

# ASSEMBLY MANUAL

## Structure 72EC5

Pitched-roof mounting. 5 panels aH72

V 6.0


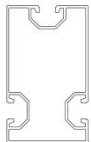
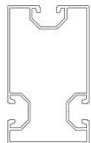
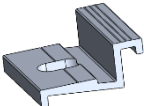


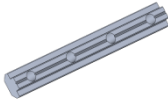

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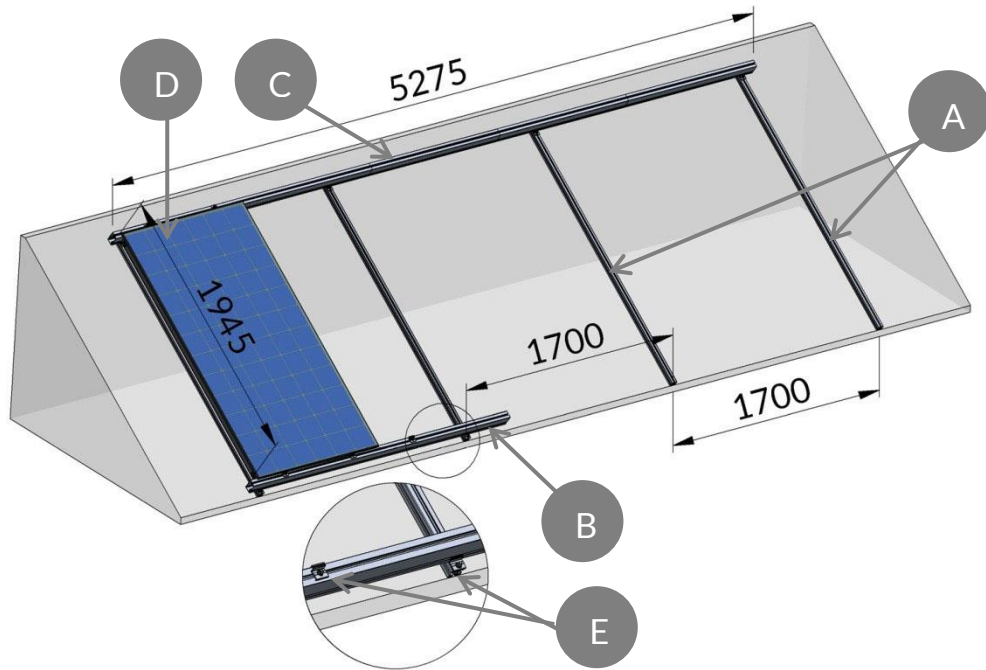
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## 1 Structure elements

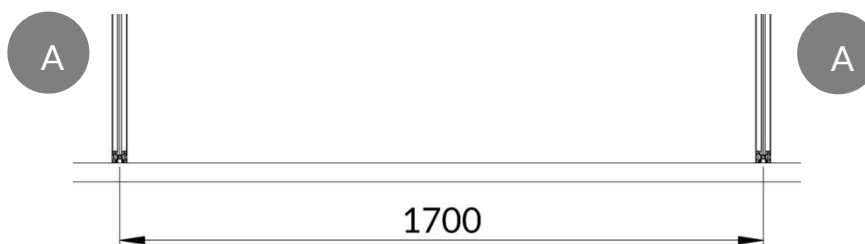
Element	Detail	Description	Length (mm)	Units included in the Mounting Kit
1		<b>Vertical profile PROFILE 40x40 mm</b>	2.110	4
2.1		<b>PROFILE 50x85 mm</b>	2.110	4
2.2		<b>PROFILE 50x85 mm</b>	1.055	2
3		<b>CLAMP</b> for anchoring panels to 50x85 mm rails and for joining rails to vertical profiles	40	37
4		<b>M8X20 HAMMER HEAD</b> screw	-	37
5		<b>FLANGE NUT M8 DIN 6923</b>	-	37
6		<b>CONNECTING STRIPS</b> with M8 ALLEN screws to join 50x85 profiles to form the panel rails	150	12
7		<b>ALLEN M8</b> screw	-	48



- |          |                  |          |                   |
|----------|------------------|----------|-------------------|
| <b>A</b> | Vertical profile | <b>D</b> | Hybrid panel aH72 |
| <b>B</b> | Lower panel rail | <b>E</b> | Mounting clamp    |
| <b>C</b> | Upper panel rail |          |                   |

## 2 Step 1: Assembly of vertical profiles

- Install the VERTICAL PROFILES (A), profiles of 40x40, on the pitched roof after installation of the roof hooks or the system provided on site for safe and sufficient anchoring between the building structure and the panel support structure.
- **IMPORTANT: 1.700 mm separation** between axes of vertical profiles (A) for structure of 5 hybrid panels aH72 on a row (72EC5).



