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1. Introduction

1.1. Brief Description

Transform your garden into a luxurious retreat by creating an outdoor space perfect for relaxation and dining. With a durable aluminium construction and a versatile louvered roof, you can enjoy the sunshine and breeze throughout the sunny season.

All components are designed for easy assembly. The parts are made of aluminium, providing high corrosion resistance, ensuring maximum service life, and allowing for full recyclability.

1.2 About The Guide

Subject

These instructions cover all system-specific information regarding the installation of the pergola, including planning, parts, and safety instructions.

Applicable Documents

In addition to this guide, the document titled "General Assembly Instructions" can be found on our website (www.alufem.com.tr).

This document provides information on standardization, safety, transport, maintenance, dismantling, and disposal. These installation instructions are an integral part of the installation system and must be followed for every installation.

It is essential to read these assembly instructions and other applicable documents before performing assembly, maintenance, or disassembly.

User Group

These installation instructions are intended for the following personnel (user group):

- Skilled Personnel
- Instructed Personnel

Skilled Personnel

Skilled personnel are individuals capable of performing installation, maintenance, and disassembly tasks properly, based on their professional training.

Instructed Personnel

Instructed personnel are individuals who have been adequately trained and instructed in their assigned tasks and the potential risks of improper behavior. An instructed person must be familiar with

necessary safety devices, precautions, relevant regulations, accident prevention measures, and working conditions, and must have demonstrated competence.

Guidance Notes

The following guidance notes outline guidelines that must be followed when using this installation manual:

Pictograms:



This symbol indicates important information and offers useful tips.



This symbol indicates methods to simplify the installation process.

1.3 Tools

In order to install the system safely and efficiently, it is important that you follow the following recommendations exactly.

According to these installation instructions, you will need the following specialised tools for easy installation:

- | | |
|-------------|------------------|
| • Helmet | • Four people |
| • Gloves | • Cordless Drill |
| • Staircase | • Bits Nut |

2. Technical Description

2.1. Product Overview

Below are general parts of the system:

Aluminium Pergola System General Parts

03. Side Frame without Reducer

04. Side Frame with Reducer

05. Leg

06. Reducer

13. Front / Rear Frana

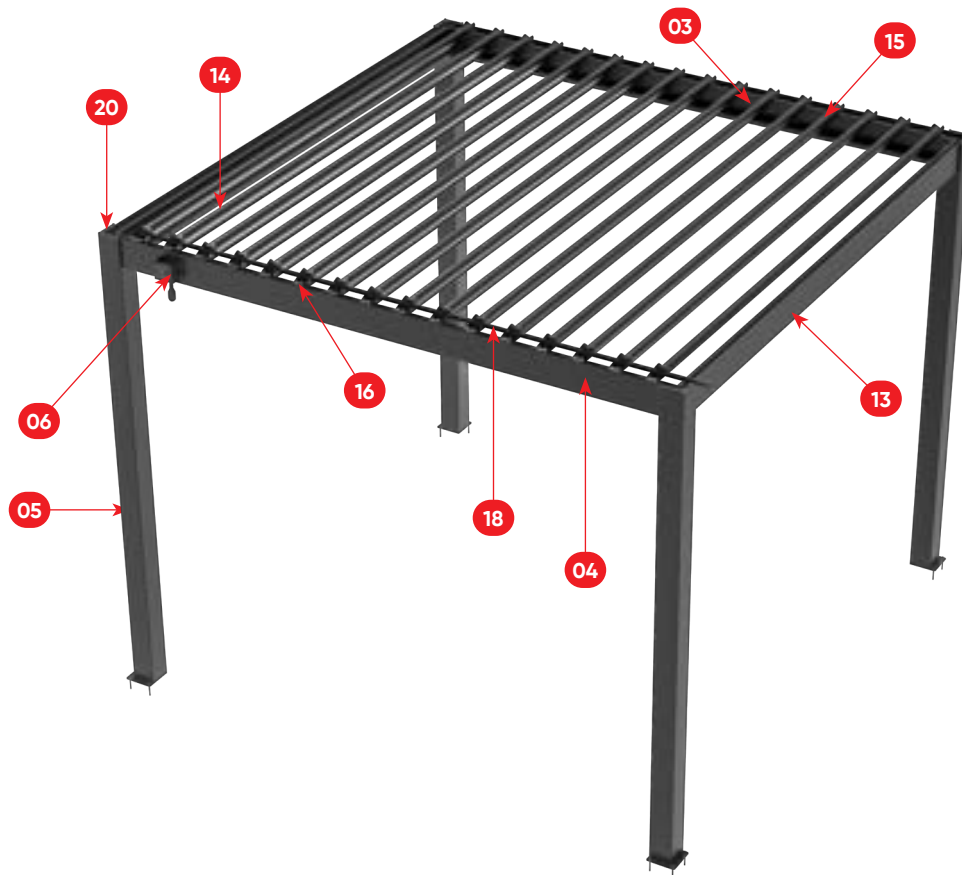
14. Flap with Reducer

15. Flap without Reducer

16. Flap Sheet

18. Reducer Crank

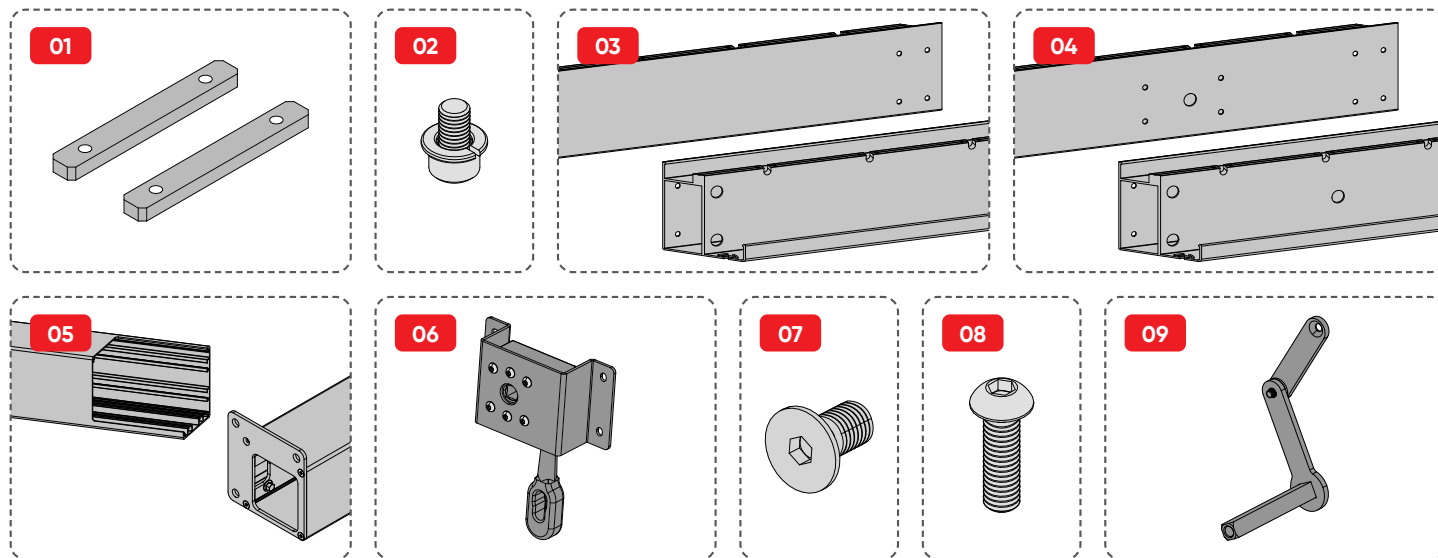
20. Leg Top Cover

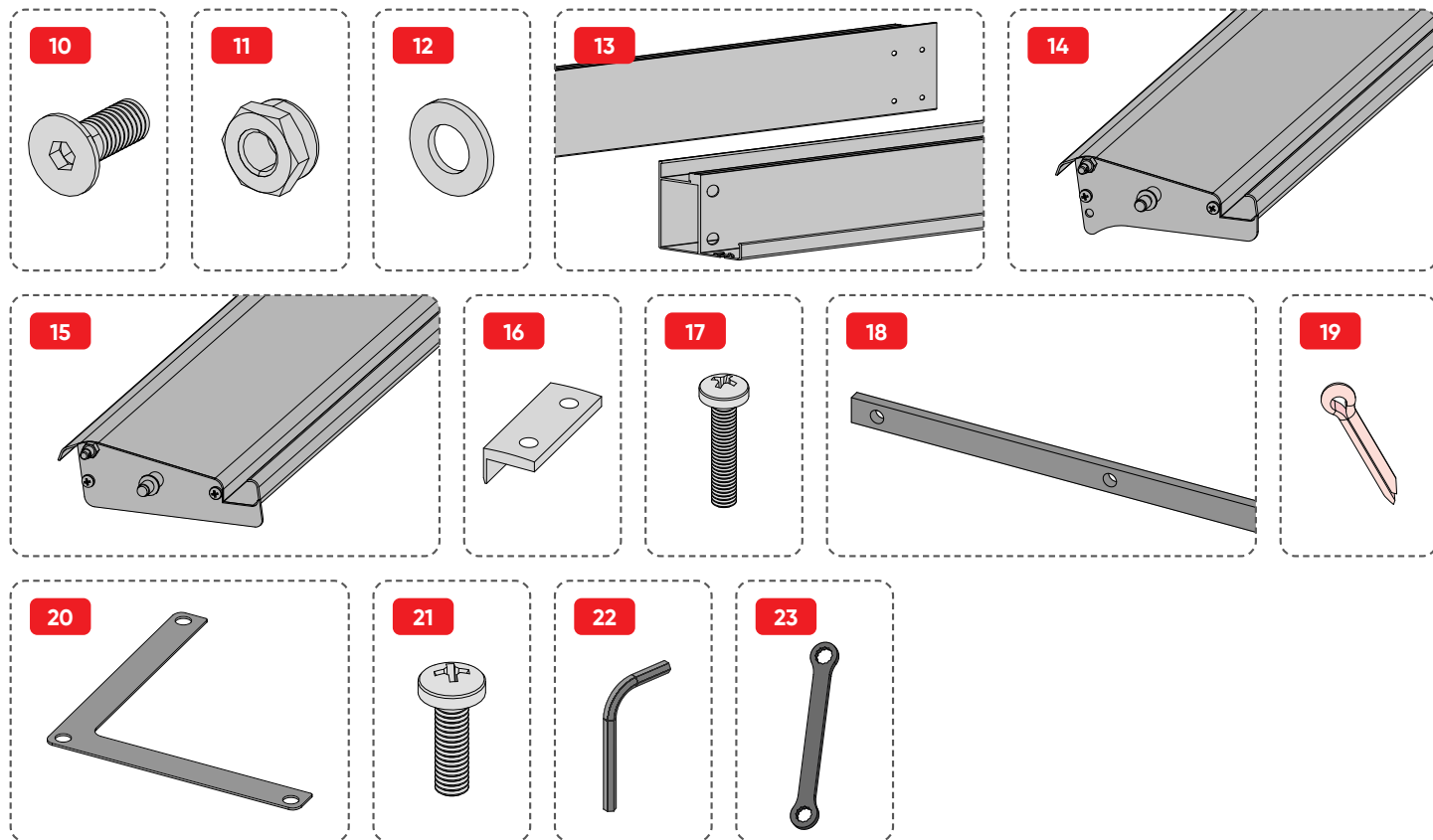


2.2. Components

All system parts that can be included in **ALUFEM Aluminium Pergola System** delivery scope are shown below. The exact scope of delivery and the number of special system parts depend on your order.

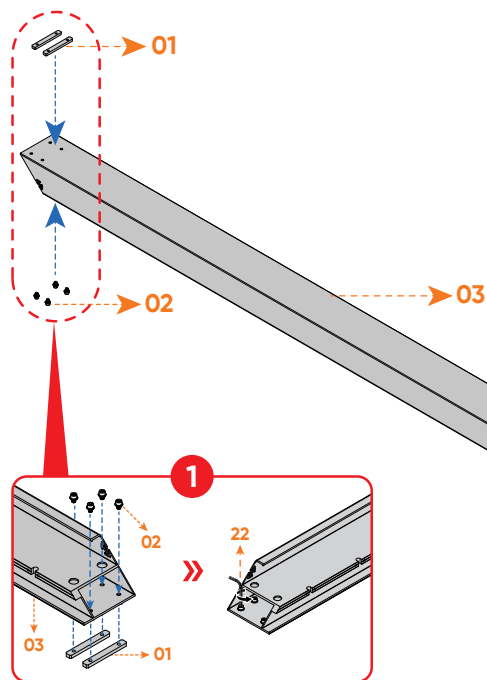
- | | | |
|--|---|-------------------------------------|
| 01. Lock Bracket (x12) | 09. Reducer Connection Part (x1) | 17. M6x30 Flap Sheet Screw (x64) |
| 02. M8x12 Lock Bracket Screw (x24) | 10. M6x16 Reducer Connection Screw (x1) | 18. Reducer Crank (x1) |
| 03. Side Frame without Reducer (x1) | 11. M6 Nut (x1) | 19. Cotter Pin (x16) |
| 04. Side Frame with Reducer (x1) | 12. Washer (x1) | 20. Leg Top Cover (x4) |
| 05. Leg (x4) | 13. Front / Rear Frame (x2) | 21. M6x20 Leg Top Cover Screw (x12) |
| 06. Reducer (x1) | 14. Flap with Reducer (x1) | 22. Allen (x1) |
| 07. M10x20 Reducer Screw (x1) | 15. Flap without Reducer (x15) | 23. Wrench (x1) |
| 08. M6x20 Reducer Sheet Metal Screw (x4) | 16. Flap Sheet (x32) | |





3. Assembly Stages

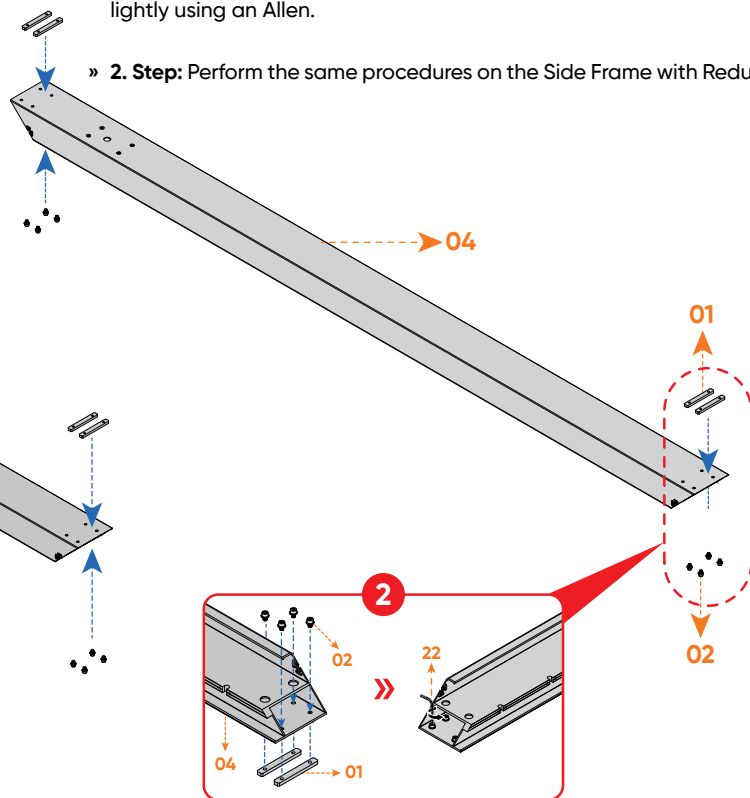
Please do not damage the surface when opening the packaging.



