

ASSEMBLY INSTRUCTIONS LIGHT MAST 6-42m

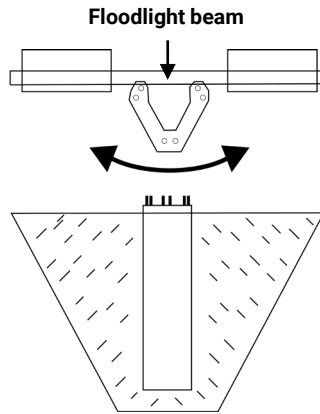
Foundation

» Mount the opening on the foundation against the surface to be illuminated. This is so that any equipment in the top can be mounted correctly.

» We recommend laying the cable pipe in the open side of the foundation.

» Filling in and against foundations must be done with materials according to the current "AMA anläggning".

» Packing must be done according to the current "AMA anläggning".



Mounting of foundation adapter for <450mm section

» Thread on the 6 bottom nuts to the bottom of the foundation studs and place washers.

» Attach the adapter and adjust it in balance with the 6 lower nuts, ensure straightness with a spirit level. Make sure that the adapter rests on all nuts, if it does not there is a risk that the adapter will become skewed after tightening the nuts.

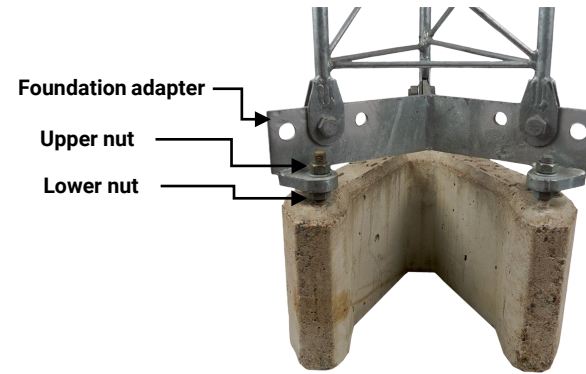
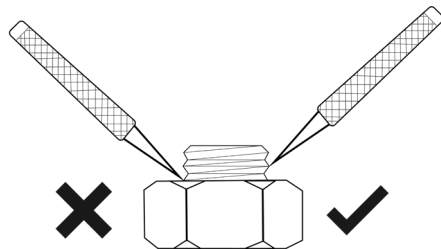
» Lift the mast on the foundation and place 6 washers on the studs.

» Thread on the upper nuts.

Tightening torque oiled joints M20 220Nm / M24 380Nm.

NOTE! A torque wrench must be used during assembly.

Drive stroke on threads for locking all nuts in the construction **MUST** be done after tightening.



Joint/transition	Bolt kit
230/340	3x M20x45 8.8 VFZ
340/450	3x M20x45 8.8 VFZ
450/560	3x M24x60 8.8 VFZ
560/690	6x M24x100 8.8 VFZ
690/890	6x M24x100 8.8 VFZ
890/1160	6x M24x100 8.8 VFZ

Assembly of mast sections

» Carefully pull out mast sections. Make sure that the hot dip galvanizing does not get damaged.

» Assemble sections with supplied bolt kits.

» Before fully tightening the nuts, make sure that the mast is straight. Use a straightening board or a long spirit level.

M20 is tightened with torque 400Nm
M24 is tightened with torque 700Nm

Mast mounting directly on stud bolt foundation >560mm section

» Thread the 6 lower nuts at the bottom of the foundation studs and add washers.

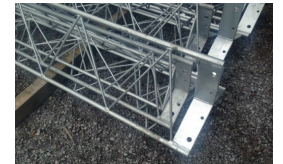
» Lift the mast onto the foundation according to the lifting instructions.

» Place a washer on each stud and thread the nuts on each stud without fully tightening.

» Use a spirit level and adjust the mast level with the lower nuts.

» Nuts are now tightened with the respective tightening torque.

Tightening torque oiled joints M20 220Nm / M24 380Nm.