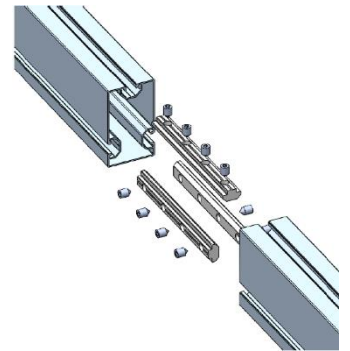
### 3 Step 2: Mounting the upper and lower panel rails

- Assemble the 50X85 PROFILES (element 2) using the CONNECTING STRIPS (element 6) and the ALLEN M8 screws (element 7) until the lower and upper support rails are complete (B and C), then assemble the lower and upper panel rails (B and C) on the vertical profiles (A).

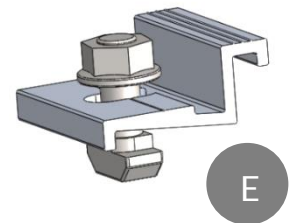
Each of the panel rails will be made up of 2 profiles of 2.110 mm (element 2.1) and 1 profile of 1.055 mm (element 2.2).

The total length of each panel rail will be 5.275 mm.

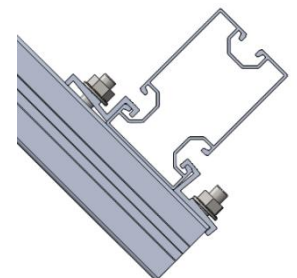
$$\text{Rail B} = \text{Rail C} = 2 * 2.110 + 1 * 1.055 = 5.275 \text{ mm}$$



- Pre-assemble the Mounting clamps (E) with CLAMPS (element 3), M8x20 HAMMER HEAD screws (element 4) and M8 DIN6923 flange nuts (element 5), as shown in the figure.

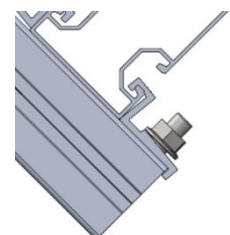


- Place the LOWER PANEL RAIL (B) on the VERTICAL PROFILES (A) and anchor it using two pre-assembled mounting clamps, as shown in the figure.

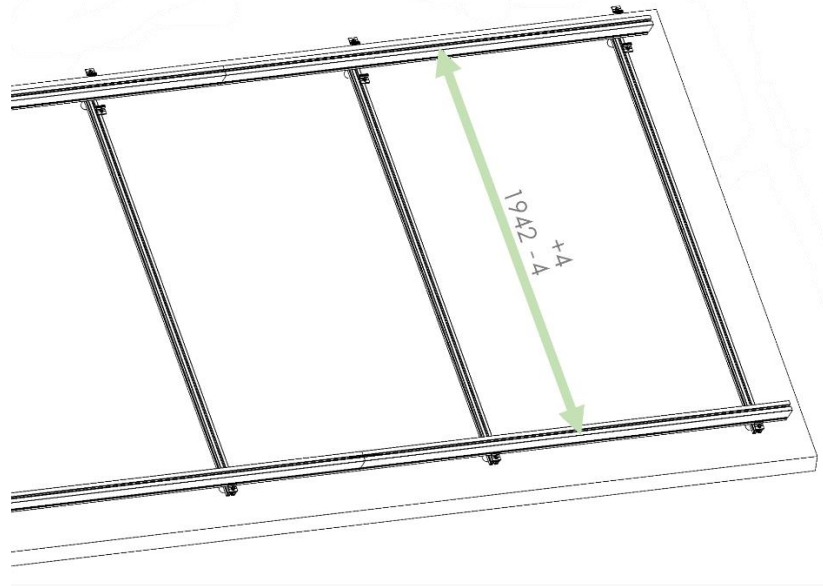
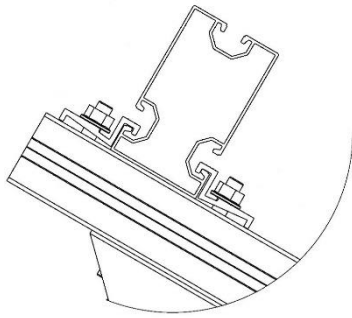


- IMPORTANT:** The lower clamp must be positioned **EXACTLY** on the **edge of the vertical profile (A)**, as shown in the figure.

This position sets the gap between the upper and lower panel rails required to properly install the panels later.



- Presentar la **GUIA DE PANEL SUPERIOR (C)** sobre los **PÓRTICOS (A)** y anclarla al pórtico mediante la utilización de dos grapas de unión pre-montadas previamente, **a una DISTANCIA ENTRE GUÍAS DE 1.942 mm (+/-4).**



#### 4 Step 3: Placing and attaching panels to the structure

- Install the hybrid panels on the structure starting from one of the ends leaving a **50 mm** gap between the end of the PANEL RAIL (B or C) and the beginning of the PANEL (D).
- Install 4 MOUNTING CLAMPS (E) for each panel to anchor them to the structure. Install 2 Clamps on the upper panel rail and 2 Clamps on the lower panel rail. They will be positioned **200 mm** from the end of each panel as shown in the figure.
- The gap between panels will be **50 mm**.

