



**avasco
solar**

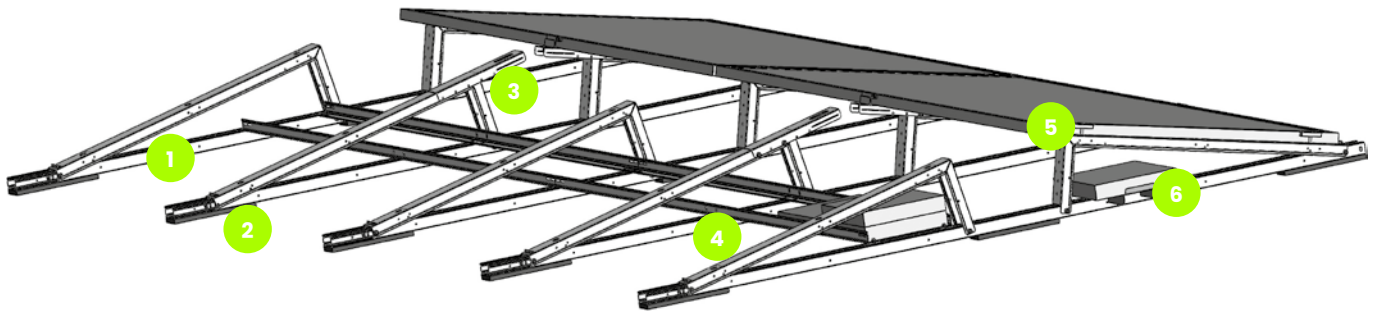


assembly instructions


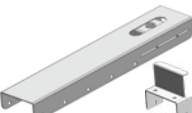

SolarSpeed 4.0 **east-west landscape**









SolarSpeed components



standard components

- 
1 basic unit:
semi-assembled triangles
+ rail + protective rubbers*
- 
2 end rubber*
- 
3 bracket +
extension piece for
mid support
- 
4 set of L-profiles
- 
5 clamps + M8 bolts
- 
6 ballast support

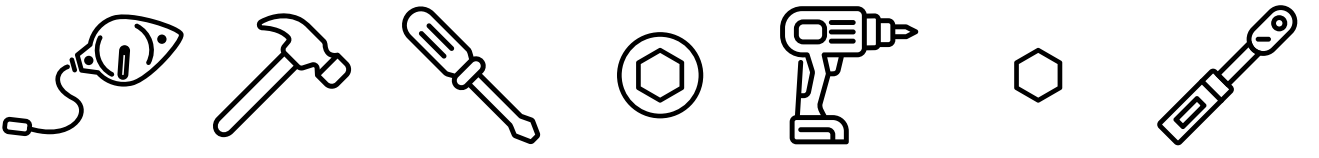
additional components

- 
concrete footing (12kg)
+ hammer plug
- 
PP footing
- 
C-rail end
reinforcement
- 
centre piece for
set of L-profiles
- 
ridge connection
- 
omega bracket


* For PVC roofs use rubber with aluminium underlay.




required assembly tools




chalk line




hammer




screwdriver




socket 3/8"
socket SW8




electric tool



hex 6.0



torque wrench
range 15-30Nm




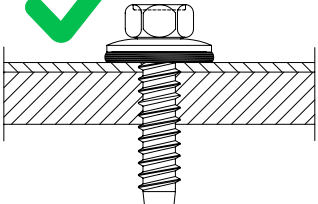
Avasco Solar spacer

prior to assembly


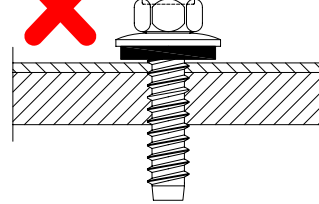
Make sure that the roof surface on which the frame is to be mounted is clean, dry and flat. Contamination such as gravel, sand or pebbles can lead to roof damage or installation instability.

correct assembly of sheet metal screws


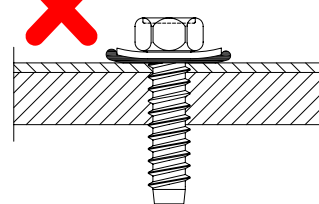
Prescribed compression EPDM washer: 25% of original thickness.
Use tools with depth control!


