Aluminum, Non-Welded, Series 500 Pipe Railing and Series 550 Pipe Picket Railing are designed to take advantage of Aluminum's strength and easy maintenance. High quality Aluminum extrusions and castings are combined with concealed Fasteners to create the finest design.

Components are easily assembled - without welding - using mechanical Fasteners at intersections and Epoxy Structural Adhesive at splice joints. Meets 2010 ADA when properly specified and installed.

Series 500 and 550 Railings are available as factory assembled units made to your specifications. This results in on-site fabrication savings. Special curves or Pipe radii can easily be made to fit your job.

Posts and Top Rails are assembled to run in continuous lengths creating a system that is stronger than cast Tee and Cross connections. It provides a continuous, smooth Top Rail surface. The Series 550 Pickets are factory assembled with a tight drive-in-fit to the Top and Bottom Rails assuring squareness and stability. Pre-assembled sections - up to 24 feet - can be shipped factory-assembled or knocked-down for reassembly.

Series 500 and Series 550 are available in 1 1/2", Schedule 40 Pipe size - 1.90" outside diameter with a .145" wall thickness. Standard heights are 32", 36", 42" or 48" - custom heights available upon request.

A practical, sound investment for the budget-minded buyer.

**Finishes:**
Your choice of Anodized or baked-on enamel. These samples are for comparison only. Contact Wagner for actual color samples.

- **Mill Finish**
- **Anodized (A)**
- **Black (B)**
- **Dark Bronze (D)**
- **Green (G)**
- **Almond (L)**
- **Brown (N)**
- **Sandstone (S)**
- **Tan (T)**
- **White (W)**
- **Light Bronze (Z)**
- **Tan (T)**
- **White (W)**
- **Light Bronze (Z)**

Add the letter noted above to the end of the part number to indicate color choice. i.e., SA502B for Black; SA502A for Clear Anodized.

- **Durable Maintenance-free Pipe Railing.**
- **Quick and Easy to Install Without Welding.**
- **Concealed Fasteners.**

**Wall Bracket**
Color
Aluminum

**1 1/2" Schedule 40 Pipe**

<table>
<thead>
<tr>
<th>Color</th>
<th>OD</th>
<th>t</th>
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</thead>
<tbody>
<tr>
<td>Aluminum</td>
<td>1.90</td>
<td>.145</td>
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**Angle Tee**
Color
Aluminum

**Adjustable Angle Elbow**
Color
Aluminum

**90° 3-Way Elbow**
Color
Aluminum

**90° Elbow**
Color
Aluminum

**Bottom Step Post Elbow**
Color
Aluminum

**NUMBERS IN BOLD TYPE** are typically in stock. Other items may not be available for immediate shipment or are made-to-order - requiring a minimum quantity and a longer lead time. Visit shopwagner.com for availability.
135° 3-Way Elbow
- Color: Aluminum
- SA522

90° Miter Elbow
- Color: Aluminum
- SA506

Cover Flange
- Color: Aluminum
- SA509

Side Mount Flange
- Color: Aluminum
- SA540

Heavy Duty Base
- Color: Aluminum
- SA597

Wall Return
- Color: Aluminum
- SA519

Splice Connector
- Color: Aluminum
- 15 Foot Lengths
- SA517, SA517-15

Post Cap
- Color: Aluminum
- SA514

Angle Flange with Post
- Color: Aluminum
- SA518

Reinforcing Bar
- Color: Aluminum
- 30" Length
- Required for all commercial applications

Adjustable Bracket - External
- Color: Aluminum
- SA520

Wall Bracket - Internal
- Color: Aluminum
- SA520

Rail Elbow
- Color: Aluminum
- SA513

Top Step Post Elbow
- Color: Aluminum
- SA512

Provide Sketch with Required Angle (0°-135°).

Pipe sets over Wall Plate – must have clean, precise cut.

Wall Bracket – Internal Wall Plate sold separately.

Pipe sets over Bracket to adjust to length.

SA521

Wall Plate

Color BASE ONLY BASE WITH POST
- Aluminum
- SA541, SA523

30° Reinforcing Bar - SA597 - is required for all commercial applications.

Order Separately.

(Flat or 4/16° Ramp)

Order Separately.

Provide Sketch with Required Angle.

Provide Sketch with Required Angle (0°-41°).

For embedded mount, 30° Reinforcing Bar - SA597 - is required for all commercial applications.

Shipped with two SA517 Splice Connectors - order Epoxy separately.

