



ASSEMBLY Manual

Kitset/Flatpack

Thank you for choosing our products, we appreciate your business and look forward to serving you again.

High Quality Ltd



SAFETY WARNING

For your safety and to avoid any injury please ensure you have safety gear on during assembly / installation, such as: Protective glasses, gloves, earmuffs, etc.

Tools required:

Electric drill, electric screwdriver, welder (Bottom runner), waterproof sealant, rivet gun, self- expansion foam, level, tape measure, clamps, ladder, skill saw, grinder and craft knife.

At least a second person (helper) is needed to ensure easier completion of assembly/installation.

Time allocation:

At least two days are required to complete assembly/installation, additional days may be required depending on DIY skill level/experience.

Construction site:

Allow at least 1m wide of clearance surround the construction site, ensuring ground is level and no risk of flooding.

If steel base/chassis is placed directly on dirt/grass, ensure there is no risk of subsidence in the soil surface during the rainy season. Concrete paving is recommended to be placed under the steel base/chassis to enable ventilation, increase the ground contact area and extend the life of the steel base/chassis.

Assembly guide contents/disclosure:

The contents of this manual aim to compile all the information necessary to complete the assembly/installation of the kitset/flatpack purchased. It does not cover the basic use of power tools or any 'how to' DIY skills/tips.

Instructions and images shown in this manual are generic and may not be a representation of the kitset/flatpack purchased. Due to multiple add-ons/options available to kitset/flatpack users, the user of this manual should skip/ignore any step not relevant to their kit. In some cases, it is not necessary to follow the steps in order, where the user sees more fit due to different circumstances and situations, moving steps around as required may still result in a correctly completed finished pod.

Kitset/Flatpack content:

Different kit sizing and options will mean that not all contents are the same for all kits. In general, a complete standard kit should have the following:

- Steel chassis(One piece welded or combined chassis)
- Plywood Flooring
- Steel bars (multi fold) for attached with steel base *(75mm wide)*
- Steel bars (double fold) for attached with multi fold steel bar on the door enter location*(75mm wide)*
- Aluminum corner piles
- Steel angle bars *(bracing between pillars and on the wall panels– 60mmwide)*
- Aluminium interior angle trims
- Joinery frames and trims with optional partition wall *(U channel attachments)*
- Windows Or Sliding doors or PA doors
- Wall & roof panels
- Roof flashing
- Screws
*115mm & 75mm for roof, 36mm countersunk for ply to steel base, 18mm high strength for window frames.
(75mm roof screws are also used on bracing steel bars – if corner steel post option is chosen)*
- Rivets
White on aluminium pillars, silver on steel and wall panels, black on grey colour roof or flashings etc.
- Slide door locks or single door lock

NOTE: Expanding foam or weatherproof sealant/silicone is not part of material supplied with the kitset/flatpack

TABLE OF CONTENTS

Base Preparation.....	4
Step 1 – Combined Chassis Base Preparation.....	4-16
Step 2 – Screw down the Plywood.....	17-18
Walls & Joinery installation.....	19
Step 4 – Wall panels.....	19-21
Step 5 – Joinery installation.....	21-22
Bracings.....	23
Step 6 – Top bracings.....	23
Roofing.....	24
Step 7 – Roof panels.....	24-26
Step 8 – Roof flashings.....	27-28
Step 9 – Roof edge finishing.....	29
Finishing.....	30
Step 10 – Expanding foam.....	30
Step 11 – Interior aluminum angle bars.....	31
Step 12 – Weatherproof sealant / silicone.....	32
Step 13 – Inserting windows & slidedoors.....	33
Step 14 – Slidedoor lock.....	33-34
PA door assembly guide.....	35-39

Assembly / installation instructions



Prepare the tools and parts that you need to join the chassis



The accessories you can find in the package.(Sample Only)

