

<i>Stalprodukt S.A.</i>	Kind of document : Assembly manual	Reference No: IM/MD-49/16
Title : ASSEMBLY MANUAL OF ROAD SAFETY BARRIER StalPro Rail hd according to EN 1317-5:2007+A2:2012	Page: 1	Issue No:III
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Documentation of the producer

According to EN 1317:5 standard point 5.2 Product description

Equipment and employees

The Contractor should produce evidence that he has the possibility to use special equipment to assemble and transport barriers, which is safe to use. The team performing road works should be under continuous supervision, executed by a properly qualified employee. The Contractor shall equip employees with means of individual protection. Vehicle marking and protection of the working place should be compliant with current legal regulations binding in the place where works are performed.

Materials

Materials should be compliant with requirements stated in Documentation of the Manufacturer.

Individual barrier elements are packed in bundles with size depending on the weight of elements and the size of the commission. Small barrier elements are delivered in containers or cases.

Each bundle or case shall have a tag including at least the following information:

- name and address of the producer,
- name of the product, together with the name and marking of the element,
- date of production,
- weight of the bundle, container or case,
- number of items in one delivery

Barrier elements should be stored in places and conditions, in which they shall not be exposed to mechanical defects or intensive corrosion.

Stages of assembly works

Assembly works include the following stages:

- 1) **Preparatory works and measurements** (indication of barrier road with verification of the course of underground installations, determination of posts location, indication of possible passage routes, crossings as well as final and initial barrier sections)
- 2) **Placing posts of the protective barriers system** – placing posts within the distance from the edge of the road stated in Project Documentation. During this stage of works it is essential to verify settlement, height and distance between posts. In case when placing posts of protective barriers system shall be executed by vibrating, due to cyclical blows of the pile-driver head on the head of the post, deformation and partial damage of the galvanized layer on the post is allowed. The scope of deformations and damages of the galvanized layer depends on the soil class and the degree of its concentration. This is a common phenomenon

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and therefore it does not signify the quality of works. In such cases the damaged galvanized layer is repaired with zinc paint. The deformed head of the post cannot be cut.

- 3) **Assembly of protective barriers system** – Assembly of protective barrier elements should be made according to Documentation of the Producer and Project Documentation. When assembling protective barriers system it is forbidden to make any holes or cuts violating the galvanized layer of particular elements. Assembly of protective road barriers includes:
 - a) assembly of distancing elements within the protective barriers system with the use of appropriate joining elements,
 - b) assembly of guides for distancing elements with the use of appropriate joining elements. During this stage of works adjoining segments of guides need to be connected according to the direction of vehicle movement, in a way, which in case of accident will enable the vehicle to slide along protective barriers system without touching edges of the guides,
 - c) assembly of initial and final segments of protective barriers system
 - d) regulation of joining element's tightening moment
 - e) checking the continuity of galvanized surface and repair of possible damages
 - f) fixing reflective elements on protective barriers system.
- 4) **Quality control of the works** should include:
 - a) verifying the compliance between the assembly of protective barriers system with Project Documentation and Documentation of the Producer, with consideration of possible size deviations,
 - b) test of galvanized layer thickness and its appearance
- 5) **Site arrangement**

Technical specification for road restraint system StalPro Rail hd on ground:

Steel quality: S235JR in accordance with EN 10025-2

Steel quality: S355J2 in accordance with EN 10025-2

Steel quality: S355MC in accordance with EN 10149-2

Hot-dip zinc coating:

- in accordance with EN ISO 1461
- continuous method according to EN 10346

Bolts:

Bolts in accordance with EN ISO 898-1

- M 16 x 25 according to drawing (appendix); property class 8.8. The usage of M16x27 is allowed.
- M 16 x 40 according to EN ISO 4017; property class 5.8
- M 16 x 40 according to drawing (appendix); property class 4.6

Nuts according to EN ISO 4032

Washers according to EN ISO 7091

Tightening torque of the bolts:

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- M 16 - T = 70 ± 10 [Nm]

The usage of Guardrail type A(W) and Guardrail type B is allowed on the base of the report number RSTA-20140806-A.