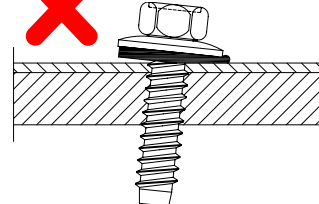
Correctly screwed on

Tightened too loosely

Tightened too far
(seal damaged)

Tightened too angled
(seal damaged)

Choosing the correct installation tool is absolutely essential for the fastener to drill and tap in the way it has been designed to perform. The selected screw gun will need to be equipped with a variable trigger to deliver a controlled overall speed without end loading, of between 1700 and 2000 rpm. It will need to provide torque of up to 30 Nm allied to a clutch mechanism to ensure that excessive torque and speed is not retained, causing damage or the 'stripping out' the fastener. Socket 3/8" must be used with sheet metal screws, socket SW8 with self-drilling screws.



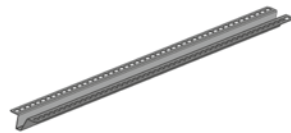
step 1: mounting basic units

step 1.1: from semi-assembled to assembled basic units

required components:



SolarSpeed basic unit
(semi-assembled)



C-rail end reinforcement
(optional)

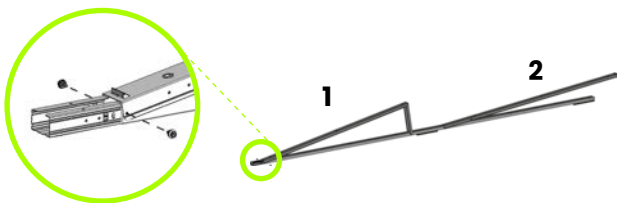


sheet metal screw
(Ø6.5x19mm)



Lift the semi-assembled basic unit and bend it until the holes in the top of the triangle are aligned. Squeeze the sides of the short leg to fit them inside the longer leg while bending.

Secure the ends of each assembly triangle to the rail by means of 2 sheet metal screws (Ø6.5x 19mm).



Bend the panel stop in an angle of 90° using a screwdriver.

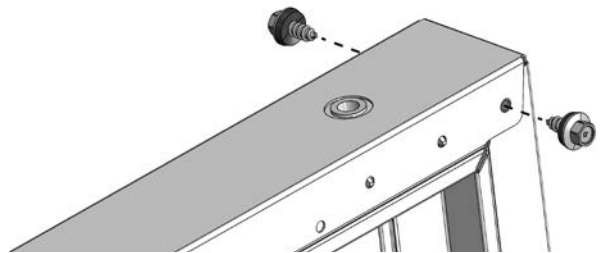


Caution! For every second basic unit follow step 3 as they will serve as mid supports.



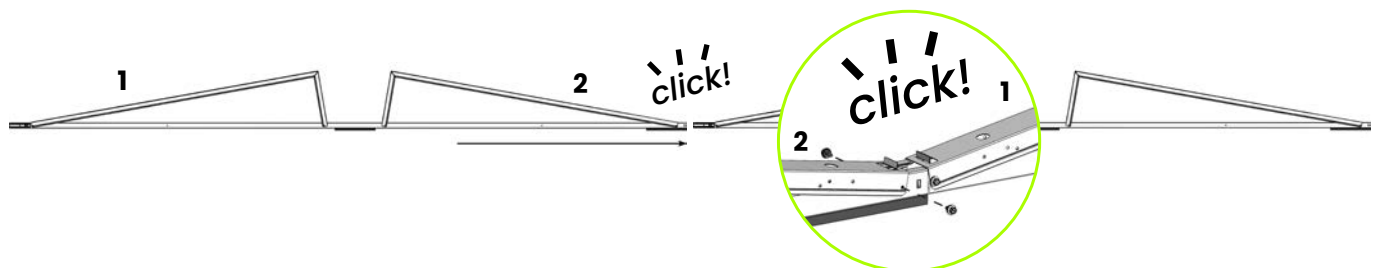
step 1.2: securing top of triangles

Secure the top of each assembly triangle with 2 sheet metal screws (Ø6.5x 19mm).