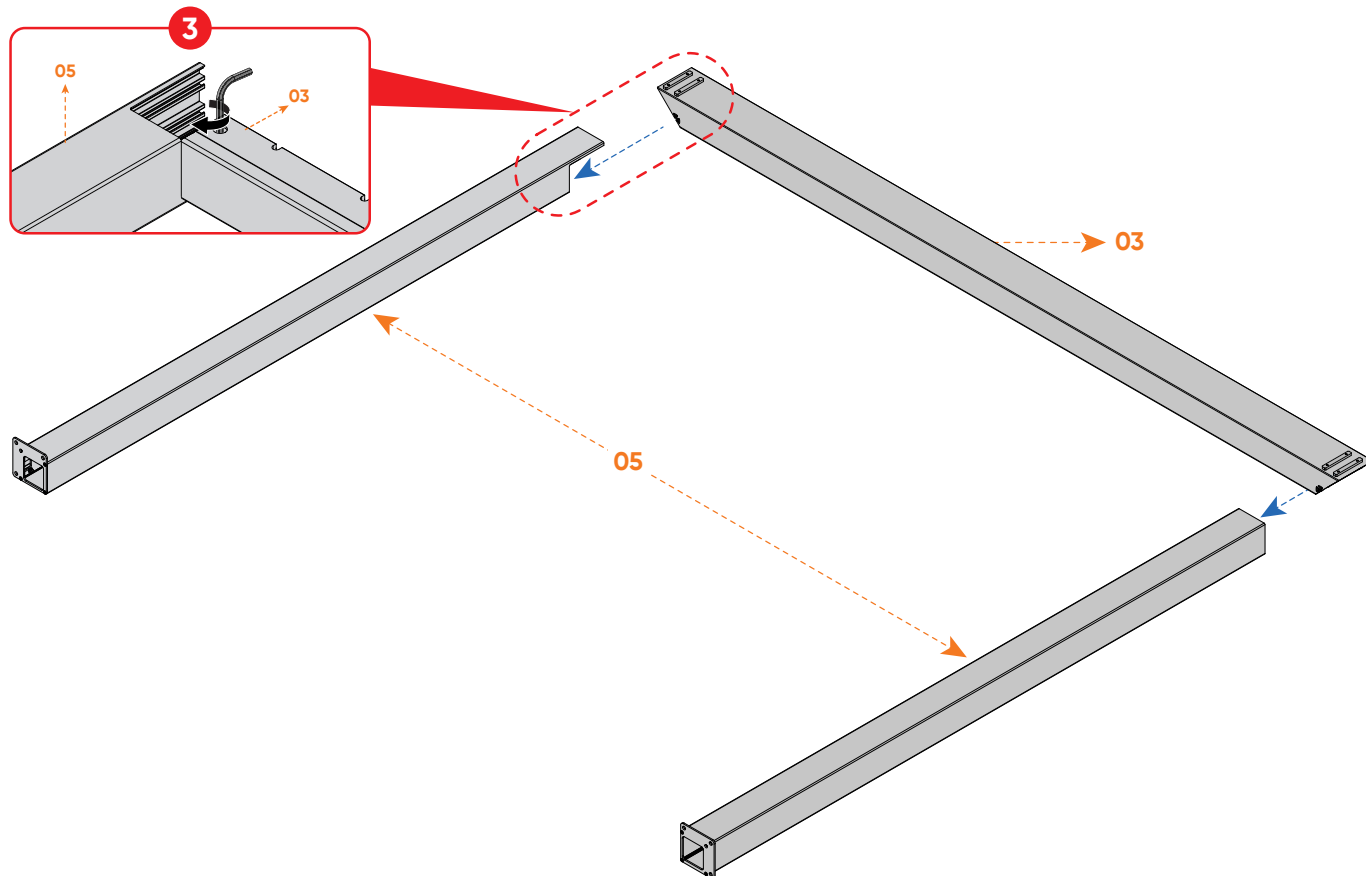
3.1. Assembly Steps

» **1. Step:** Place the Lock Bracket and M8x12 Lock Bracket Screws on the Side Frame without Reducer as indicated by the arrow. Tighten them lightly using an Allen.

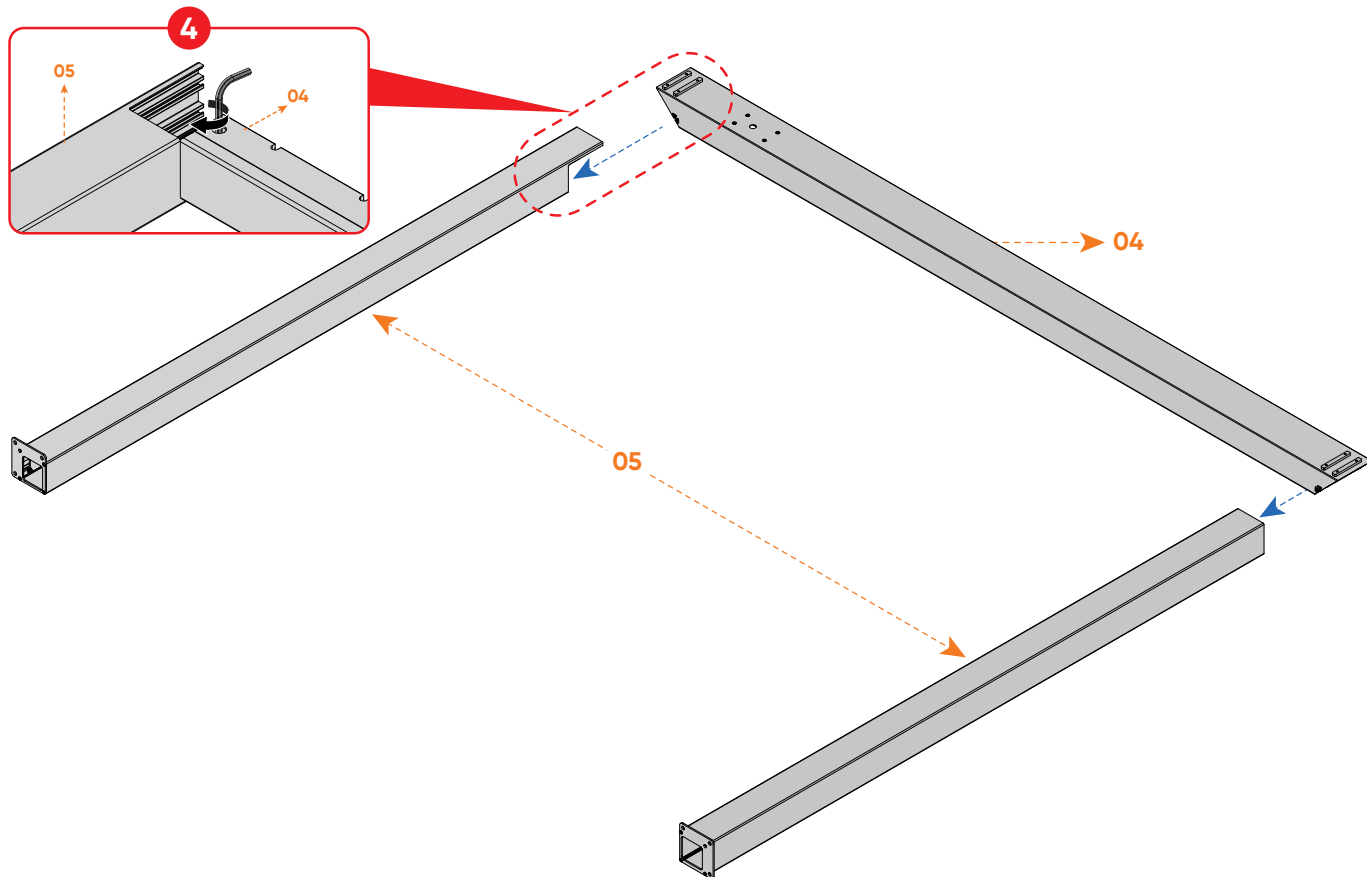
» **2. Step:** Perform the same procedures on the Side Frame with Reducer.



- » **3. Step:** Place the Side Frame without Reducer onto the Legs as indicated by the arrow and tighten it using an Allen.



» **4. Step:** Perform the same procedures on the Side Frame with Reducer.

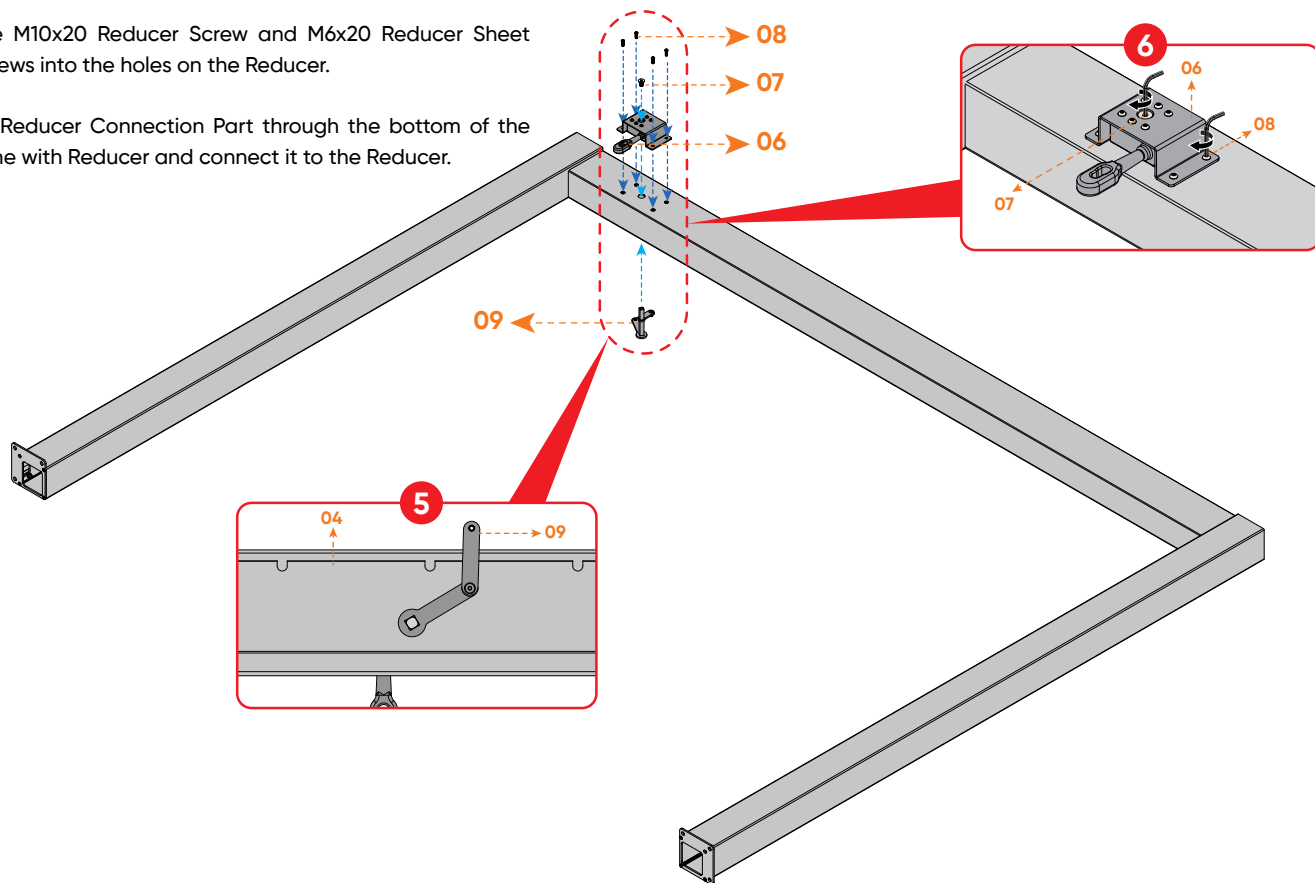


- » **5. Step:** Place the Reducer onto the Side Frame with Reducer as indicated by the arrow.

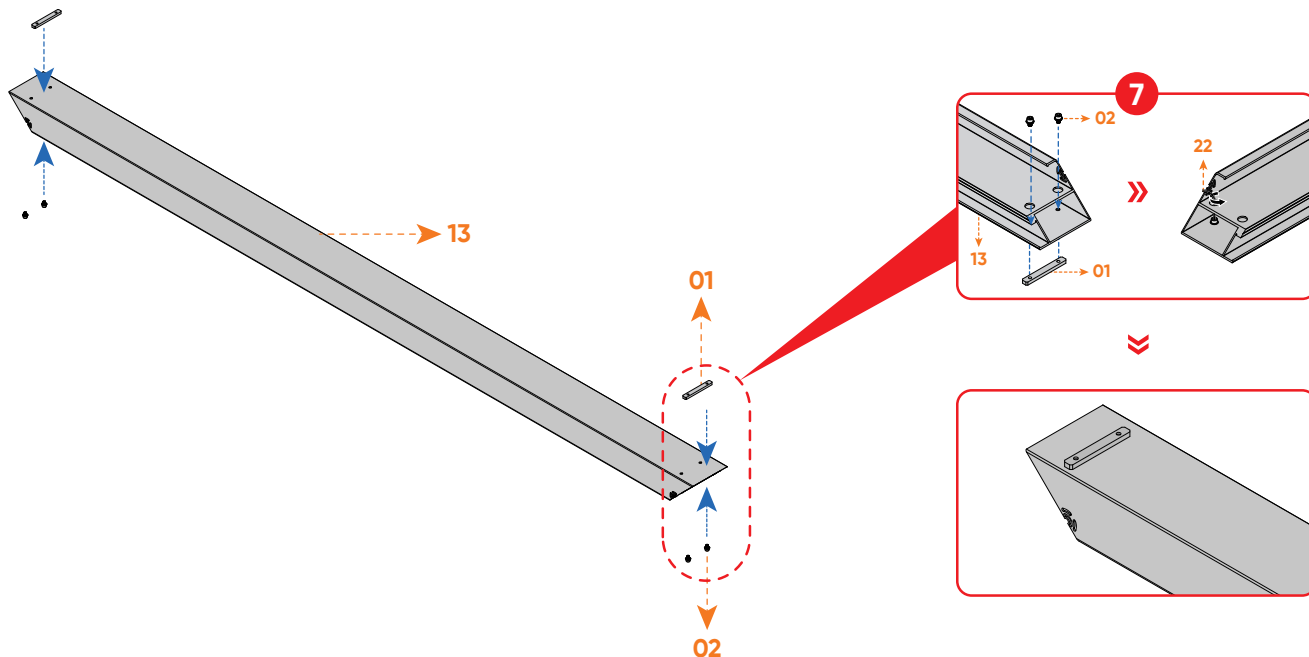
Insert the M10x20 Reducer Screw and M6x20 Reducer Sheet Metal Screws into the holes on the Reducer.

Pass the Reducer Connection Part through the bottom of the Side Frame with Reducer and connect it to the Reducer.