List of elements StalPro Rail hd

ID	Part name	Material	Theoretical mass [kg]
1	Guardrail type B or A(W)	S355MC	43.0/47.3
2	C120 road post L=1650[mm]	S355MC	19.5
3	C120 road post L=1200[mm]	S355MC	14.2
4	Single outrigger STP	S355J2	4.0
5	Frontal Single Joining Piece	S235JR	10.0
6	Washer M16	S235JR	0.16

Sequence of assembly in accordance with attached drawings:

StalPro Rail hd - Assembly drawing safety barrier StalPro Rail hd
 StalPro Rail hd - Single side safety barrier StalPro Rail hd (Single section)
 StalPro Rail hd - Terminal for system StalPro Rail hd
 StalPro Rail hd - Single side safety barrier StalPro Rail hd
 StalPro Rail hd - Assembly of bolt M16x40 (Outrigger-Post) for system StalPro Rail hd
 StalPro Rail hd - Assembly of bolt M16x25 for system StalPro Rail hd
 StalPro Rail hd - Assembly of bolt M16x40 (Outrigger-Guardrail) for system StalPro Rail hd
 Bolt M16xL

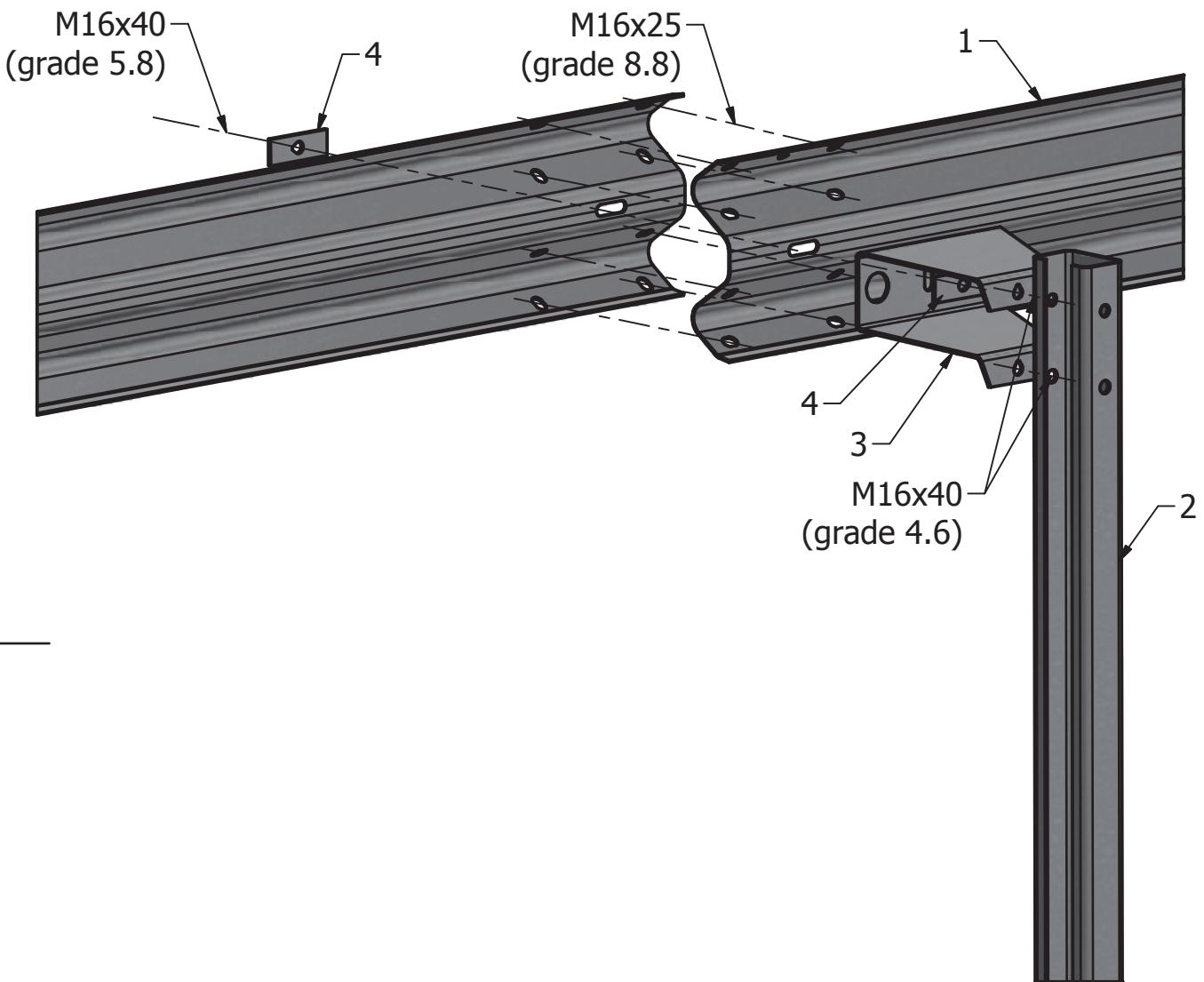
The tolerance for height of the top of the system is ±20mm
 The minimum length of system is 60 m (without terminals).