step 1.3: connecting the basic units

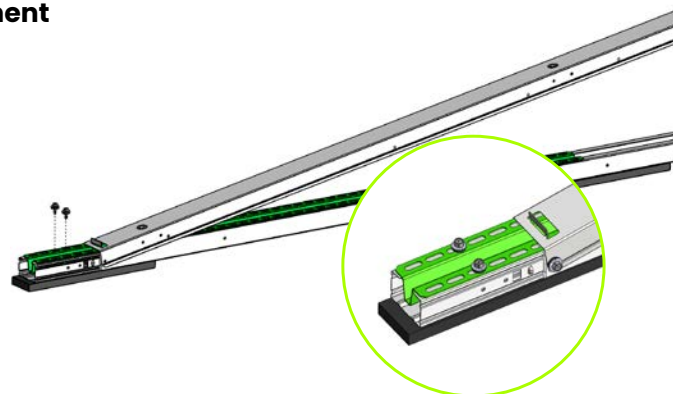
- Place the basic units on a flat and stable roof surface.
- Connect the basic units by sliding the tapered rail end into the rail of the previous basic unit until you hear a clicking sound.
- Secure assembly triangle 2 of the previous basic unit with 2 sheet metal screws (Ø6.5x 19mm).
- Every 30 metres a dilatation must be provided. See step 2.2.



step 1.4: (optional) installing C-rail end reinforcement

Install the C-rail end reinforcement by sliding it between the assembly triangle and the rail. Secure it with 2 sheet metal screws (Ø6.5x 19mm).

An indication of the locations can be calculated with our free online calculator. solarspeed.avasco.be.





step 2: aligning the rows

step 2.1: plotting the rows

required assembly tools:



Avasco Solar spacer



chalk line

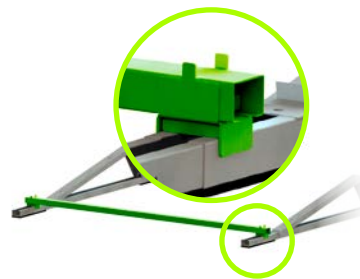
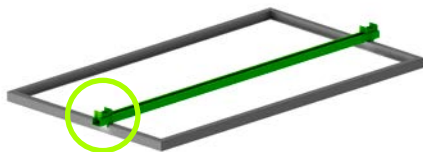
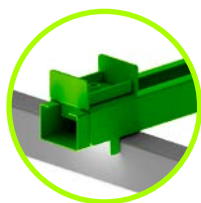
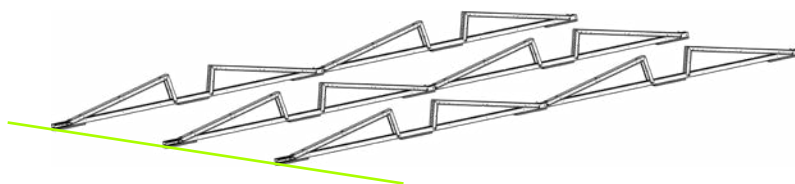


Tip!

Make a horizontal and vertical mark on the roof using a chalk line. When setting out the markers, respect the minimum edge zones (see general notes).



Align the rows according to plan, taking into account the length of the panels.
To easily determine the distance between the basic units, you can use the Avasco Solar spacer.



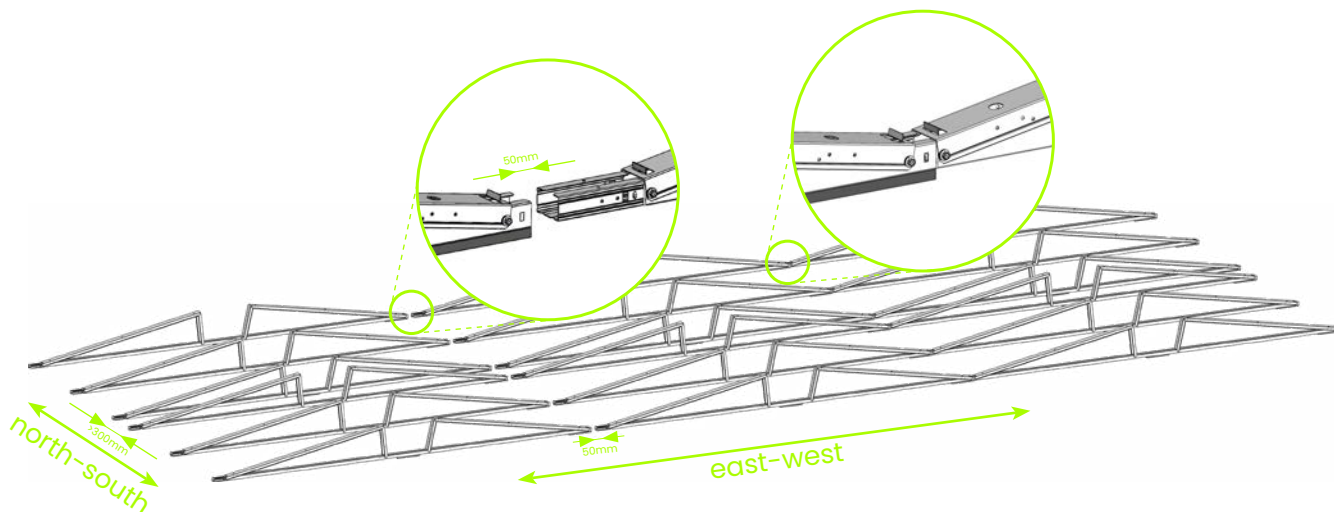
Set the length of the panel on the spacer.

