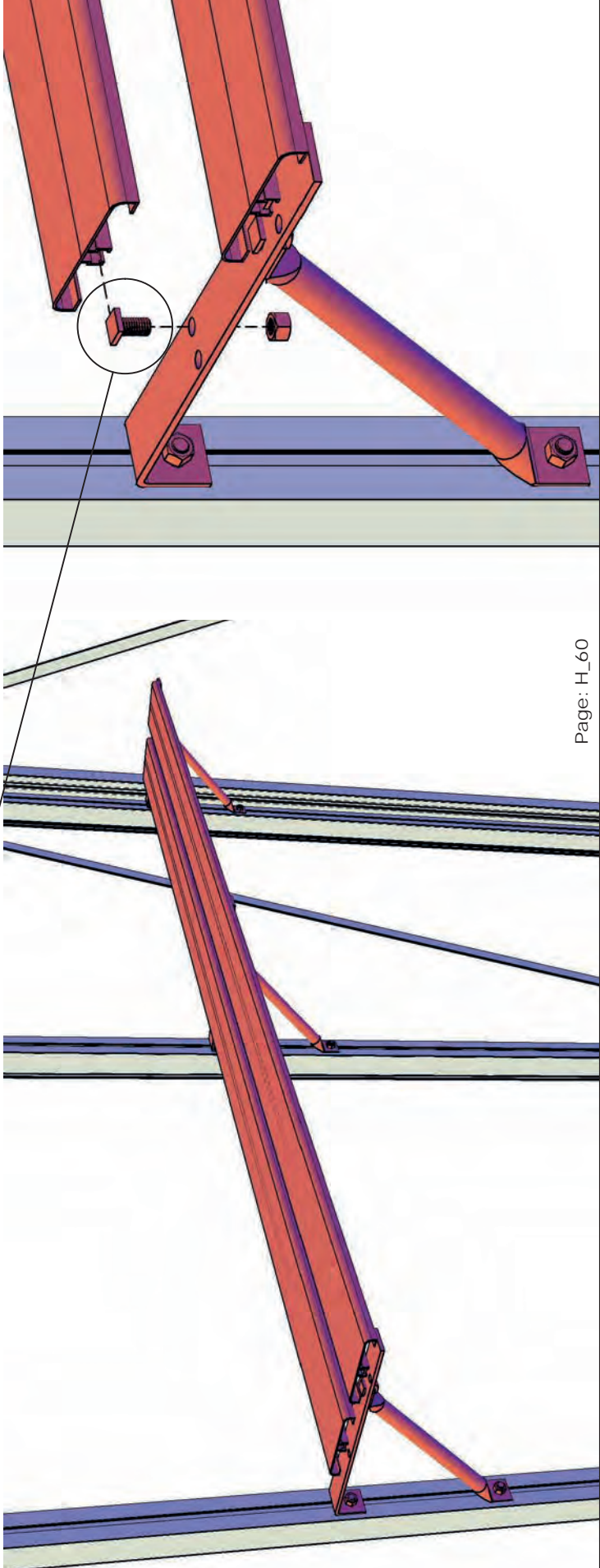
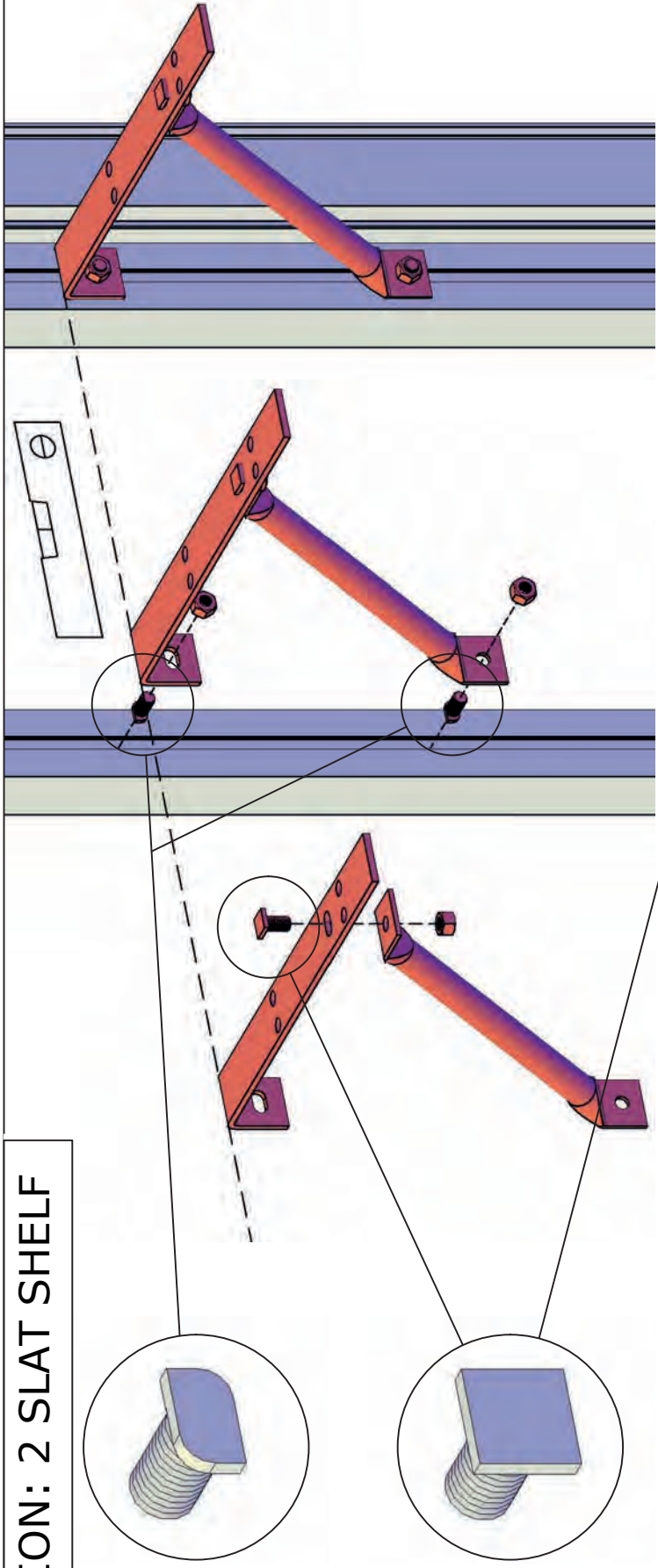