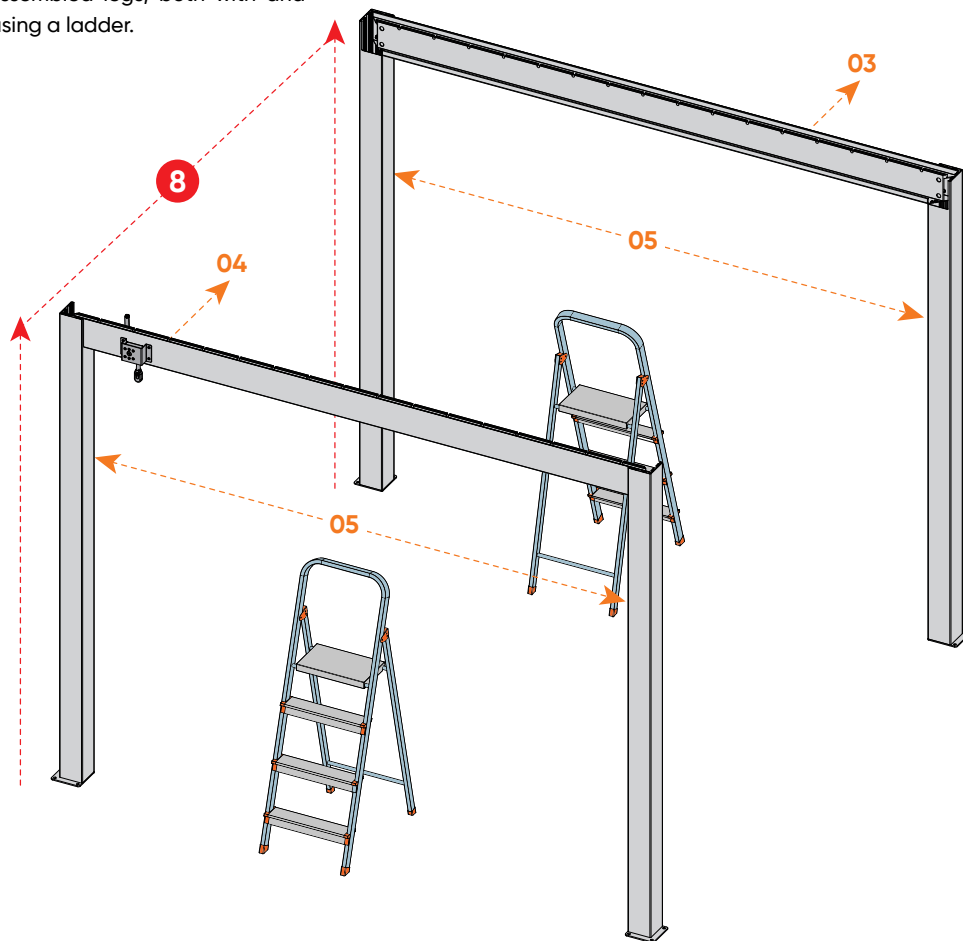
- » **6. Step:** After completing all the steps, tighten the M10x20 Reducer Screw and M6x20 Reducer Sheet Metal Screws using an Allen.



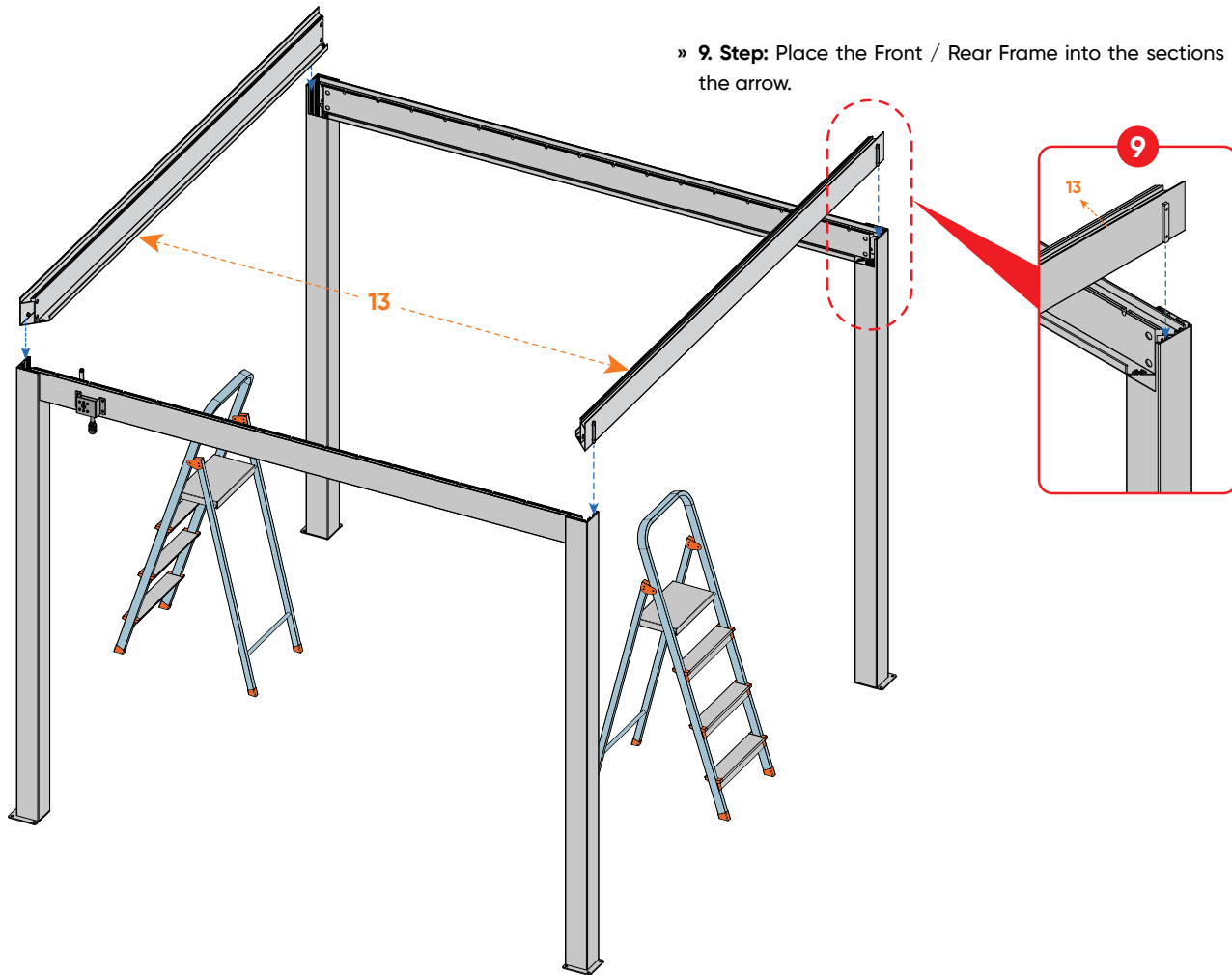
- » **7. Step:** Place the Lock Bracket and M8x12 Lock Bracket Screws on the Front / Rear Frame as indicated by the arrow. Lightly tighten them using an Allen.



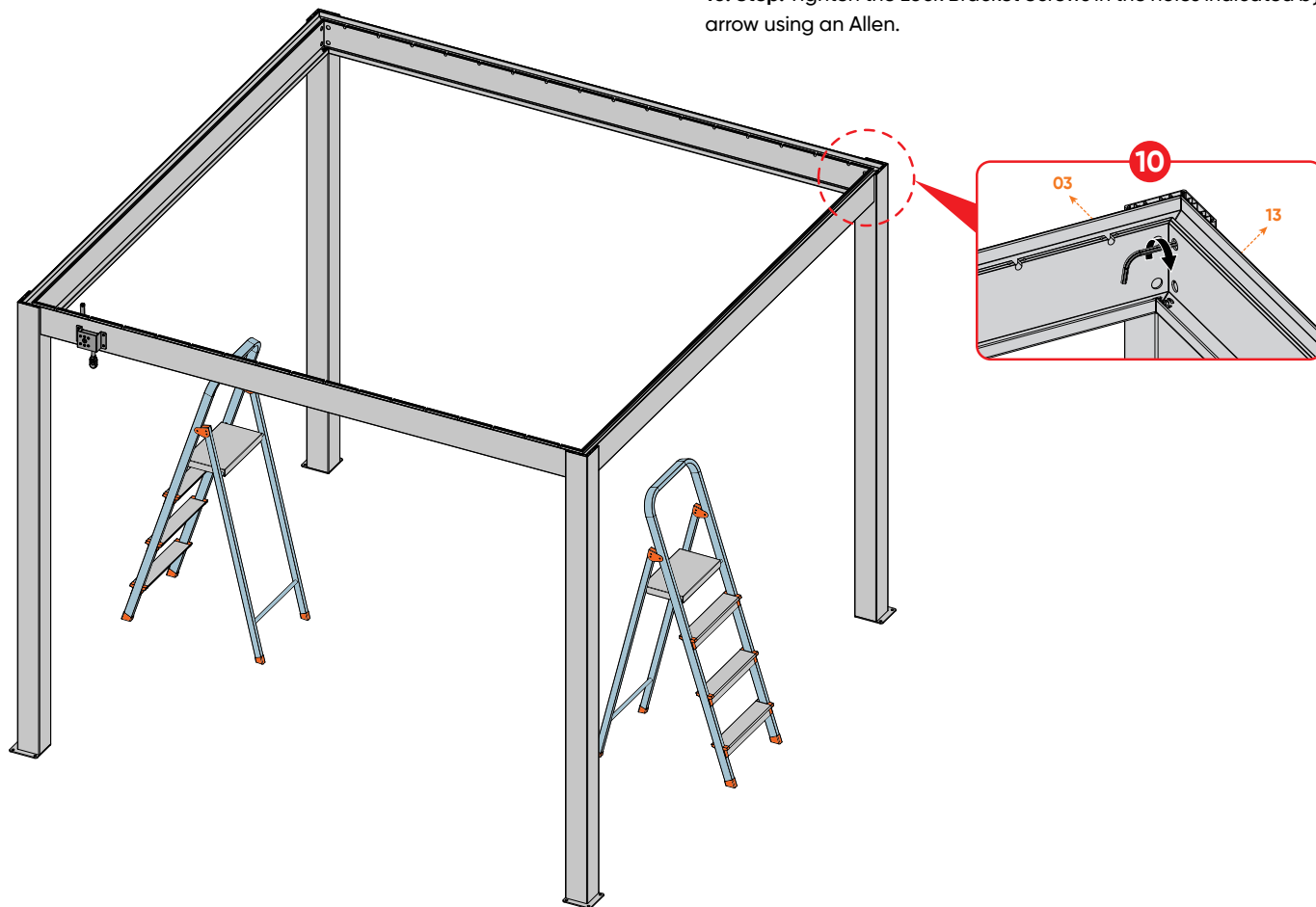
- » **8. Step:** Lift the assembled legs, both with and without reducers, using a ladder.



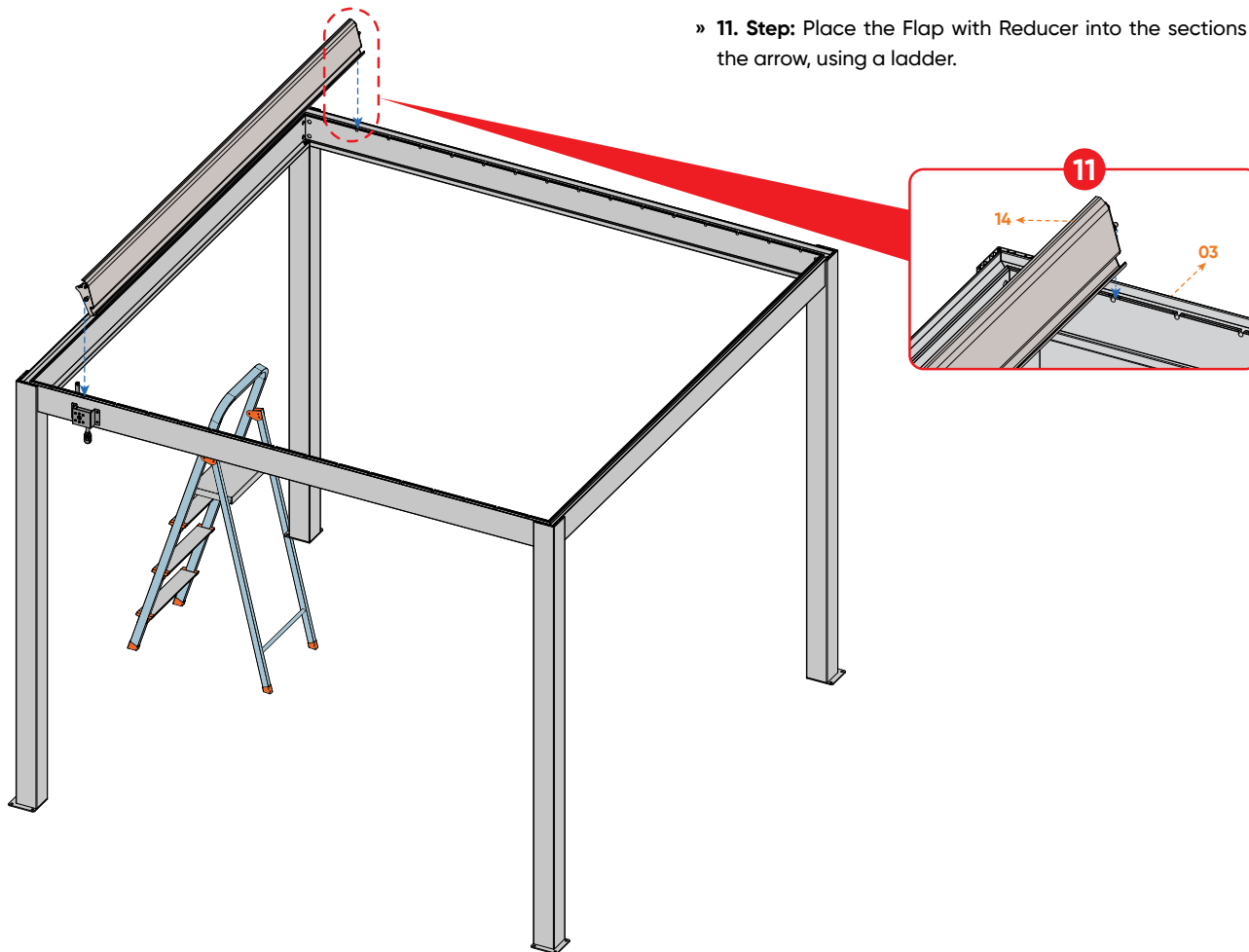
» **9. Step:** Place the Front / Rear Frame into the sections indicated by the arrow.