A

B

C

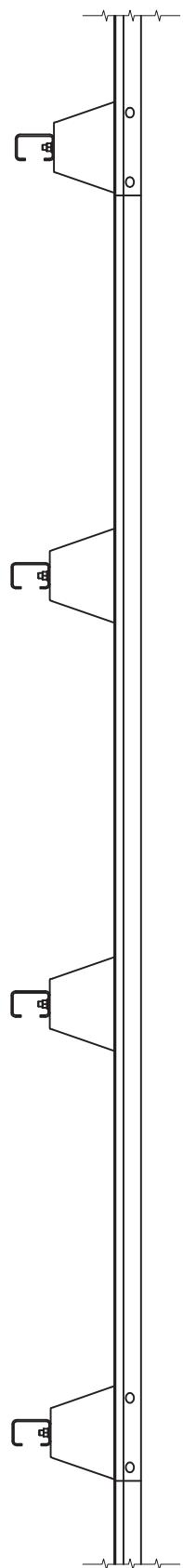
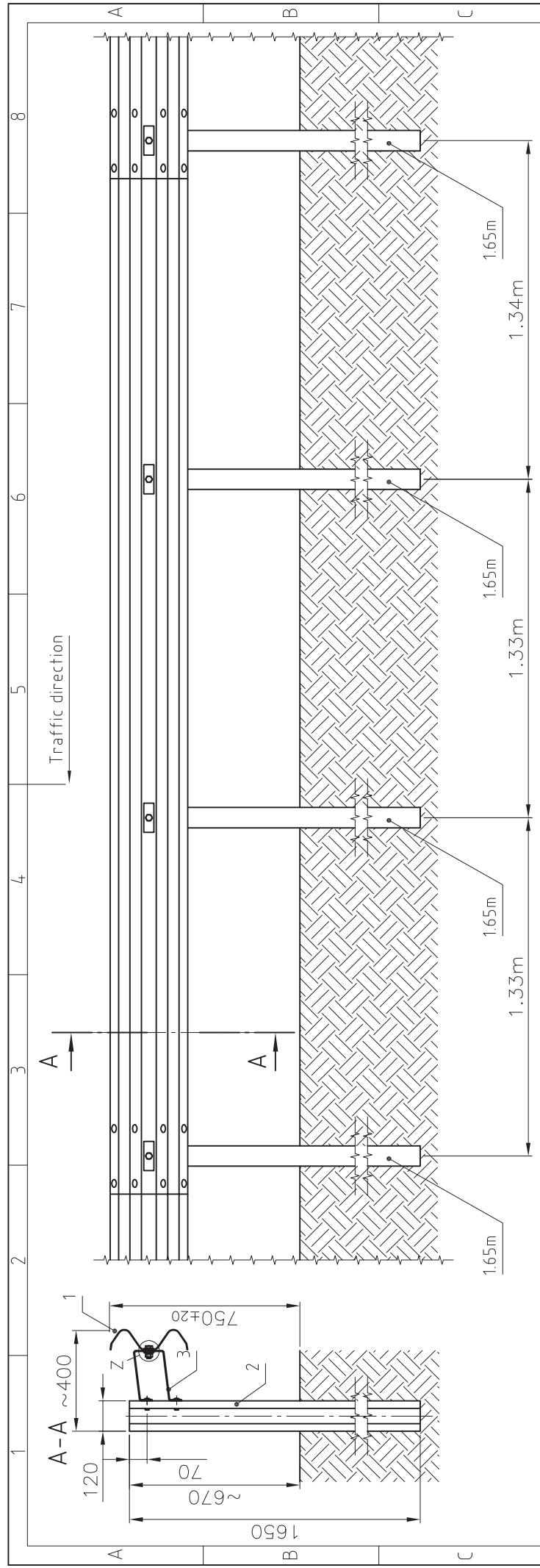
D