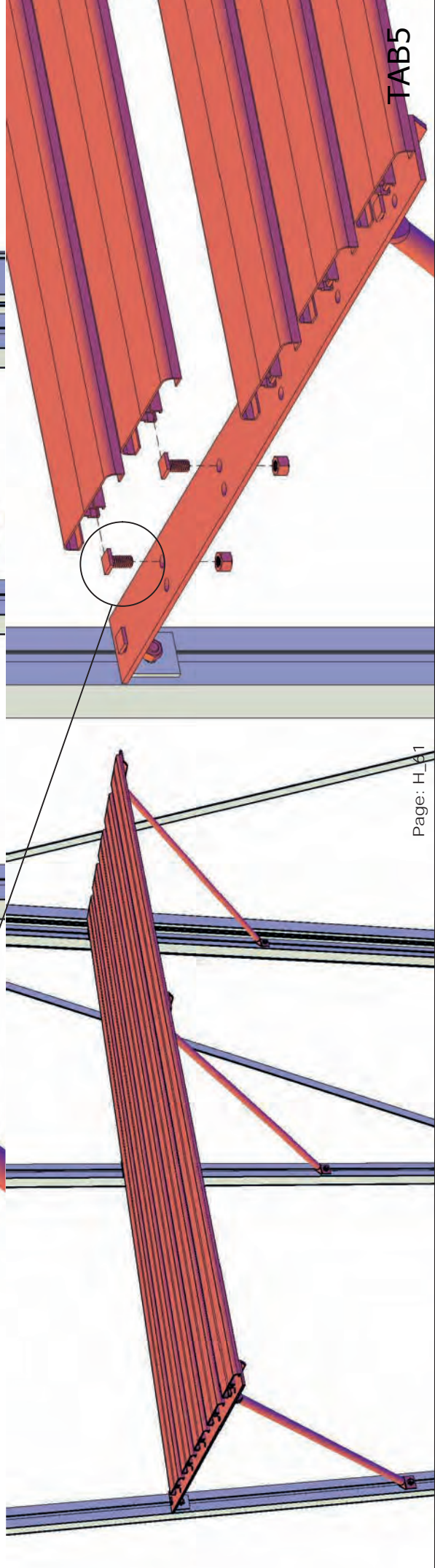
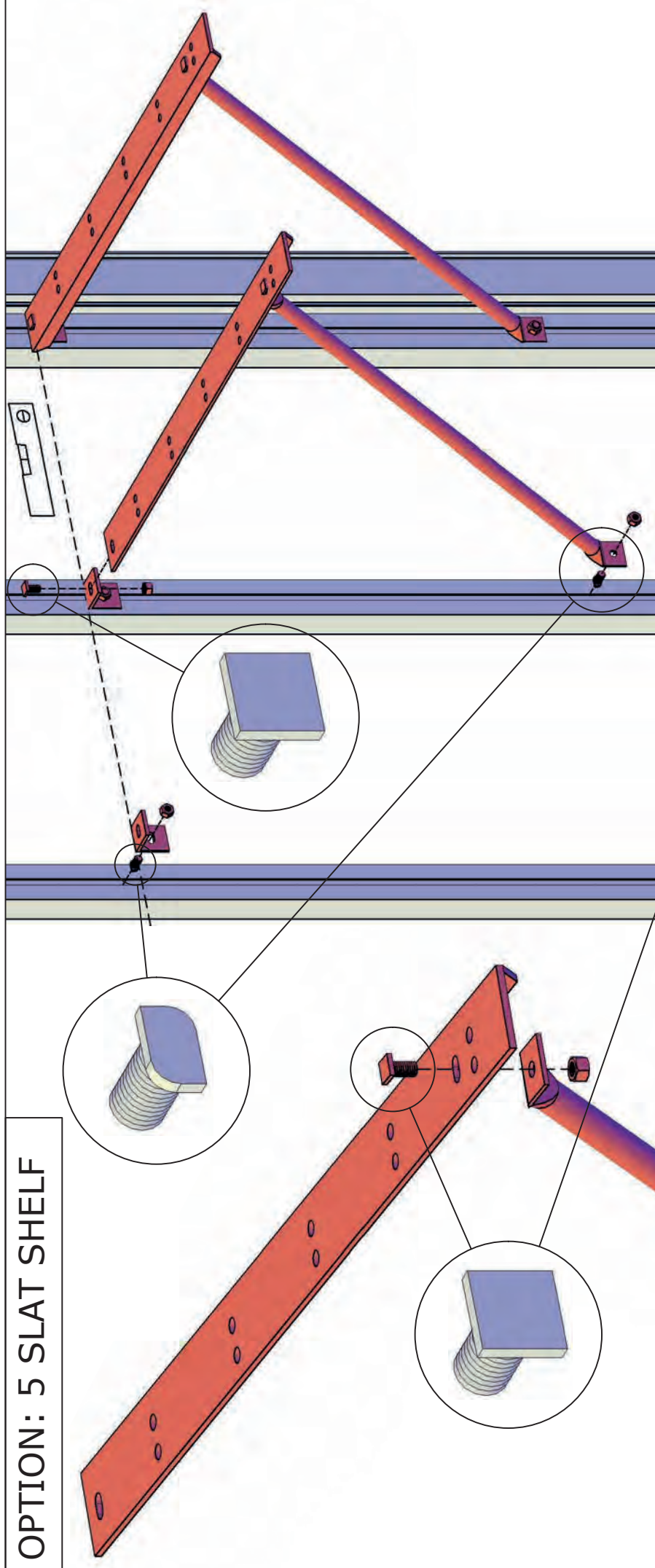
Double  
Doors