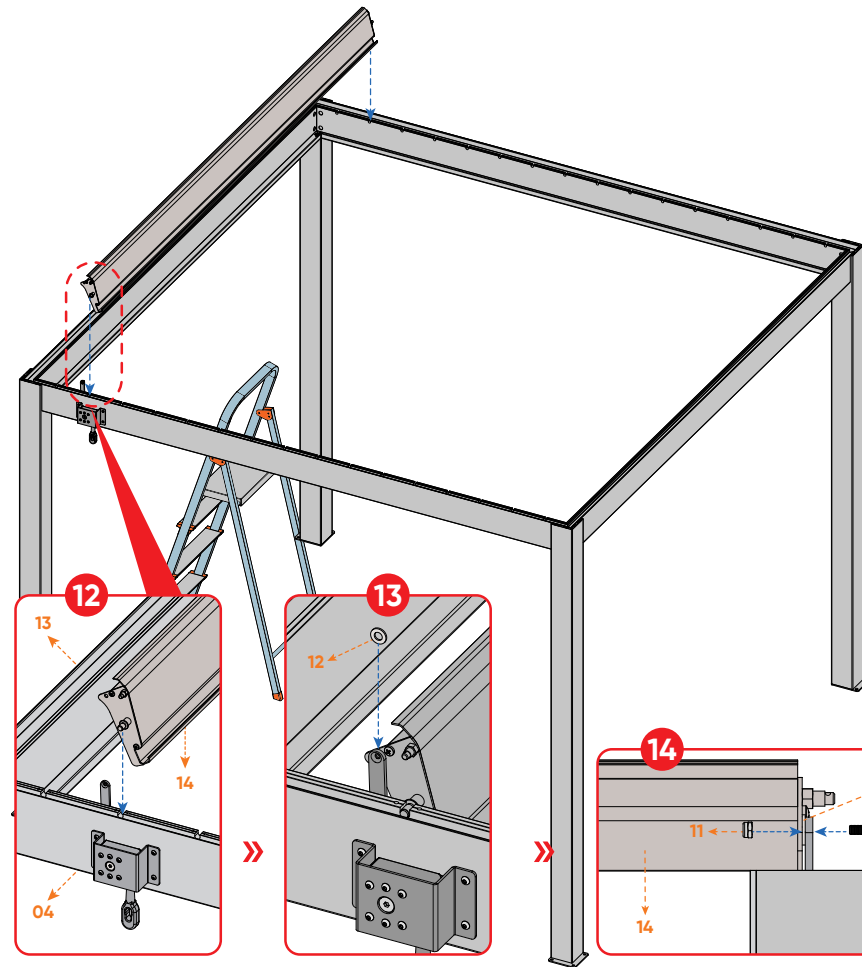


» **10. Step:** Tighten the Lock Bracket Screws in the holes indicated by the arrow using an Allen.

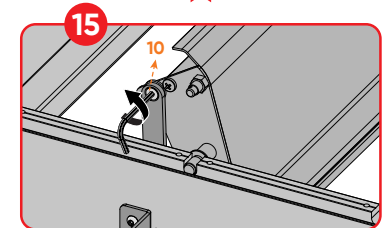
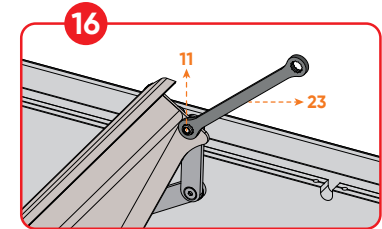


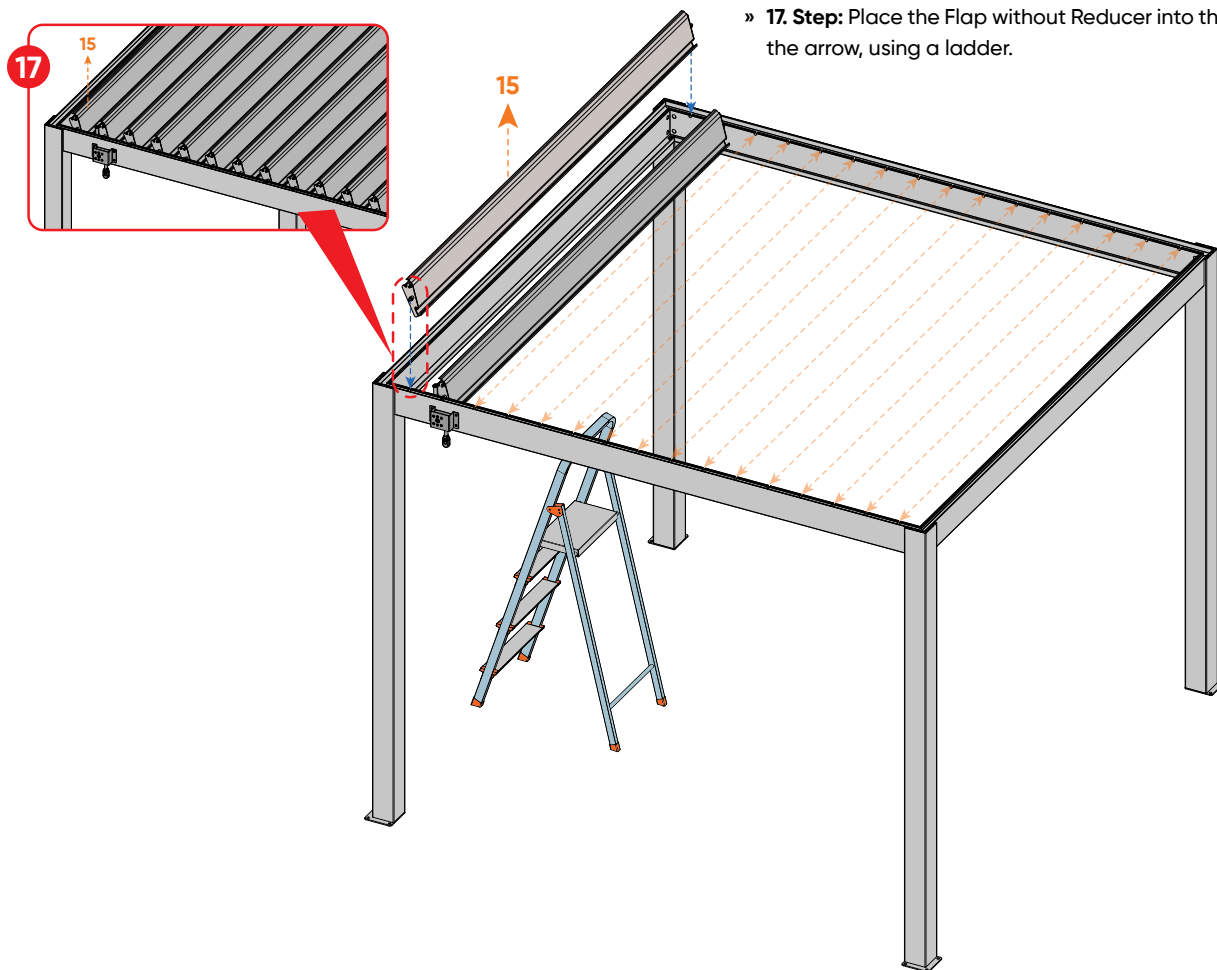
- » **11. Step:** Place the Flap with Reducer into the sections indicated by the arrow, using a ladder.





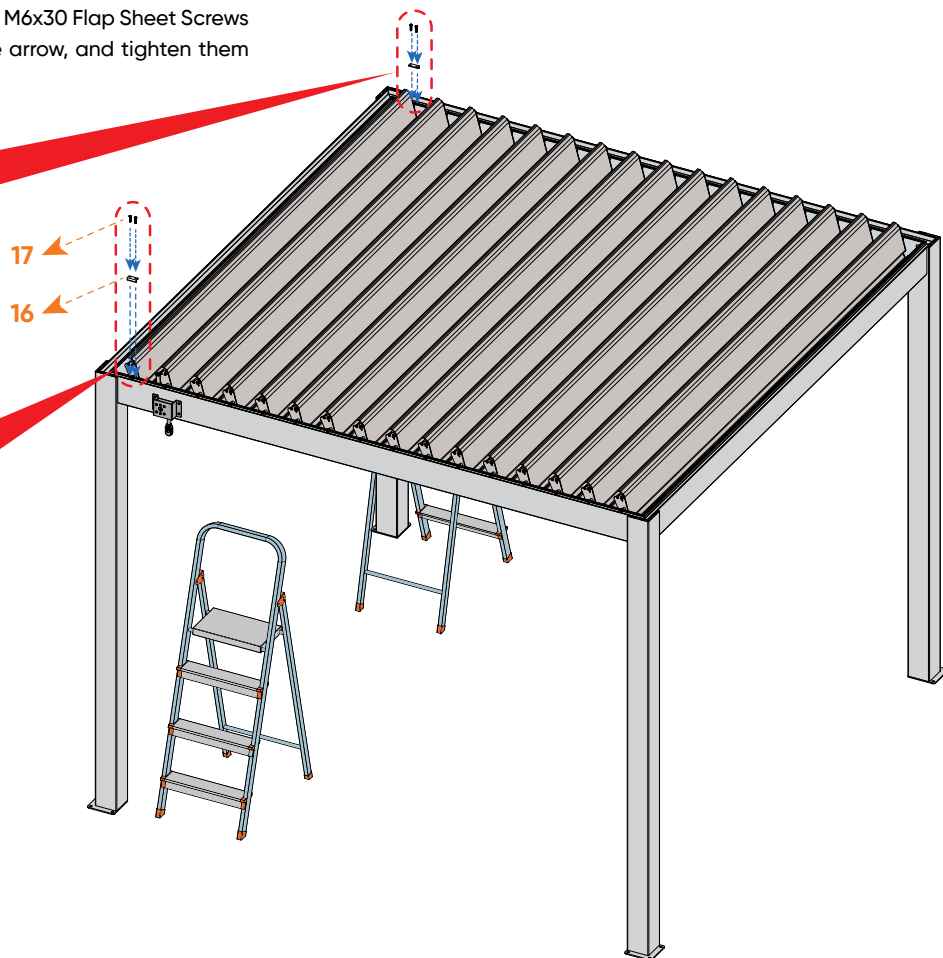
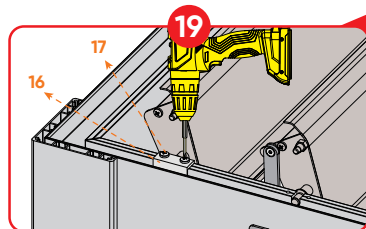
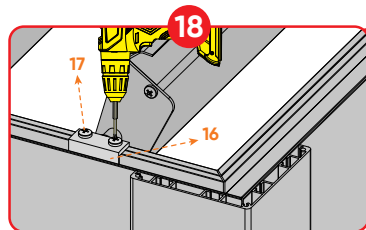
- » **12. Step:** Align the Flap with Reducer with the Reducer Connection Part as indicated by the arrow.
- » **13. Step:** Insert the Washer between the Flap with Reducer and the Reducer Connection Part.
- » **14. Step:** Pass the M6x16 Reducer Connection Screw and M6 Nut through the hole in the Reducer Connection Part.
- » **15. Step:** Tighten the M6 nut using a wrench.
- » **16. Step:** Tighten the Reducer Connection Screw using an Allen.





» **17. Step:** Place the Flap without Reducer into the sections indicated by the arrow, using a ladder.

- » **18. and 19. Step:** Insert 32 Flap Sheets and 64 M6x30 Flap Sheet Screws into the holes of the Flaps indicated by the arrow, and tighten them using a drill.

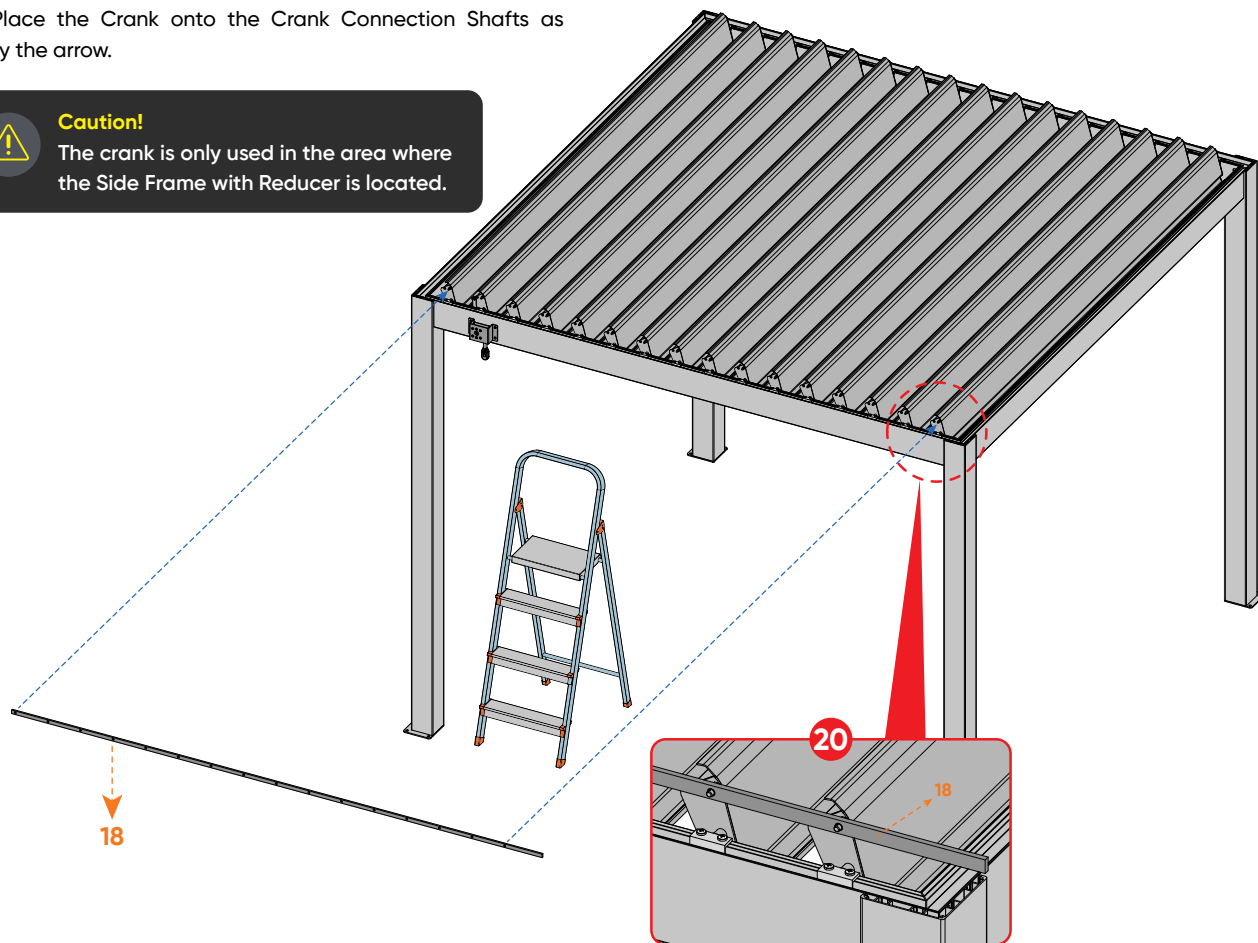


- » **20. Step:** Place the Crank onto the Crank Connection Shafts as indicated by the arrow.