Turn the spacer 180° and align the rows.

step 2.2: providing dilatations (thermal breaks)

In the north-south direction, also referred to as the ALU direction, a dilatation must be provided at least once every 26 metres. The distance between these 2 basic units must be at least 300mm to allow the use of ballast supports.

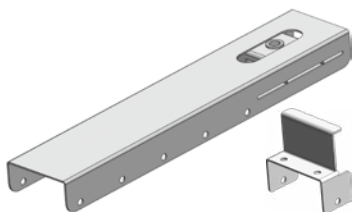
In the east-west direction, also referred to as the steel direction, a dilatation must be provided at least once every 30 metres.





step 3: Installing bracket and extension piece

required components:



bracket + extension piece for mid support

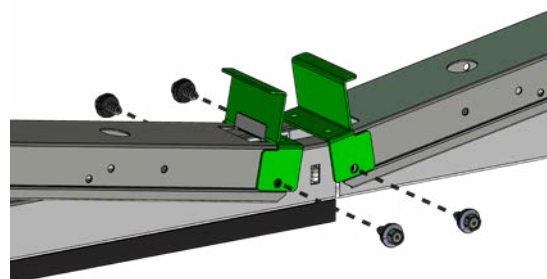


sheet metal screw (Ø6.5x19mm)

step 3.1: installing bracket

Install on every second assembly triangle a bracket. Secure it together with the assembly triangle on the rail with 2 sheet metal screws (Ø6.5x19mm).

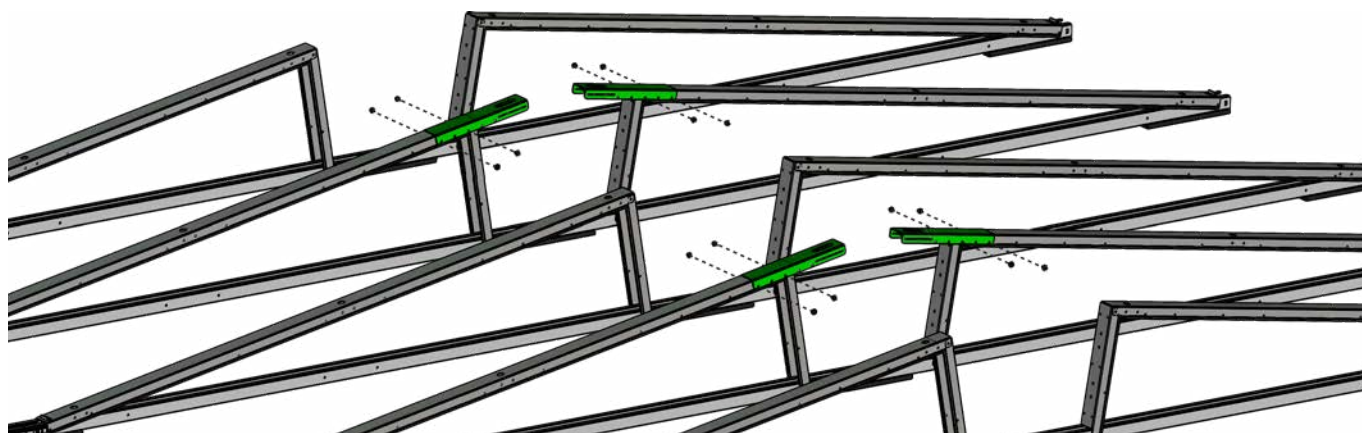
The bracket will serve as a mid support for the modules.



step 3.2: installing extension piece

Install on every second assembly triangle an extension piece. Secure it with 4 sheet metal screws (Ø6.5x19mm) in the provided holes in the assembly triangle.

The extension piece will serve as a mid support for the modules.





step 4: attaching footing system

An indication of the required footing systems and ballast, their locations and the method of footing and ballasting can be calculated with our free online calculator: solarspeed.avasco.be.