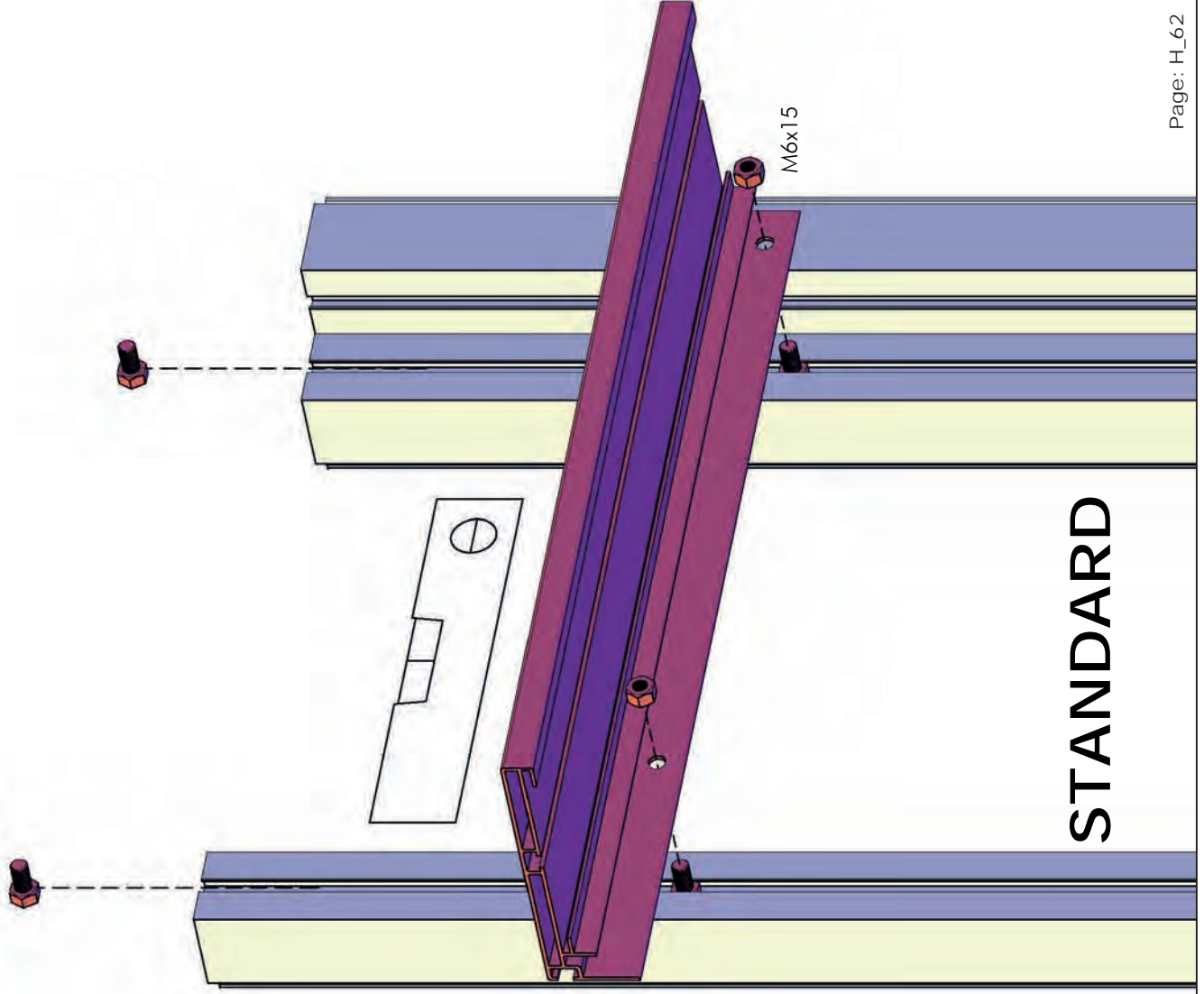
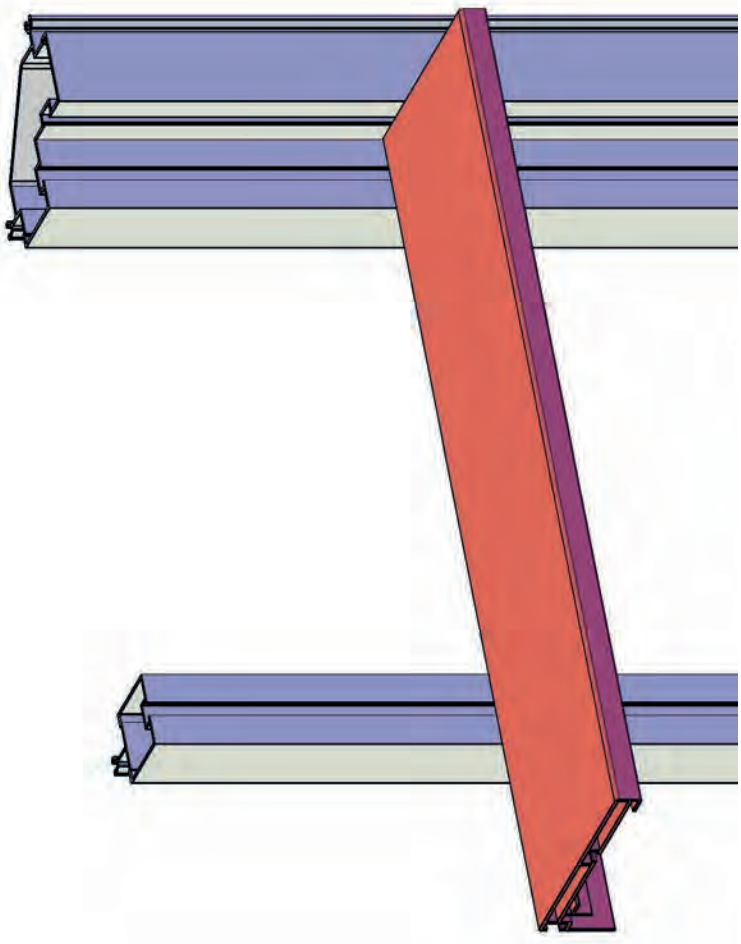
OPTION: 2 SLAT SHELF



