

# Coffman<sup>®</sup>

## FORGED INSTALLATION INSTRUCTIONS

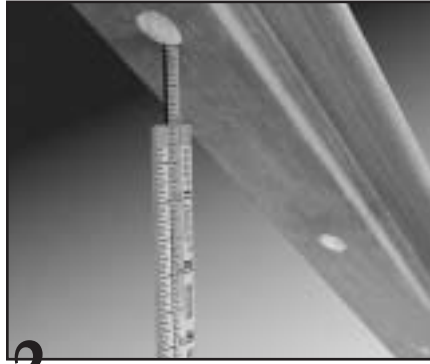


*THE PROFESSIONAL'S  
CHOICE for installations  
that are attractive,  
simple to install, and  
permanently secure.*

## Forged Installation Option 1. *Requires slower drying epoxies.*



**1.** Begin the installation by **TEMPORARILY** attaching the handrail throughout the stair and marking the treads and underside of the rail for baluster placement. At each baluster location drill the appropriate diameter hole  $3/4''$  deep into the treads and a  $1/2''$  diameter hole approximately  $1''$  deep in the underside of the rail.  
*NOTE:* The tops of Medallion and Belly Baluster are square and will require a  $11/16''$  diameter hole in the rail.



**2.** With all baluster holes drilled and the rail temporarily set back in place, use a carpenter's rule to measure the exact distance from the tread to the lower side of the drilled  $1/2''$  diameter hole in the rail.



**3.** After adding  $5/8''$  for insertion into the rail and  $3/4''$  for insertion into the tread (a total of  $1-3/8''$ ), use a chop saw equipped with a standard  $1/8''$  flexible cut-off blade to trim the baluster to the exact length.



**4.** When all balusters are trimmed, remove the rail from the newels and deposit epoxy adhesive into each baluster hole in both the treads and the rail.



**5.** With the base collar in place on the bottom of the baluster, set each baluster into the tread hole.



**6.** Working one baluster in at a time, replace the rail system on top of the balusters and install the rail permanently to the newels.



**7.** Use a combination square to straighten each baluster.



**8.** Finish the installation by using epoxy to fill any void around the base of the baluster and to secure the Base Collar.

*The installation of Coffman's forged balusters is very similar to the time-honored techniques of "standard" hardwood stair systems.*

*Always check and understand local building codes before beginning any installation.*

## Forged Installation Option 2. Use with any epoxy.



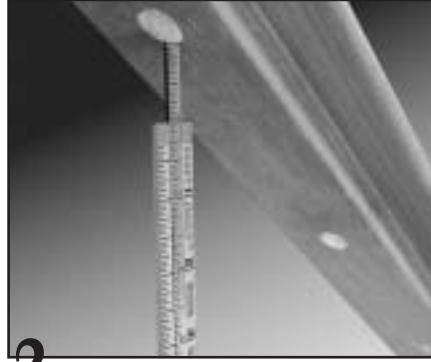
**1.** Begin the installation by **PERMANENTLY** attaching the handrail throughout the stair and marking the treads and the underside of the rail for baluster placement. At each baluster location drill the appropriate diameter hole  $3/8''$  deep into the treads and a  $1/2''$  diameter hole approximately  $1''$  deep in the underside of the rail.  
*NOTE:* The tops of Medallion and Belly Baluster are square and will require a  $11/16''$  diameter hole in the rail.



**4.** Working one baluster at a time, deposit epoxy adhesive for a single baluster into both the tread and baluster hole.



**7.** Finish installation by using epoxy to fill any void around the base of the baluster and to secure the base collar.



**2.** With all baluster holes drilled and the rail permanently installed, use a carpenter's rule to measure the exact distance from the tread to the lower side of the drilled  $1/2''$  diameter hole in the rail.



**5.** With the base collar placed on the bottom of the baluster, work the baluster into place by inserting the top of the baluster into the rail hole and sliding the bottom of the baluster over and down into the tread hole.



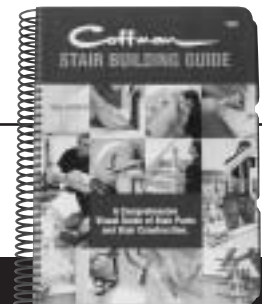
**3.** After adding  $1/2''$  for insertion into the rail and  $3/8''$  for insertion into the tread (a total of  $7/8''$ ), use a chop saw equipped with a standard  $1/8''$  flexible cut-off blade to trim the baluster to the exact length.



**6.** Use a combination square to straighten each baluster.



The Coffman Program is a SYSTEM that combines one of the broadest selections in the industry with epoxy adhesives, application tools, and finish accessories.



For more complete stair information, refer to Coffman's C-165 "Stair Building Guide", available at any Coffman dealer.

# Specialty Instructions and Accessories

## MEDALLION BALUSTERS



C-2932 Arch Medallion Balusters are shipped with installation brackets and hardware included. After installing the baluster into the treads, attach to rail by predrilling and screwing the brackets into place.



Medallions consist of two halves that screw together. Apply epoxy adhesive on the screw and contact points....



...and screw together for permanent installation.

## ADJUSTABLE COLLARS



The Adjustable Collar, when used with the C-2555 straight forged baluster, can be used to design a distinctive pattern within any forged system. Place the required number of adjustable collars on each C-2555 straight baluster before installing. After the balusters are installed, use an allen wrench to tighten the collar's set screw, permanently attaching the collar at the desired location.



## RAKE COLLARS



Rake Collars (*angled collars*) replace the base collar on knee wall stairs. Place a collar onto the bottom of all balusters before installing. With the collar resting firmly on the knee wall, permanently attach the rake collars by tightening the provided set screw.



If desired, Rake Collars can also be used underneath the handrail.

## C-2919 ROUND COLLARS



The C-2919 Round Collar is a versatile base collar that can be used with both 1/2" and 5/8" Forged Balusters. The plastic insert holds the collar out of the way during epoxy installation.



The round base makes for a quick and perfect alignment of the collar.

## FLARED COLLARS



The C-2910 Flared Collar with Screws is an installation system where the drilling of treads is not required. Trim the baluster flush to the top of the tread....



...and secure the base collar by predrilling and screwing into place.

## C-2360 FORGED NEWELS



The C-2360 Forged Newel Attaching System is shipped complete with the base collar, shaft, and all necessary screws needed for installation.



2. Place the shaft into the hole and permanently attach with provided 3" anchoring screws.



1. Begin installation by drilling or cutting a hole in the proper location. With the base collar placed on the newel, attach the shaft to the precut newel with the provided allen wrench and screws.



3. Finish the installation by using epoxy to secure the base collar.