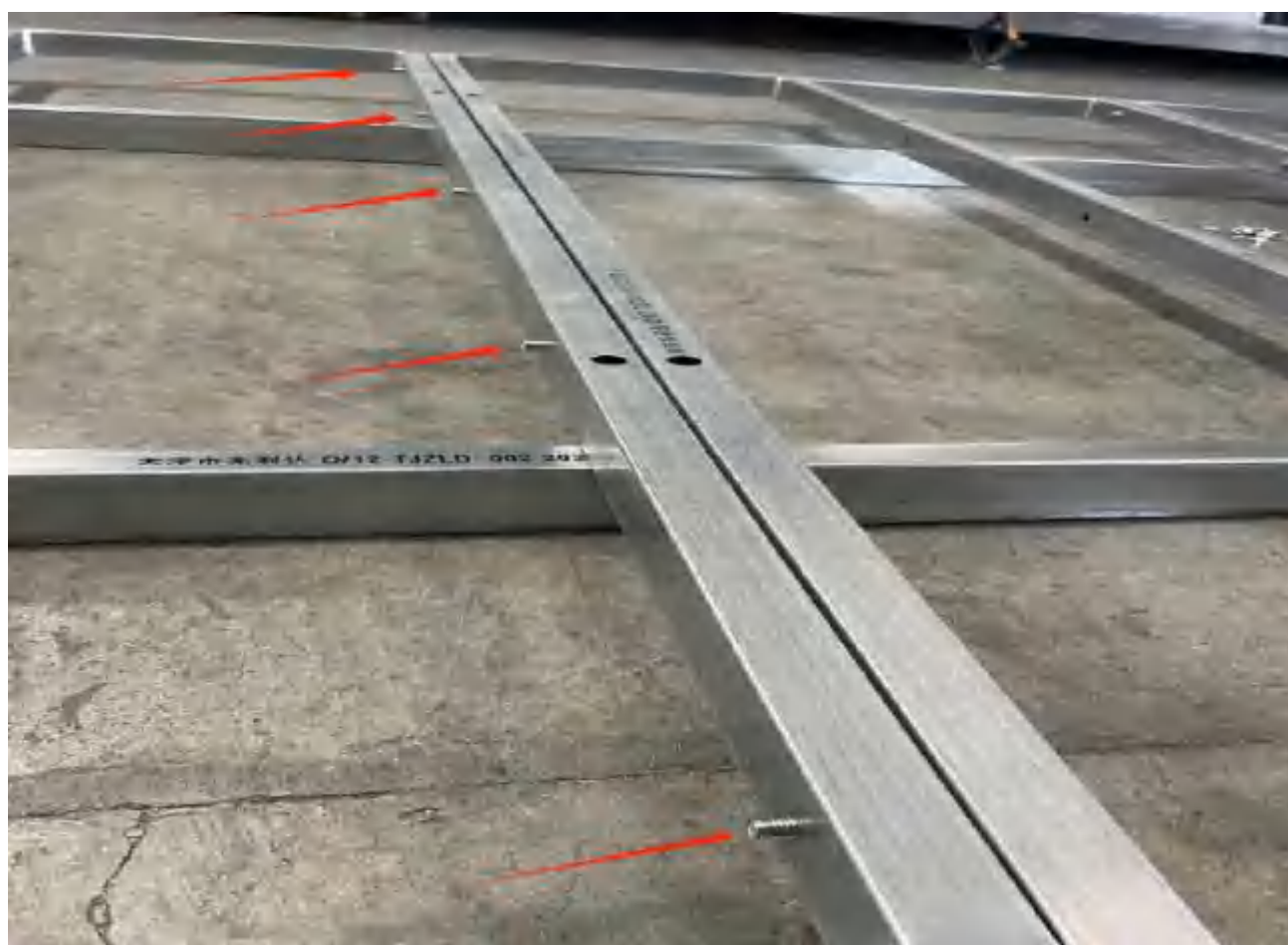


Place the long bottom beams on the leveled ground (the beams may need to be Joined or welded together if more than 6.25m)



Use the provided bolts to join the Sub floor frame (Sample Only)







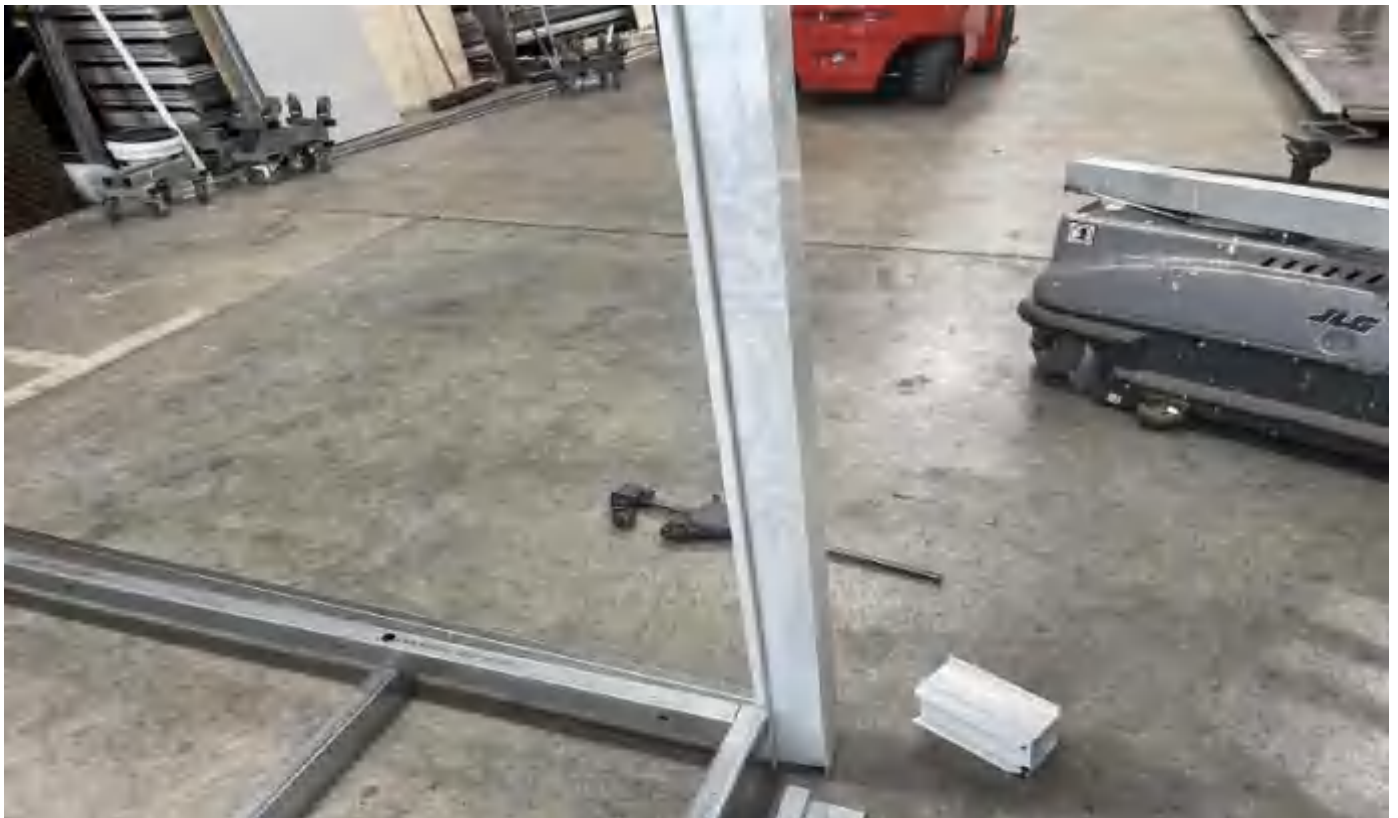
Make sure the flat and spring washers on the correct order.