2°
Series 500 Non-Welded Aluminum Pipe Railing

Railing Splices are designed for a tight press fit and must be compressed with a pliers to permit them to slip into the Pipe. The areas to be joined should be cleaned thoroughly. Mix 3M® Scotch-Weld® Epoxy according to manufacturer’s directions. Mix only enough that you can use within ½ hour. Apply Epoxy to inside surface of Pipe. Compress Splice Sleeve with pliers then slip into the Pipe. Wipe off excess Epoxy after components are properly joined. The areas connected together should be left undisturbed for eight hours – longer in cold weather. See page 29 to inside surface of Sleeve Pipe.

Attachment of tee fitting to a vertical post.

A through bolt is used in combination with two 90° tees for a cross connection.

Tee Fittings
To attach the Tee Fitting to the Post, a self-tapping, Stainless Steel, Hex Head Screw with Lockwasher is positioned through the Fitting and threaded into the Post. Use of a thread Adhesive – i.e., Lido-Weld on page 29 – is strongly recommended. When two 90° Tees are located directly opposite each other to form a Cross, a Stainless Steel Through Bolt, Lockwasher and Locknut are used – SA524 and SA525.

Mounting Options
Pipe or Picket Railing can be embedded in concrete and grouted, or mounted on decks and platforms with Base Flanges, or side-mounted on fascia or stringer by means of Fascia Flanges.

Embedded Post
• Cover Flange.
• 30° Reinforcing Bar – SA597 – is required in all commercial applications. • ¼" Weep hole at ½" above Flange.
• Minimum depth: 4" (5" to 6" preferred).
• 3½" Minimum from center of Post to edge of slab.
• 1½" Minimum from edge of hole to edge of slab.
• 1" Minimum grout pad.
• Set into place with Rockite® or Kwixset® Anchor Cement.

Expansion Joints
For continuous spans in excess of 40 feet, expansion joints should be provided. To make an expansion joint, one end of a spliced joint should not have Structural Adhesive applied so that it is free to move in or out of the Pipe. If a joint is provided every 30 feet, the width of the gap should allow ¼" expansion for each 40 °F of expected temperature rise. All Pipe Railing splices should be made no more than 12" from the nearest Post.

Materials
All Rails and Posts are produced from extruded, 6063-T6 Aluminum Pipe, ¼" Schedule 40 – 1.900" outside diameter with a .145" wall thickness. Where there are Formed Elbows, 6063-T4 Alloy is used. All Railing accessories are cast from ANSI 713 Alloy. Fasteners used in the system should be Aluminum or Stainless Steel.

Rigidity
Post spacing is not to exceed 6'-0", center-to-center. All Posts will be single, unspliced Pipe length. Lower Rails should be single, unspliced lengths between Posts. All Top Rails shall be continuous whenever possible. All Fasteners should be tightened so that the completed Railing is rigid and free of play at joints and component attachments.

Durable, maintenance-free, Pipe Railing that is quick and easy to install – Without Welding.

Consider the Advantages . . .
• No rusting - No painting.
• Unlimited designs.
• Easy installation without welding.
• Durable and functional design.
• Strong and decorative.
• Saves on installation and maintenance labor.

. . . and the Possibilities
• ADA Ramps
• Condominiums
• Industrial Buildings
• Stores
• Waste Water Treatment Plants
• Nursing Homes
• Municipal Buildings
• Schools
• Office Buildings
• Motels
• Churches
• Hospitals
• Factories
• Amusement Parks
• Restaurants
• Swimming Pools
• Cafeterias
• Residential

ISO 9001:2008 F 414 214 0450 • P 414 214 0444 • T 888 243 6914
Series 550 Pipe Picket Railing

Finishes:
Your choice of Anodized or baked-on enamel. These samples are for comparison only. Contact Wagner for actual color samples.

Pre-assembled Post Design Selections
Pre-assembled Posts have 30" Aluminum Reinfocing Bar for strength. Mounting and spacing to be determined. Contact Wagner with your Post style, dimensions and mount option.

Picket Railing Design Selections
3/4" Round; 4 1/2" On Center.

3/4" Pickets
16' Lengths. Select from available colors above. Part of the Series 550 Picket System.

Rockite® Anchor Cement
Gypsum-based Follow package instructions.

For interior applications use Rockite. For exterior applications use Kwixset. Refer to page 63 for more information on Rockite and Kwixset Cements.

Note: To avoid corrosion, Aluminum should be kept from directly contacting Portland-based cement by painting with a heavy coat of bituminous paint or an appropriate primer.