ASSEMBLY INSTRUCTIONS FLOODLIGHT BEAM

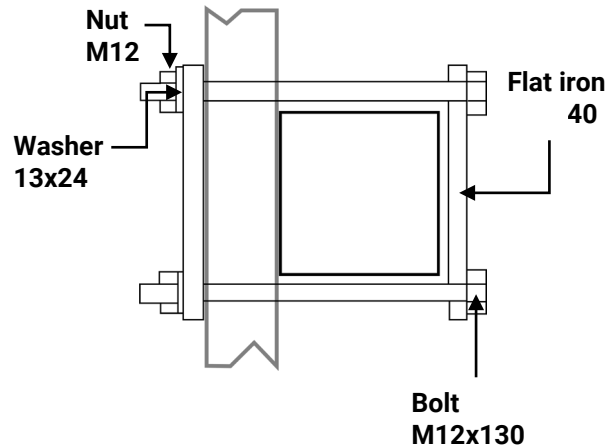
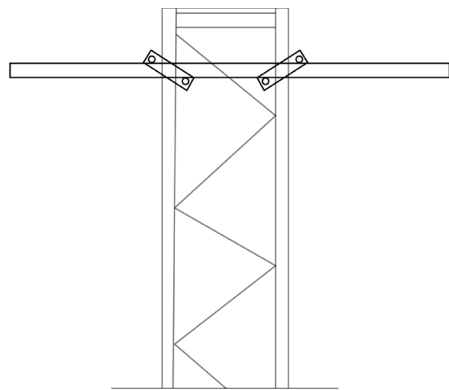
Mounting of beam on mast

» The beam is mounted on the side of the mast.
Fits sections: 230, 340, 450 & 560.

» The beam is clamped with flat iron in the outer round bars.

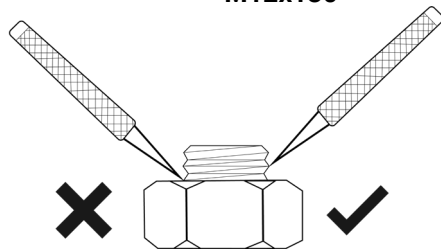
» Nuts are tightened with a torque wrench and locked with a drive stroke.