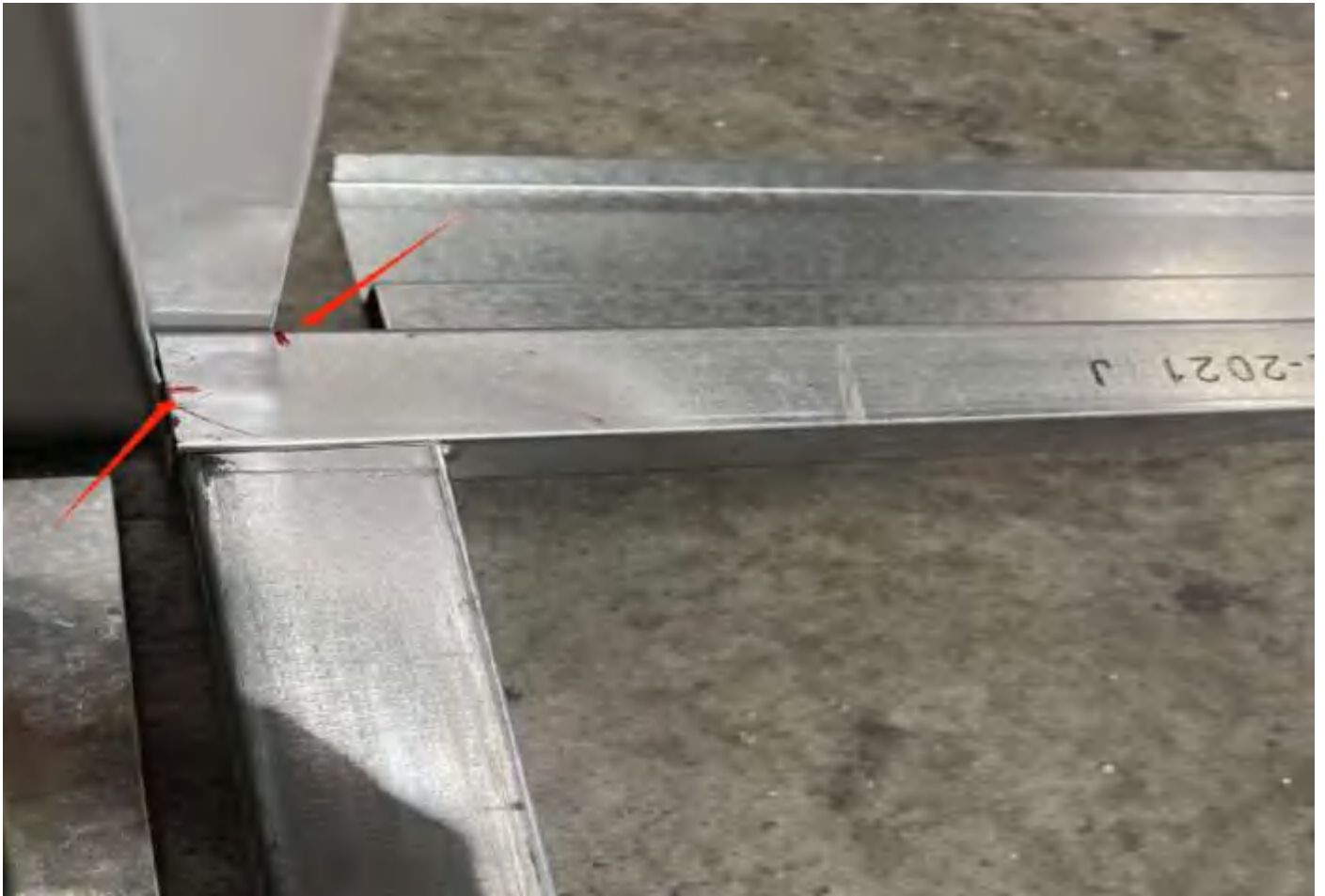


Secure the hex screws to the attach top chassis to the long beams



Put the U channel around the chassis.





Use the aluminium piles to mark out the starting point of the U channel.



Keep at least 2mm spaces between the U channel and the marks(trim off the over lap).