List of elements:

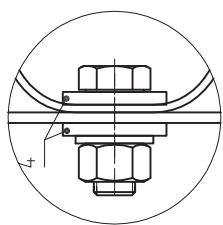
1. Guardrail type A(W)
2. C120 road post
3. Single outrigger STP
4. Washer M16

Drawing name Assembly drawing safety barrier StalPro Rail hd		Mass -	INVENTOR	Change drawing No
	Archive index	Number of drawing StalPro Rail hd		Substituted by
		Sheet No 1	Amount 1	
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List of elements:

1. Guardrail type A(W)
2. C120 road post
3. Single outrigger STP
4. Washer M16



Drawing name		Mass	AutoCAD	Change drawing No
Archive index	Single side safety barrier StalPro Rail hd (Single section)	Number of drawing	StalPro Rail hd	Substituted by

1

2

3

4

5

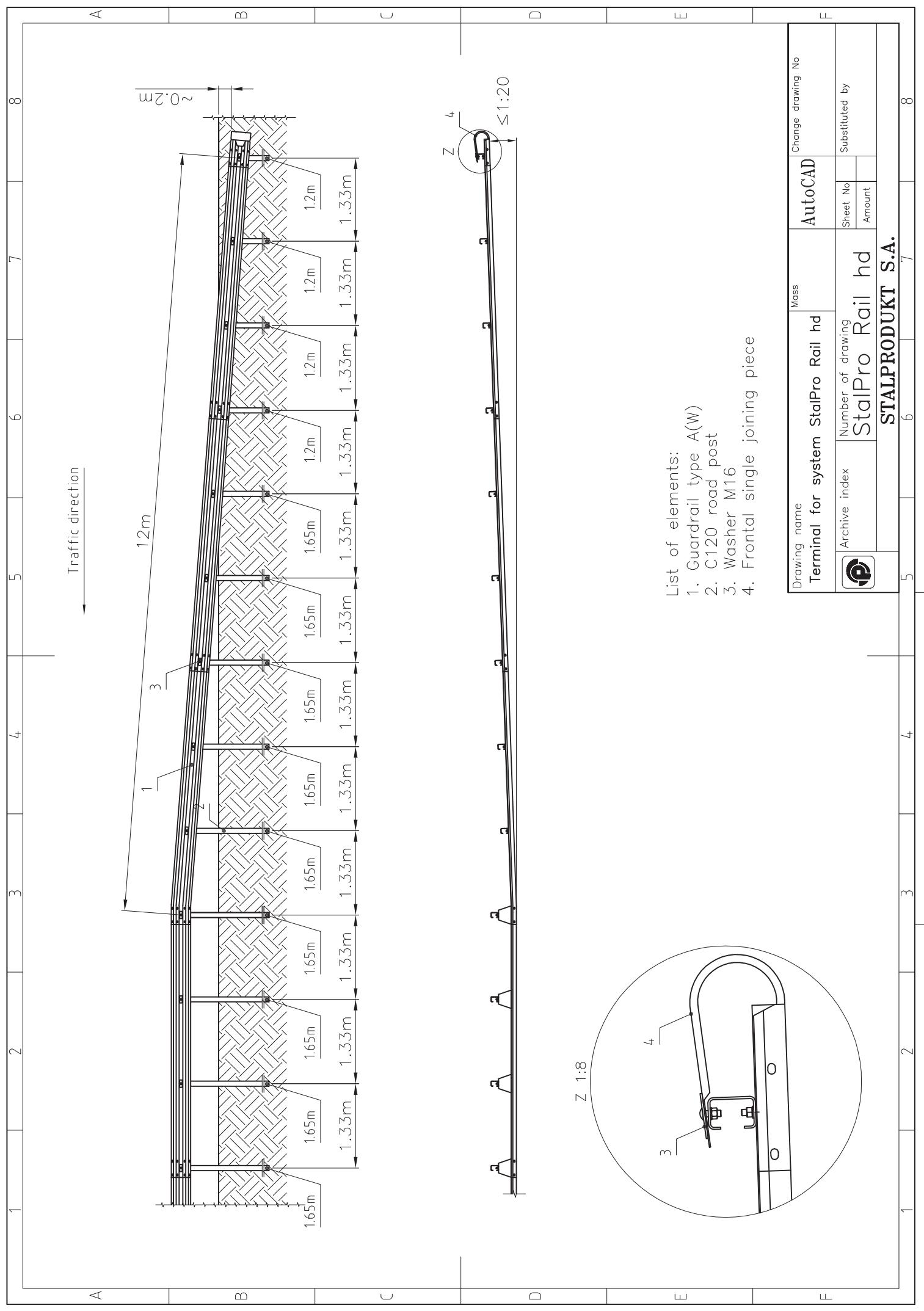
6

7

8

E

F

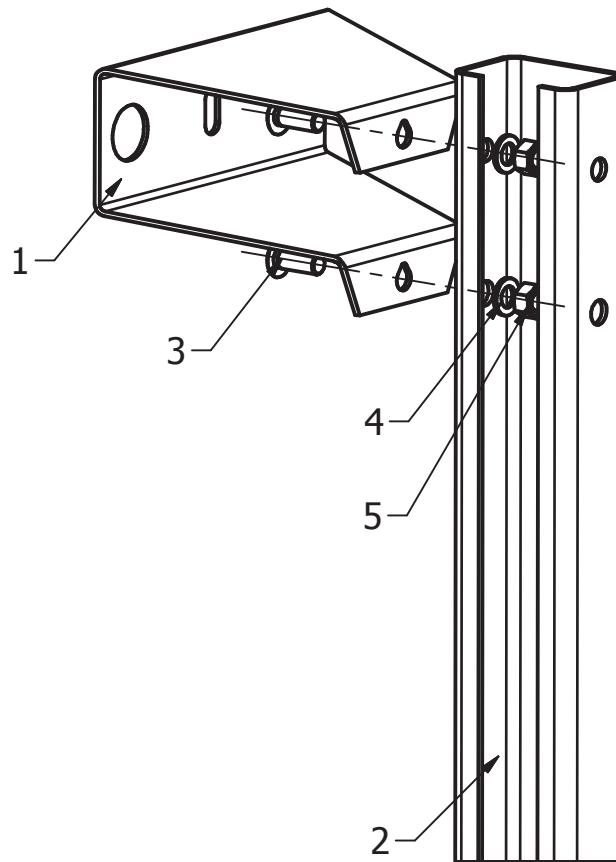


A

B

C

D



List of elements:

