

ASSEMBLY INSTRUCTIONS

Note: Large Star Assemblies, 18"-24" require additional steps which have been highlighted in yellow.

PARTS

PART	QTY	DESCRIPTION
1	2	Saddle Weldment
2R/2L	4	2 x 2 x 1/4 Angle or 3x3x1/4 Angle for Large Star Assemblies, 18"-24"
3	4	1 1/2 x 1 1/2 x 3/16 Angle (outer bracing)
4	4	1 1/2 x 1 1/2 x 3/16 Angle (inner bracing)
A	8	3/8-16 x 2 Flange Bolt Gr. 8 Yellow Zinc
B	20	24 3/8-16 x 1 1/4 Flange Bolt Gr. 8 Yellow Zinc
C	28	32 3/8-16 Stover Flange Nut Yellow Zinc

STEPS

STEP 1

Attach saddles (Part #1) to pipe finger tight using long bolts (A) and nuts (C).

STEP 2

Attach 2" Angles (2R/2L) to saddles (part #1) finger tight using short bolts (B) and nuts (C).

STEP 3 *LARGE STAR ASSEMBLIES, 18"-24" ONLY

Attach 1 1/2" Angles (4) to center holes of 3" Angles (2R/2L) finger tight using short bolts (B) and nuts (C).

STEP 4

Attach 1 1/2" angles (3) one on top and one underneath in the corresponding holes for that size in the 2" angles (2R/2L) (3" for Large Star Assemblies, 18" - 24") finger tight using short bolts (B) and nuts (C).

STEP 5

Repeat steps 1-3 torque tighten bolts working from the center outward starting with the saddle.

NOTES

Use appropriate hole for desired saddle size.

6" or 12" or 18" Cable Hole
8" or 14" or 20"
10" or 16" or 24"