Several options are possible:

- Go to step 4.1 for rubbers
- Go to step 4.2 for PP footings
- Go to step 4.3 for concrete footings
- Go to step 4.4 for mounting on metal substructure

step 4.1 attaching end rubber at the end of the rail

required components:



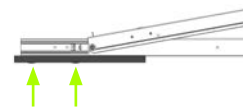
end rubber



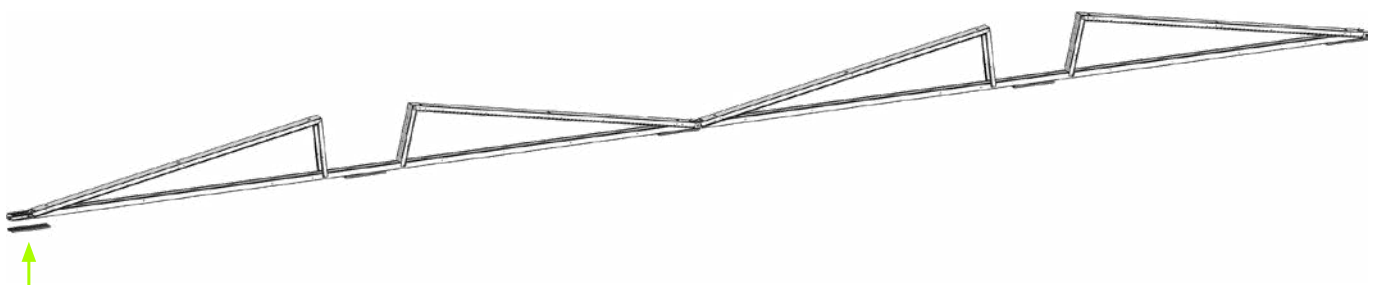
plastic plugs



Push 2 plugs into the holes of the rubbers



Attach the rubbers to the rail by pushing the plugs into the provided holes.



Go to step 4.



step 4.2: installing Avasco PP footing

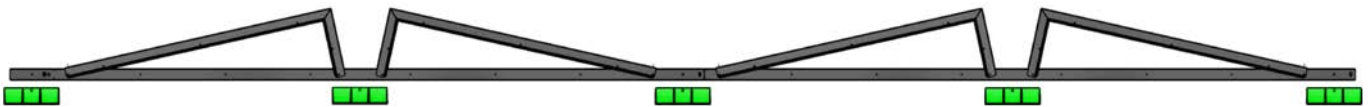
required components:



PP footing



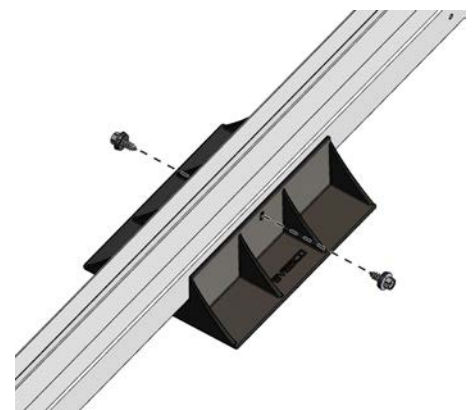
sheet metal screw (Ø6.5x19mm)



Avasco PP footings are placed under the full length of the connected basic units. This means that a footing is always placed at the beginning and end of the connected basic units, as well as centrally beneath the basic unit.

The PP footing can be attached to the basic unit by securing it with 2 sheet metal screws in the provided holes in the rail of the basic unit.

The PP footings are available with or without pre-installed rubbers.



Go to step 4.



step 4.3: installing Avasco concrete footing

required components:



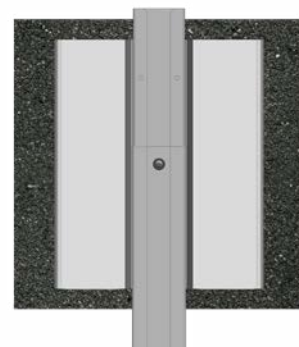
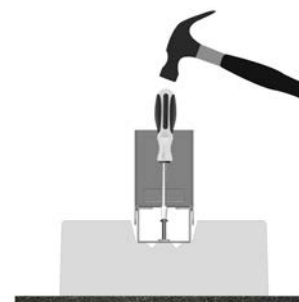
concrete footing + hammer plug



rubber protection

Concrete footings are placed under the full length of the connected basic units. A footing is placed at the beginning and the end of the connected basic units. A rubber is always placed under the concrete footings to protect the roof surface. At least 10mm of rubber must be visible on each side of the concrete footing.

In case of green or pebble roofs, remove the plants or pebbles at the places where the concrete footings need to be installed.