Dimension	Socket	Tightening torque (oiled joint)
M12	19	55Nm

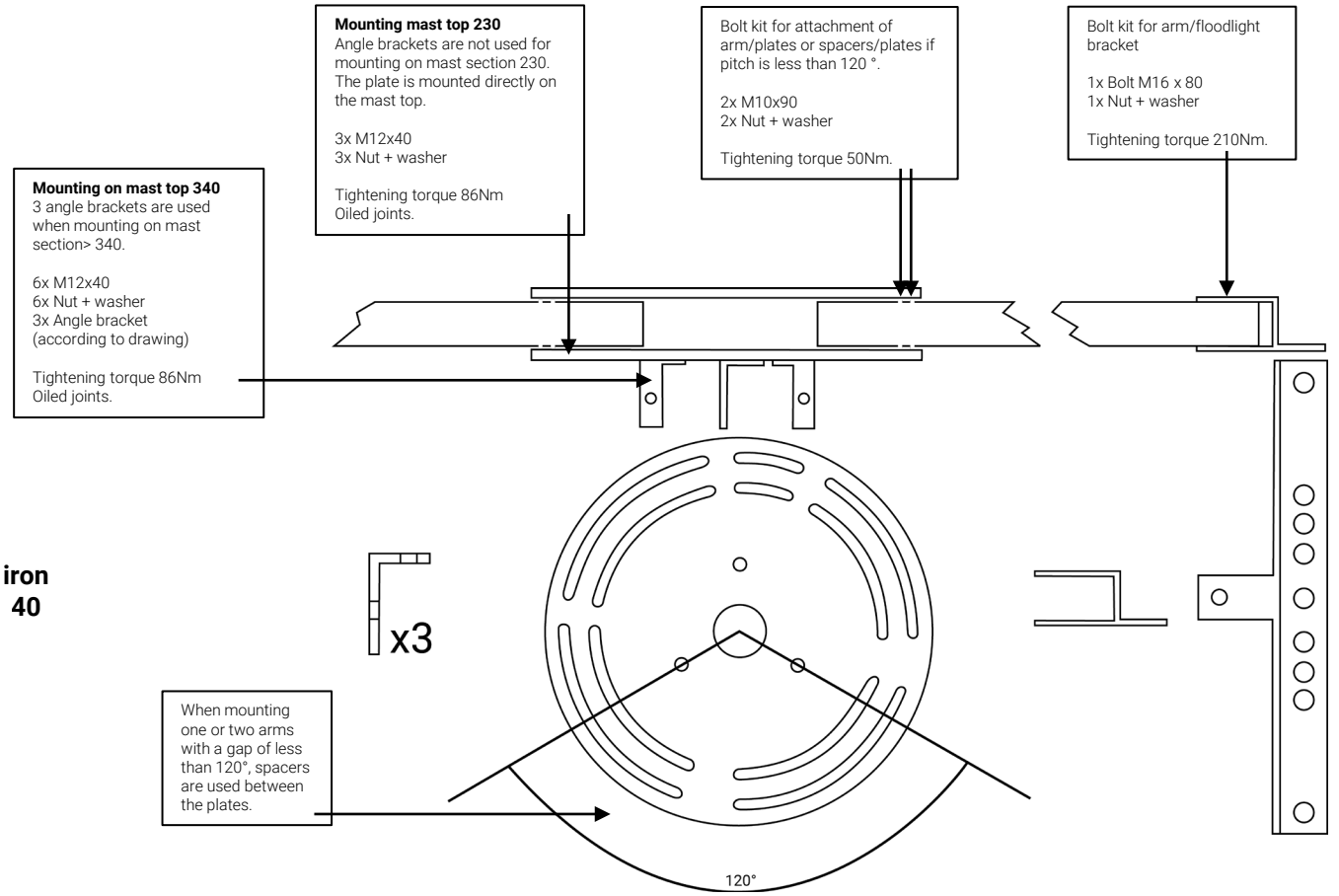


NOTE! A torque wrench must be used during assembly.

Drive stroke on threads for locking all nuts in the construction **MUST** be done after tightening.



ASSEMBLY INSTRUCTIONS ROTABLE BRACKET



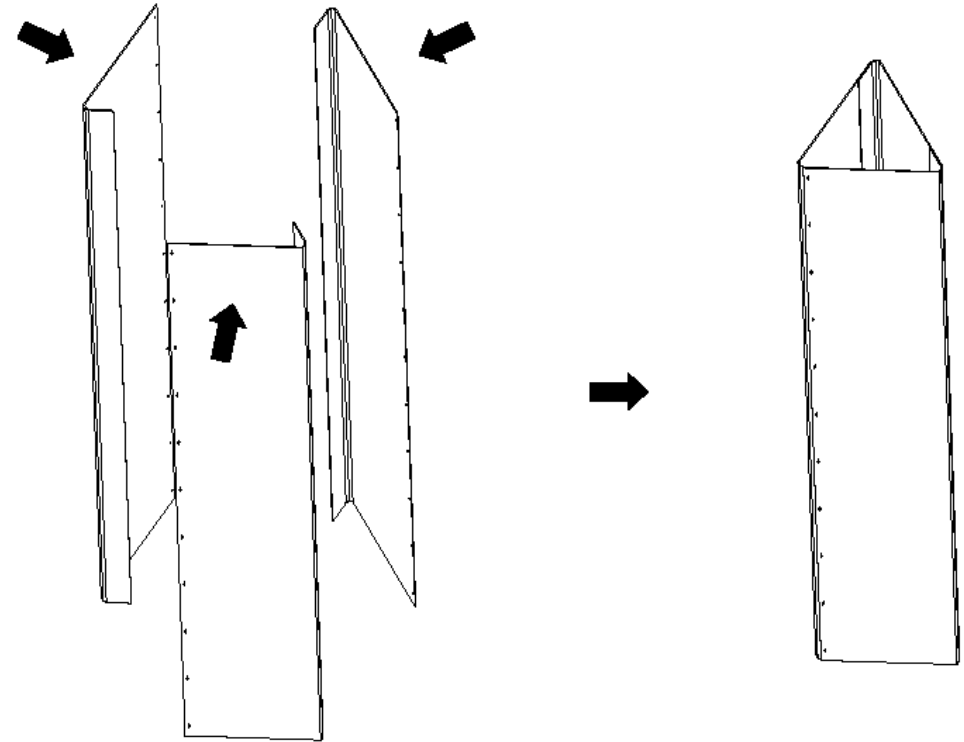
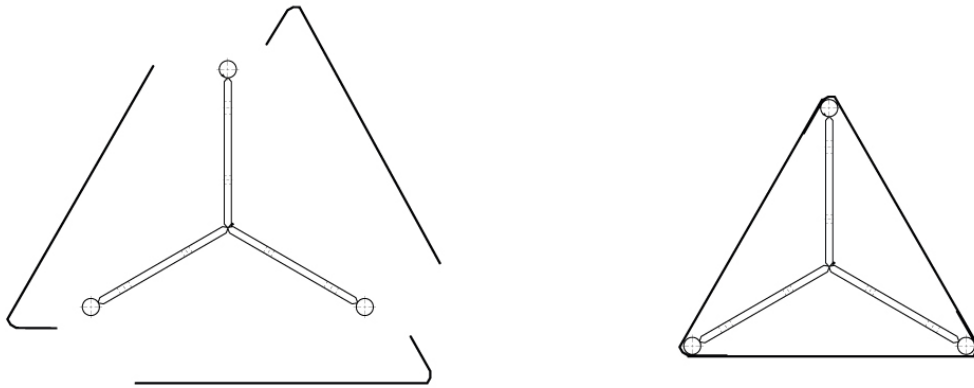
ASSEMBLY INSTRUCTIONS CLIMBING PROTECTION