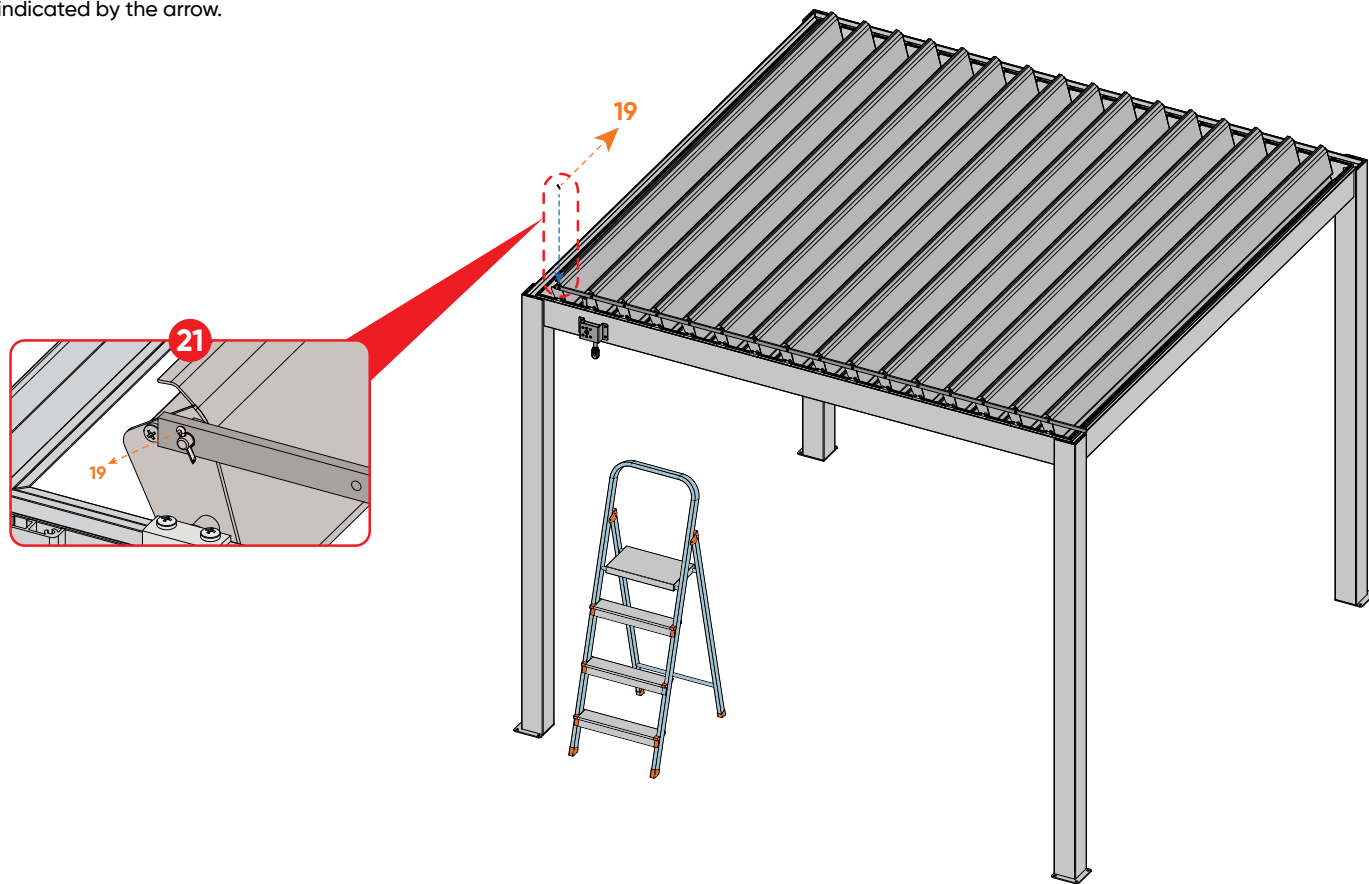


Caution!

The crank is only used in the area where the Side Frame with Reducer is located.



- » **21. Step:** Insert 16 Cotter Pins into the Crank Connection Shafts as indicated by the arrow.



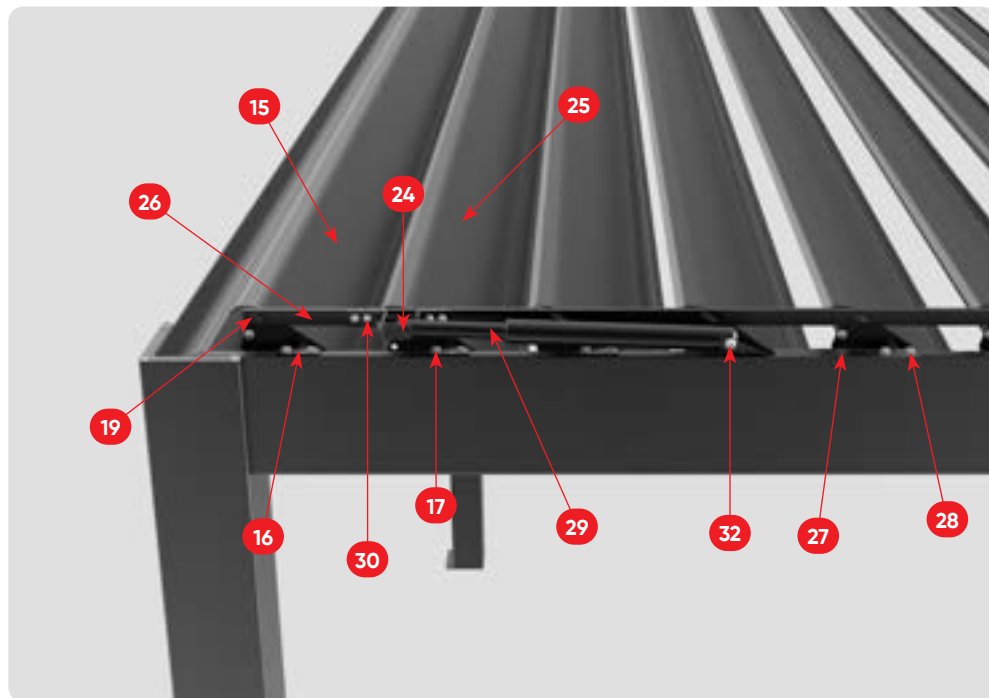
4. Linear Motor Assembly

4.1. Product Overview

Below are general parts of the system:

Linear Motor System General Parts

- 15. Flap without Reducer
- 16. Flap Sheet
- 17. M6x30 Flap Sheet Screw
- 19. Cotter Pin
- 24. Linear Motor Shaft
- 25. Linear Motor Flap
- 26. Linear Crank
- 27. Liner Motor Sheet
- 28. M6x8 Star Head Bolt
- 29. Linear Motor
- 30. M6x20 Allen Head Bolt
- 32. M6x40 Allen Head Bolt



4.2. Linear Motor Components

- 16. Flap Sheet (x30)
- 17. M6x30 Flap Sheet Bolt (x30)
- 19. Cotter Pin (x16)
- 22. Allen (x1)
- 23. Wrench (x1)

- 24. Linear Motor Shaft (x1)
- 25. Linear Motor Flap (x1)
- 26. Linear Crank (x1)
- 27. Linear Motor Sheet (x1)
- 28. M6x8 Star Head Bolt (x4)

- 29. Linear Motor (x1)
- 30. M6x20 Allen Head Bolt (x4)
- 31. M6 Nut (x5)
- 32. M6x40 Allen Head Bolt(x1)
- 33. Linear Motor Washer (x1)



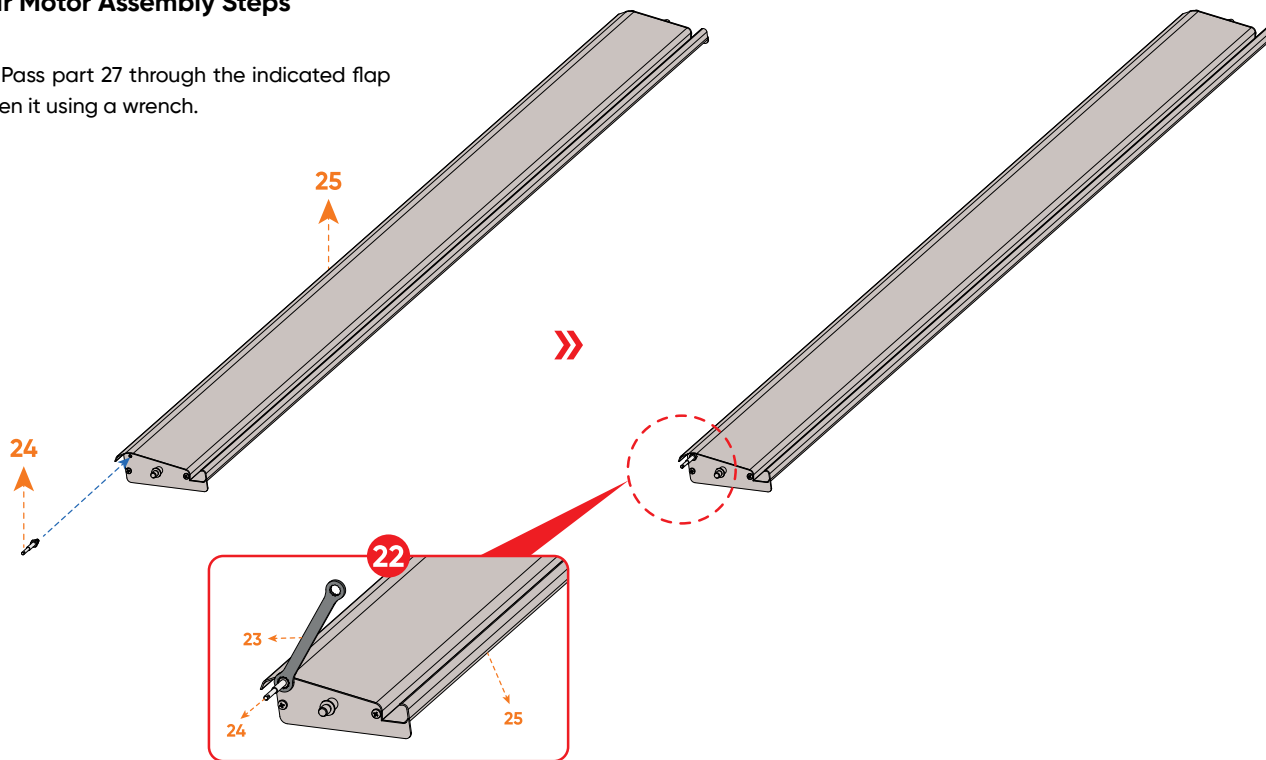


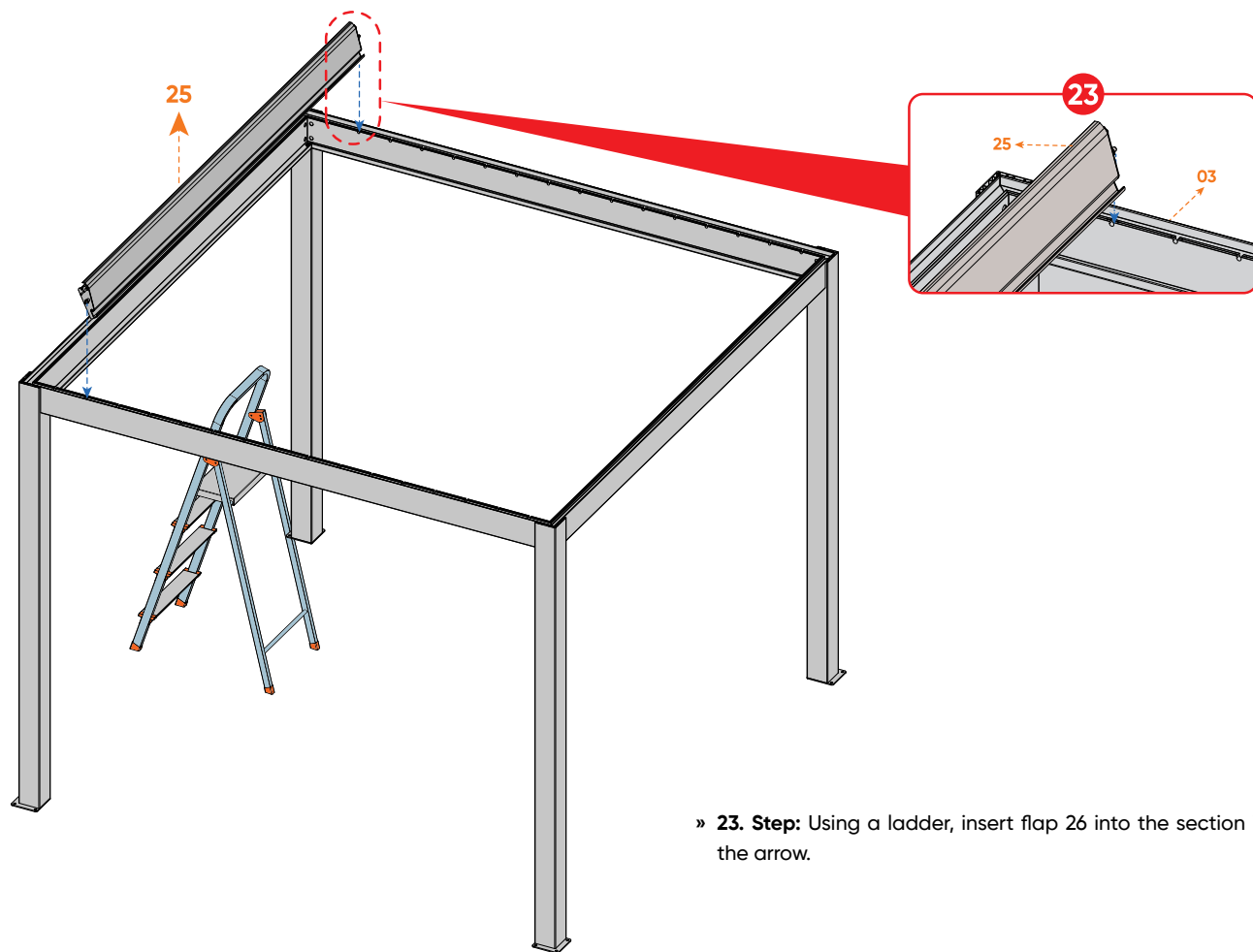
Caution!

If you want to use flaps with linear motor optionally, you should follow the steps below.

