

**Stainless Steel Handrail Support Assembly:**

Before installing handrail support fittings, use degreaser to clean out any grease or debris from the inside of the post top open end. Remove any remaining fluid or debris with a clean rag so the area that you are going to apply adhesive is dry and clean.

Use metal adhesive to glue on handrail support fittings (if not welding or using fasteners) :

\*Must be over 50 degrees F. (Also store adhesive at over 50 degrees F.) It is preferred to use a primer agent to assist and activate adhesion of the adhesive. To ensure a fast and reliable cure, primer Activator 7649™ should be applied to one of the bond surfaces and the adhesive to the other surface. Parts should be assembled within 15 minutes. The recommended bondline gap is 0.1 mm. Where bond gaps are large (up to a maximum of 0.5 mm), or faster cure speed is required, Activator 7649™ should be applied to both surfaces. Parts should be assembled immediately (within 1 minute). Excess adhesive can be wiped away with organic solvent. You may need to clamp or temporarily secure parts during adhesive setting to maintain tight connections. (If using knocked-down fittings you can either assemble your rail mounts or insert bottom piece first then assemble the neck and saddle after.) You may need to file the post end, and/or use a mallet to allow insertion.

Let set for 30-60 minutes before handling. **\*Wait 24-72 hours before tensioning of any cable assemblies connected.** Be careful not to put unnecessary lateral stress which could bend any connections. \*(You may need to wait longer if working in a moist environment.)

\*Make sure to tighten the screw to secure your saddle if moveable.

Degreaser

Metal Adhesive

Primer

Post Insert Handrail Fittings



**Post (Round with Flange Pictured)**

\*(See opposite page for handrail assembly.)

**Stainless Steel Handrail & Component Assembly:**

Cut your tube/handrail lengths needed, while keeping your layout, posts, handrail component styles and locations in mind. You may want to “dry fit” before cutting or assembly. Make sure you are using the proper style saw and blade for the materials. Cutting stainless steel can be done with various methods that require various different cut finishing.

Before installing handrail components, use degreaser to clean out any grease or debris from the inside of the tube open end. Remove any remaining fluid or debris with a clean rag so the area is clean and dry.

Use metal adhesive to glue on handrail components (if not welding or using fasteners). \*Must be over 50 degrees F. It is preferred to use a primer agent to assist and activate adhesion of the adhesive. To ensure a fast and reliable cure, primer Activator 7649™ should be applied to one of the bond surfaces and the adhesive to the other surface. Parts should be assembled within 15 minutes. For large gaps or faster cure time Activator 7649™ should be applied to both surfaces and parts assembled in 1 minute. Excess adhesive can be wiped away with organic solvent. You may need to clamp or temporarily secure parts during adhesive setting to maintain tight connections. You may need to file the tube end, and/or use a mallet to allow insertion.

Let set for 30-60 minutes before handling. **Wait 24-72 hours before tensioning of any assemblies connected.** Be careful not to put unnecessary lateral stress which could bend connections.

Secure your handrail support to the tube/handrail with fasteners. Carefully mark hole locations and pre-drill with the recommended size bit. You may need to tap the hole for thread depending on fastener.

**Tube/Handrail**



**Commonly Used Handrail Components**



Use fasteners to attach handrail support to tube handrail. (if not welding) \*You should pre-drill and in most cases you may need to tap the hole for thread depending on fastener. Threadlock is optional.



**Degreaser Metal Adhesive Primer**

Use degreaser, primer & adhesive, then insert components (if not welding).

**Screw (fastener)**

**Handrail Support**



\*Make sure to tighten the screw to secure your saddle if moveable.