Installation of climbing protection on the mast

» The plates are mounted on the three sides of the mast and comes in custom dimensions for mast sections: 230-890.

» The bent part is placed on the inside of the flat side.

» Drill holes and use supplied pop rivets to join the parts to enclose the mast.



Drill diameter	Pop rivets per side	Total number of pop rivets
5mm	10pcs	30pcs

ASSEMBLY INSTRUCTIONS FUSE BOX (L = 1600mm)

Mounting the fuse box on the mast

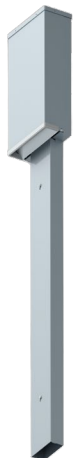
» Loosen the bolts and fittings at the back of the fuse box.

» Place the fuse box centered against one of the sides of the mast with the bottom edge above ground level.

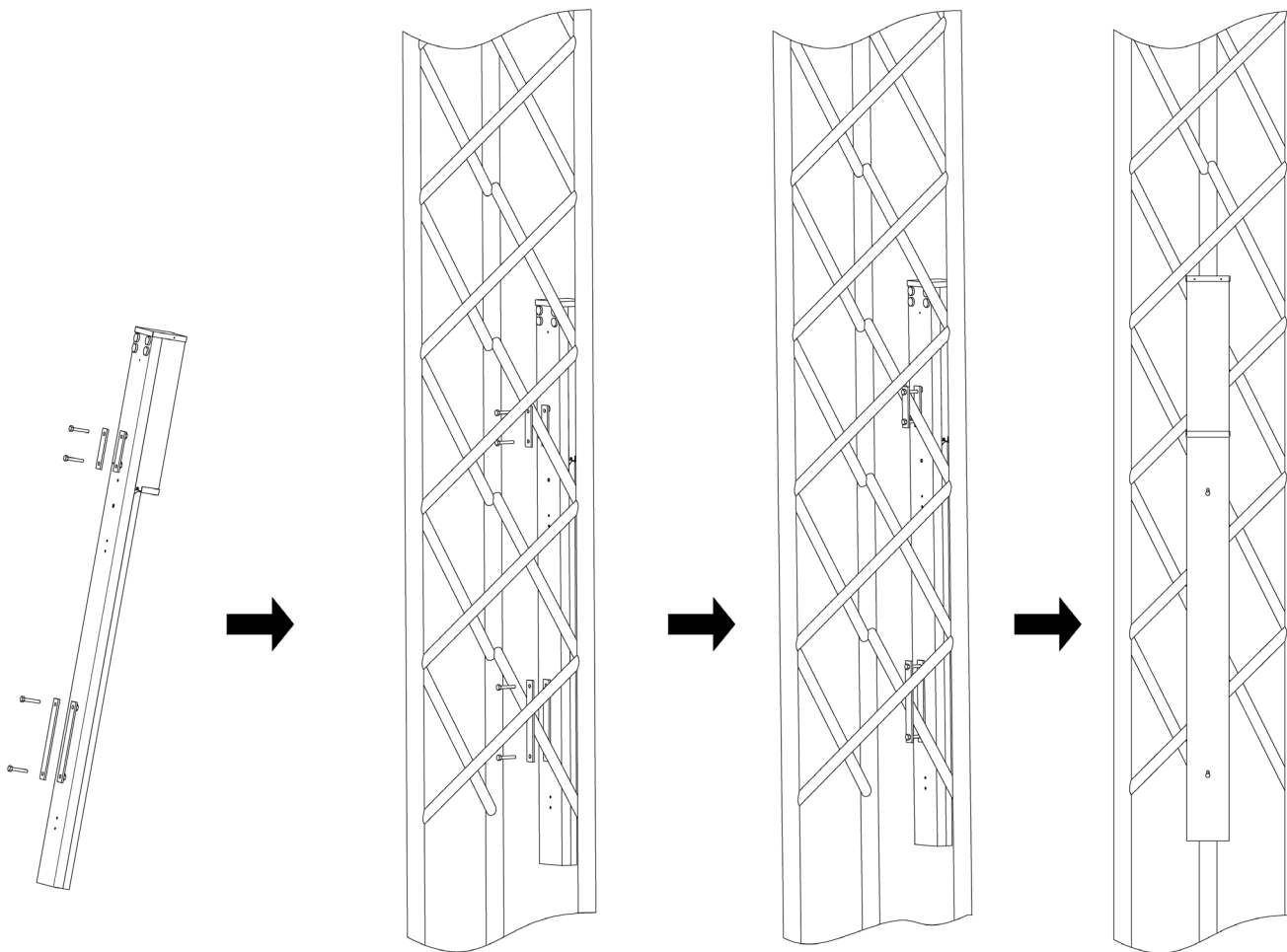
» Place the fittings on the inside of the diagonal bars of the mast and thread in the bolts by hand.