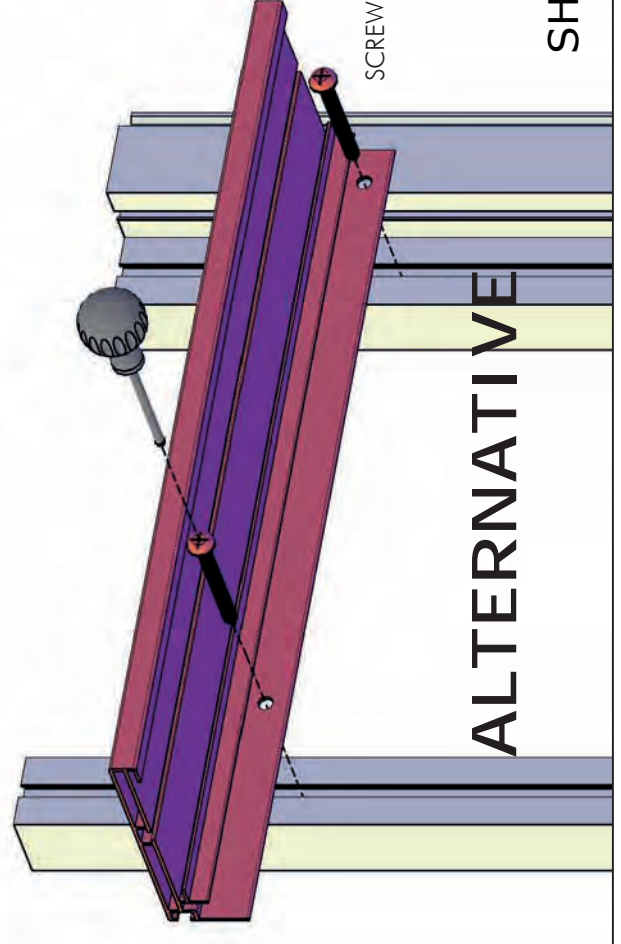
# OPTION: 5 SLAT SHELF



OPTION: 4" NARROW TOP SHELF



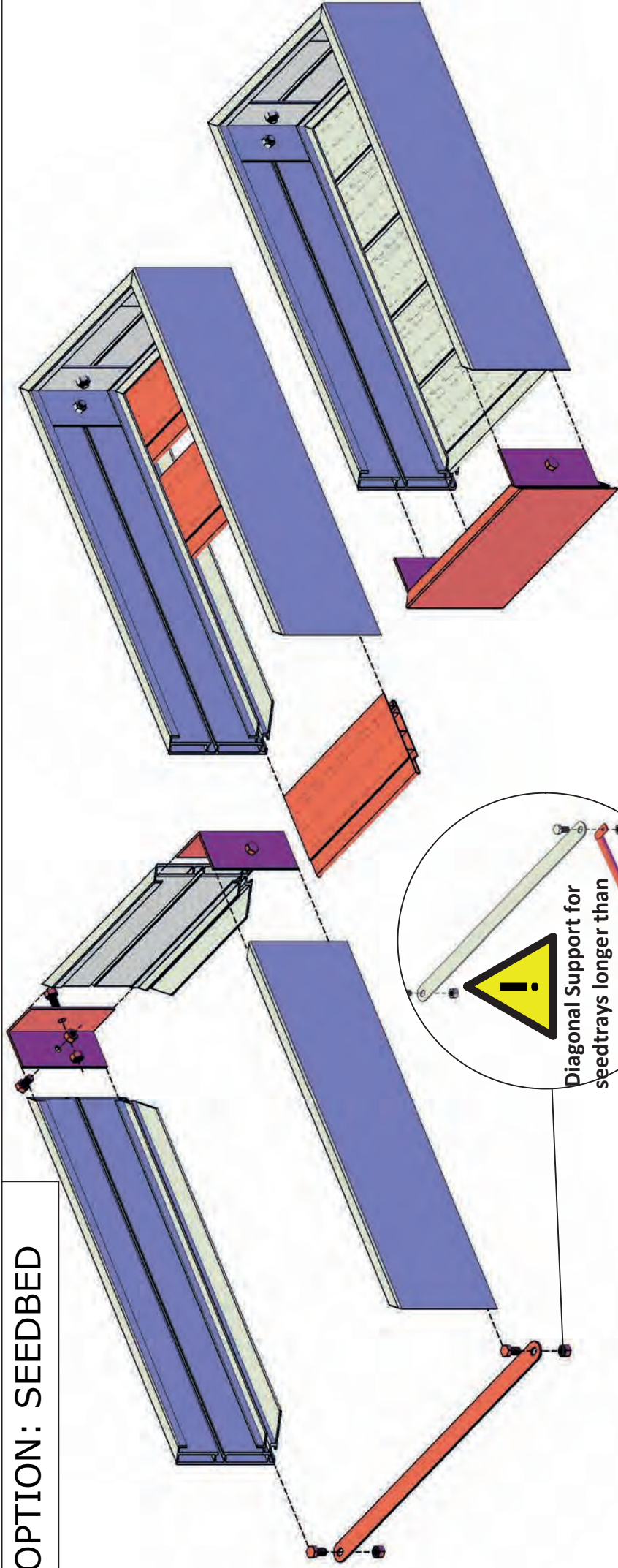