Caution! Depending on the required ballast, it may also be necessary to place an extra concrete footing in the center of the basic unit.

Once the concrete footings are correctly positioned, the connected basic units can be attached to them. This is done with hammer plugs HPS-1 R 8/10x40.

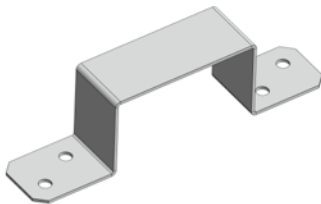
The hammer plug is inserted into the provided holes and hammered down. Use a screwdriver as an extension to prevent damage to the basic unit.

Go to step 4.



step 4.4: installing on metal substructure

required components:

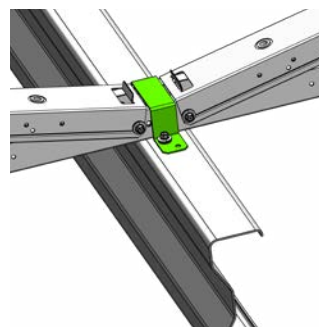
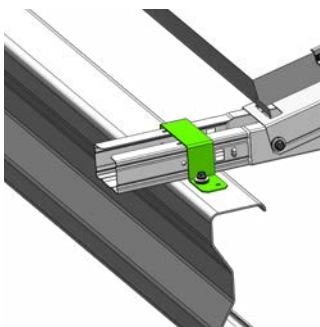
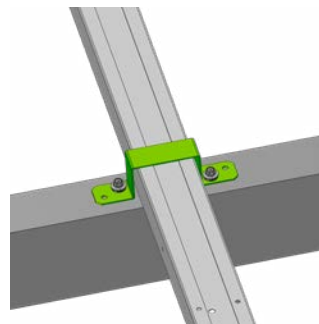
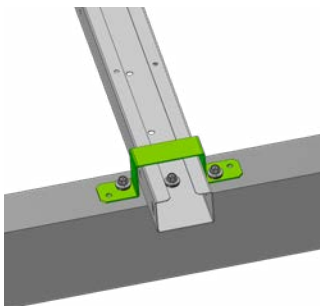


omega bracket



self-drilling screw
($\text{Ø}5.5 \times 25\text{mm}$)

SolarSpeed can be installed on metal substructure e.g. steeldeck, aluminium or steel profiles, ... This can be done with an omega bracket and 2, 3, 4 or 5 self drilling screws.



More detailed information can be found in the assembly instructions of the specific metal substructure.



step 5: placing the ballast

An indication of the required footing systems and ballast, their locations and the method of footing and ballasting can be calculated with our free online calculator: solarspeed.avasco.be.

step 5.1: providing ballast with ballast support

required components:



ballast support



ballast tile
(provided by installer)

On the inside of the installation, the ballast can be placed on ballast supports. These can simply be placed over the rails.





step 5.2: providing ballast with L-profiles

required components:



set of L-profiles



centre piece for set of L-profiles (optional)



ballast tile (provided by installer)



sheet metal screw (Ø6.5x19mm)

On the outer side of the installation ballast is always placed on sets of L-profiles.

The sets of L-profiles must be fixed with 4 sheet metal screws (Ø6.5x19mm) in the pre-drilled holes of the rails of the basic units (together with the optional C-rail end reinforcement).

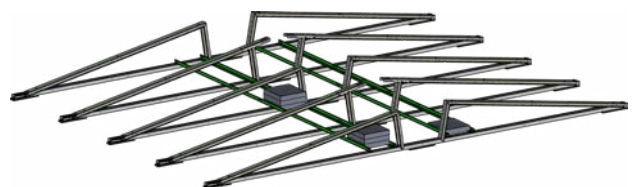
Each optional C-rail end reinforcement must always be fixed with 4 sheet metal screws (Ø6.5x19mm) together with the L-profiles.

The optional center piece must be placed in the center of the L-profiles set where it can be assembled with 2 sheet metal screws (Ø6.5x19mm) in the pre-drilled holes.

For a set-up on PP footings the center piece must also be placed on a PP footing.

For a set-up on concrete footings a higher center piece is provided.