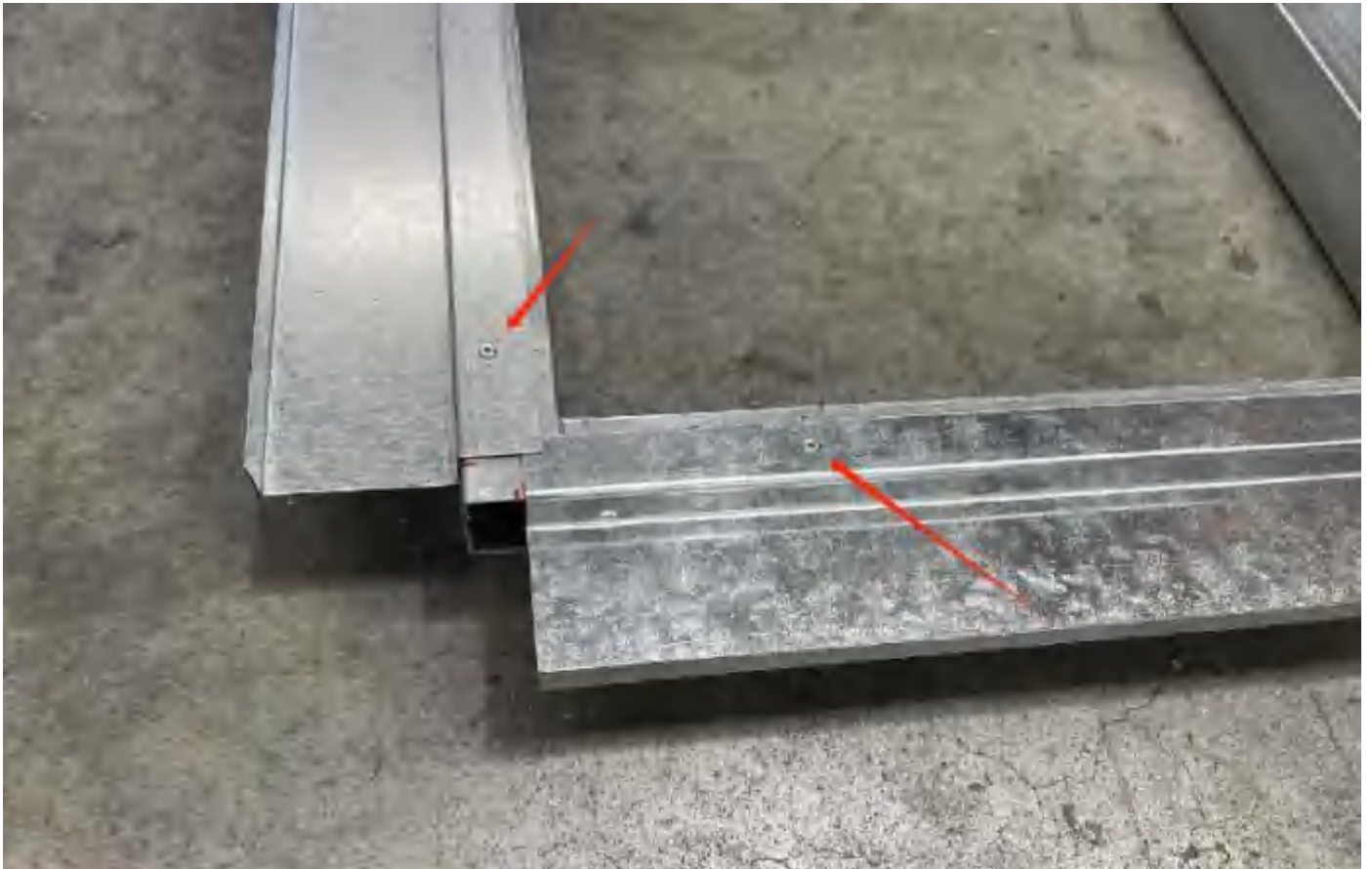


Use the clamps to secure the U channel to the chassis.



Drill 2-3 holes on each U channel.





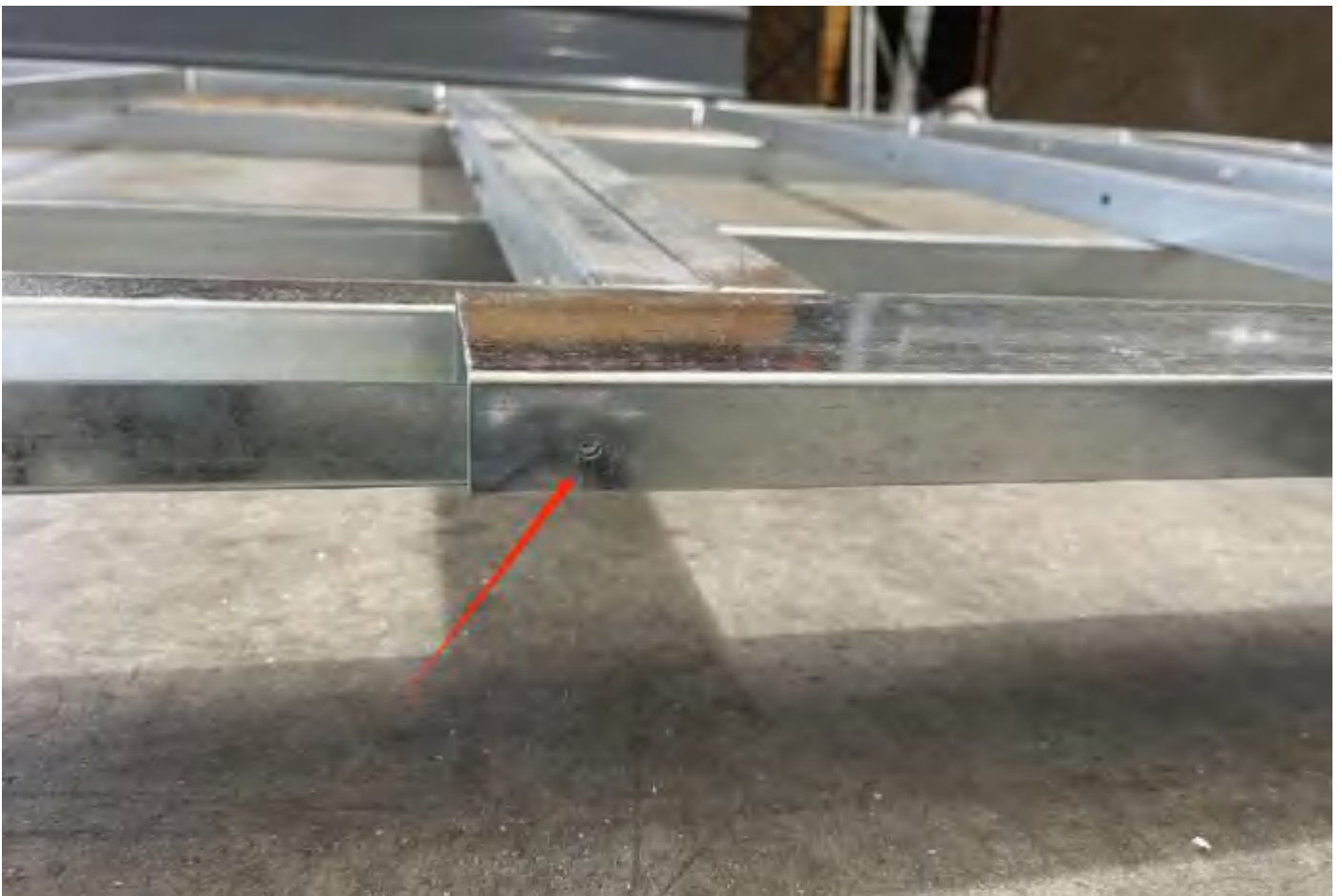
Use the rivets to fix the U channel to the chassis.