1. Single outrigger STP
2. C120 road post
3. Bolt M16x40 (grade 4.6)
4. Round washer
5. Nut M16

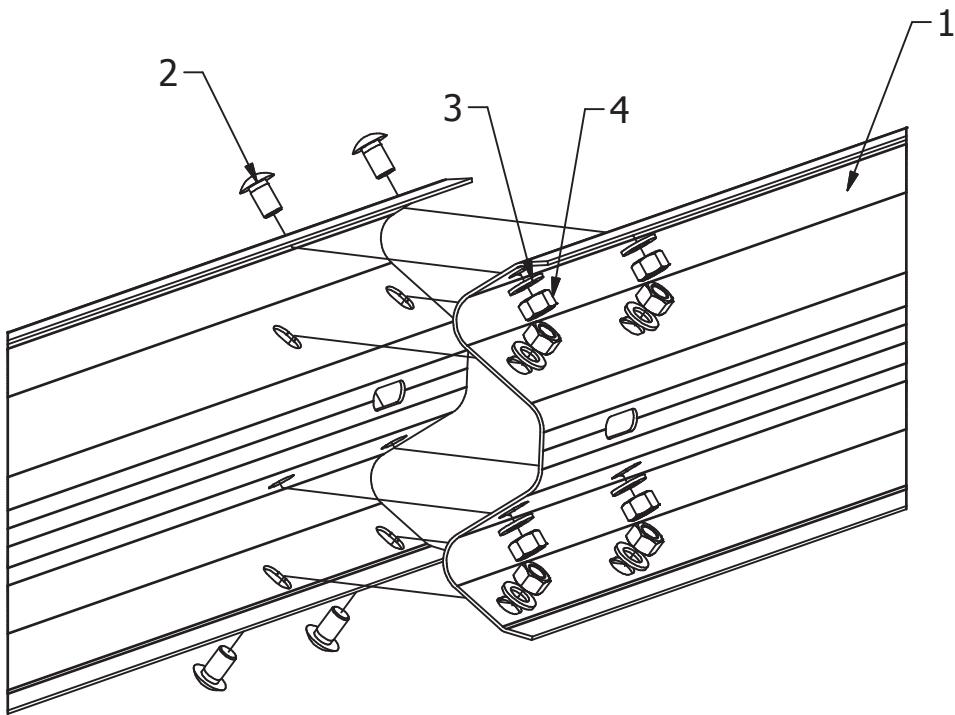
Drawing name Assembly of bolt M16x40 (Outrigger-Post) for system StalPro Rail hd		Mass -	INVENTOR	Change drawing No
	Archive index	Number of drawing StalPro Rail hd		Sheet No 1 Amount 1
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A

B

C

D



List of elements:

1. Guardrail type A(W)
2. Bolt M16x25 (grade 8.8)
3. Round Washer M16
4. Nut M16

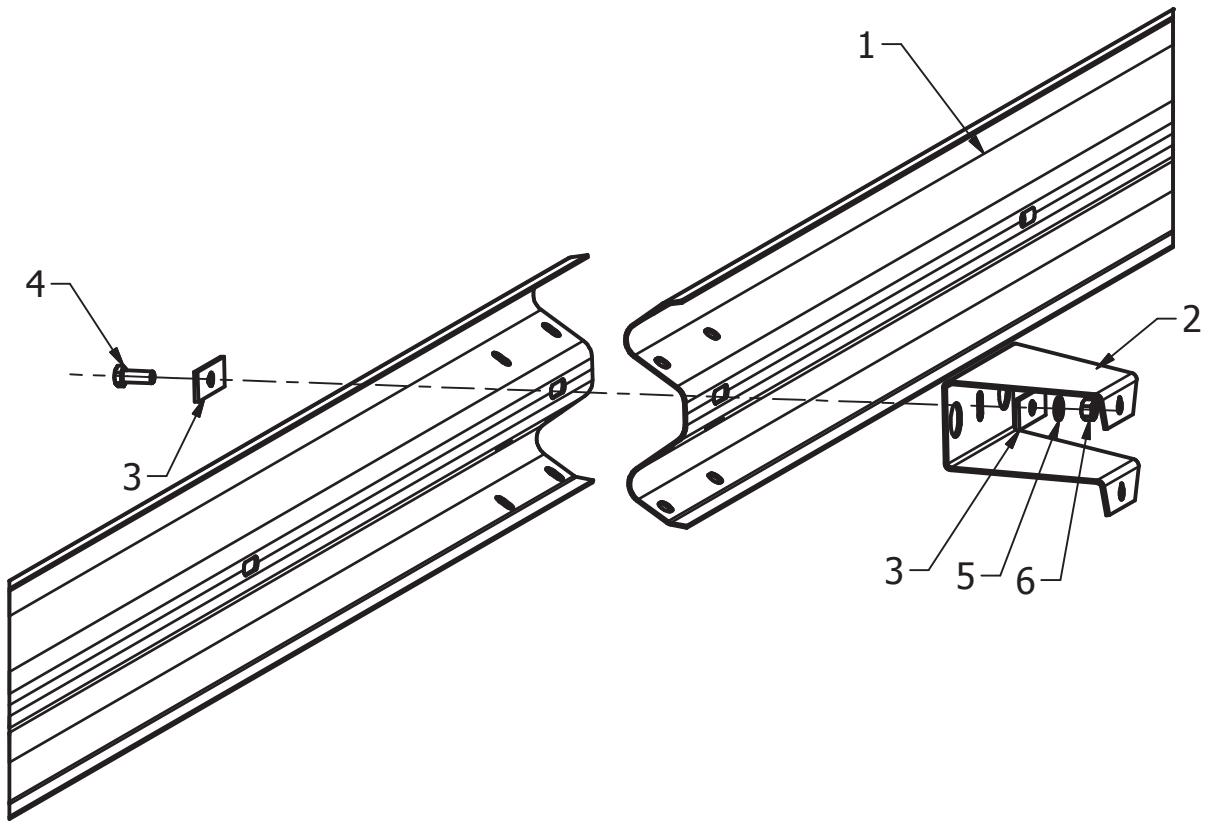
Drawing name Assembly of bolt M16x25 for system StalPro Rail hd		Mass -	INVENTOR	Change drawing No
	Archive index	Number of drawing StalPro Rail hd	Sheet No 1 Amount 1	Substituted by
STALPRODUKT S.A. - BOCHNIA				