STANDARD




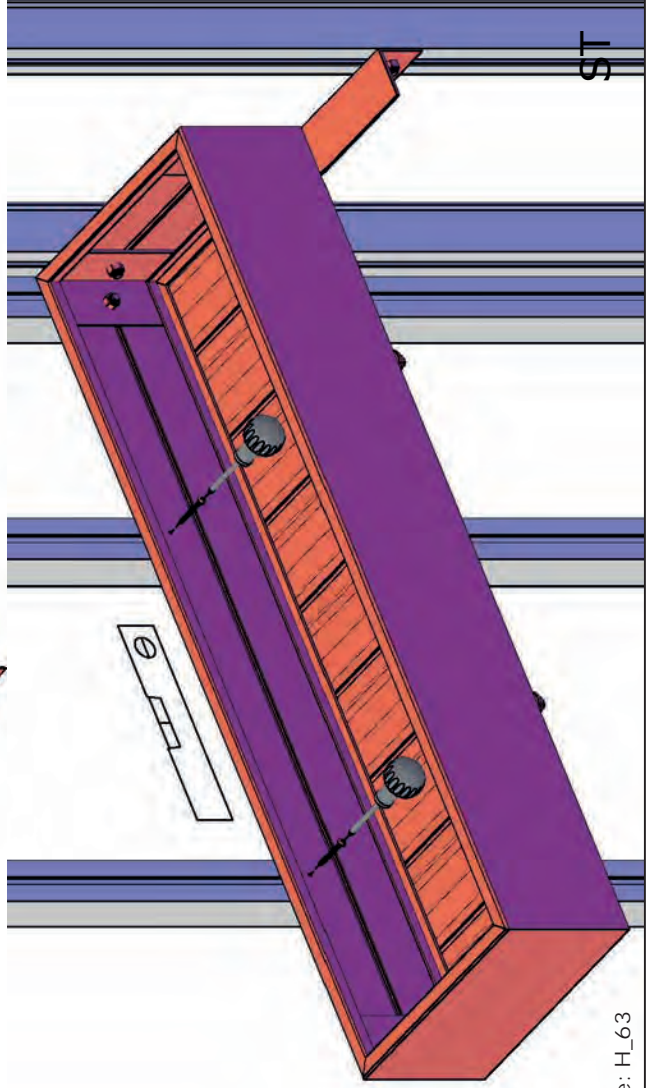
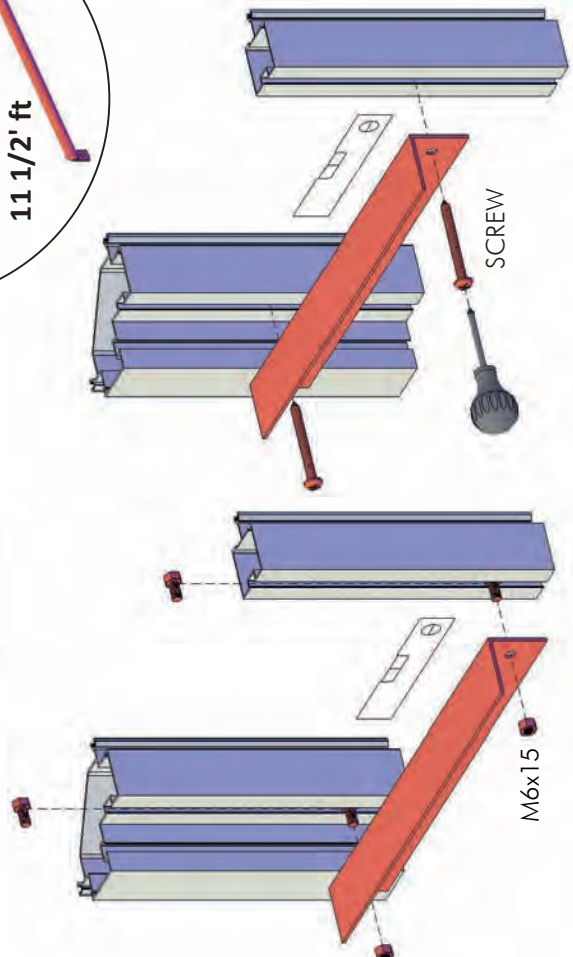
ALTERNATIVE