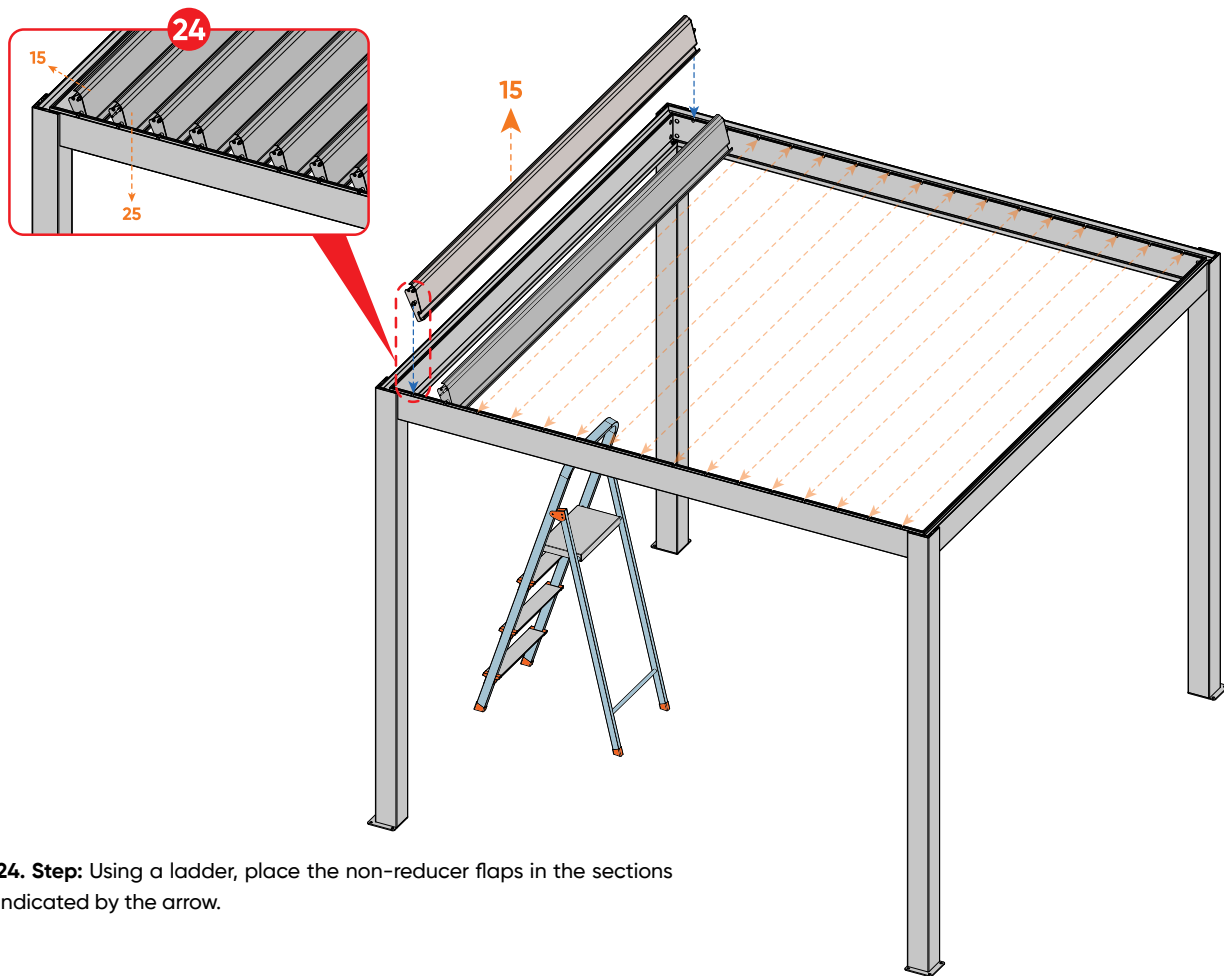
4.3. Linear Motor Assembly Steps

- » **22. Step:** Pass part 27 through the indicated flap and tighten it using a wrench.



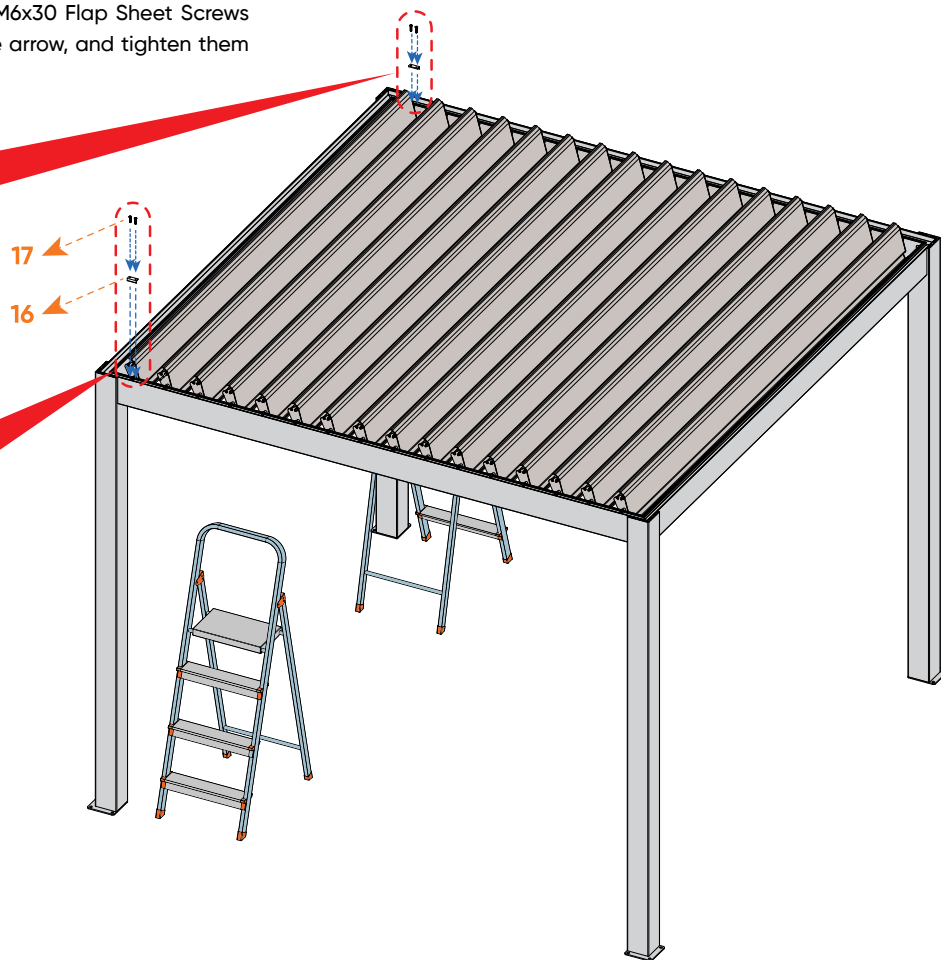
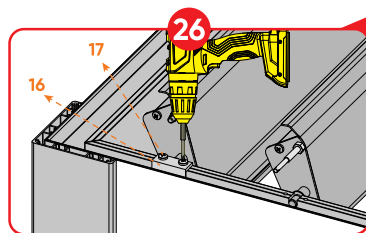
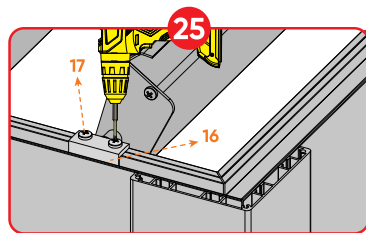


» **23. Step:** Using a ladder, insert flap 26 into the section indicated by the arrow.



» **24. Step:** Using a ladder, place the non-reducer flaps in the sections indicated by the arrow.

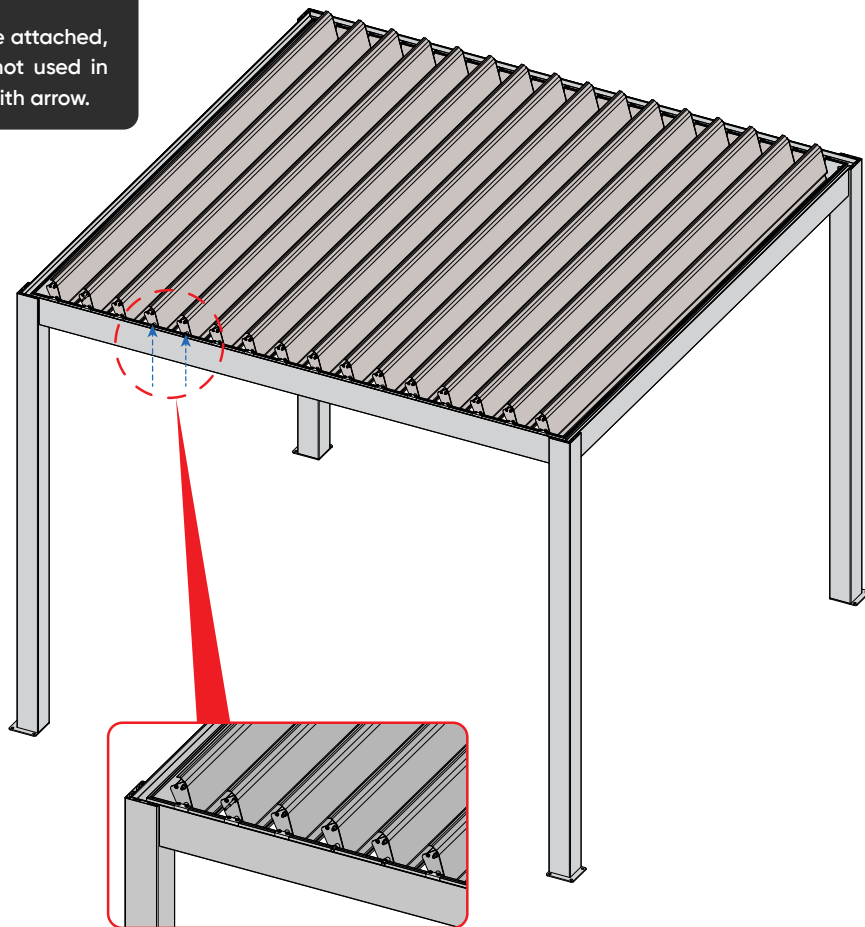
- » **25. and 26. Step:** Insert Flap Sheets and M6x30 Flap Sheet Screws into the holes of the Flaps indicated by the arrow, and tighten them using a drill.





Caution!

Since the Linear Sheet will be attached, flap sheet and screws are not used in the 4th and 5th flap shown with arrow.

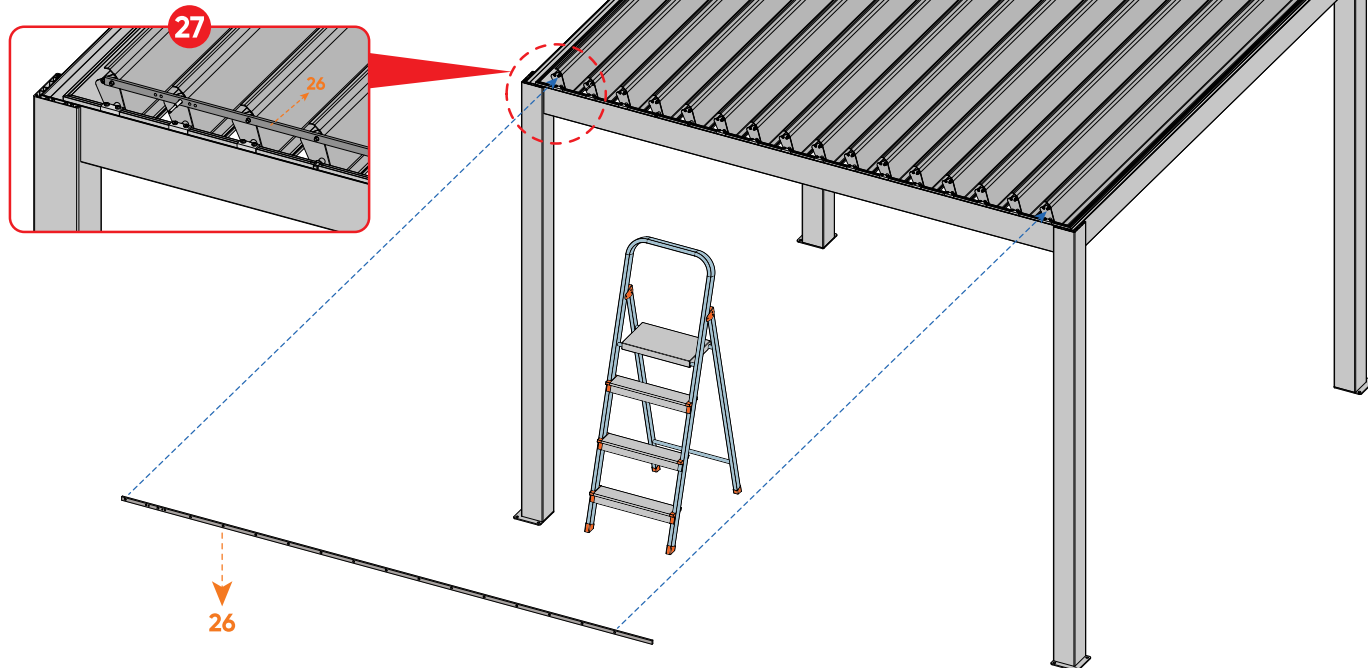


- » **27. Step:** Place the Crank onto the Crank Connection Shafts as indicated by the arrow.

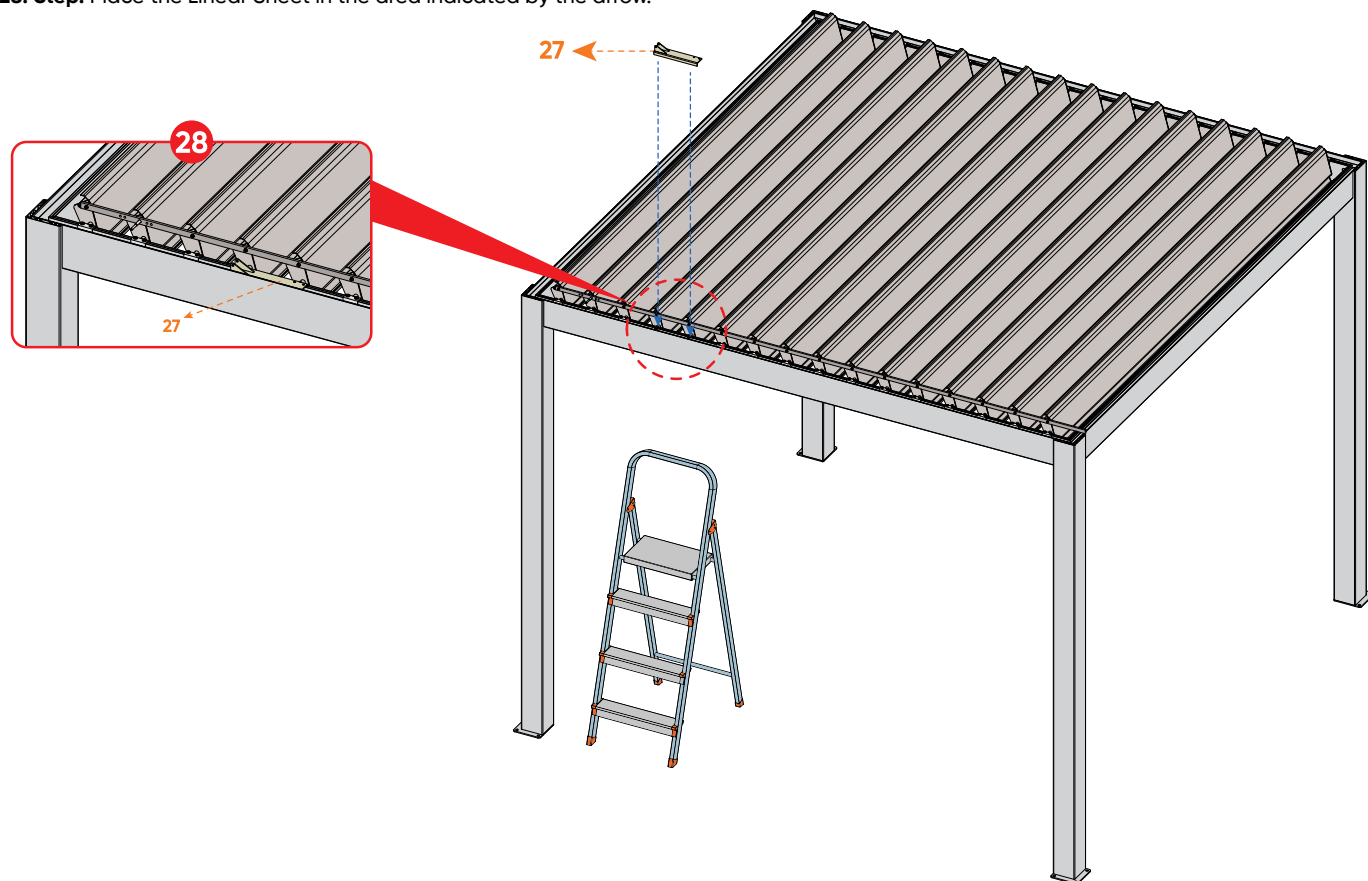


Caution!