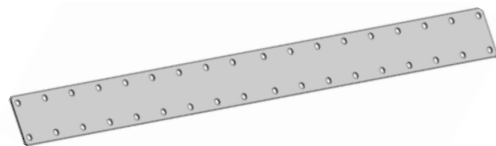
On the inner side of the installation sets of L-profiles are used when not enough ballast can be placed on ballast supports.





step 6: installing ridge connection

required components:



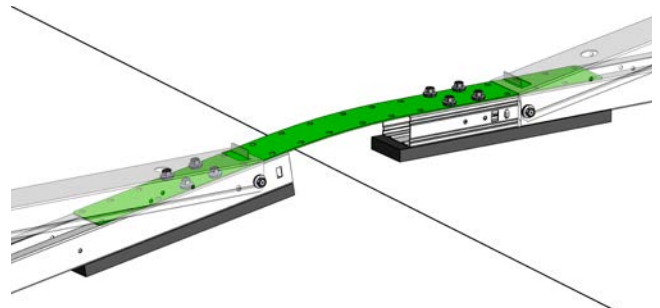
ridge connection



self-drilling screw
(Ø5.5x25mm)

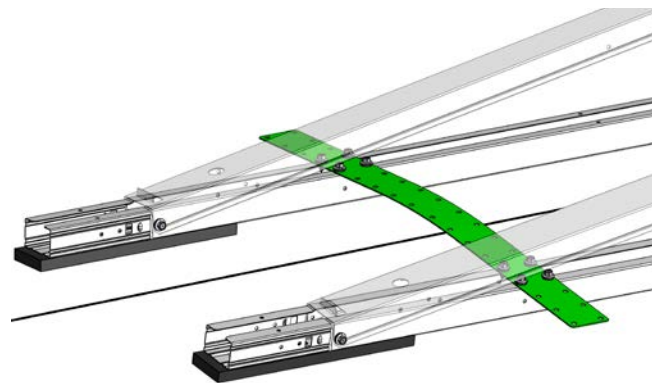
step 6.1: transverse ridge connections

In the transverse direction, one ridge connection is placed on every basic unit. These are attached on top of both rails. The ridge connection will bend to the appropriate slope when attached to the basic units. Use 4 self-drilling screws (Ø5.5x25mm) per rail.



step 6.2: longitudinal ridge connections

In the longitudinal direction, one ridge connection is placed on every basic unit. These are attached on top of both rails. The ridge connection will bend to the appropriate slope when attached to the basic units. Use 4 self-drilling screws (Ø5.5x25mm) per rail.

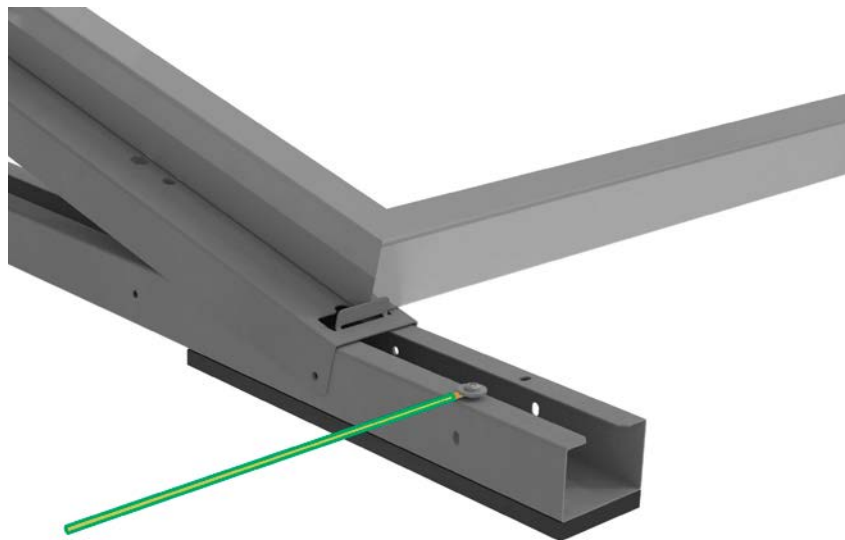




step 7: ensuring earthing and equipotential bonding

Since the rows are electrically and mechanically interconnected, no additional connections need to be made between the different basic units to provide proper earthing.