Locate the bottom door support/step on the correct position.

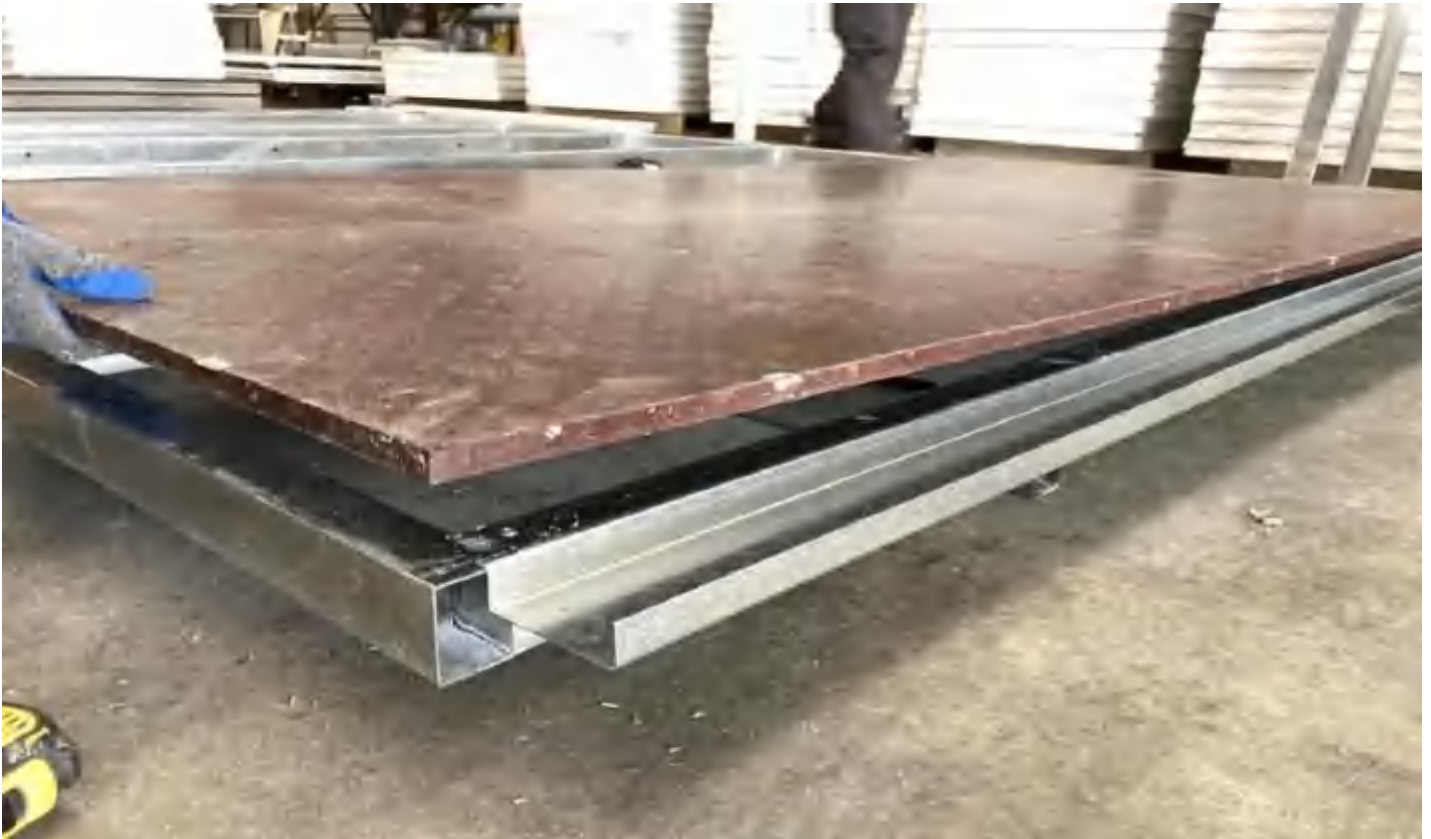


Make sure the support piece is level.





Using four rivets to secure the bottom piece to the U channel.



Place plywood on the prepared base.



Using self-drilling/countsunk head screws supplied to attach plywood to steel frame.



Plywood placement

- Ensure steel base is placed as flat as possible.
- Attach plywood to steel frame using self-drilling/countersunk head screws supplied.

WALLS & JOINERY INSTALLATION

Begin wall installation from the back corner, working your way to the front. As each side is completed, ensure that it is square (by confirming the bottom length of the wall is the same as the top length). Wall panels overlap at the tongue of one panel and are riveted together at the tongue at approx. 300mm-400mm intervals.

Riveting aluminium pillar to base

- **If the white aluminium corner pillars option is chosen**, position the pillar in the corner, rivet bottom over steel base and begin inserting wall panels as shown in Fig. 11.
- **If the steel corner posts option is chosen**, begin inserting the wall panels.



Clamping corners



Clamping wall panels

- Whether steel or aluminium corner option is used, clamping wall panel edge to corner and between panels, helps in aligning the walls to ensure walls are square before riveting, as shown in Fig. 12 & Fig. 13.