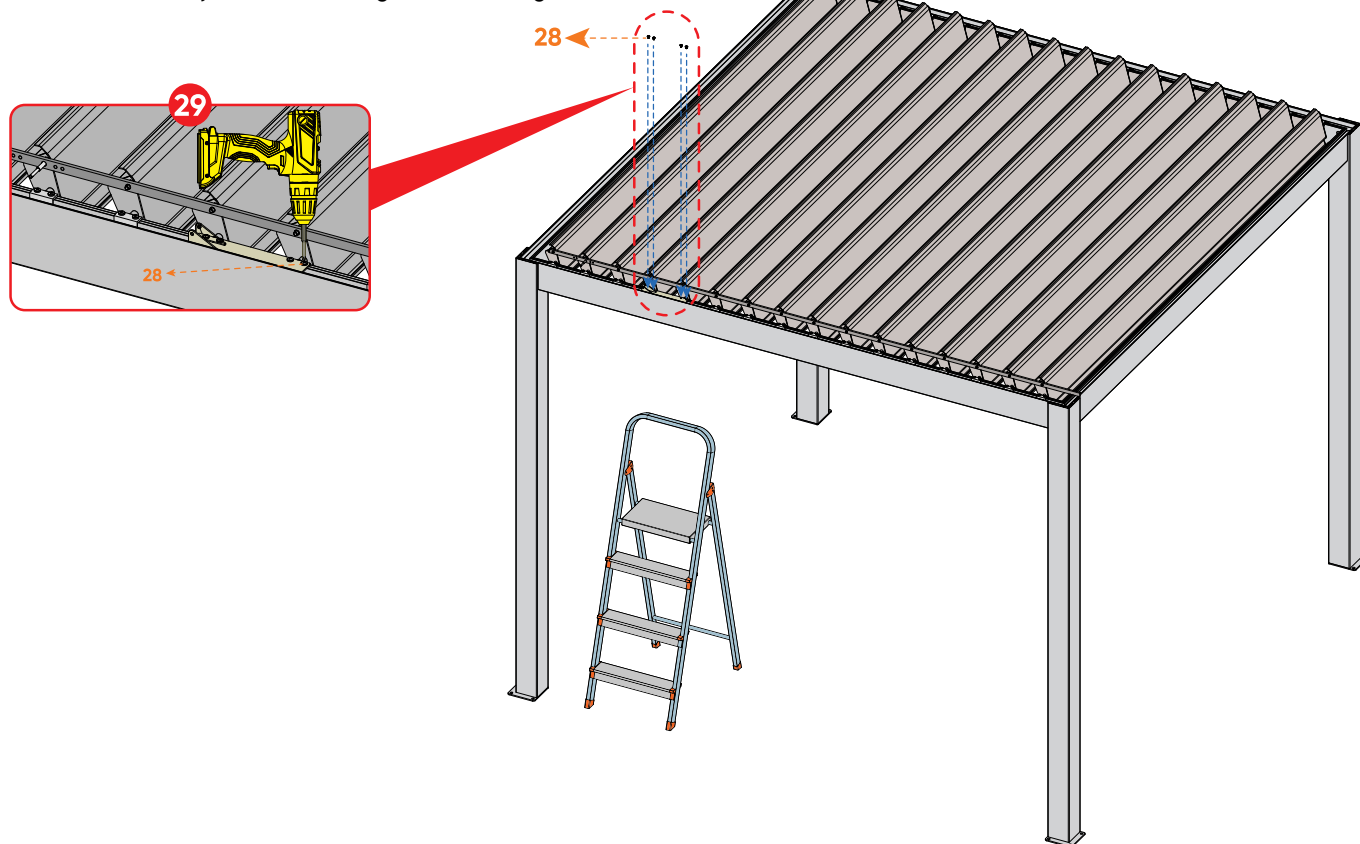
The crank is only used in the area where the Linear Motor is located.



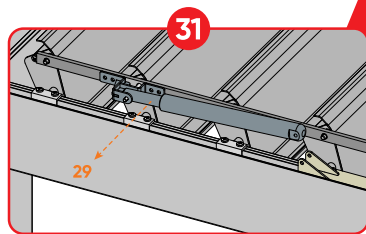
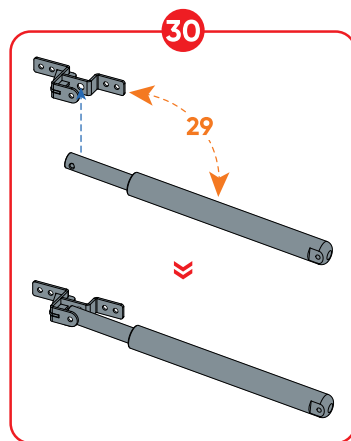
» **28. Step:** Place the Linear Sheet in the area indicated by the arrow.



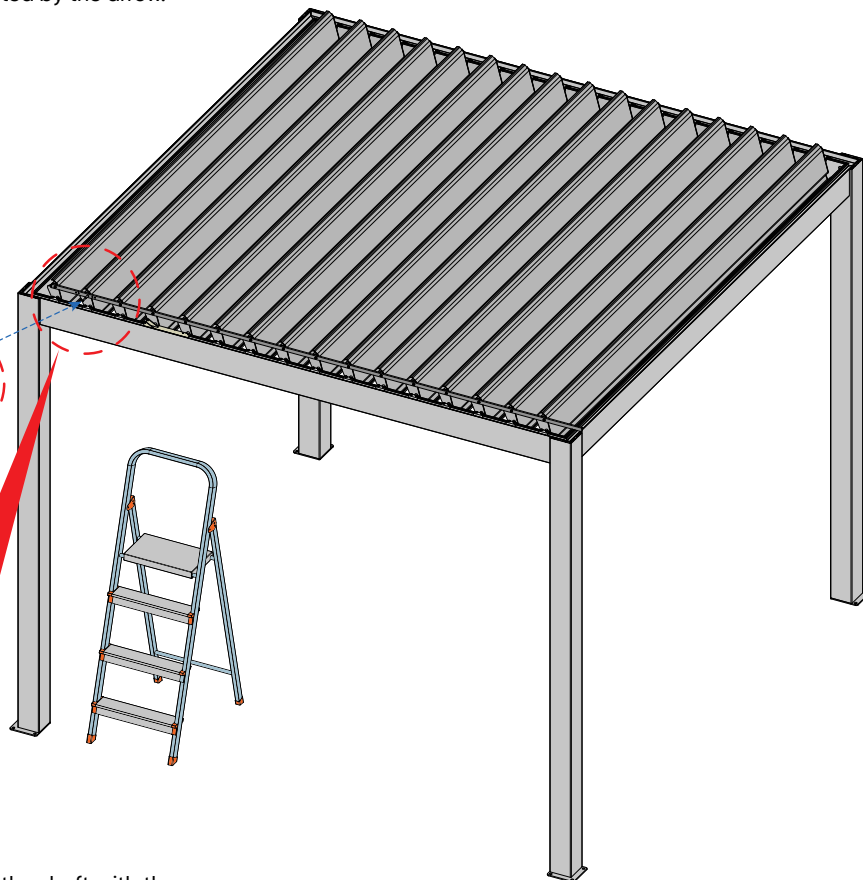
- » **29. Step:** Place the Linear Sheet Screws into the holes of the Linear Sheet as indicated by the arrow, and tighten them using a drill.



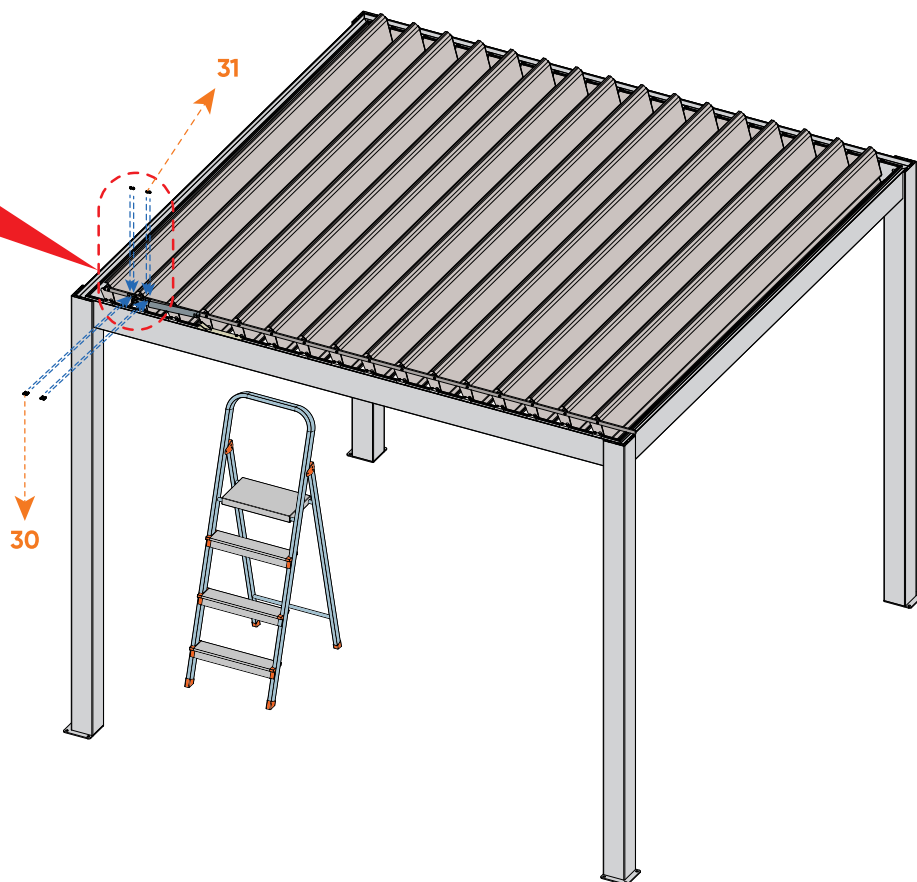
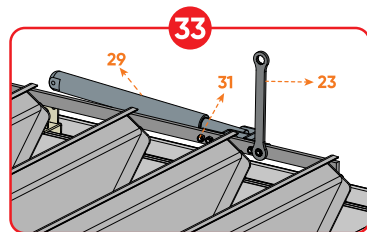
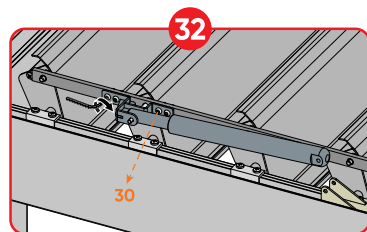
» **30. Step:** Assemble the Linear Motor parts as indicated by the arrow.



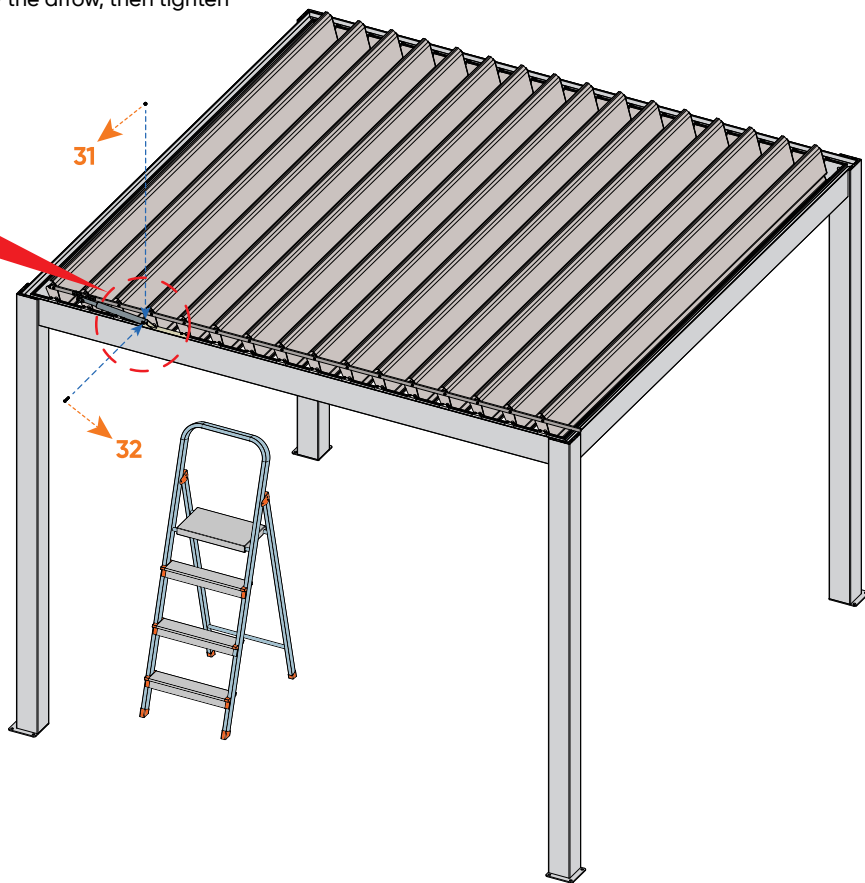
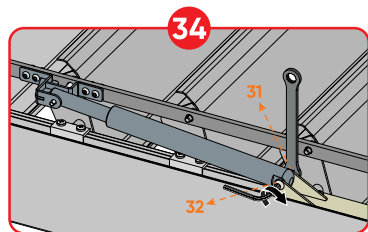
» **31. Step:** Pass the assembled Linear Motor through the shaft with the 25th flap, as indicated by the arrow.