SH

OPTION: SEEDBED





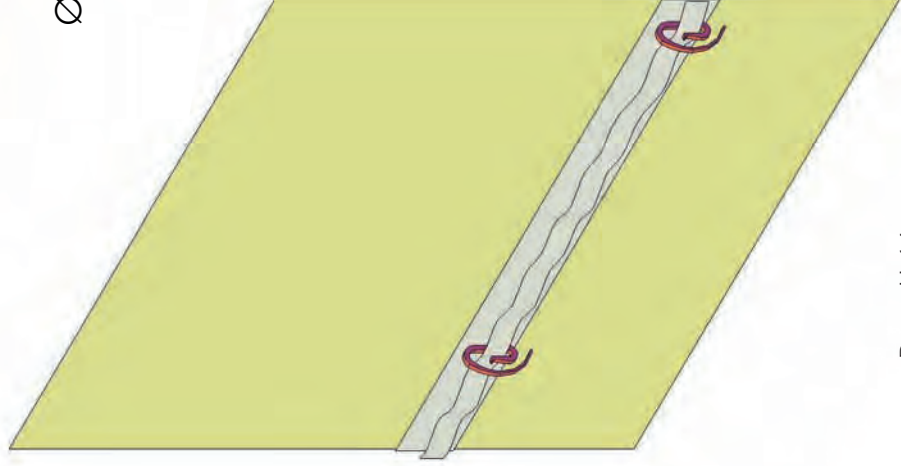
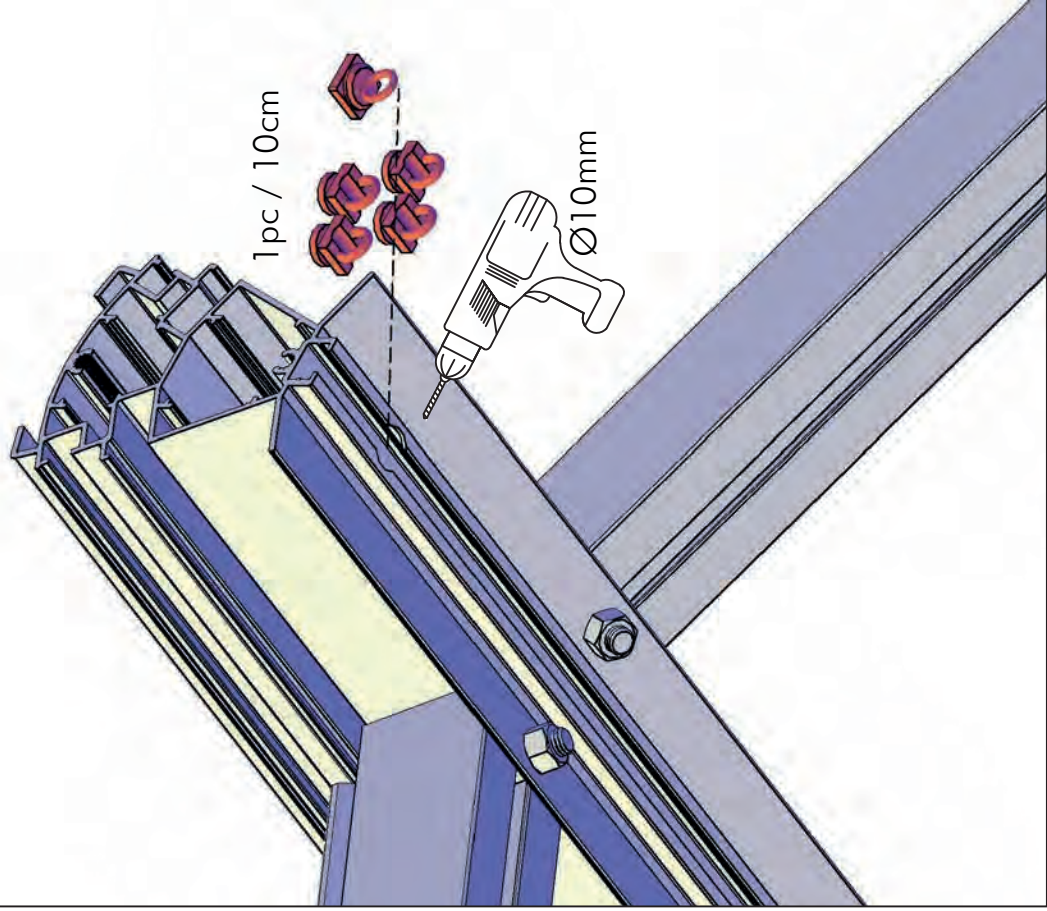
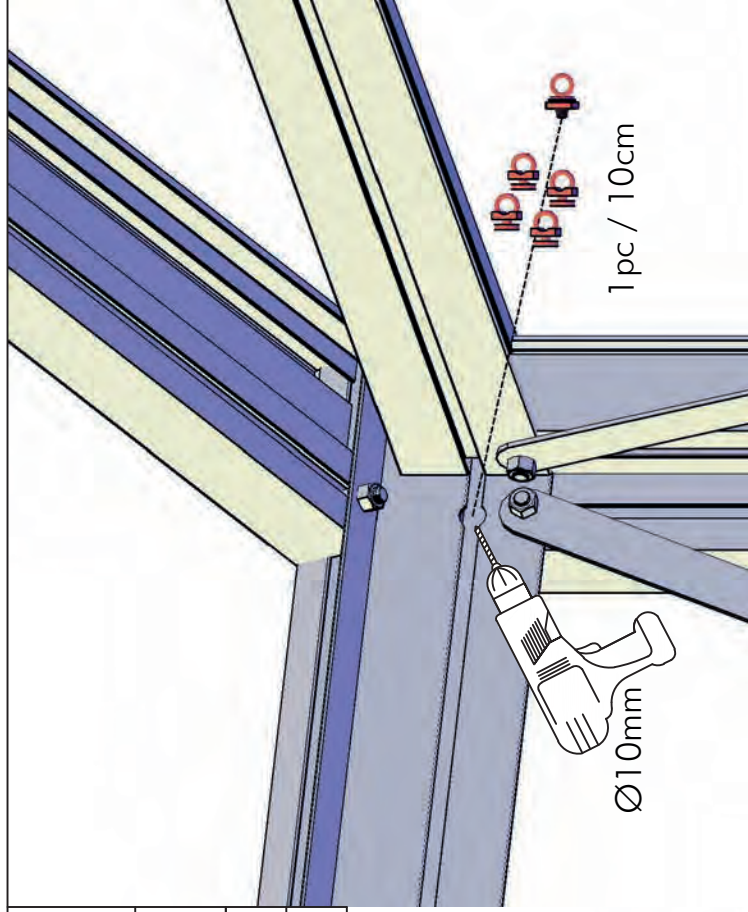
  