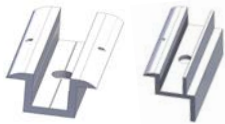
However, the individual fields must be connected to each other with an earthing wire. This connection can be made by clamping the insulation-free ends of the wire to the basic unit with a sheet metal screw.





step 8: installing the modules

required components:



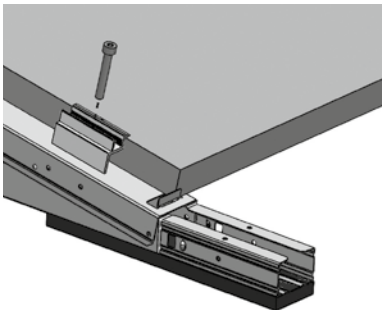
middle and end clamps



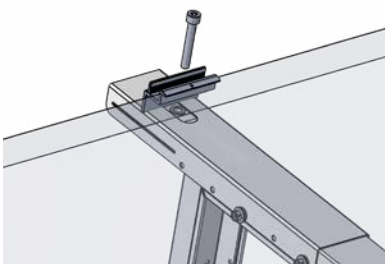
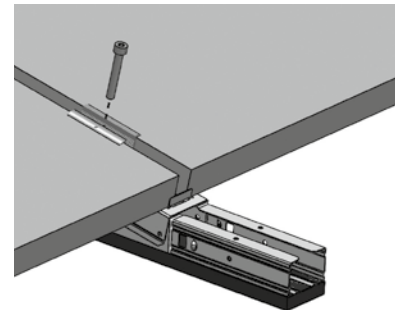
M8x55/55 bolt



solar panel
(provided by installer)



Fix the clamps into the screw thread provided in the assembly triangles with the M8 bolts. Screw the bolts hand tight. After the complete solar module array has been assembled, tighten the bolts with minimum 19Nm and maximum 25Nm. (see general notes)



Fix end clamps into the screw thread provided in the extension pieces with M8 bolts. Screw the bolts hand tight. After the complete solar module array has been assembled, tighten the bolts with minimum 19Nm and maximum 25Nm. (see general notes)



General notes

- The installer should always check whether the rubber protection is sufficient when installing on soft or semi-soft surfaces. The installer should also check the compatibility of the rubber protection with the roof surface.
- Only use the clamps approved and/or recommended by the module manufacturer. Always tighten the clamping bolt with the correct torque: Minimum 19Nm is required, maximum 25Nm is allowed.
A loss of torque is to be expected: At least 13Nm must be measured during inspection after installing.
- In the following situations/circumstances, the mounting frames of Avasco Solar are not suitable, unless written confirmation is provided for a specific project:
 - PVC or TPO roofs with pitches $> 3^\circ$
 - Bitumen or EPDM roofs with pitches $> 5^\circ$
 - Places where buildings or other objects can cause a wind tunnel effect or increased wind speeds.
 - Installations closer than 2 km as the crow flies from the coastline.
 - In an aggressive environment: All materials must be in stainless steel with the correct specifications to be determined on the basis of the aggressive substances.
 - In a saline environment: Execution in anodised aluminium or stainless steel.
- Polluted roof surfaces can lead to a lower friction coefficient over time, which means that more ballast or (extra) mechanical connections must be provided to prevent sliding.
- Edge zone: The installer must always keep the minimum edge zone free as described in the applicable standard(s). An example of such a standard is the NEN7250, but this is not exhaustive.
- Installers must always provide sufficient ballast depending on the situation. In case of doubt, please contact a specialised consultancy/engineering bureau.
- It is the installer's responsibility to check if the panels can be clamped in the manner (on the short or long side, position of the clamps, etc.) as provided in this manual. If this is not the case, Avasco Solar can in no way be held responsible for any damage, in whatever form.
- Avasco Solar nv can never be held liable if materials are used for assembly that are not supplied by Avasco Solar nv.
- The warranty conditions with regard to the assembly frames of Avasco Solar nv are available upon request. Failure to strictly follow the assembly instructions will void all warranty.
- The installer is responsible for the use of the necessary PPE.
- Avasco Solar nv reserves the right to change the assembly instructions at any time. It is the installer's responsibility to always follow the latest version, which is the only valid one. This is available at all times on the website www.avasco-solar.be or can be obtained upon request.



**avasco
solar**



100% belgian made

SolarSpeed is manufactured from A to Z at our production site in Ypres. As a result, we are always in control of the quality of our products, throughout the entire production process. This local production under our own management also ensures that we can respond to market demands in an extremely flexible way. The standards that are applied at all times are those of our quality management system, ISO 9001.



on-site delivery

We always have a large number of mounting frames in stock in our warehouse. This allows us to continue to guarantee short delivery times, even for your industrial projects. If desired, we can also deliver the materials directly to the site, both domestically and abroad.

Avasco Solar nv
Rodenbachstraat 53
8908 Vlamertinge - Belgium
T +32 (0)57 27 15 00
VAT BE 0721.474.320
info@avasco-solar.be
www.avasco-solar.be

**solar
mounting
frames**