

MEMO 550

BSF – PRACTICAL ADVICE FOR UNITS IN  
PAIRS

PRODUCTION

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## BSF – PRACTICAL ADVICE FOR UNITS IN PAIRS

When using units in pairs it is important to ensure correct/identical distance between the units in both the beam and the column. It is also important to ensure the reference levels are identical for both units. This may be achieved in the following way:

Make a steel template. Two protruding plate with thickness: BSF knife +3mm, shall pass through a vertical supporting steel plate mounted on a base plate. The protruding plates must be parallel and at right angles to the supporting plate. The slots in the supporting plate must be ground, in order for the welds between the supporting plate and the protruding plates to be completely hidden within the steel sections. (see section A-A). One side of the steel template is used to align the column units, while the opposite side is used for the beam units.

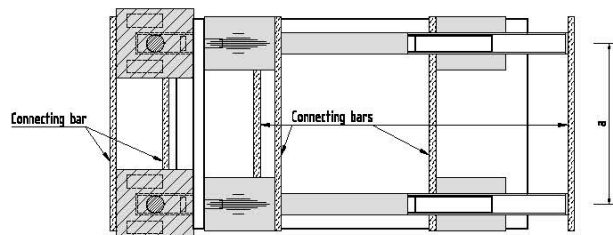
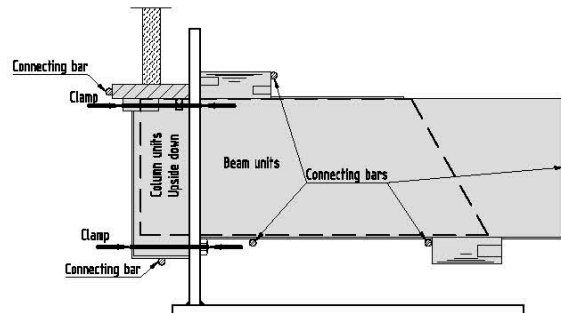
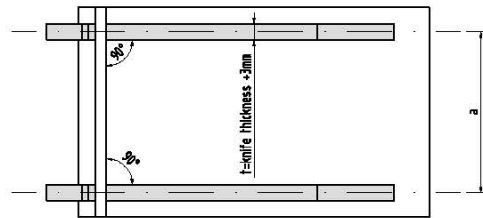
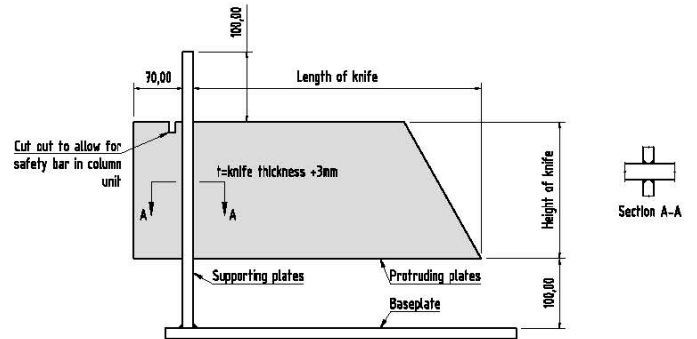
The column units are to be placed upside down on the template. This ensures the bottom plates (to be used as reference level) are lined up at the same level.

For the beam units, the bottom of the half round steel is the reference level. Thus, the beam units can be placed directly on the template and not upside down.

When the units are aligned, and temporarily clamped, they may be connected by welding a reinforcement bar (or another connection device) between the units.

The distance «a», c/c units, may be found from calculations. However, the distance is not recommended less than:

ENHET	a [mm]
BSF225	230
BSF300	230
BSF450	280
BSF700	450



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REVISION HISTORY	
Date:	Description:
02.12.2013	First Edition.
24.05.2016	New template.