Diagonal Support for  
seedtrays longer than  
11 1/2' ft



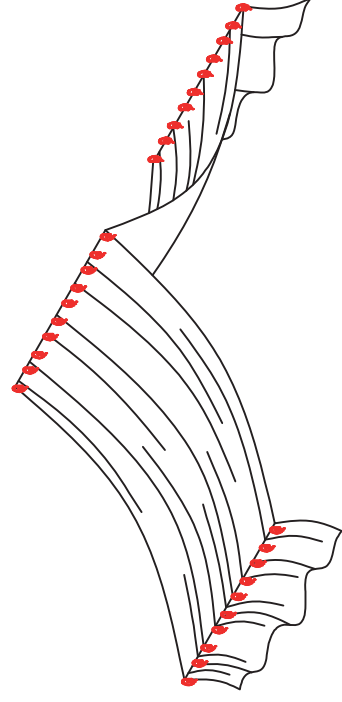
STANDARD ALTERNATIVE

OPTION: Shadecloth (please see next page as well)

TYPE	SUN236_73	SUN310_73	SUN236_300	SUN310_300
	24 pcs	24 pcs	93 pcs	93 pcs
	24 pcs	24 pcs	93 pcs	93 pcs



Insert hooks every 6th loop



HELIOS

## OPTIONAL ACCESSORY: SHADECLOTH

**Inserting the curlicue hooks into the curtain:** The curlicue hooks that insert into the curtain will go in every 6<sup>th</sup> loop in the white ribbon— look at the picture diagram to ensure you are inserting them in the correct direction so the curtain hangs well. Your curtains will have one looped ribbon running across the center (for the ridge) and 3 white looped ribbons on either side. If you have a VI23 you will use the ribbons closest to the center, the VI34 and 36 as well as the Royal Orangerie use the center ribbons. The VI46 will use the ribbons closest to the edge. Please note in the 10 ft long curtains there are 2” gaps located about 30” in from each edge along the center ridge ribbon, this is not a defect. These gaps are intentional to allow for misting system support hooks (as needed) and diagonal supports (VI 34/36/46). **Please note: if you have forgotten to insert any items during assembly, you may “notch” the channel with a ½” drill bit in an inconspicuous place. We can send a touch up paint pen if you need one.**

**VI 23 (7’9” x 10’2”)** - One shadecloth section (SUN236-300). The misting system is best hung from one bolt/hook at one end of the shadecloth and through the intentional gap at the other side. This allows for the curtain to be gathered around one of the hooks when not needed. Insert the following in this order:

- In ridge profile:
  - 1 bolt (for L bracket that connects at gable end)
  - Twist lock (optional)
  - 30 Sliding Eye Hooks
  - Twist lock (optional)
  - 1 bolt (for L bracket that connects at gable end)
- In each gutter profile:
  - 1 Twist lock (optional)
  - 30 Sliding Eye Hooks
  - 1 Twist lock

**VI 34 (10’2” x 15’)** - Has three separate curtains – (2) SUN310-73 (these smaller sections fit between each gable end and the diagonal support) and (1) SUN310-300 (placed in the longer middle section). The misting system is best hung from 2 bolts/hooks placed next to each diagonal support so the larger curtain moves freely in the middle. Insert the following in this order:

- In ridge profile:
  - 1 bolt (for L bracket that connects at gable end)
  - 9 Sliding Eye Hooks
  - 1 bolt for diagonal support
  - 1 bolt for hook for misting system
  - Twist lock (optional)
  - 30 Sliding Eye Hooks
  - Twist lock (optional)
  - 1 bolt for hook for misting system
  - 1 bolt for diagonal support
  - 9 Sliding Eye Hooks
  - 1 bolt (for L bracket that connects at gable end)
- In each gutter profile:
  - 1 Twist lock (optional)
  - 48 Sliding Eye Hooks
  - 1 Twist lock







**VI 36 (10’2” x 19’11”) and VI 46 (12’7” x 19’11”)** -Shade cloths are (2) SUN310-300. The diagonal supports at the gable ends will be inserted through the intentional gaps in the shadecloth. The misting system is best supported by (3) bolts/hooks: one by each of the diagonal supports and one in the center. The VI 36 and VI 46 have additional “scroll” supports that are placed across the gutter and ridge profiles in the middle of the greenhouse – there is no hardware inserted in these profiles for the supports, but they will be mentioned. Insert the following in this order:

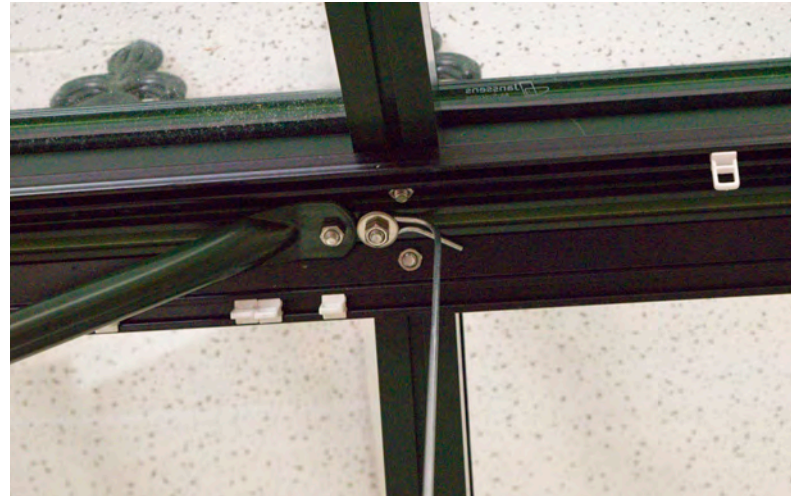
- In ridge profile:
  - 1 bolt (for L bracket that connects at gable end)
  - 9 Sliding Eye Hooks
  - 1 bolt for diagonal support
  - 1 bolt for hook for misting system
  - 20 Sliding Eye Hooks
  - Twist lock (optional)
  - 1 bolt for hook for misting system
  - Space for “scroll” support
  - 1 Twist lock (optional)
  - 20 Sliding Eye Hooks
  - 1 bolt for hook for misting system
  - 1 bolt for diagonal support
  - 9 Sliding Eye Hooks
  - 1 bolt (for L bracket that connects at gable end)
- In each gutter profile:
  - 1 Twist lock (optional)
  - 30 Sliding Eye Hooks
  - Space for “scroll” support
  - 30 Sliding Eye Hooks
  - 1 Twist lock (optional)