Note: When reaching a wall panel that joins to a window or slide door, pre-assembly of the window frame/trim and inserting into the wall panel is required before moving to the next wall panel.

STEP 5 – JOINERY INSTALLATION

Slide door and window frames will require assembly before being inserted into the wall panels.

Note: Slide doors & windows have 4 pieces constituting the frame, however the windows have 4 mitre-cut trims (U-channel attachments) to the frame while the slide door has only 3 mitre-cut trims (U-channel attachments).



Window frames (side and bottom)

- Locate the side and bottom plate of the frames, mark, silicone and screw using screws supplied as shown in the picture.



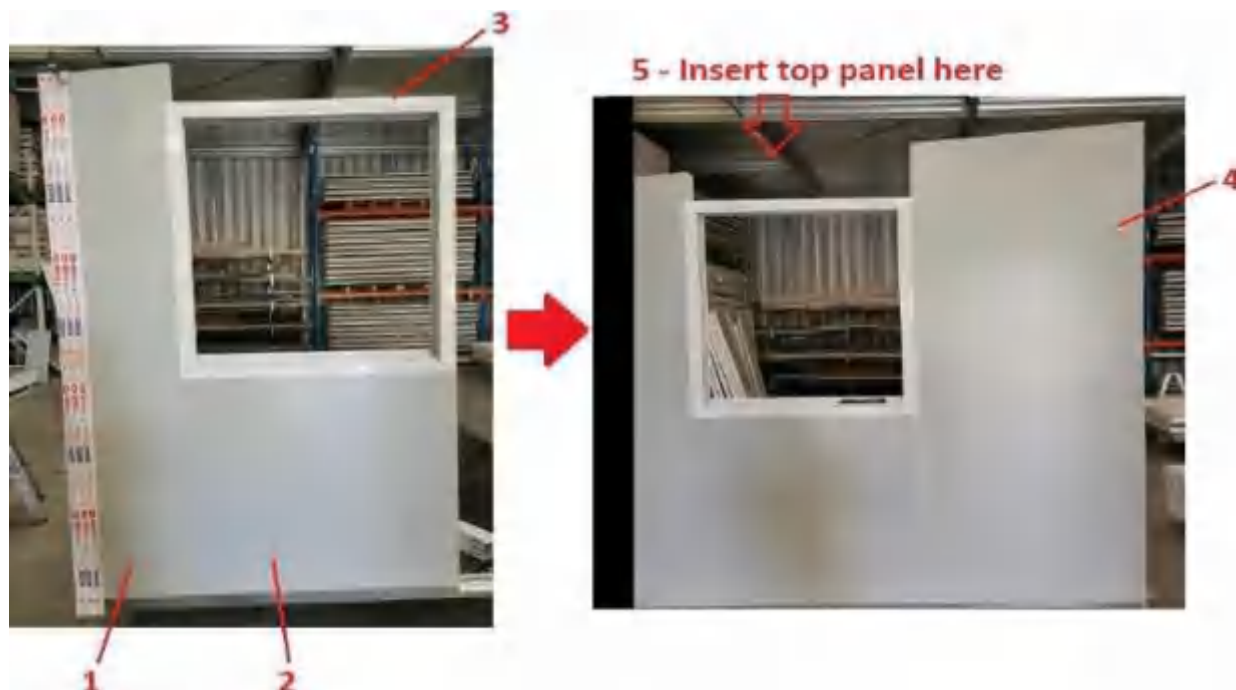
Window frames (Top plate)

- Locate the top side of the frames (with two middle tracks), position and screw.



Window trims

- Clip the window frame trims (U-Channel attachments) on to the window frames, with the mitre-cut angle facing away from the frames.
- Drill and rivet on corner.



Wall with frame insert

- Slot window/slide door frame into wall panel, slot the next SIDE joining wall panel and then insert from the TOP the quarter above window panel.

BRACINGS



Aluminum pillar 'corner to corner' steel angle bar bracing

- Ensure the walls are square before attempting this step.
- **If the white aluminium corner pillars option is chosen**, place the steel angle bar from 'corner to corner' overlapped by the aluminium pillar lip and rivet.

ROOFING

STEP 7 – ROOF PANELS

Roof panels are placed on the walls in sequence where they overlap at the top (ridges) and underneath at the ceiling point (tongue).

On standard size kits (2.4m wide pods), a 2.9m roof panel length will have an overhang of 500mm, which is generally positioned 300mm overhanging the front side of the pod and 160mm to the back. This may be adjusted to the user's preference or as available depending on the width of the pod.