» Tighten all four bolts. Be sure to cross-tighten the bolts.

Fuse box L
top part 220 mm



Fuse box S
top part 120 mm



ASSEMBLY INSTRUCTIONS FUSE BOX (L = 600 mm)

Mounting the fuse box on the mast

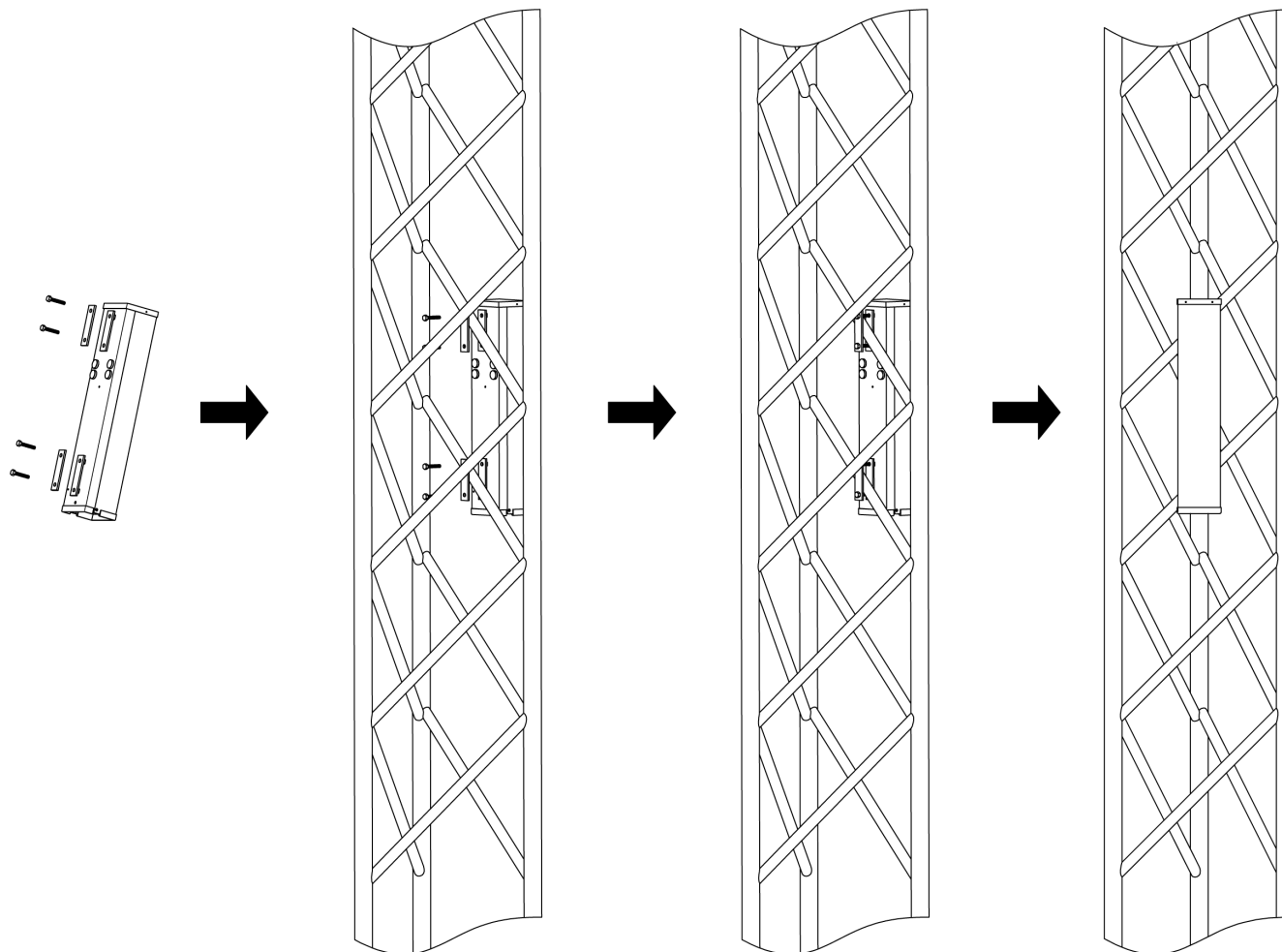
» Loosen the bolts and fittings at the back of the fuse box.