A

B

C

D

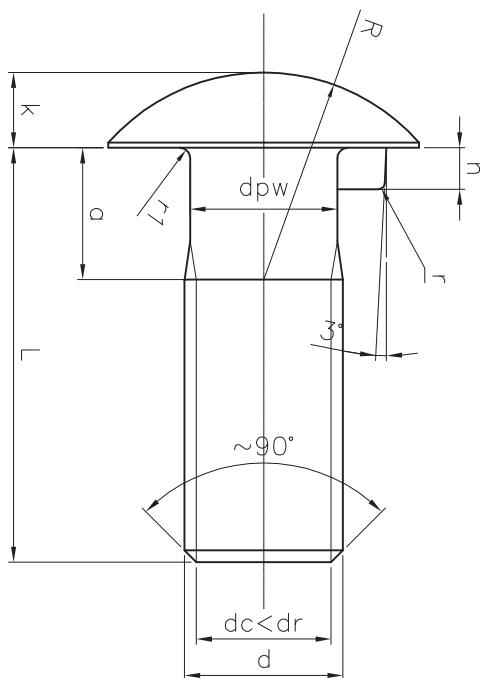
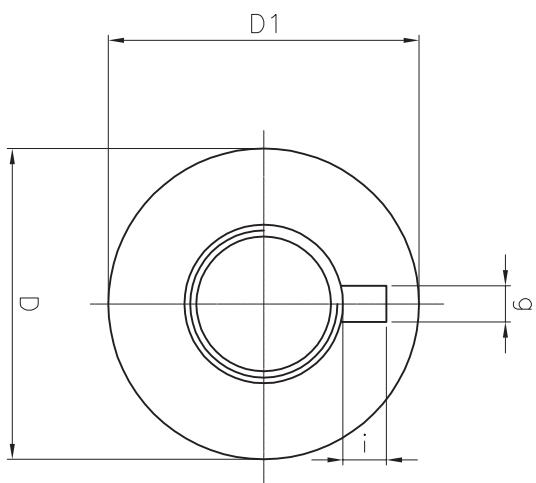


List of elements:

1. Guardrail type A(W)
2. Single outrigger STP
3. Washer M16
4. Bolt M16x40 (grade 5.8)
5. Round washer
6. Nut M16

Drawing name Assembly of bolt M16x40 (Outrigger-Guardrail) for system StalPro Rail hd		Mass -	INVENTOR	Change drawing No
	Archive index	Number of drawing StalPro Rail hd		Sheet No 1 Amount 1
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BOLT M16 x L



Dimension		Thread	M16
L			25,27 or 40
d	min		15.235
	max		15.685
d_p	min		14.02
	max		14.22
d_r	min		12.904
	max		13.231
d_{pw}	min		14.13
	max		14.20
r	min		1
	max		29.35
D	min		30.65
	max		30.90
D_1	min		29.0
	max		29.55
k	min		7.55
	max		8.45
R	~		20.0
g	min		3.25
	max		3.8
n	min		4.0
	max		4.2
i	min		4.2
	~		0.6
a	min		—
	max		—
d_c	min		13.0
	max		—

Drawing name
Bolt M16xL

Mass
AutoCAD
Change drawing No

Archive index
Number of drawing
M16xL

Sheet No
Amount

F

Substituted by

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1 2 3 4

5 6 7 8