Roof panels

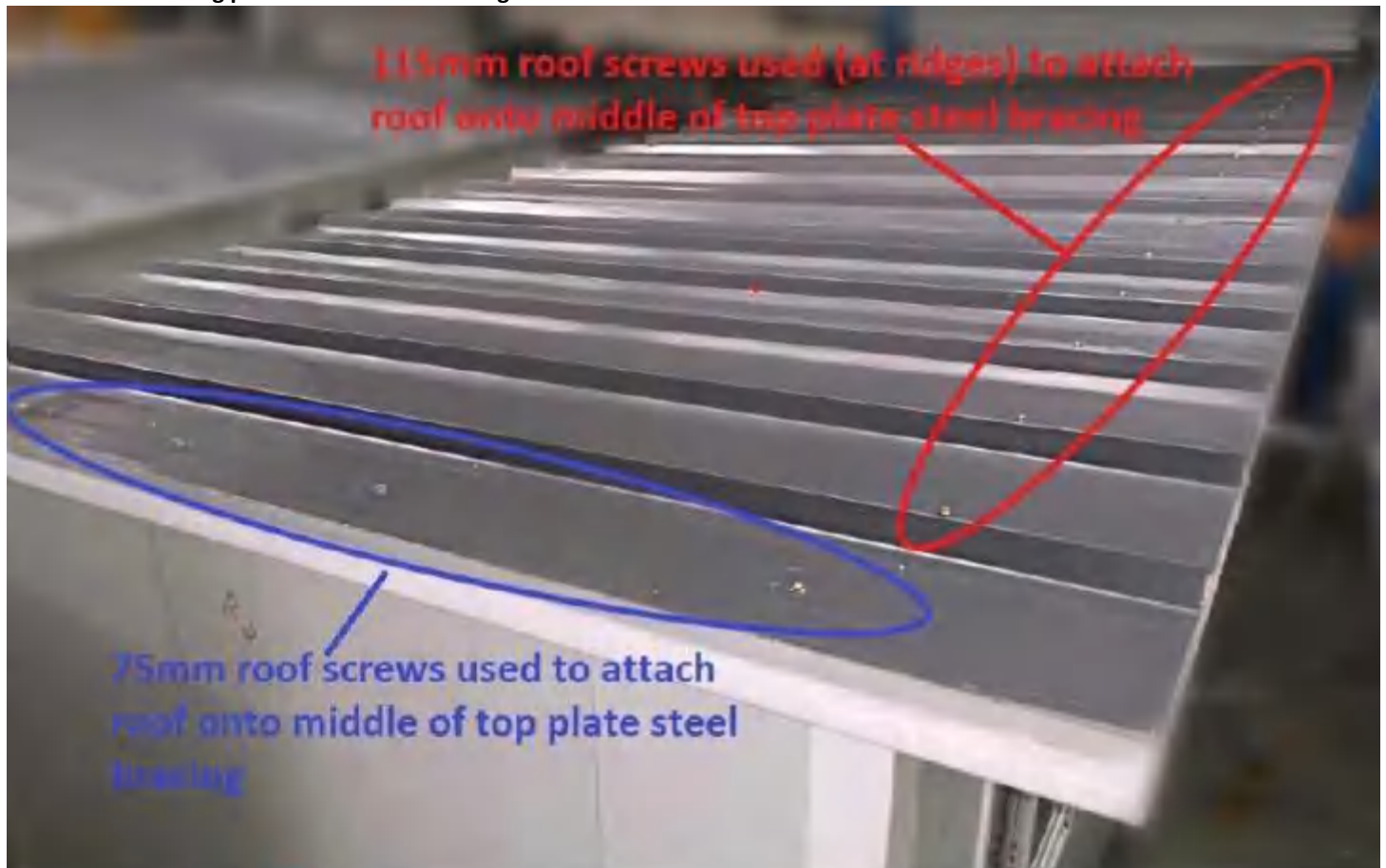
- Begin by check the total width of the roof panels when joined, to determine the overall overhang available for the short sides of the pod. (***Note:** Most kits will have a 'half roof panel' that will require a trim of the width on the edge to enable the attachment of roof flashing, be sure to take this into account when taking the measurement – refer to roof flashing step if required*)
- Use the measurement to determine where to position the first panel over the edge of the pod. Join the remainder roof panels, ensuring they are positioned as straight as possible to enable easier installation of roof flashing.



Roof panels positioned as straight as possible

- Rivet the roof panels together at the angled overlapping point of the ridges as shown in Fig. 21, at 300mm-400mm intervals. Apply weatherproof sealant / silicone over all roof rivets.

Roofing panels attached to bracings




 Into middle of bracing
 (Aluminum corner option)



- Determine the correct position and screw down the roof to the top plate bracings, using the appropriate length screws.
- Ensure that the 115mm screws are used on the ridges (front and back – long sides) and 75mm roof screws are used on the short sides.

- It is good practice to pre-drill the steel on the top side ONLY of the roof panel, apply silicone, and then screw down the roof to ensure weather tightness at screw point penetration.
- Rivet the underside of the roof panels (ceiling) in the interior of the pod at the tongue overlap points.

STEP 8 – ROOF FLASHINGS

There are 3 types of roof flashing, these are: -

1- 80mm U-channel flashing *(For front long side and in some instances the short side)*

2- 2- L shaped flashing *(For short side)*

3- 45mm double folded U channel flashing *(For back long side)*

Note: Depending on the pod size, the roof panels on the short side of the pod may end at either the ridge (80mm high) or low end (50mm high).

- Begin by placing the 80mm U-channel flashing on the roof panels at the front long side of the pod.



Figure 24 – End roof panels adjustment

- Adjust the roof ending panels, depending on the panel end type and flashing in your kit, by either: -
 - Using a skill saw to cut at the beginning of the ridge, and cover with 80mm U-channel flashing , or
 - Using a skill saw to cut off the tongue (if any) and cover with L shaped flashing



U Channel flashing



L shaped flashing



45mm double folded U-channel flashing

- Tuck the 45mm double folded U-channel flashing into roof panel at the back long side of the pod.



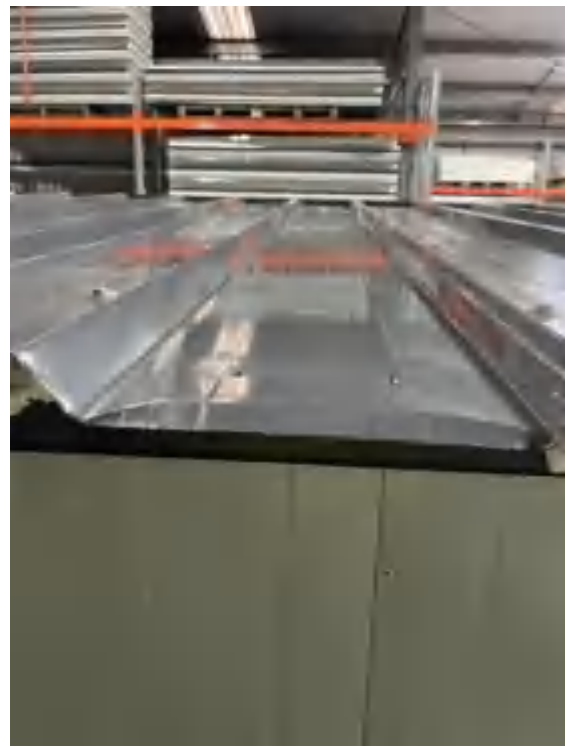
Roof flashing riveting

- Using the black rivets supplied, drill and rivet at all the required points of the roof flashing at minimum intervals of 600mm.