» Place the fuse box centered against one of the sides of the mast with the lower edge above the climbing protection, approx. 2.7 m above ground level.

» Make sure there is enough space to route the cables properly without damage.

» Place the fittings on the inside of the diagonal bars of the mast and thread in the bolts by hand.

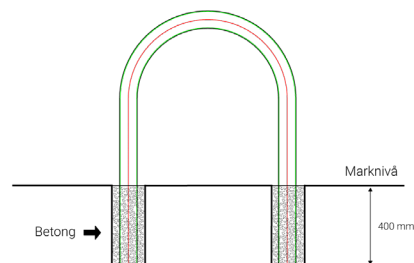
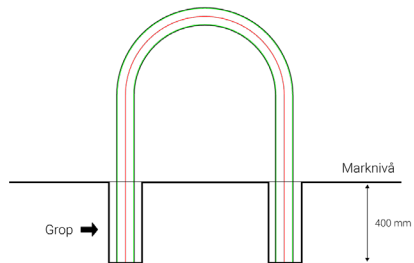
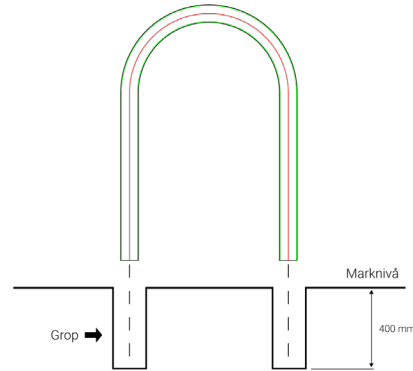
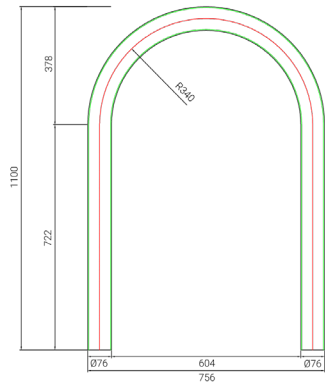
» Tighten all four bolts. Be sure to cross-tighten the bolts.