# Misting System (If Equipped)

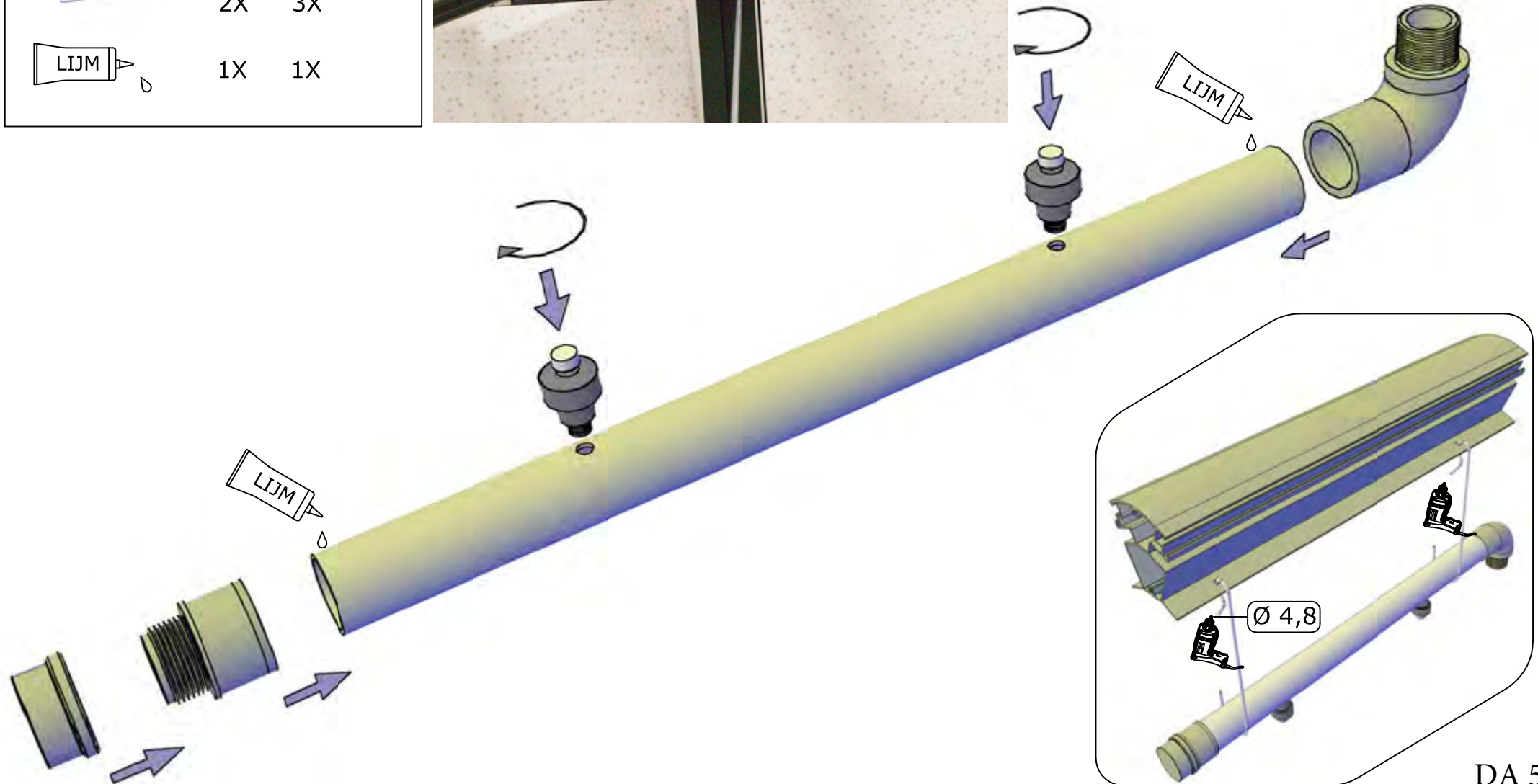
TYPE    Vi23    Vi34/36  
**310    458**

	3X	4X
	1X	1X
	1X	1X
	2300	3300
	2X	3X
	1X	1X



Note: If curtains are going to be installed, the misting system should be hung with bolts as shown to the left. The hangers will need to be bent into position.

If there are no curtains it can be hung by drilling holes and hooking the hangers through them. (Shown below)





Customer Service or  
Assembly Questions?

Give us a call  
Toll free: 1-877-760-8500  
customerservice@exaco.com  
Exaco Trading  
www.EXACO.com

*Please watch our animated assembly  
video on our Exaco Tracing Co  
YouTube Channel.  
Find the link at [www.exaco.com](http://www.exaco.com)*

**Janssens NV** Mechelsesteenweg 388, B-2500 Lier Belgium  
(T) +32 15 30 67 80 (W) [www.janssens-alusystems.be](http://www.janssens-alusystems.be) (E) [info@janssens-alusystems.be](mailto:info@janssens-alusystems.be)