STEP 9 – ROOF EDGE FINISHING



Before

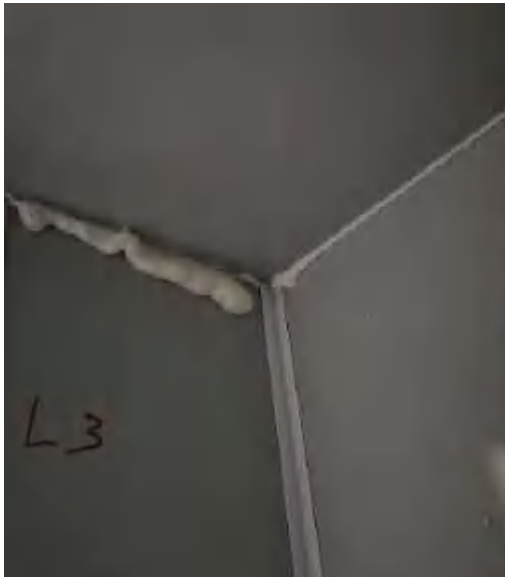


After

- After the main roof panels are installed, bend the eaves section downwards as the final edge treatment. This downward fold ensures that rainwater flows off the roof properly and does not collect at the edge, which could otherwise lead to leakage. Make sure the fold is angled enough to guide the water away from the building.

FINISHING

STEP 10 – EXPANDING FOAM



Expanding foam application

- Apply expanding foam on any gaps and specifically around the interior of the ceiling and at roof ridge ends at the back of the pod.



- Once dry, cut off excess using a craft knife.

STEP 11 – INTERIOR ALUMINUM ANGLE BARS



Interior aluminium angle trims

- Place and rivet the interior aluminium angle trims to the ceiling perimeter of the pod.
- If the steel post option is chosen, vertical aluminium trims require placement and riveting in each corner.

STEP 12 – WEATHERPROOF SEALANT / SILICONE



Weatherproof sealant / silicone application

- Apply weatherproof sealant/silicone to all exterior/interior gaps seen on the pod and specifically to the areas shown by a red line, to ensure weather tightness is achieved.
- Apply weatherproof sealant/silicone over any roof rivet points to ensure no rusting occurs.

STEP 13 – INSERTING WINDOWS & SLIDEDOORS



Slide door adjustment points

- The slide door and window panels can be inserted into the frames by tilting forward at a 15 to 30-degree angle, pushing upwards into frame track and then resting on bottom track.
- Adjust the height of the doors and windows as required by tightening/loosening the screws on the bottom sides of the panels.

STEP 14 – Windows and Door adjustment & Lock Installation

1. Put the the short window panel into the Frame
2. Put the long panel into theFrame



3.The panel with hook must be outside when You outside the cabin and face to the window.



4. Check there is no gap between the Window Frame

5.Use this screw to adjust the height for window Until the gap has been minimized.

6.Make the position for the internal Lock.

7. Use the 4.2mm drill bit to drill a hole

8. Use the white rivets to fix the lock into the frame

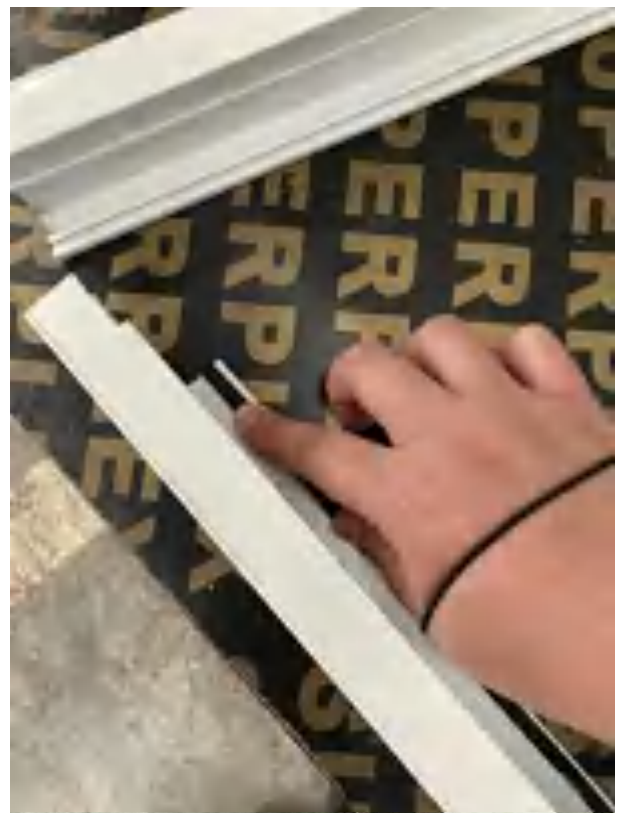
PA door assembly guide



1. Assemble wall panels next to the PA door.



2. Attach U channels



3. Preparing door trims



4.Adjusting the door trim to U channel frame



5. Attach door to the trim on three hinges



6. Completed

The Sliding door installation is same as window. Please contact us if you have any further question.

Email: HQNZPC@GMAIL.COM