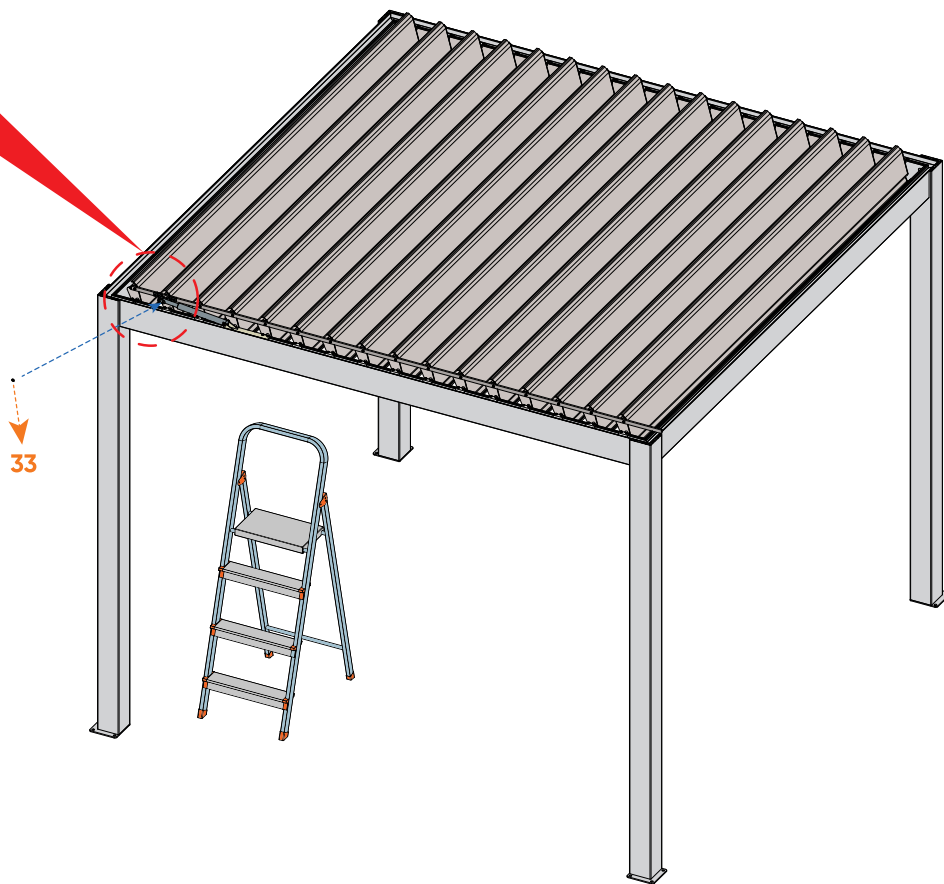
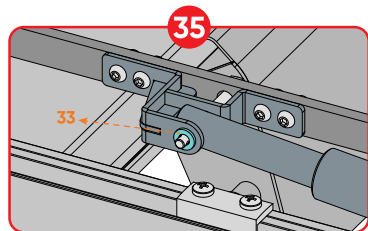
- » **32. and 33. Step:** Pass the Linear Motor bolts and nuts through the holes indicated by the arrow. Tighten the bolts using an Allen key and the nuts using a wrench.



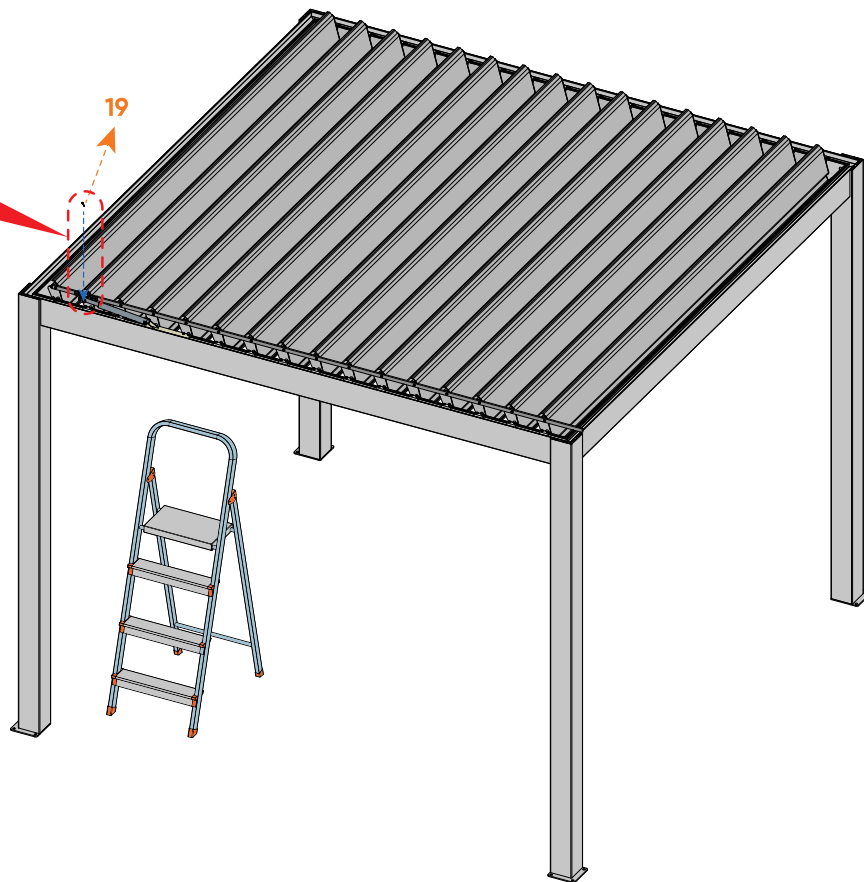
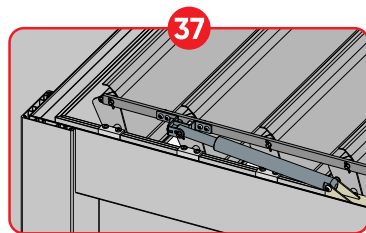
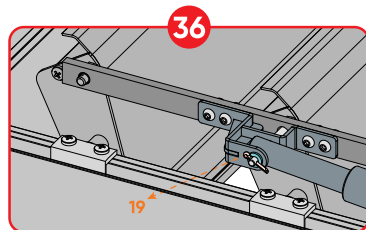
- » **34. Step:** Pass the 33rd bolt and 34th nut through the holes of the Linear Motor and Linear Sheet as indicated by the arrow, then tighten them using an Allen key and a wrench.



» **35. Step:** Place the 35th plastic washer in the area indicated by the arrow.



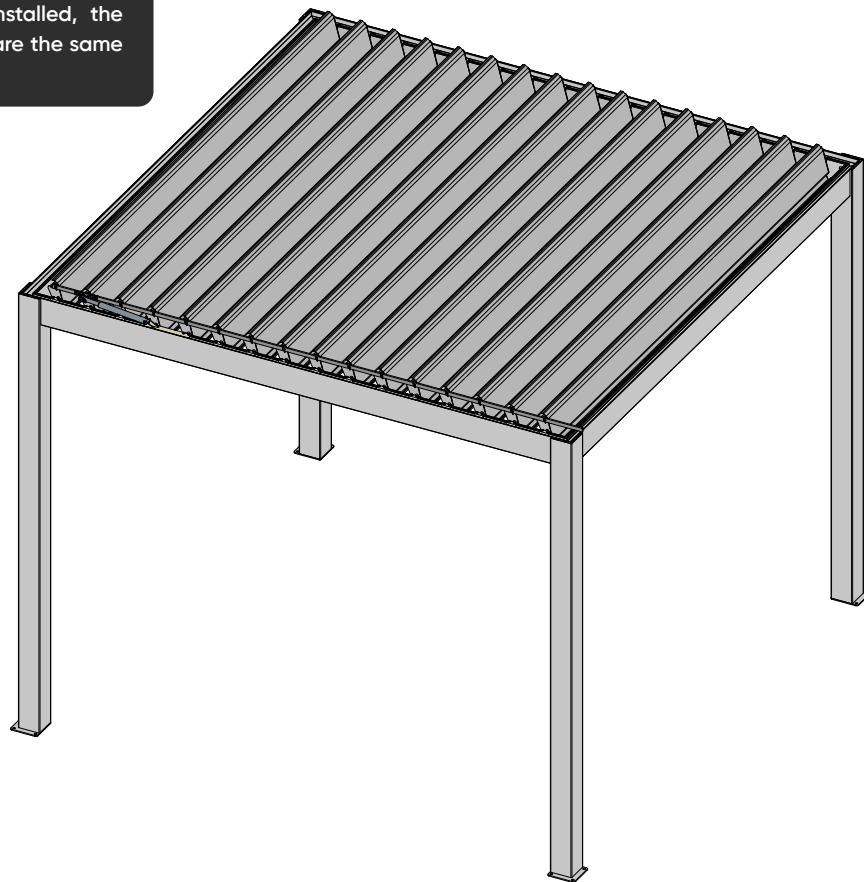
- » **36. and 37. Step:** Insert Cotter Pins into the Crank Connection Shafts as indicated by the arrow.



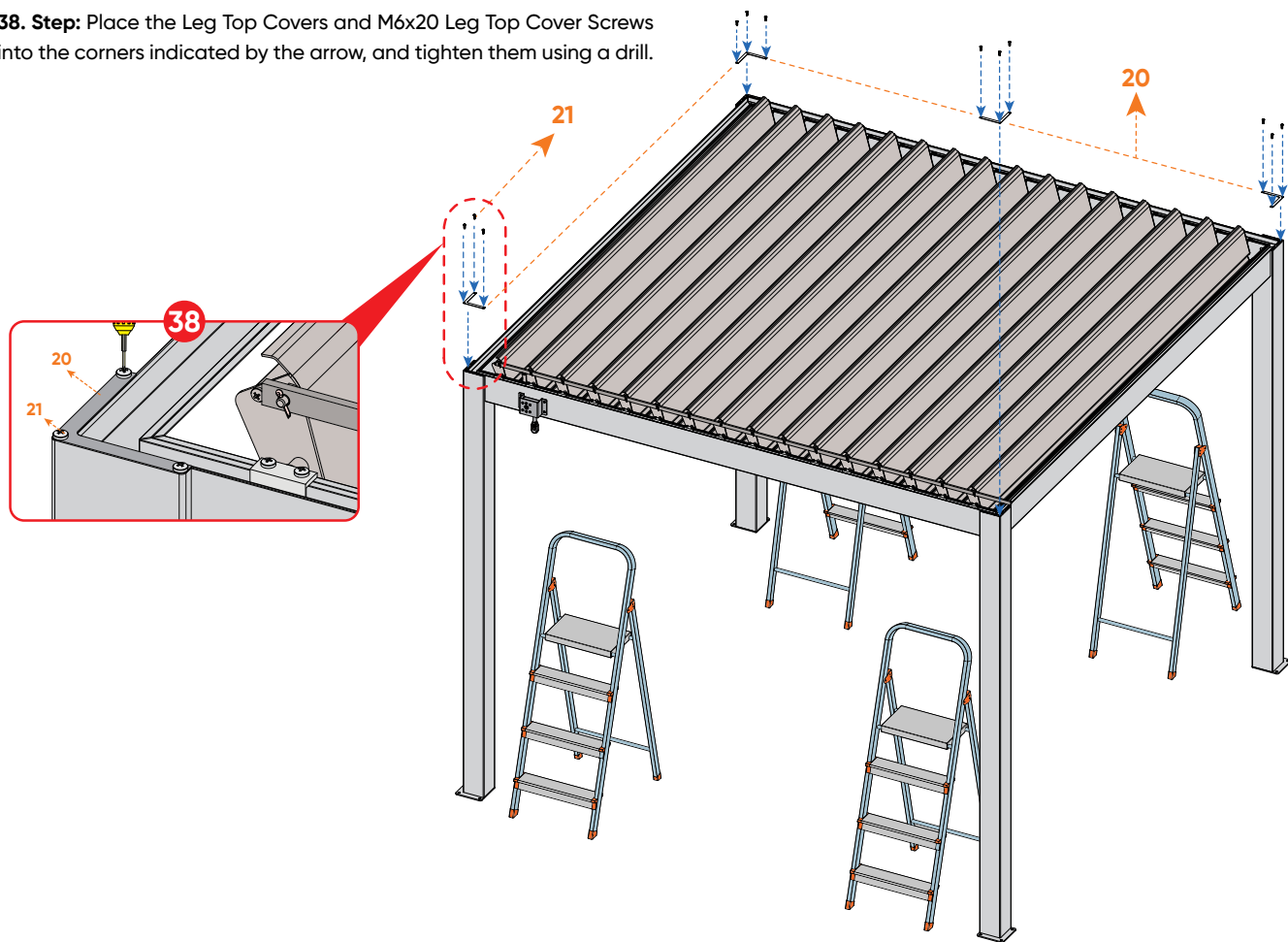


Caution!

After the couplings are installed, the remaining assembly steps are the same as with the geared motor.



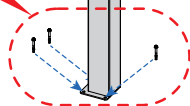
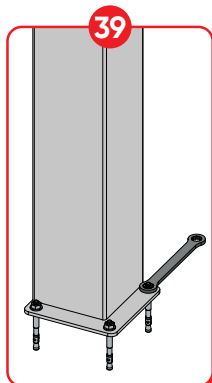
- » **38. Step:** Place the Leg Top Covers and M6x20 Leg Top Cover Screws into the corners indicated by the arrow, and tighten them using a drill.



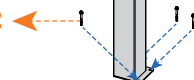


Warning!

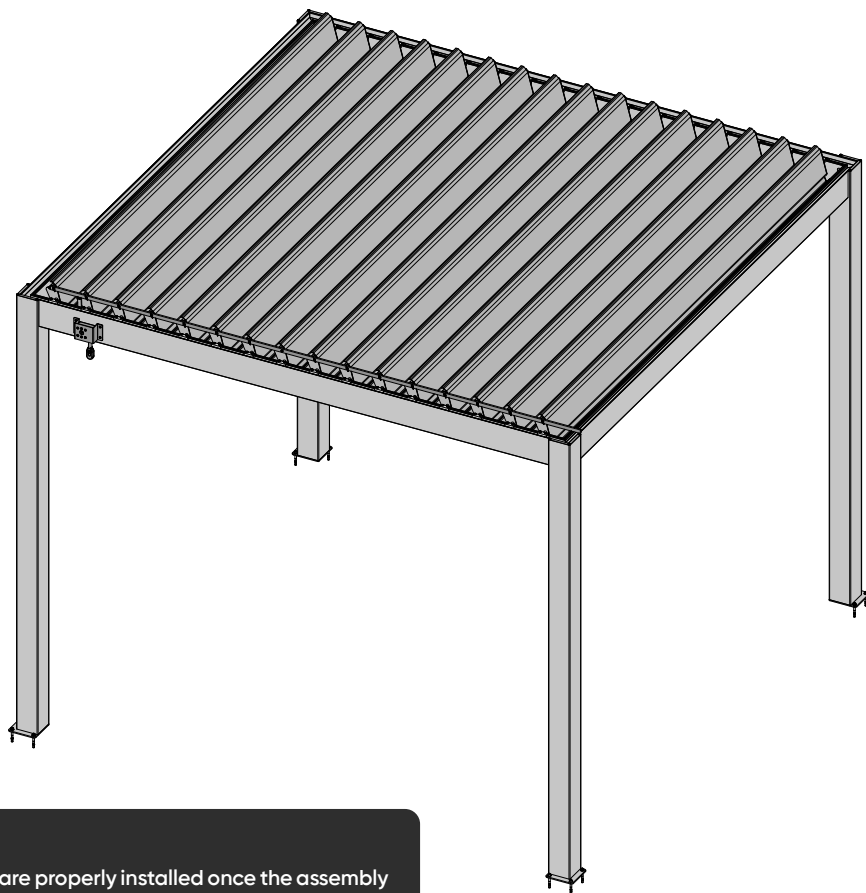
The 12 dowels attached to the leg anchors are the customer's responsibility. We recommend using M8x80 as the appropriate size.



22



- » **39. Step:** Insert 12 M8x80 Dowels into the anchor holes of the Leg as indicated by the arrow, and tighten them using a wrench.



Caution!

Check if all parts are properly installed once the assembly is complete.



PATIOSPHERE
Think Outside