ASSEMBLY INSTRUCTIONS IMPACT PROTECTION

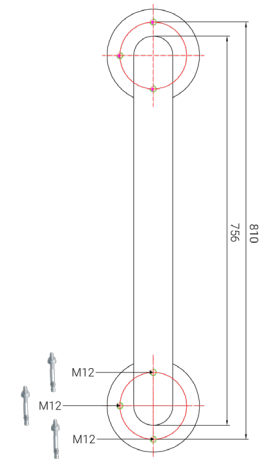
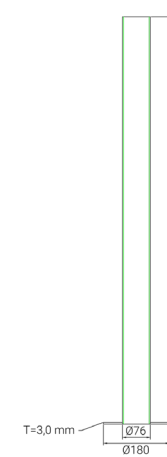
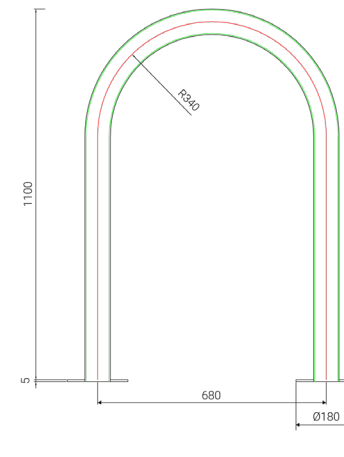
Installation of impact protection for pouring in

- » Excavate 400 mm
- » Lower the impact protection into the pits and fix so that it is straight.
- » Fill the pits with concrete



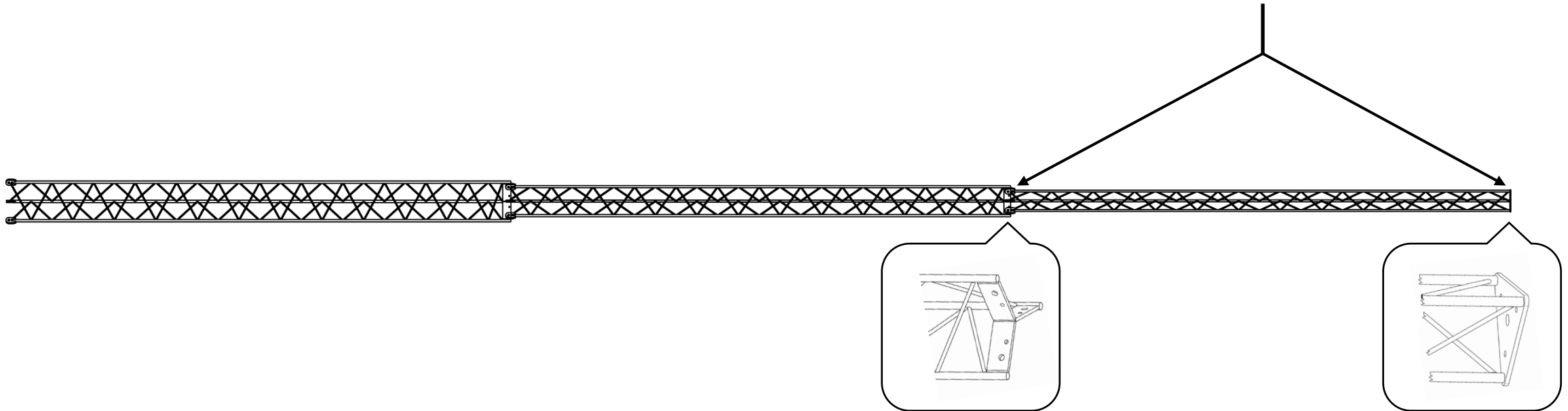
Installation of impact protection for bolts in the ground

- » Place the impact protection in place
- » Mark and drill according to the hole pattern with the intended drill size.
- » Bolt on with 3 pcs M12 expansion screws on each side



LIFTING INSTRUCTIONS LIGHT MAST 6-42m

» Use soft lifting straps approx. 2/3 up on the mast, see below:



» Connect straps in the flat irons, **DO NOT** lift in the round bars.

» Make sure that the masts are straight and that the bolt connections are tightened with the correct torque before raising.

CHECKLIST FOR MOUNTING LIGHT MAST 6-42m

PROJECT:

Point	Check	OK	NOT OK	N/A	Comment
1	Delivery control				
2	Foundation inspection				
3	Horizontal straightness of sections				
4	Vertical straightness of sections				
5	Mechanical damage				
6	Surface layer damage				
7	Torque wrench calibrated				
8	Foundation nuts tightened with correct torque				
9	Clamping connection bolts tightened with correct torque				
10	Other joints tightened with the correct torque				
11	Drive stroke on all nuts/bolts				
12	Floodlight beam mounted according to instructions				

Installer(s) on site, sign:

Date: