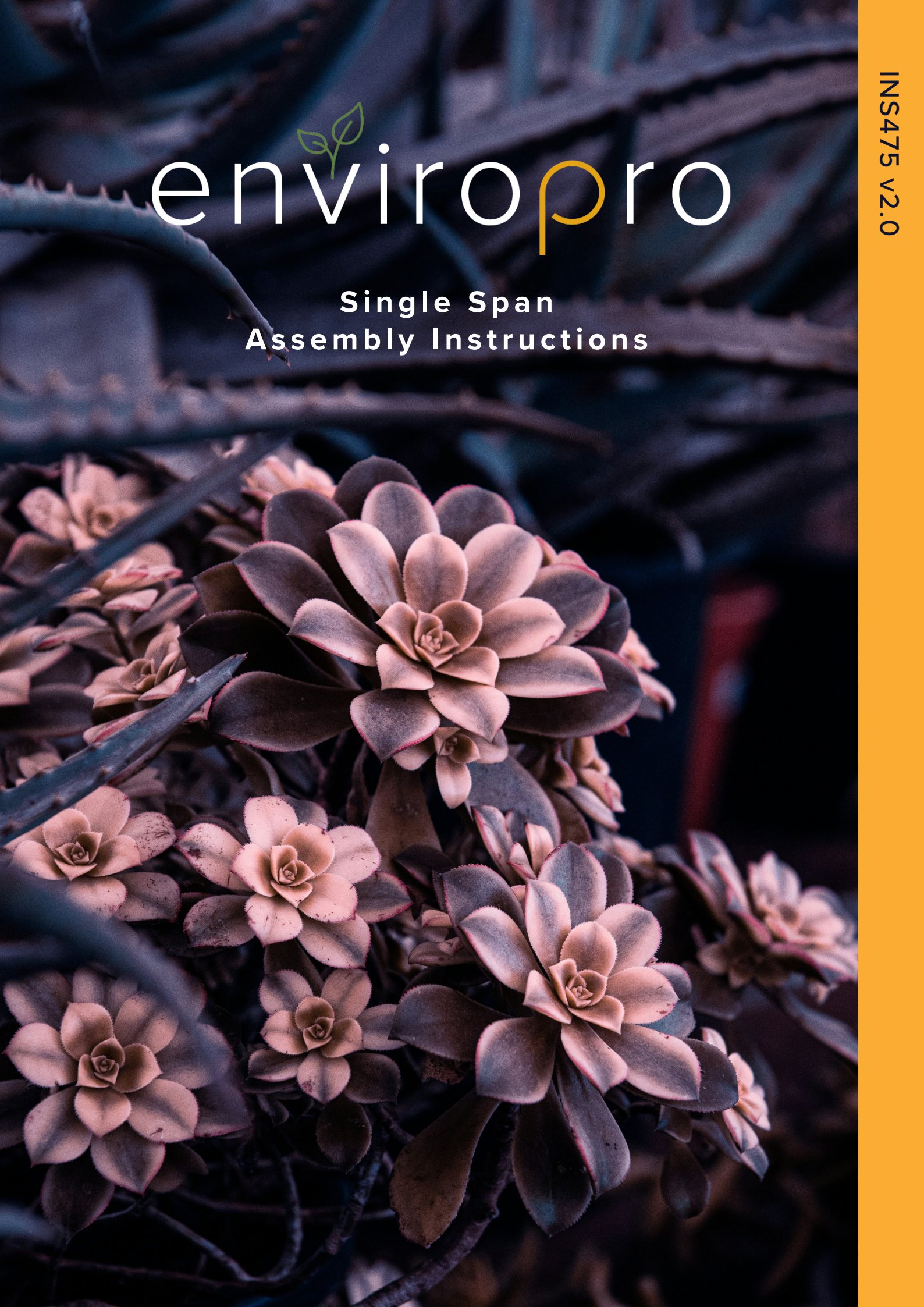




envirop^{ro}

Single Span Assembly Instructions

INS475 v2.0

Thank you for purchasing your EnviroPro Single Span polytunnel

Before you begin:

- Check that all parts are present
- Read the instructions

Your safety matters

Please take care during construction and follow all guidance provided.

Need help?

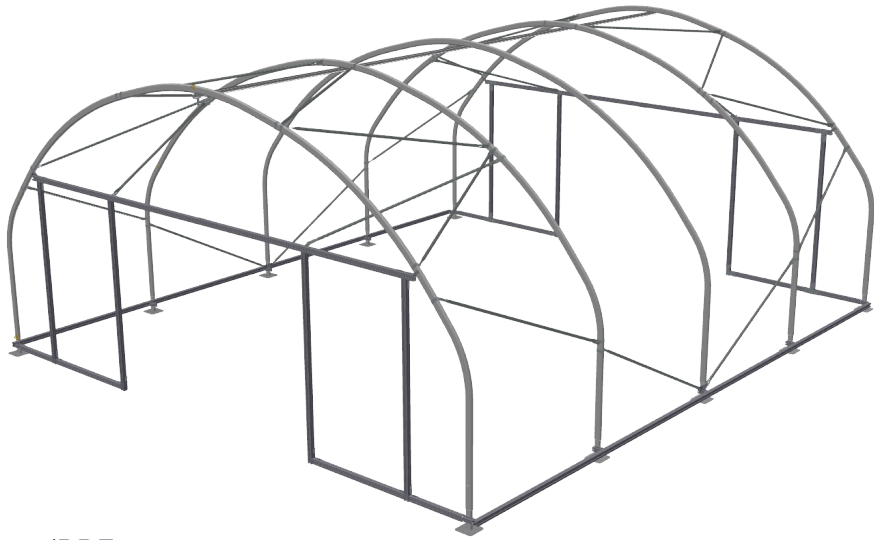
-  01282 873 120
-  info@npstructures.co.uk
-  northernpolytunnels.co.uk

 **Important**
Failure to follow these instructions may compromise the structural integrity of your polytunnel.

NP Structures Ltd accepts no liability for damage resulting from misuse or failure to follow instructions.

 Drawings are not to scale.

 **Tools Required**
Stakes/Pegs
Spirit Level
Spade
Tape Measure
Marker Pen
String
Hammer
Stanley Knife
Battery Drill
Angle Grinder
Wire Cutters
Spanners
Gloves
Goggle/Eye Protection/PPE
G-clamp



Code	Description
HNP100	Hex Nut Plain M10
HNN600	Hex Nut Nylock M6
HNN100	Hex Nut Nylock M10
HNF600	Hex Nut Flanged M6
HNF800	Hex Nut Flanged M8
HNF100	Hex Nut Flanged M10
CSB840	Cup Square Bolt M8 x 40mm
CSB850	Cup Square Bolt M8 x 50mm
CSB865	Cup Square Bolt M8 x 65mm
CSB880	Cup Square Bolt M8 x 80mm
CSB815	Cup Square Bolt M8 x 140mm
HBT607	Hex Bolt M6 x 70mm
HBT107	Hex Bolt M10 x 60mm
HBT811	Hex Bolt M8 x 110mm
HBT114	Hex Bolt M10 x 110mm
HSS101	Hex Set Screw M10 x 20mm
HSS104	Hex Set Screw M10 x 35mm
BHS602	Button Head Screw M6 x 16mm
ECB32	Exhaust Clamp Bracket 32mm
ECB42	Exhaust Clamp Bracket 42mm
ECB50	Exhaust Clamp Bracket 50mm
SAR107	Sleeve Anchor M10 x 100mm (Concrete bolt)

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Tools needed: tape measure, string, spirit level, markers/canes

Planning Foundations

Use the diagram on the next page to lay out your foundations accurately

Choose a level, even site where possible. Avoid stony ground, especially if trenching in the polythene, as this may cause damage. Allow at least 1 metre of working space around the structure.

To mark out the site

- Use string (thin polypropylene twine) and pegs to plan out your foundation positions
- Use the table provided to check the diagonal and hoop spacing measurements — this ensures your layout is square.
- Mark the stringline at each hoop position and place a ground tube at each mark.

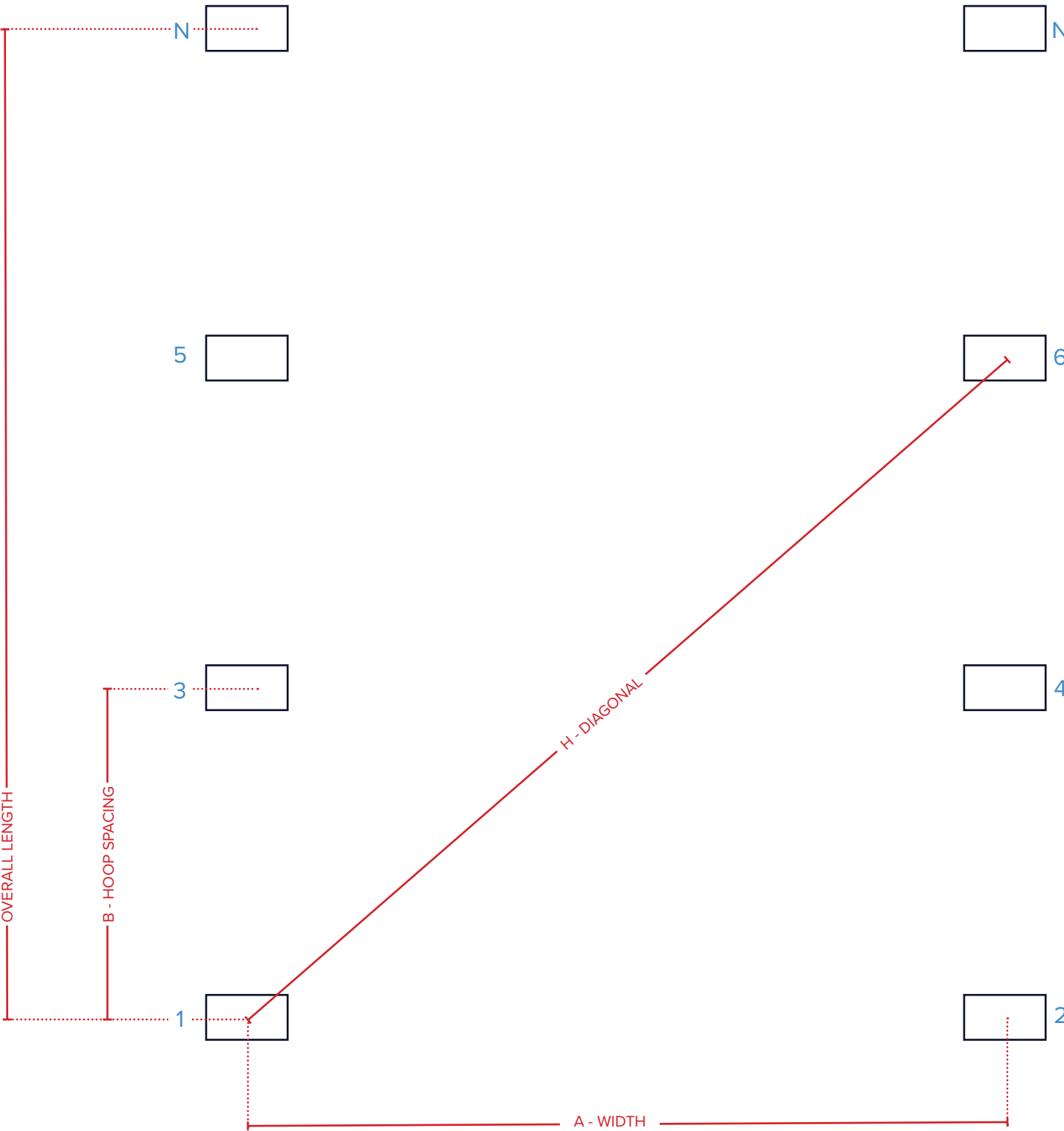
i The diagram is for illustrative purposes only. Repeat the layout process according to the number of hoops you have ordered.

i All measurements are taken from the centre of the foundation.

Foundation Measurements

Tunnel Width	A - WIDTH Centre to Centre	B - HOOP SPACING Centre to Centre	H - DIAGONAL Centre to Centre
5 metres	5000mm	2500mm	7071mm
6 metres	6000mm	2500mm	7810mm
7 metres	7000mm	2000mm	8062mm
8 metres	8000mm	2000mm	8944mm
9 metres	9000mm	2000mm	9849mm

N = last hoop

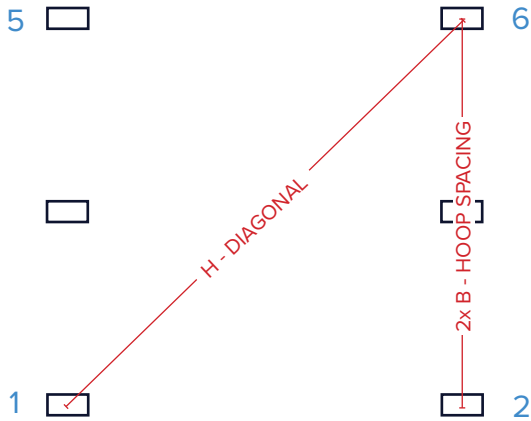


Method

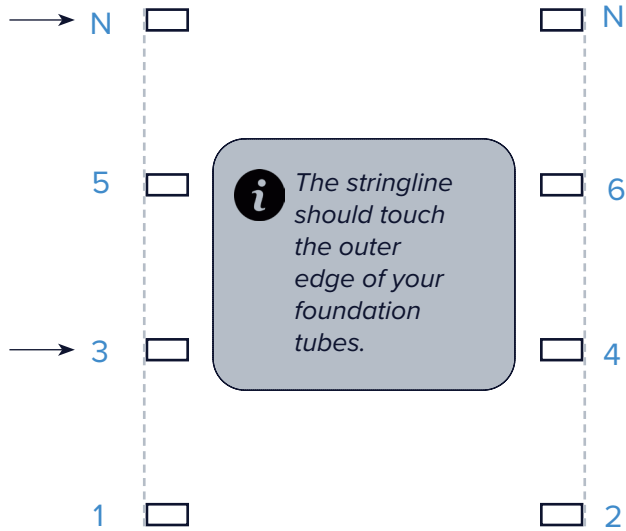
You may wish to mark out your foundation placement with markers or stakes before positioning the actual foundations. For “Foundation Measurements” see page 6.



1. Position foundations 1 and 2.
Check **A - WIDTH** is correct.
Check alignment of the two foundations.

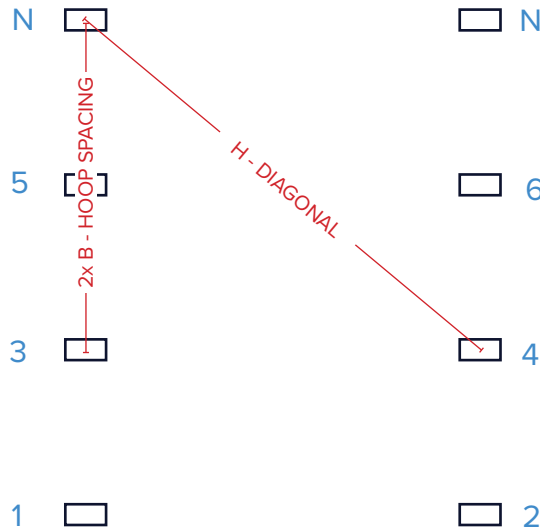


2. Position foundation 6
Check **H - DIAGONAL** is correct.
Check **2x B - HOOP SPACING** is correct.
Repeat for foundation 5.



3. Stringline the length of the tunnel from 1 and 2 to last foundations (**N**).

Use the stringline to help you place your last foundations (**N**) as well as any other foundations e.g. 3 and 4.



4. Check alignment of the far end of your polytunnel:

Check **H - DIAGONAL** is correct.
Check **2x B - HOOP SPACING** is correct.
Repeat on each end foundation.

Installing Base Plate Foundations

1. Position the Base Plates

Use your string line as a guide. For “Foundation Measurements” see page 6.

2. Mark and Drill

Mark the position of the four fixing holes on each base plate.

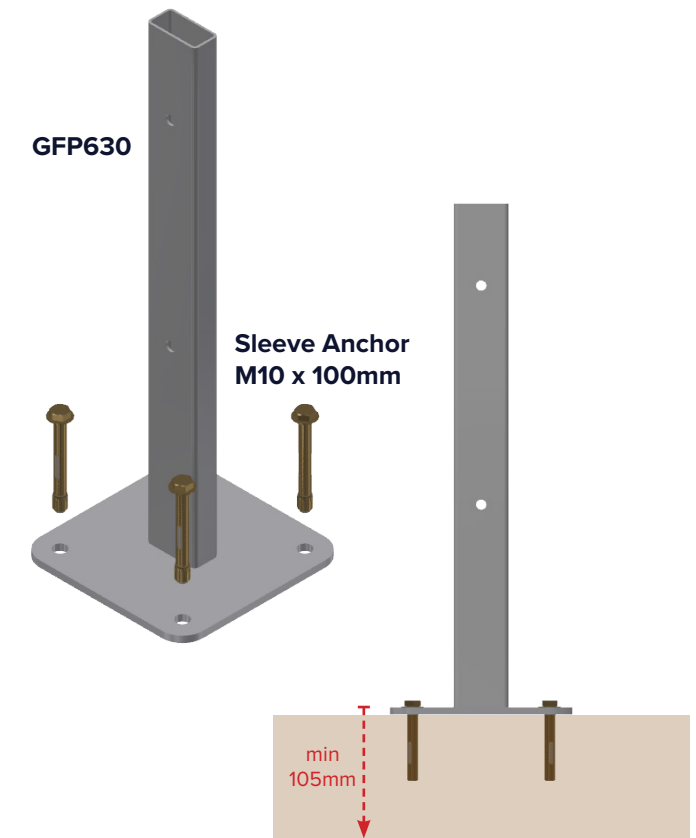
Drill four holes per plate: **12mm diameter x 100mm** deep into the concrete.

Vacuum out dust from each hole to allow full depth insertion of the anchor bolts.

3. Fix in Place

Insert the sleeved anchor bolts through the base plate and into the holes.

Hammer them fully in, then tighten the bolts securely.



! It is essential that the anchor bolt sleeves are fully inserted to ensure a secure fit.

For “Installing Concrete Foundations” see page 10



Installing Concrete Foundations

1. Dig the Foundation Holes

Follow the diagram for hole size. For “Foundation Measurements” see page 6.

Ensure holes are evenly spaced and aligned.

2. Pour Concrete into Each Hole

Recommended: ready-mix GEN3, 20 N/mm², 60mm slump.

3. Set the Ground Tubes (GFT630) in Concrete

Insert a concrete bar into the bottom hole of the foundation, then position the ground tubes in the concrete and align them using a string line - they must be straight and level.

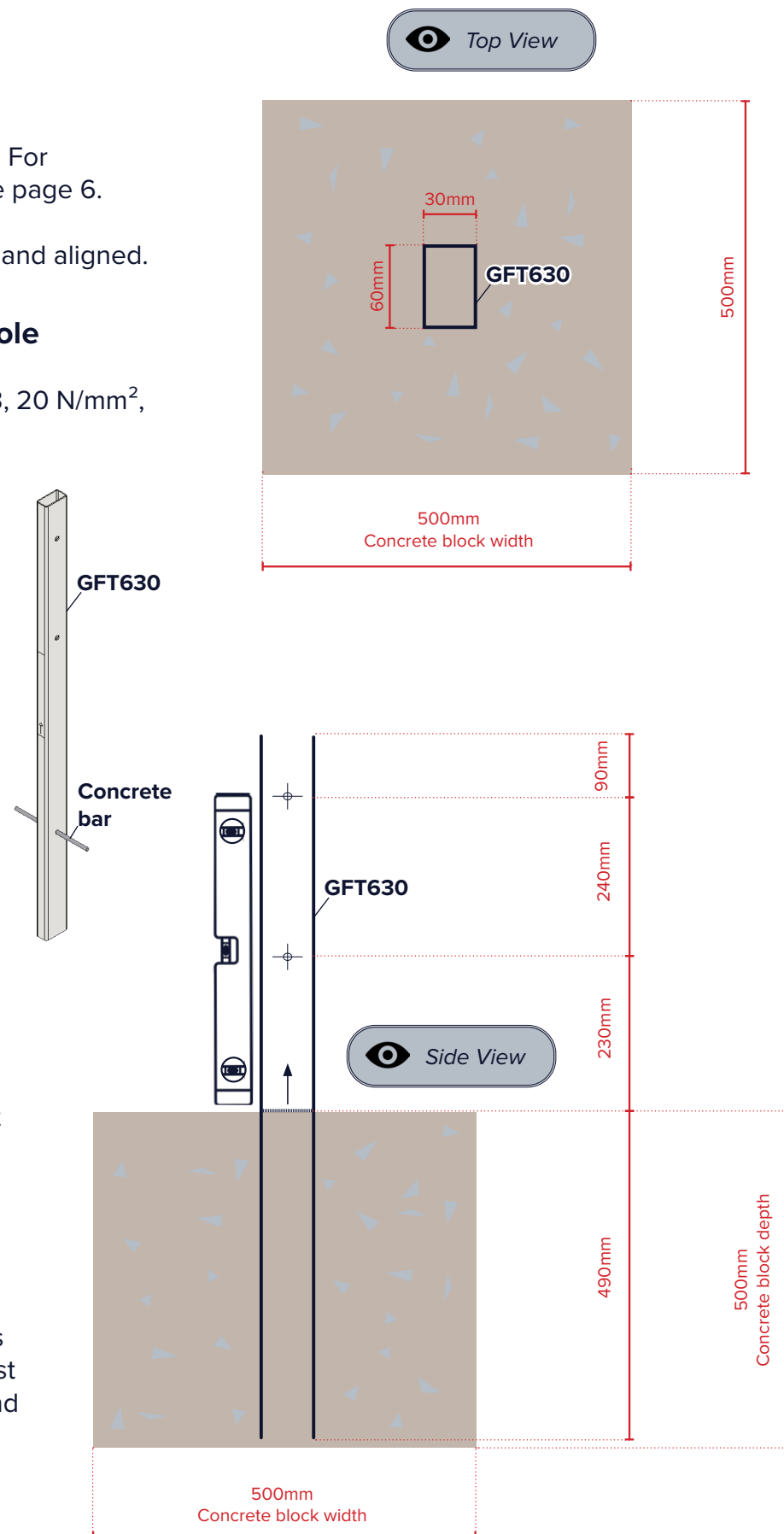
i Ground level is etched onto ground tube. Arrow pointing up.

4. Allow Concrete to Set

Let the concrete cure for at least 48 hours (longer in cold or wet weather).

5. Mark the End Frame Lines

Once set, run a string line across the inside face of the first and last hoop to mark the lines for the end frame uprights.



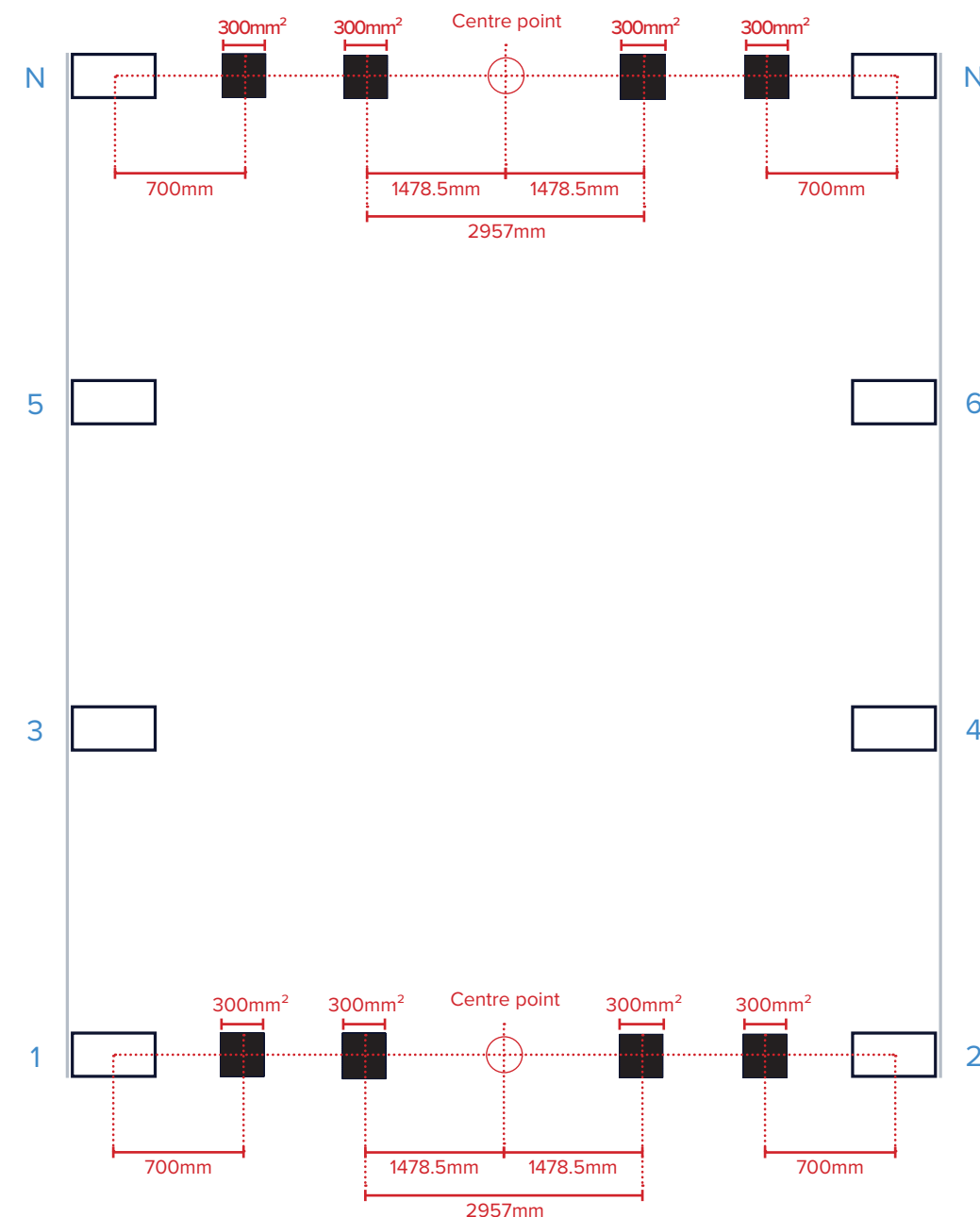
Digging Holes For End Frame

At each gable end, mark the post positions as shown in the diagram. Then dig:

- Two 300mm² holes for the door frame posts
- Two 300mm² holes for the outer upright posts (not required on 5m tunnels)

All holes should be 300–400mm deep.

N = last hoop

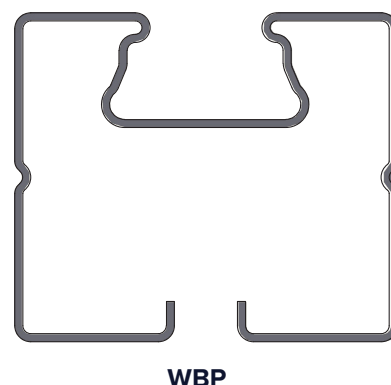


Familiarise Yourself With The Steel Box Profile

This steel box profile (WBP) is used throughout the construction of your EnviroPro Single Span Polytunnel, including end frames, base rails, side rails. It is useful to familiarise yourself with this profile to avoid confusion.

The top (larger) channel is for wiggle wire which is used for attaching the cover. The bottom (smaller) channel is used to slide M8 bolts with cotter in for fixing brackets.

The top wiggle wire channel should be on the outside of the tunnel, and the bolts should be on the inside.

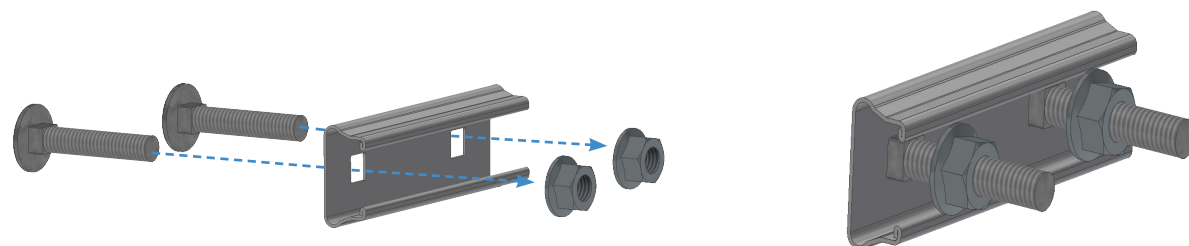


Using Cotters

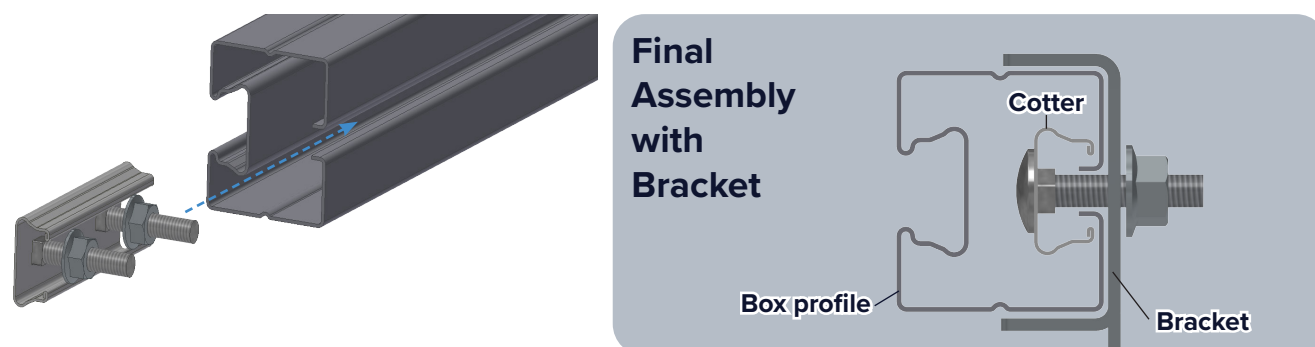
Cotters are used throughout for attaching brackets to the steel box profile. Cotters come in various sizes.

1. Assemble cotter, bolts, and bracket

2. Finger tighten cotter



3. Slide cotter and bracket assembly into box profile



Take note of the cotter positions at each stage of the build.

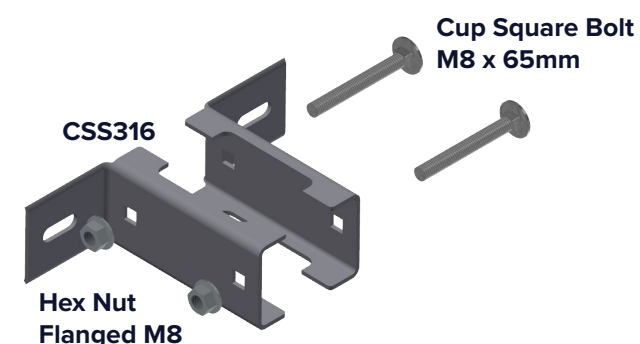
It isn't possible to retrofit cotters, therefore it is critical that cotters are in position before the section is fitted to the frame.

Pack(s): CSS206, CSS204

Bracket Assembly

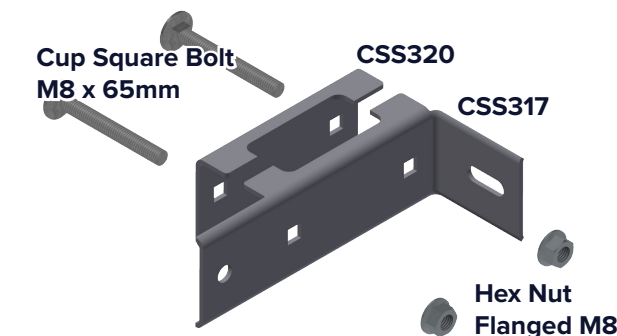
Inner Hoop Foundations = a

x2 per hoop



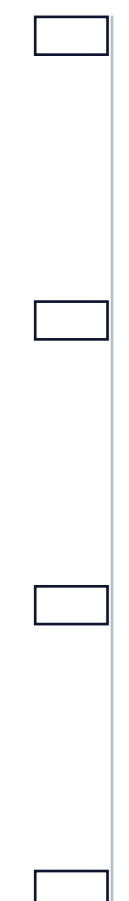
End Hoop Foundations = b

x4 total



Bracket Layout

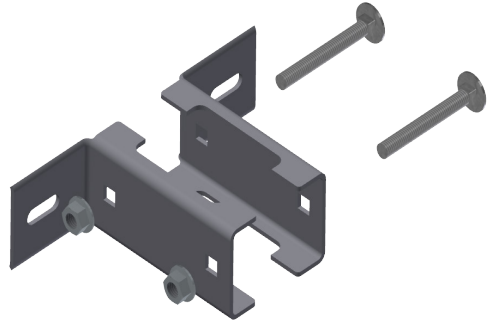
Loosely place parts into position.



For all inner hoop foundations (a)

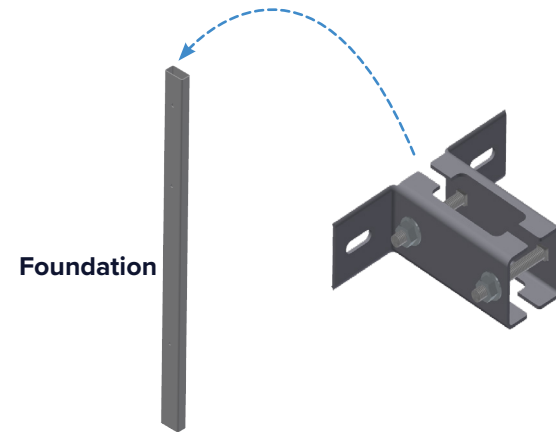
i Leave bolts hand-tightened at this stage.

1. Loosely assemble inner hoop base rail bracket

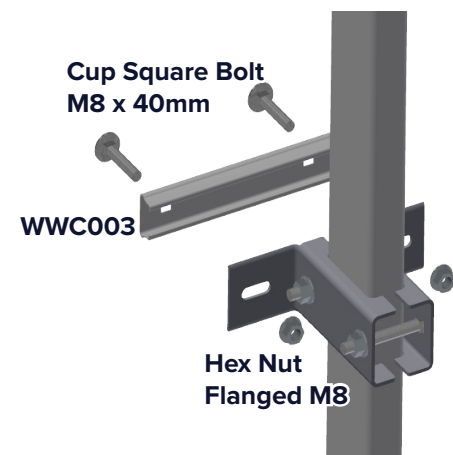


For "Bracket Assembly" see page 13

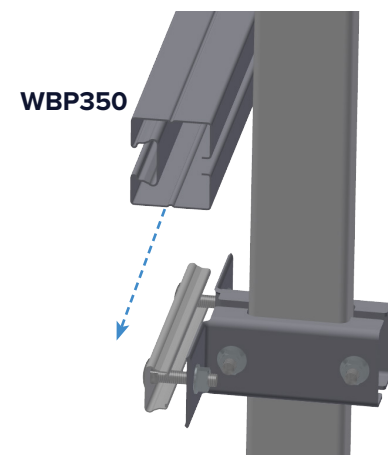
2. Slide bracket onto inner foundations



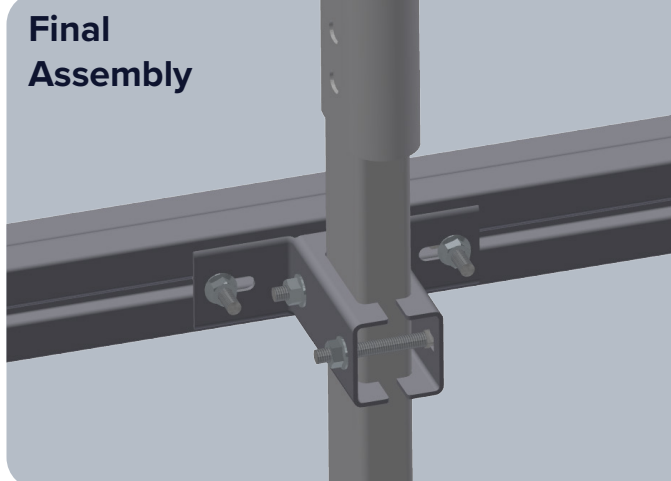
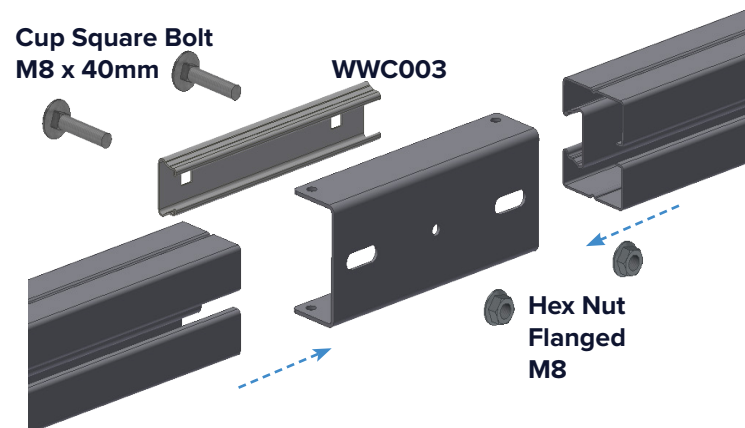
3. Loosely attach cotter



4. Slide base rail onto brackets



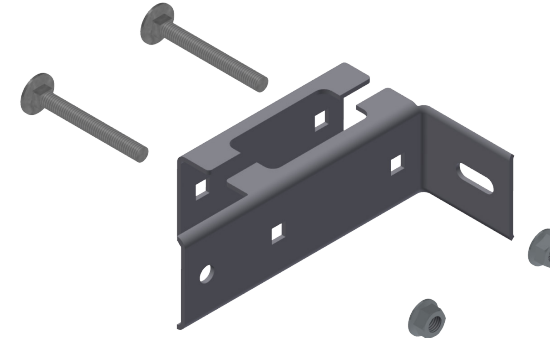
Join base rail profiles when required



For all end hoop foundations (b)

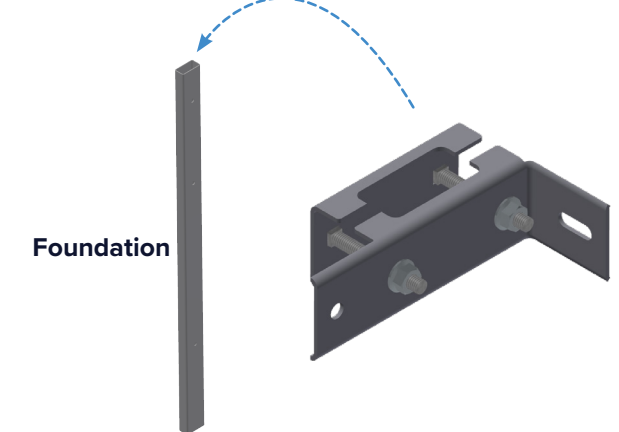
i Leave bolts hand-tightened at this stage.

1. Assemble end hoop base rail bracket

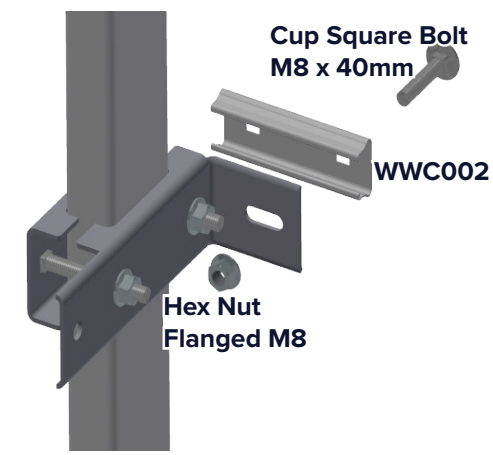


For "Bracket Assembly" see page 13

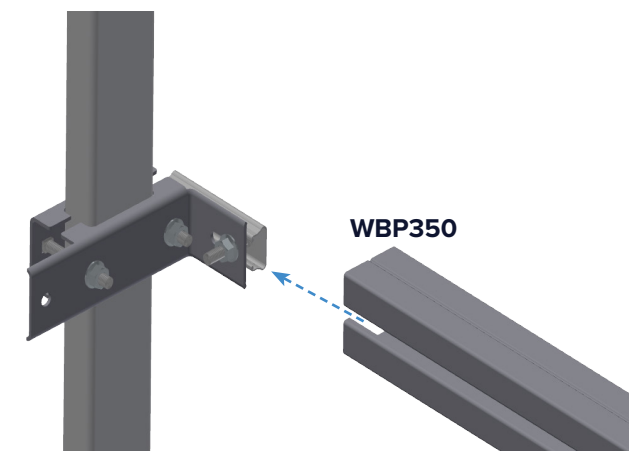
2. Slide bracket onto end hoop foundations



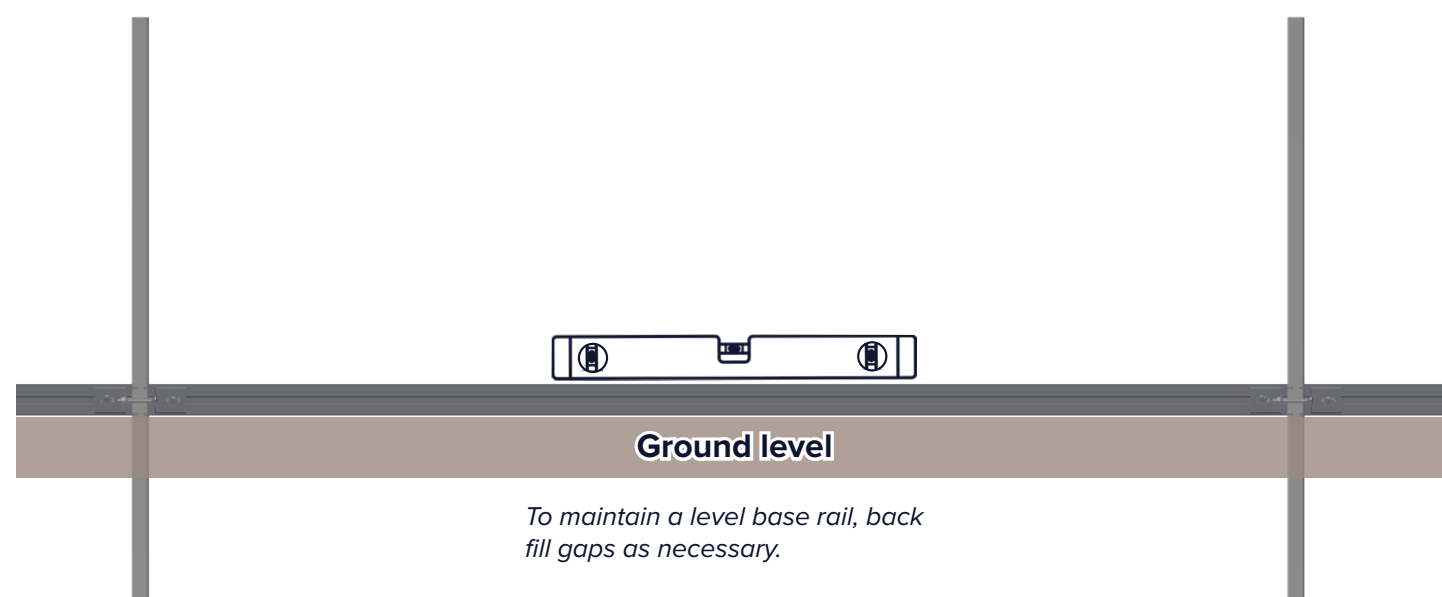
3. Loosely attach cotter



4. Slide base rails onto corner brackets



Level and tighten base rails



i Maintaining a level base rail is of particular importance if you have side ventilation.

Hoop Assembly

Hoop parts

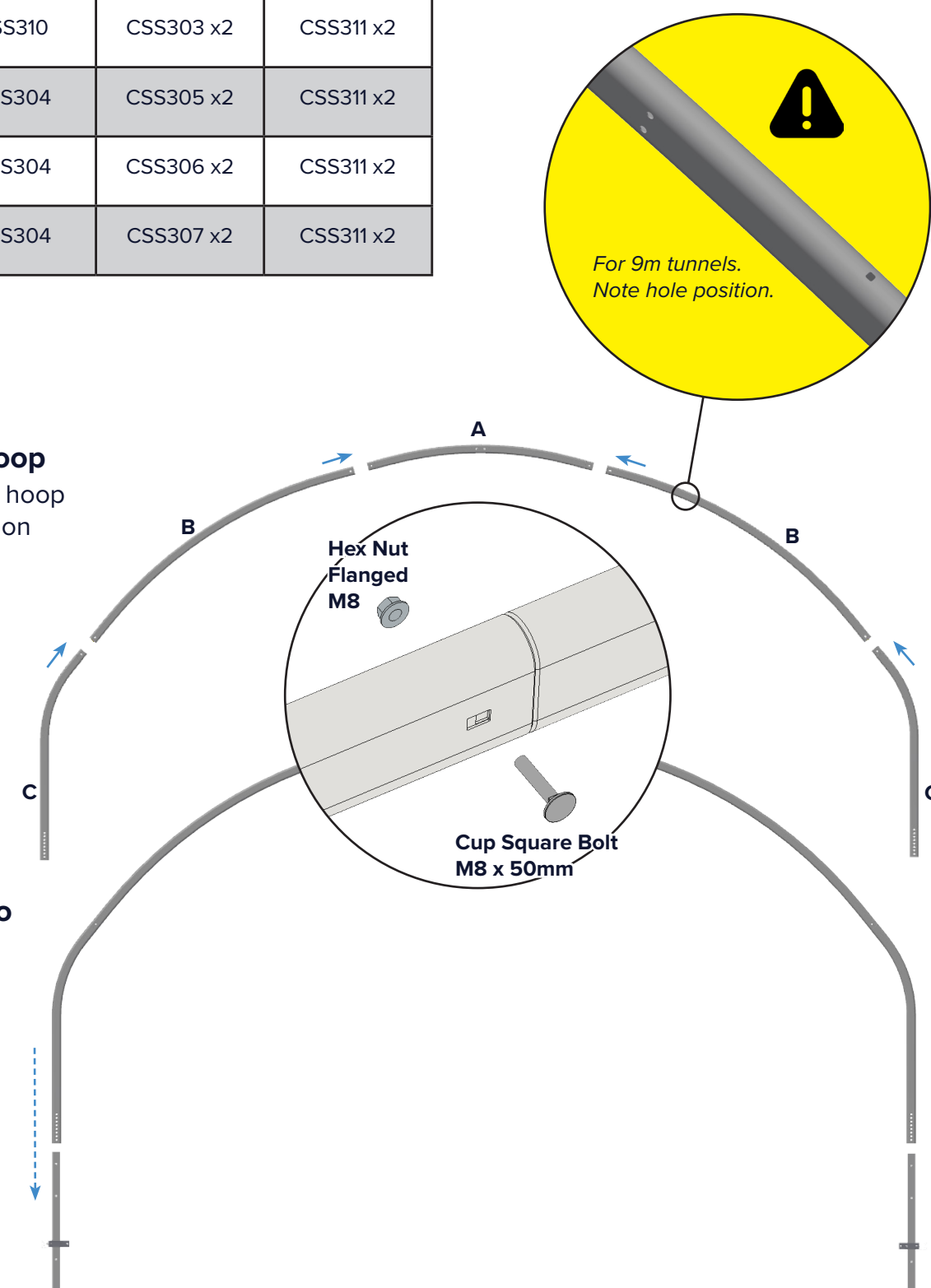
Width	A	B	C
5 metre	CSS310	CSS301 x2	CSS311 x2
6 metre	CSS310	CSS303 x2	CSS311 x2
7 metre	CSS304	CSS305 x2	CSS311 x2
8 metre	CSS304	CSS306 x2	CSS311 x2
9 metre	CSS304	CSS307 x2	CSS311 x2

For each hoop

1. Slot together hoop

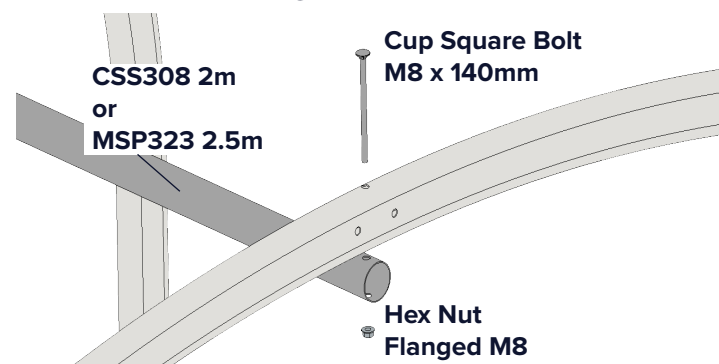
Slot together 5 piece hoop and fix each connection with nut and bolt.

2. Slide hoop onto foundation tubes



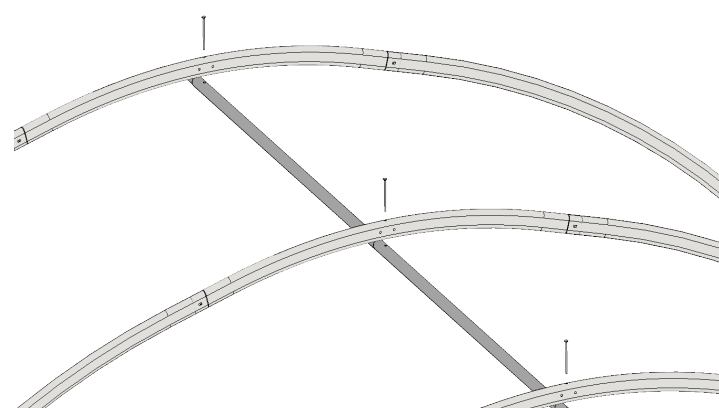
Install Ridge Bars

1. Attach first ridge bar



Starting at the front hoop, attach first ridge bar piece (CSS308) to hoop using nut and bolt.

3. Fasten ridge tubes to hoops



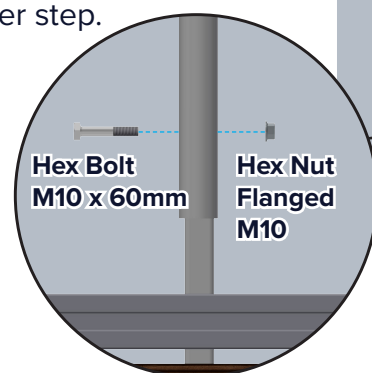
...and attach to hoop with nut and bolt. Continue for each hoop.

Raise Two Outer Hoops

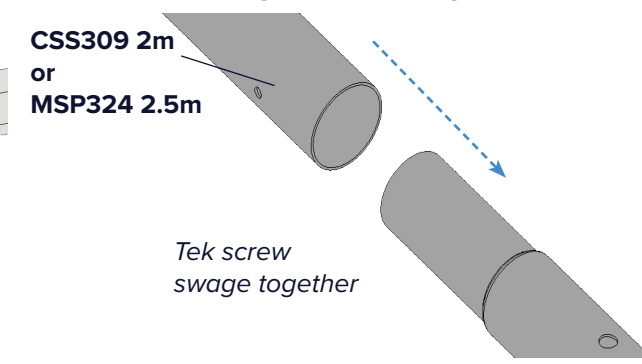
Lift the two outer hoops by around 100mm and fix in place.

Leave all inner hoops at lowest level.

We'll use this for tensioning the cover in a later step.

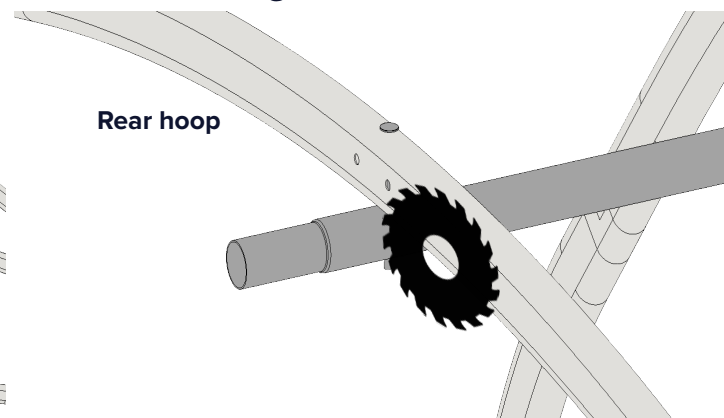


2. Connect ridge tube lengths

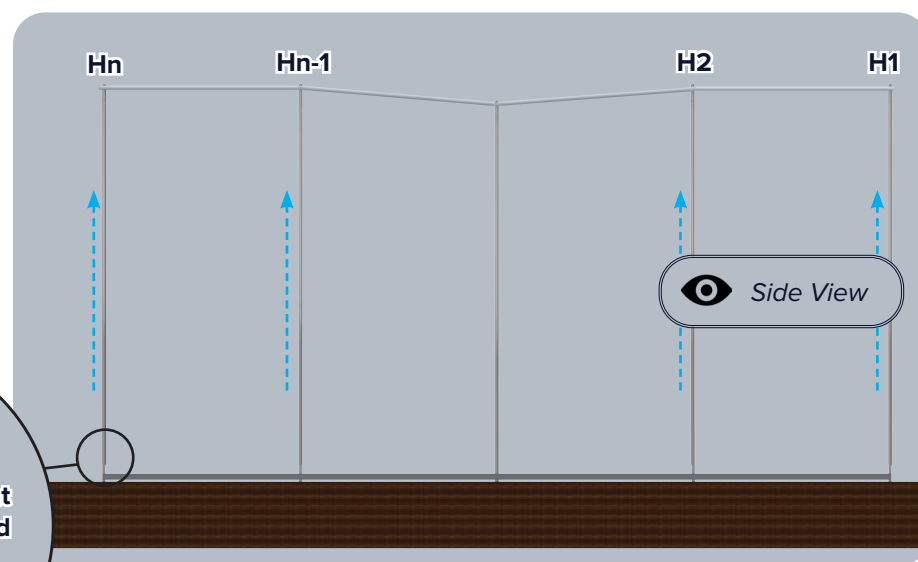


For each inner hoop, connect a length of ridge tube (CSS309)...

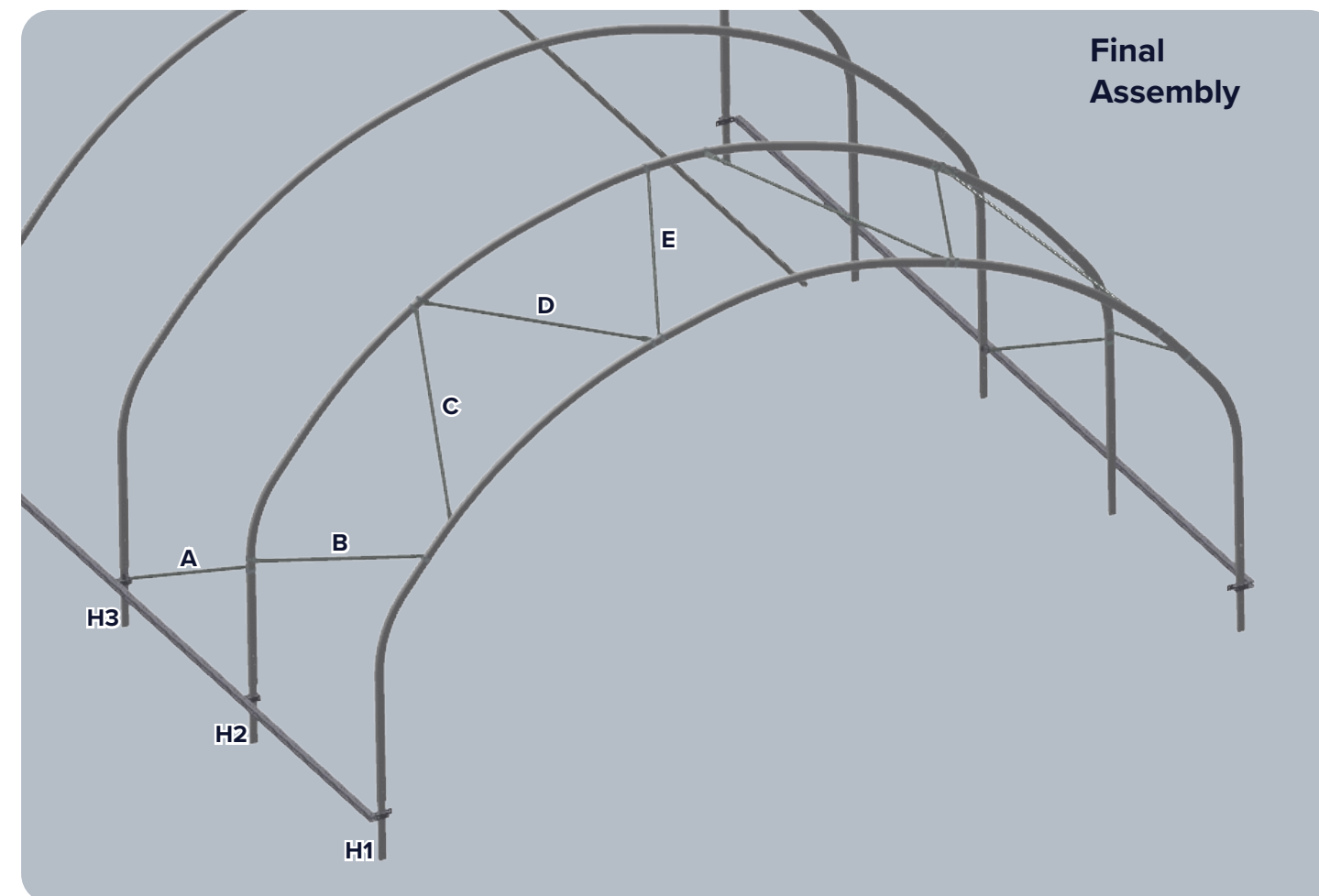
4. Trim final ridge tube



On the rear hoop, cut the protruding ridge bar flush with the outer face of the hoop. Insert plug RPP50.



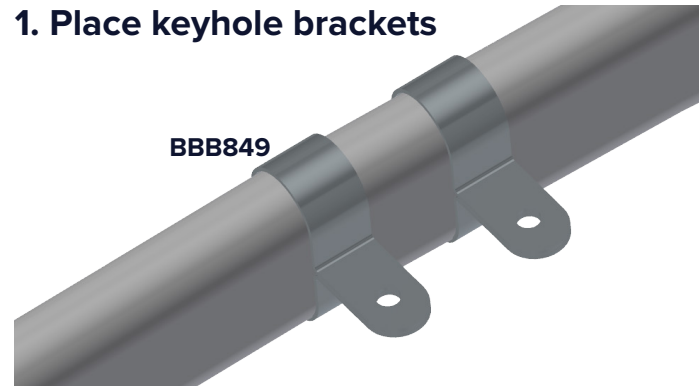
Brace Bar Configuration



Width	Hoop Spacing	A	B	C	D	E
5 metre	2500mm	FB3252-FF	FB3252-FF	FB3252-FF	FB3252-FF	FB3252-FF
6 metre	2500mm	FB3252-FF	FB3252-FF	FB3252-FF	FB3252-FF	FB3252-FF
7 metre	2000mm	FB3210-FF	FB3210-FF	FB3210-FF	FB3210-FF	FB3210-FF
8 metre	2000mm	FB5215-FF	FB5215-FF	FB3220-FF	FB3220-FF	FB3220-FF
9 metre	2000mm	FB5215-FF	FB5215-FF	FB5215-FF	FB3244-FF	FB3244-FF

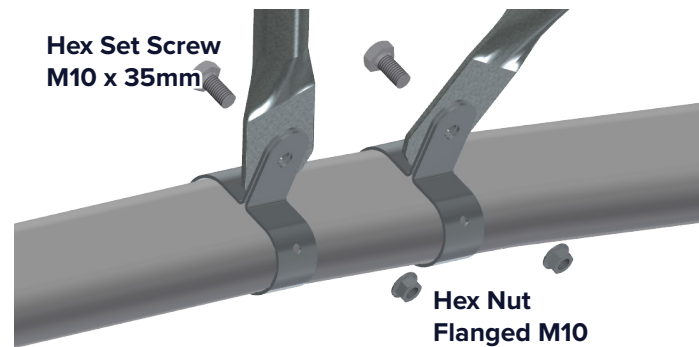
Fitting Brace Bars

1. Place keyhole brackets



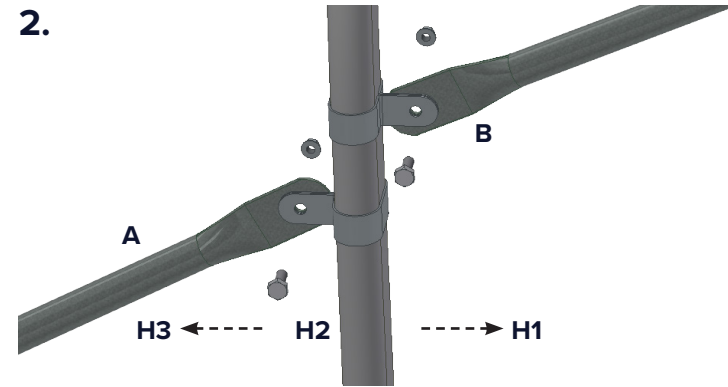
Place keyhole brackets on hoops. Splay the bracket to slide over the hoop.

3. Attach brace bars



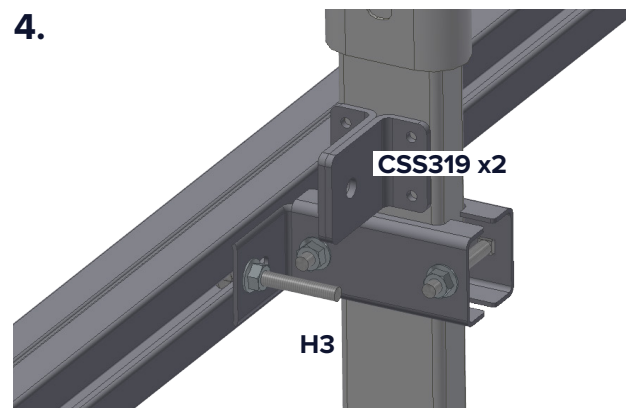
Attach brace bars to key hole clamps with nut and bolt.

2.

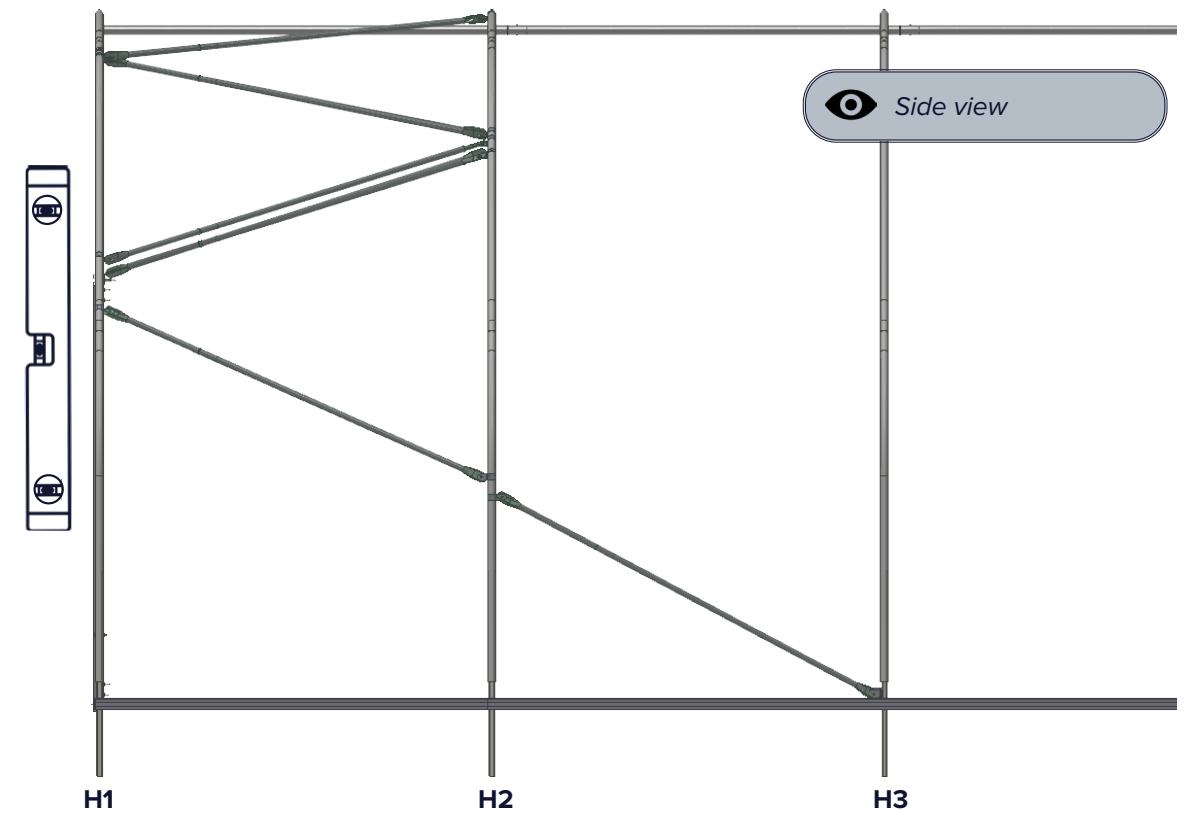
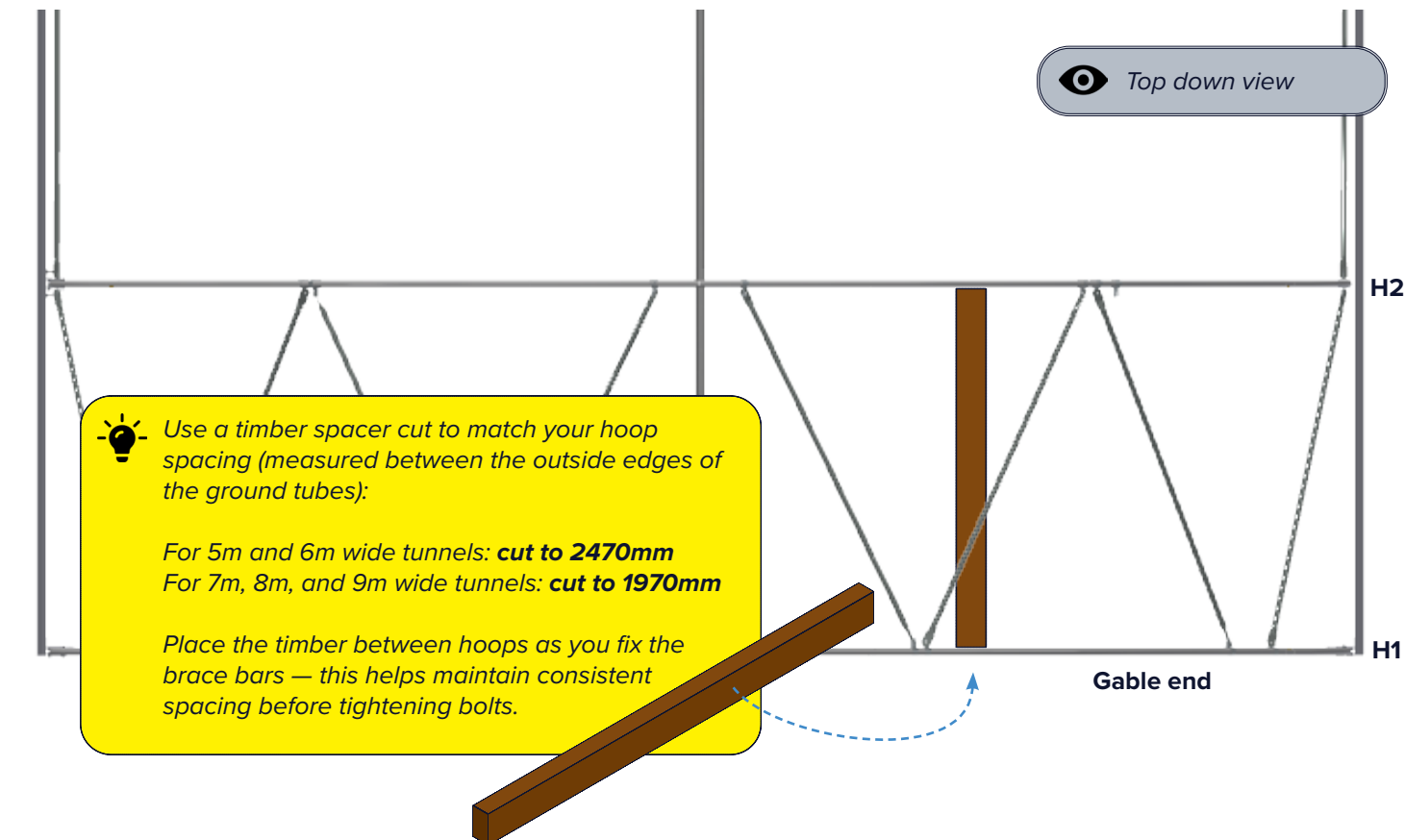


Note bracket configuration for brace bar **A** & **B** on hoop **H2**.

4.

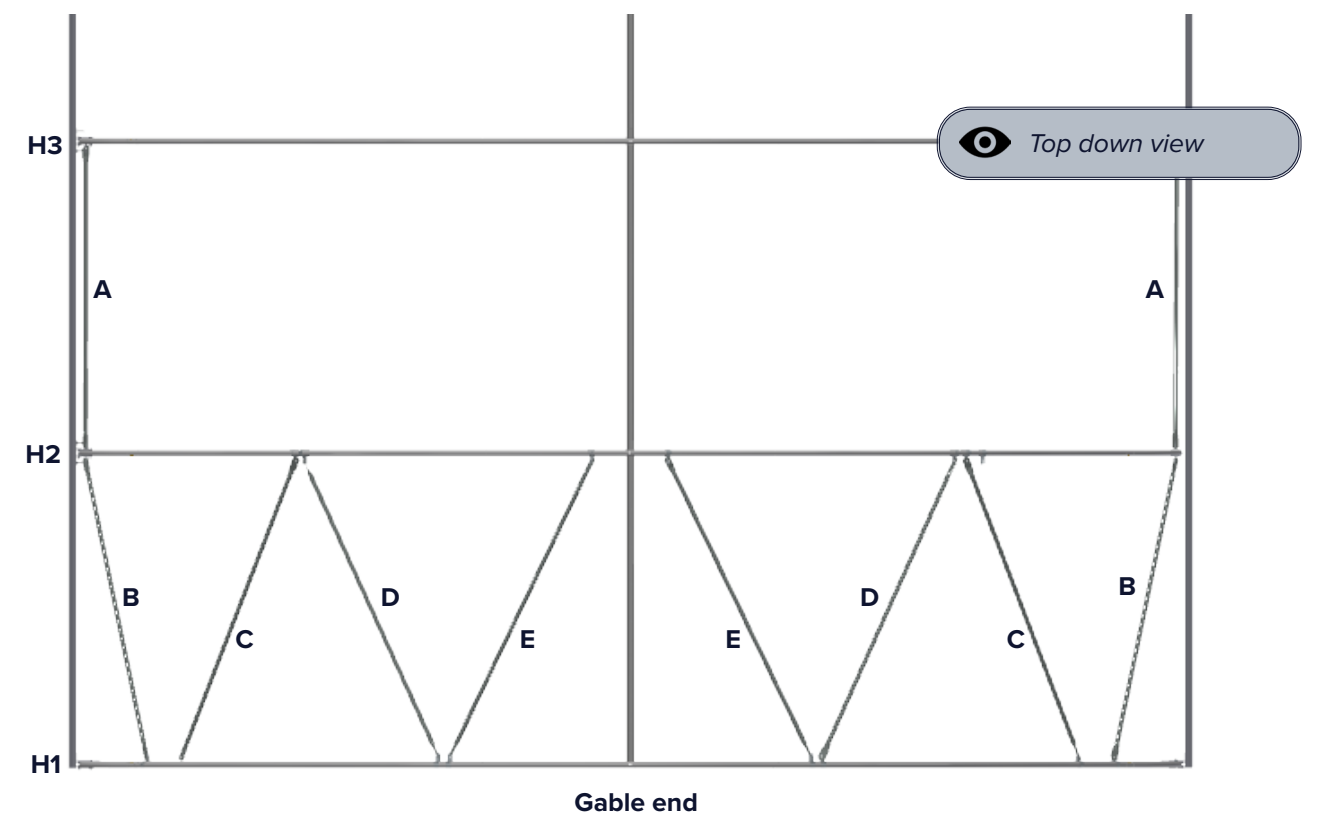


Note hoop **H3**. Attach bracket with tek screw and bolt brace bar **A** to bracket.



Ensure all hoops are vertical before fully tightening up. Fix brackets to hoops with tek screws.

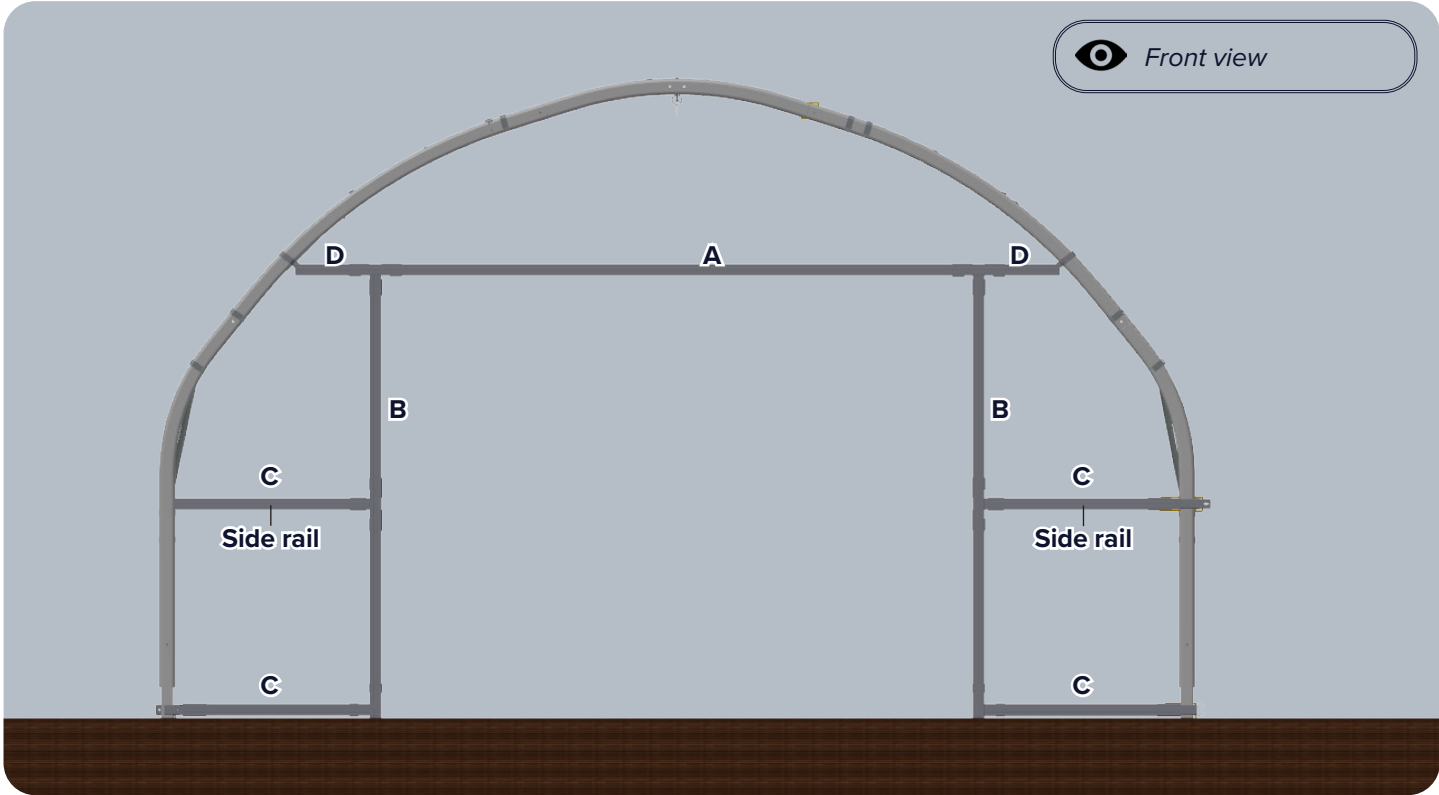
Refer to image below for final configuration. Mirror configuration to complete the front end bracing as pictured below. Then repeat at the rear end of the tunnel.



Gable End Frame Configuration

Review the diagrams and tables for the correct gable end configuration.

5m wide configuration



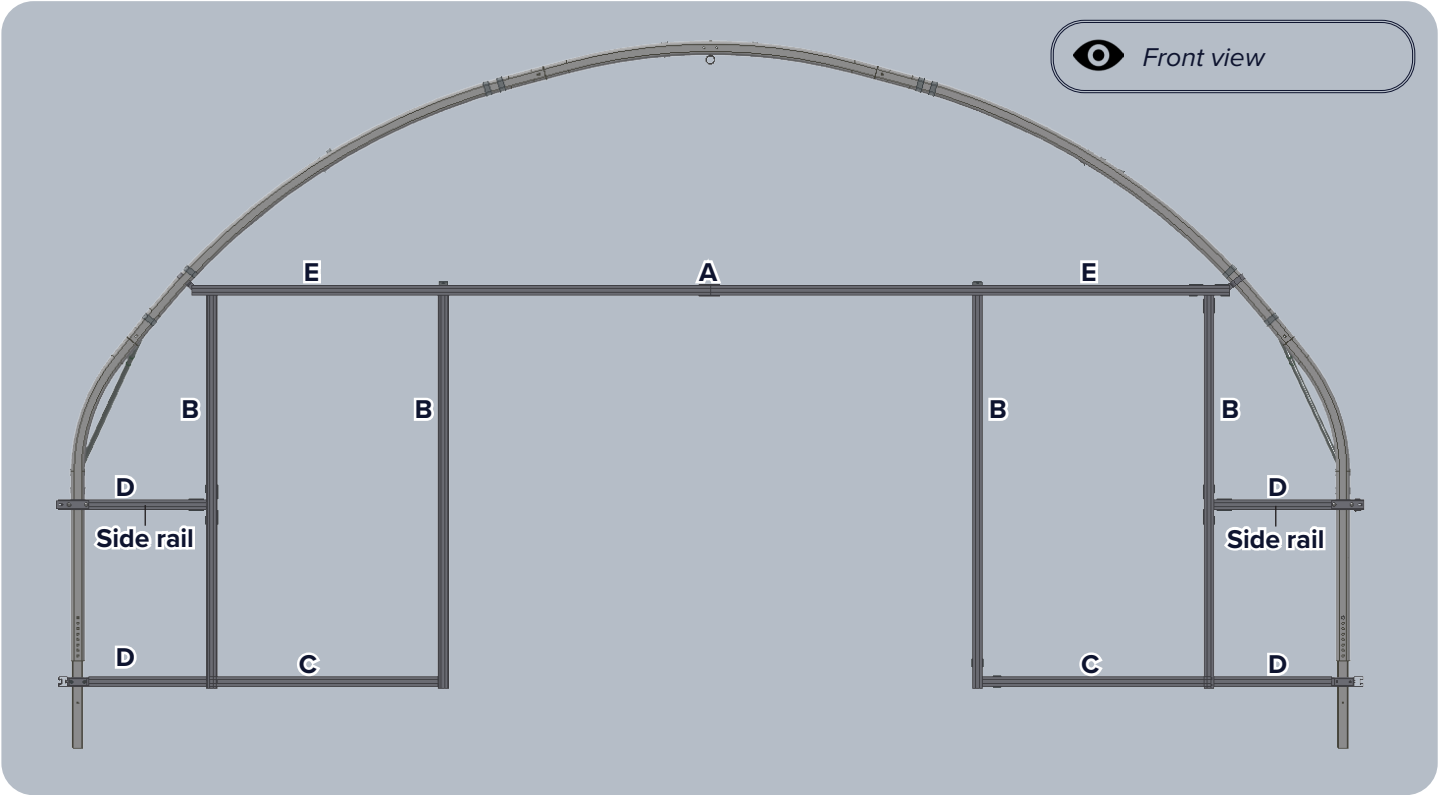
! Side Rail only required if polytunnel includes side rails.

Gable End Parts

Box profile lengths are oversized and require cutting to size.

Width	A	B	C	D	Fittings
5 metre	WBP290 x1	WBP290 x2	WBP210 x1	WBP080 x2	CSS200

6m & 7m wide configuration



! Side Rail only required if polytunnel includes side rails.

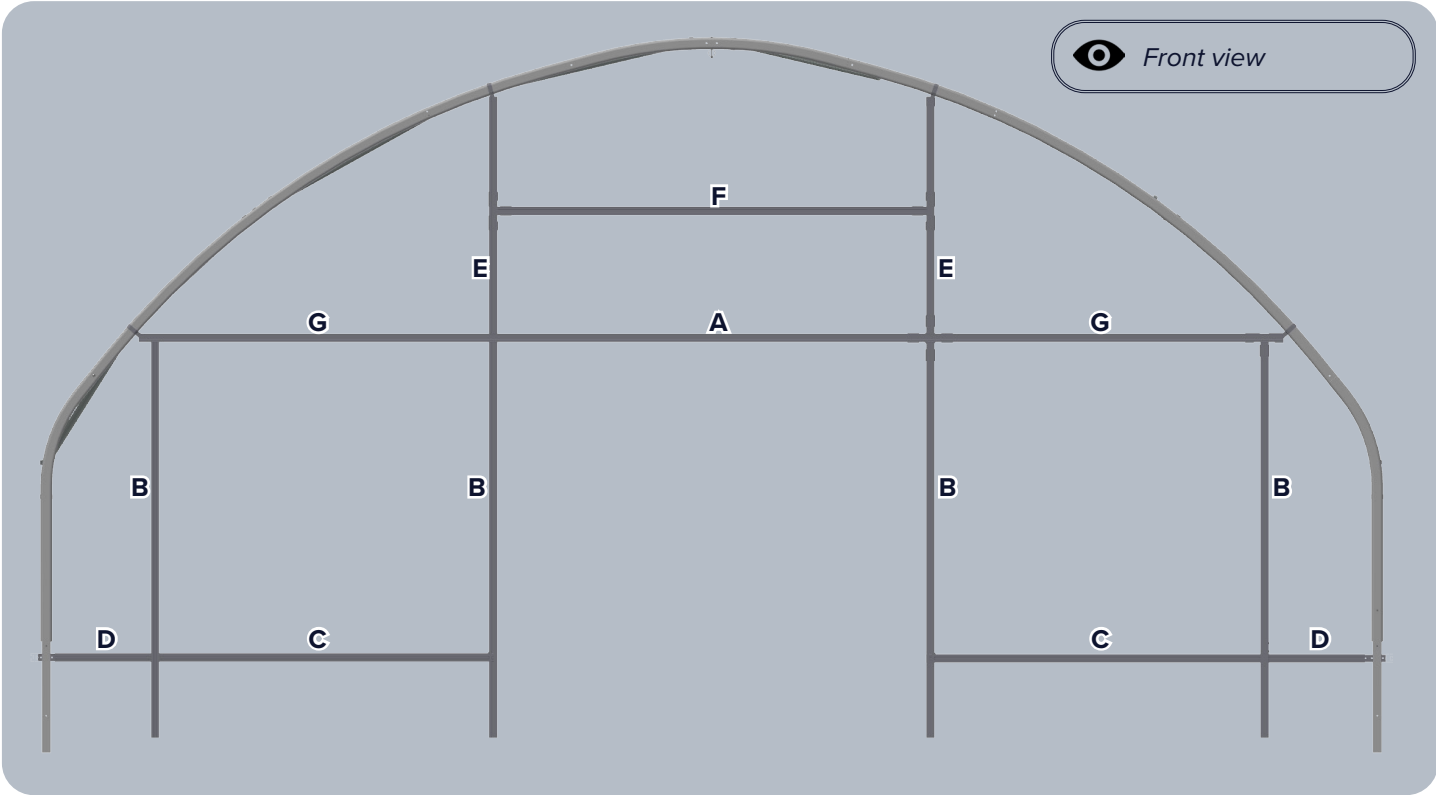
Gable End Parts

Box profile lengths are oversized and require cutting to size.

Width	A	B	C	D	E	Fittings
6 metre	WBP290 x1	WBP290 x4	WBP080 x2	WBP080 x4	WBP170 x2	CSS201
7 metre	WBP290 x1	WBP290 x4	WBP170 x2	WBP080 x4	WBP170 x2	CSS201

For “8m & 9m wide configuration” see page 24 >

8m & 9m wide configuration



Gable End Parts

Box profile lengths are oversized and require cutting to size.



Side Rail only required if
polytunnel includes side rails.

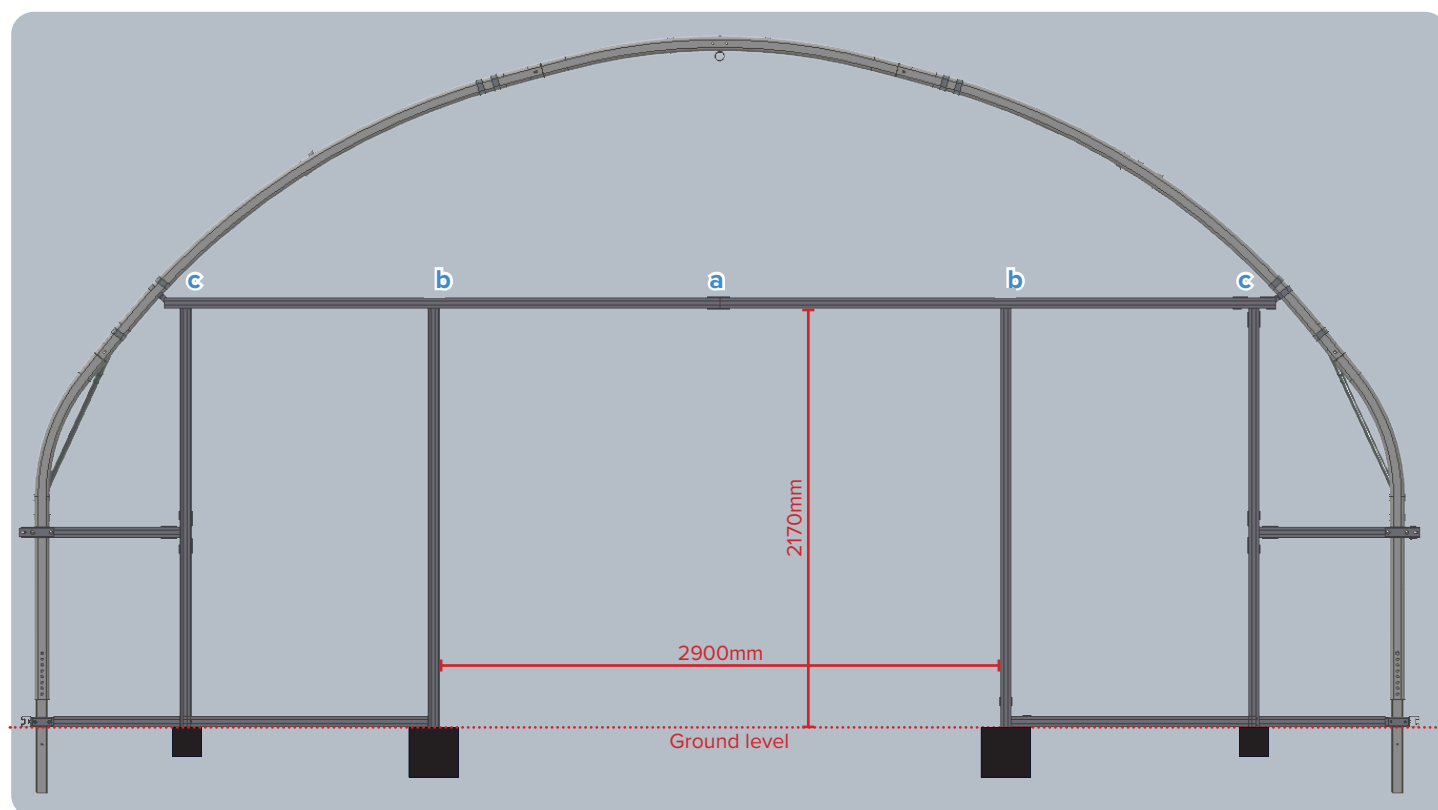
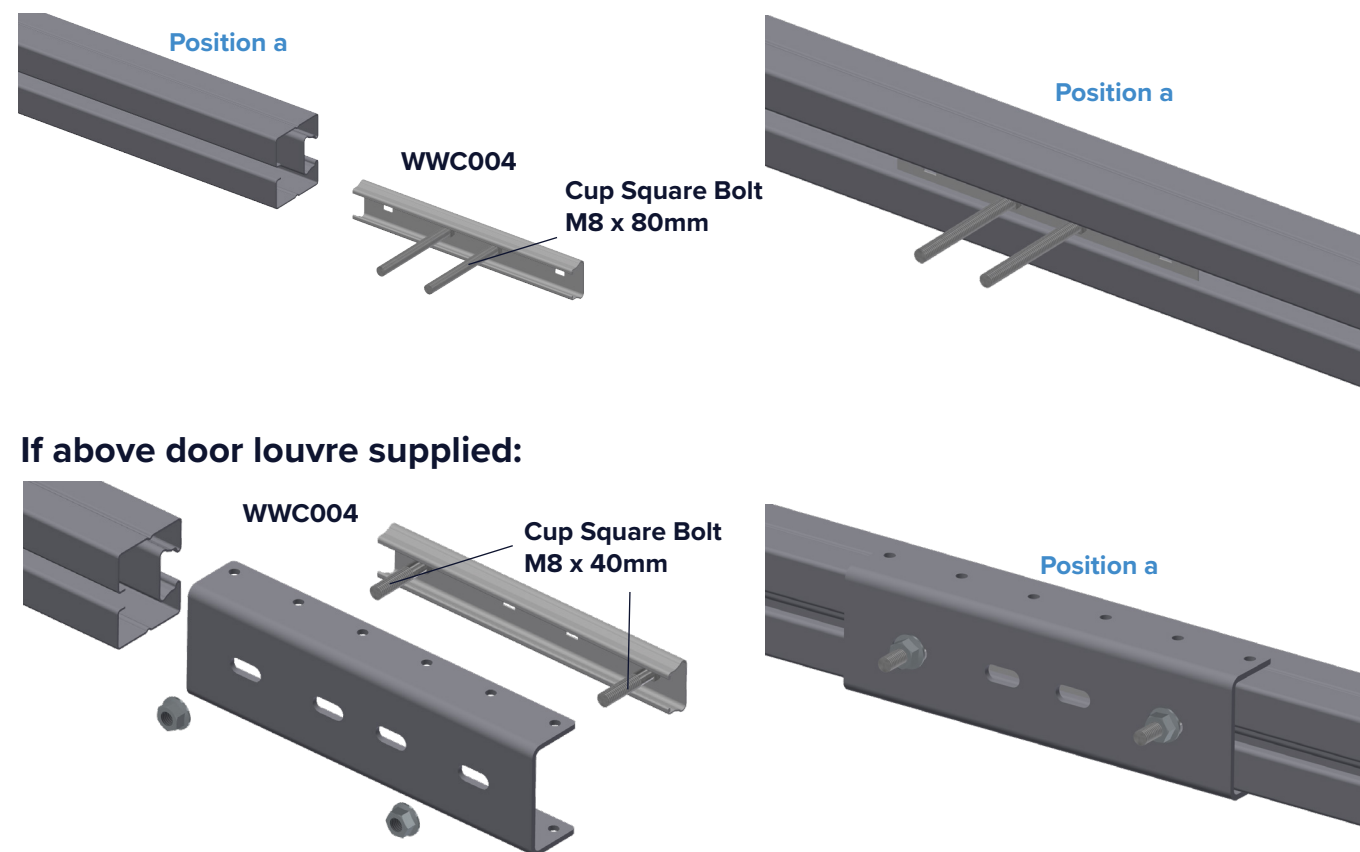
Width	A	B	C	D
8 metre	WBP290 x1	WBP290 x4	WBP210 x2	WBP080 x4
9 metre	WBP290 x1	WBP290 x4	WBP250 x2	WBP080 x4

Width	E	F	G	Fittings
8 metre	WBP210 x2	WBP290 x1	WBP210 x2	CSS201
9 metre	WBP210 x2	WBP290 x1	WBP290 x2	CSS201

Fitting Gable End Frame

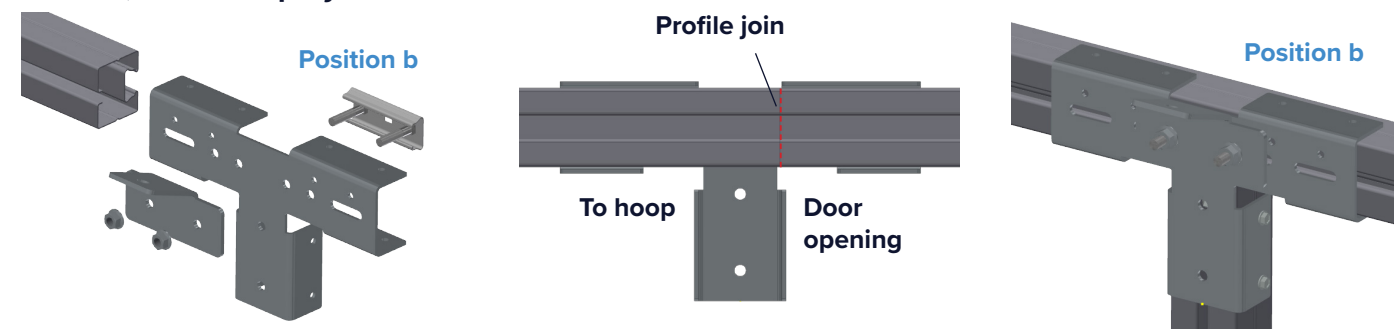
1. Assemble lintel. Fit to centre of 2.9m length.

i Finger tighten only at this stage.

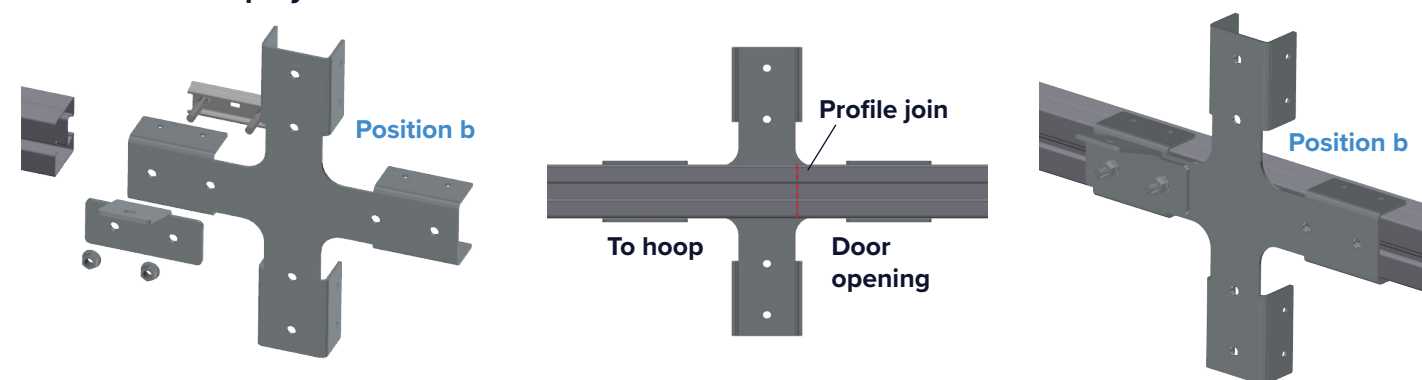


2. Join lintel using door post brackets at position b

For 5m, 6m & 7m polytunnels

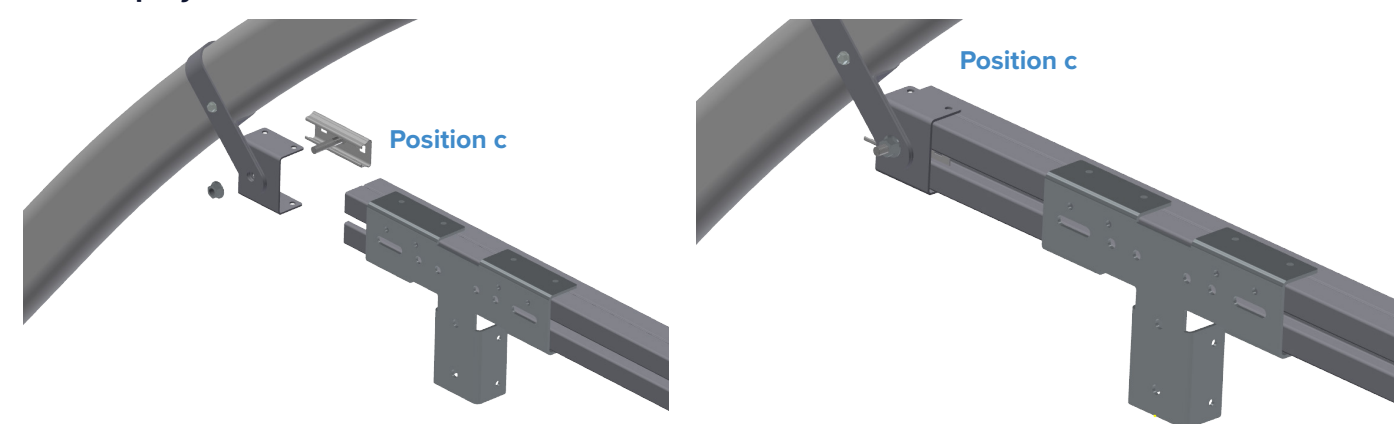


For 8m & 9m polytunnels

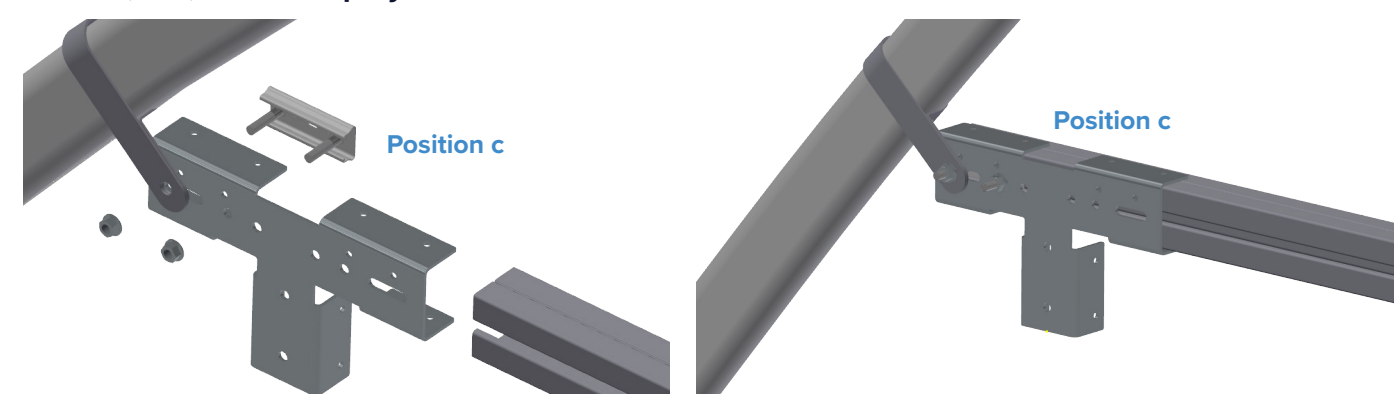


3. Attach lintel to hoop at position c

For 5m polytunnels

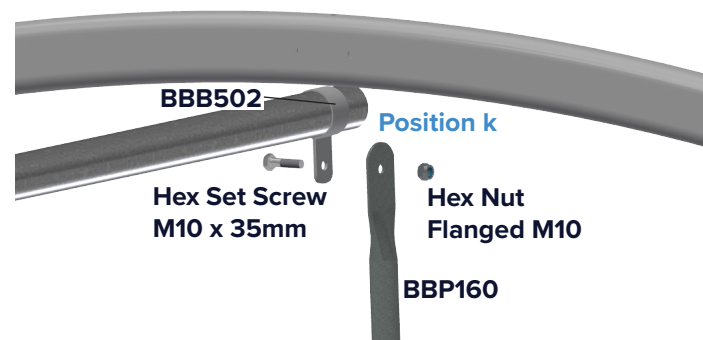
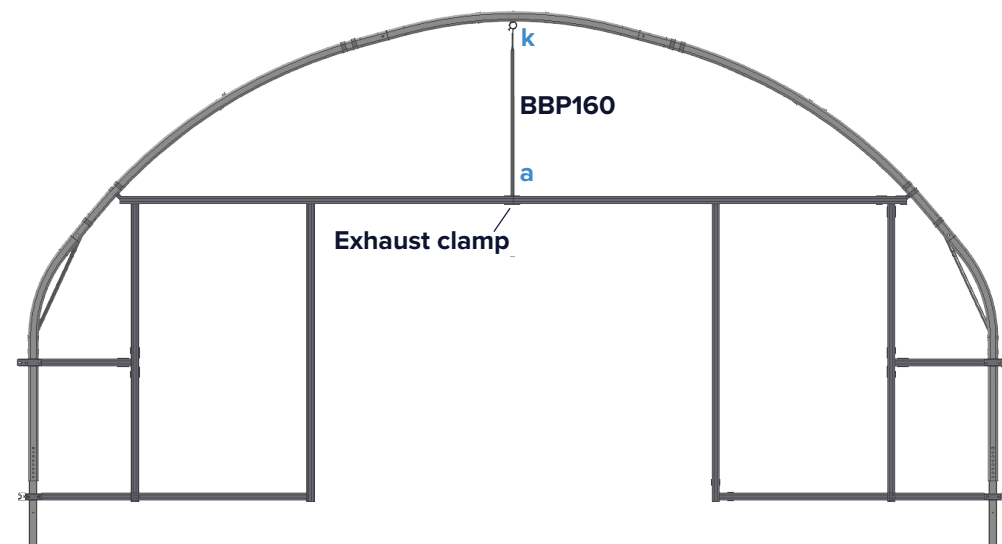


For 6m, 7m, 8m & 9m polytunnels

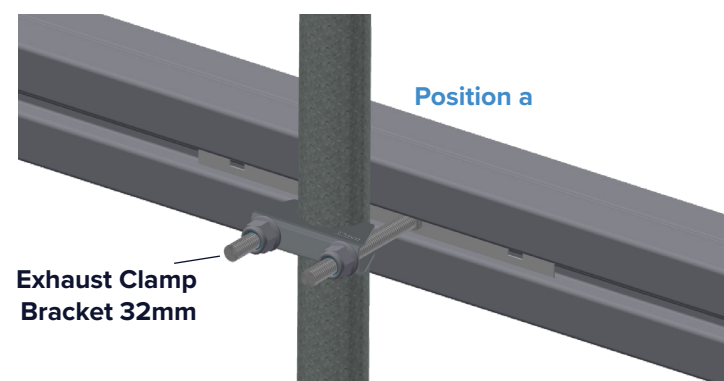


4. Install lintel centre support

! Skip if installing louvres or 8m, 9m tunnel.

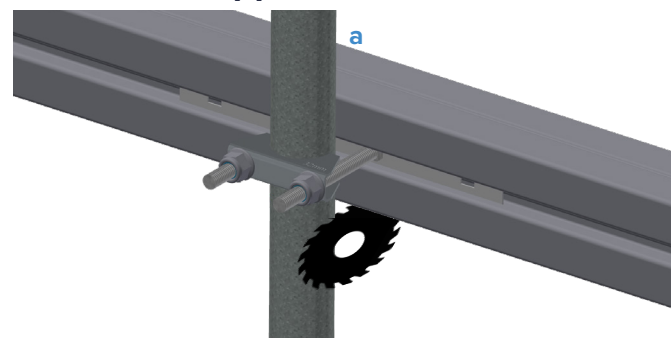


Attach centre support to ridge bar with bracket.

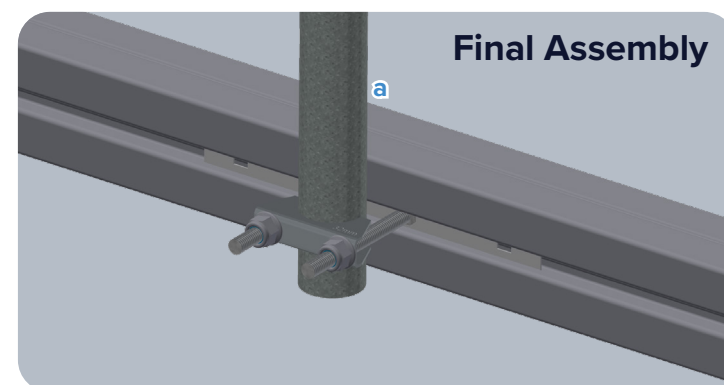


Attach centre support to lintel with exhaust clamp.

Trim centre support

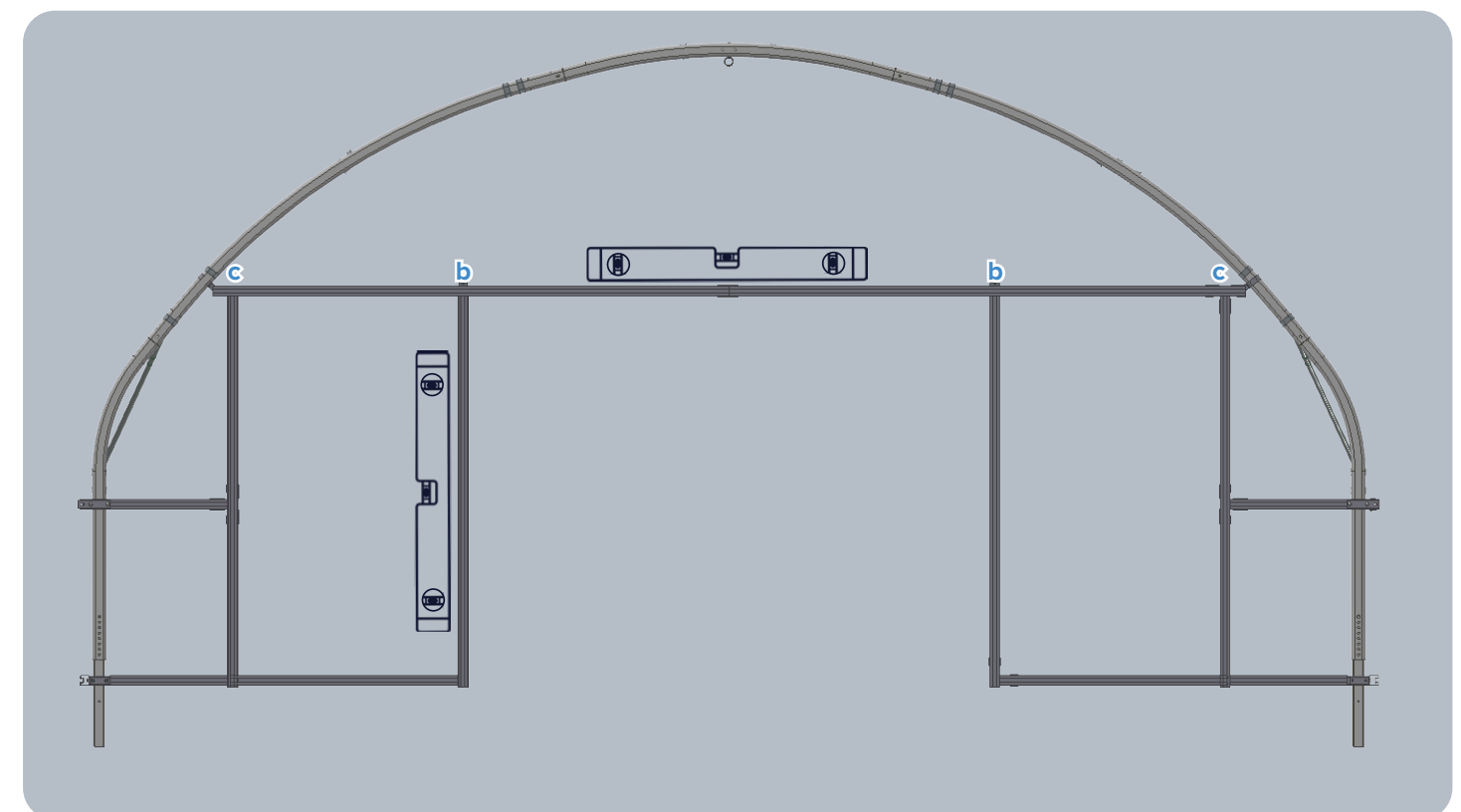
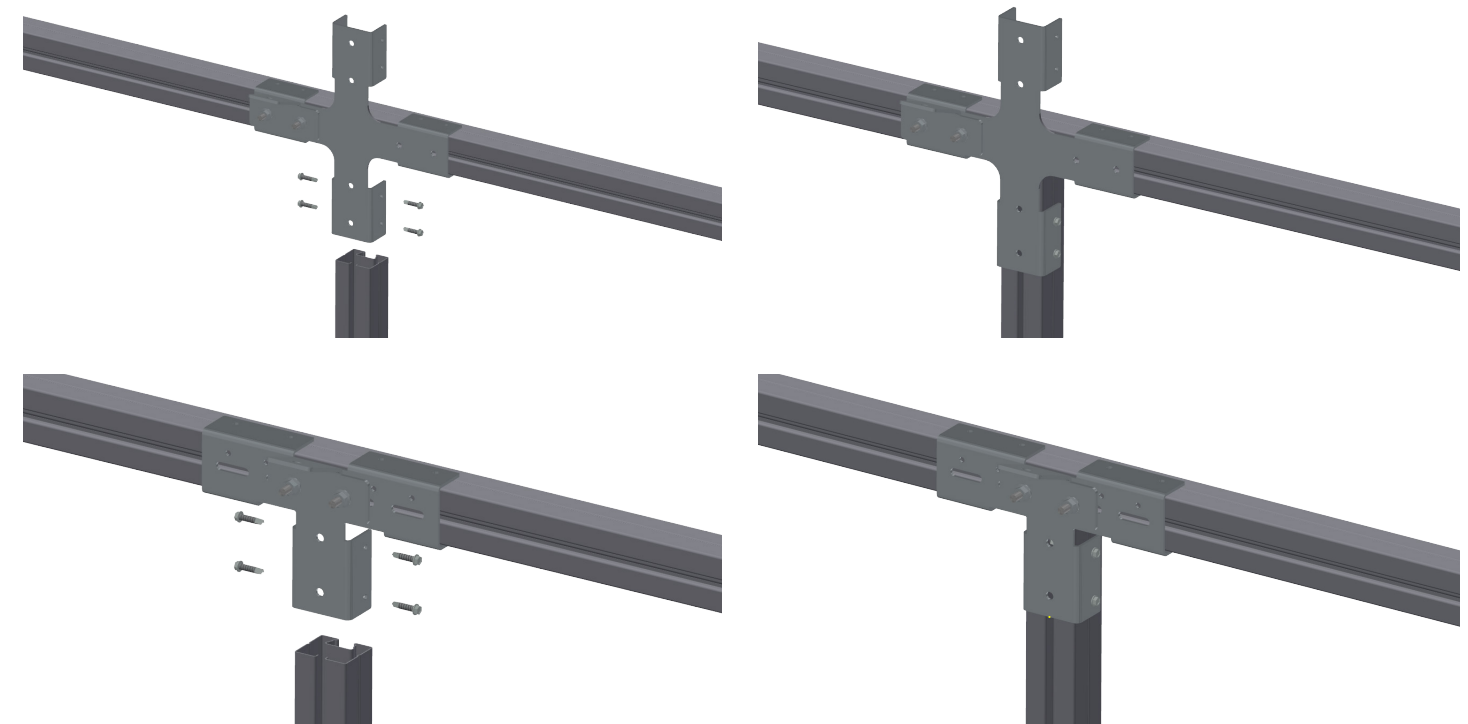


Then cut centre support flush with the underside of the lintel.



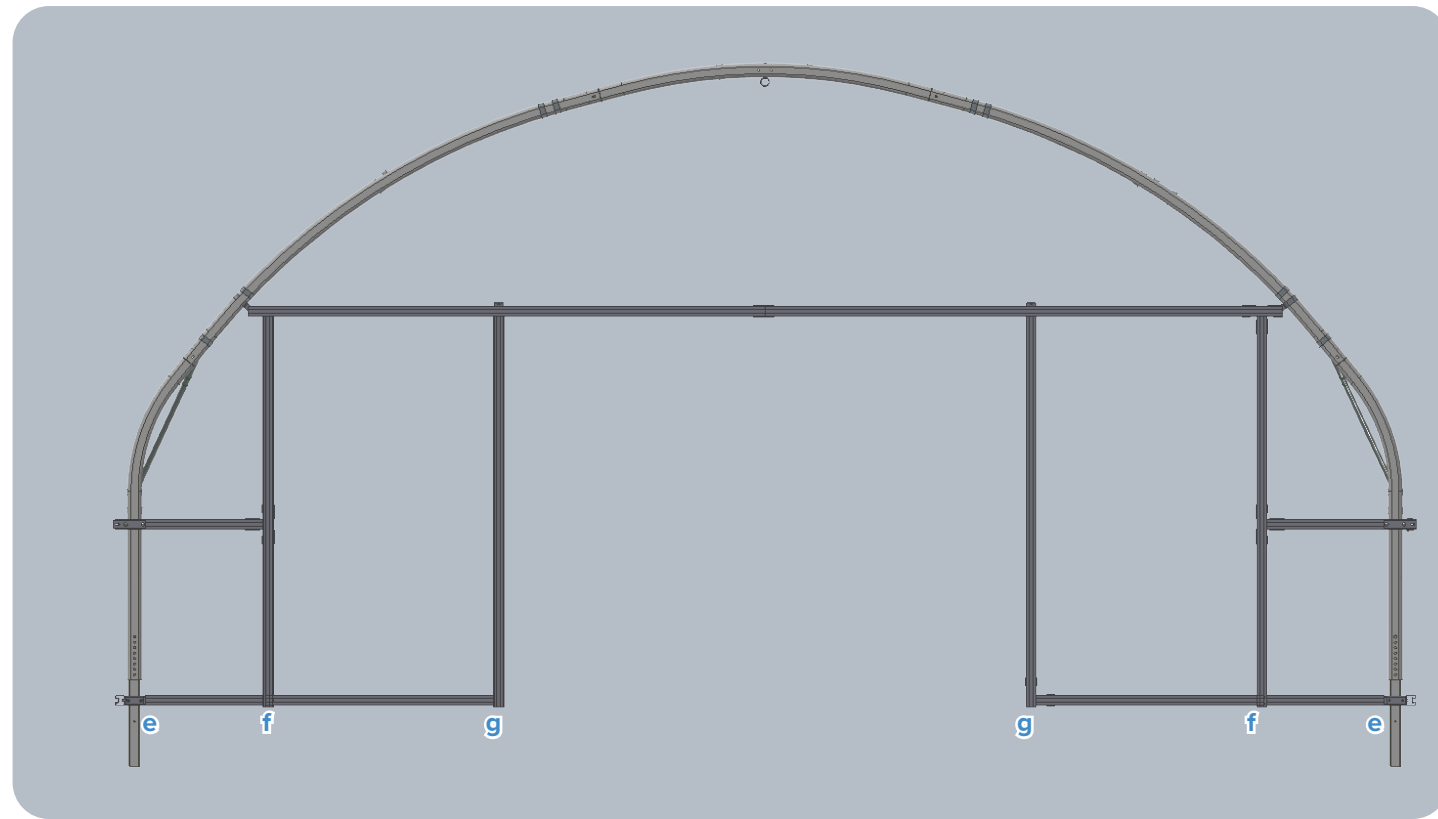
5. Fit door posts

Position b & c

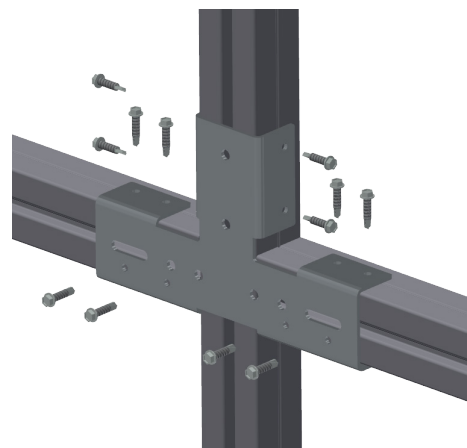


! Check levels on all bars before tek screwing.

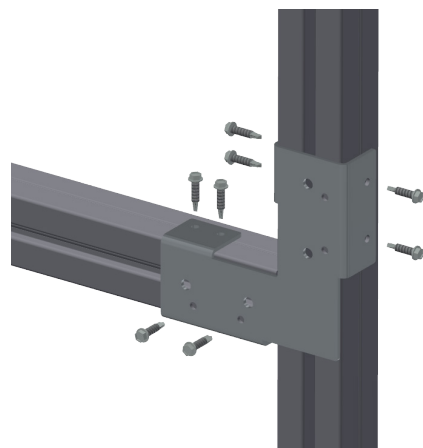
6. Fit base rail



Position f



Position g

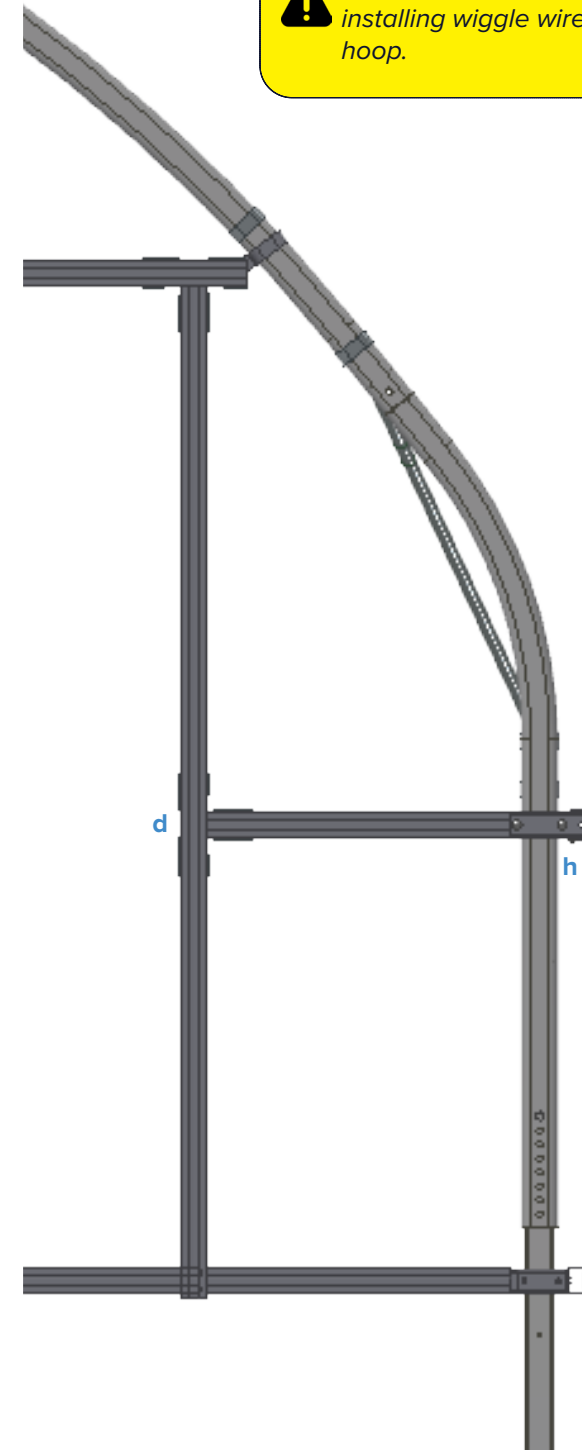


Position e

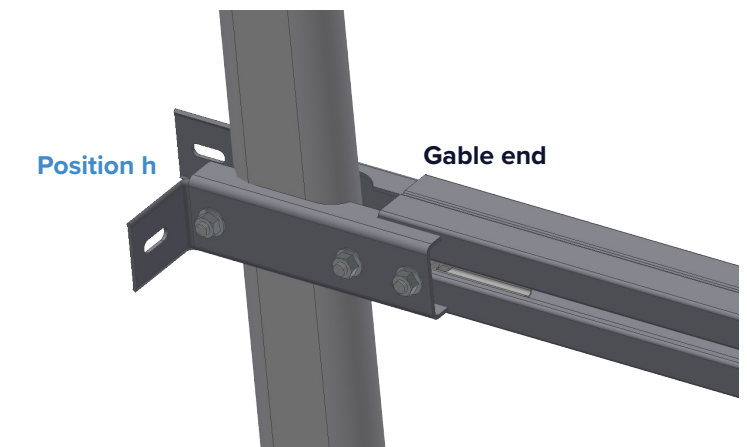


7. Attach gable end side rail (if required)

! Skip these steps if **NOT** installing wiggle wire over hoop.

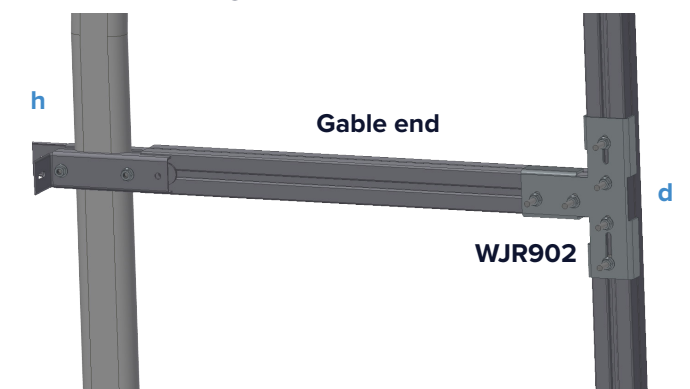


Attach gable end side rail to hoop using a side rail bracket. **Only on sides with side rail.**



Finger tighten to hold in place.

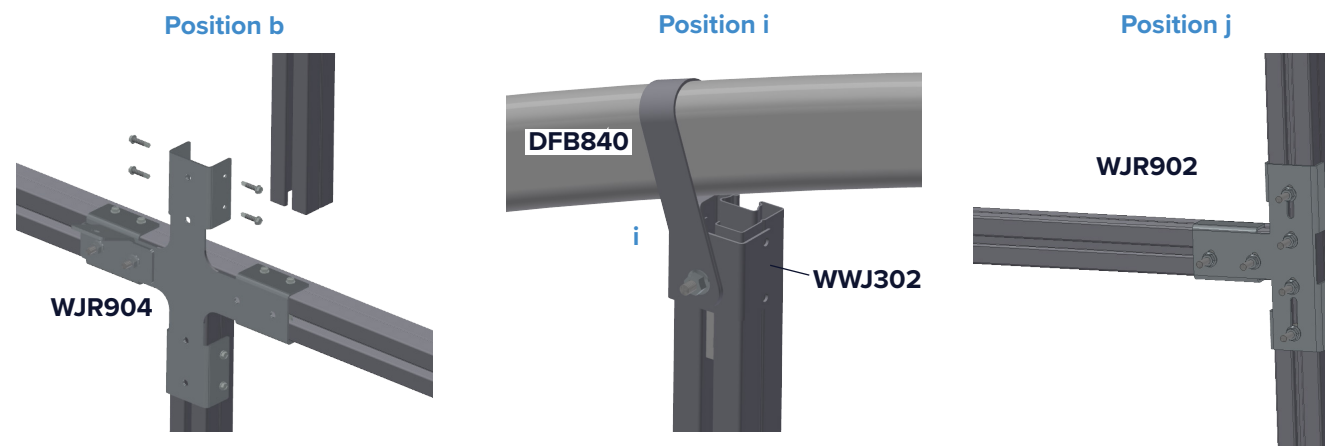
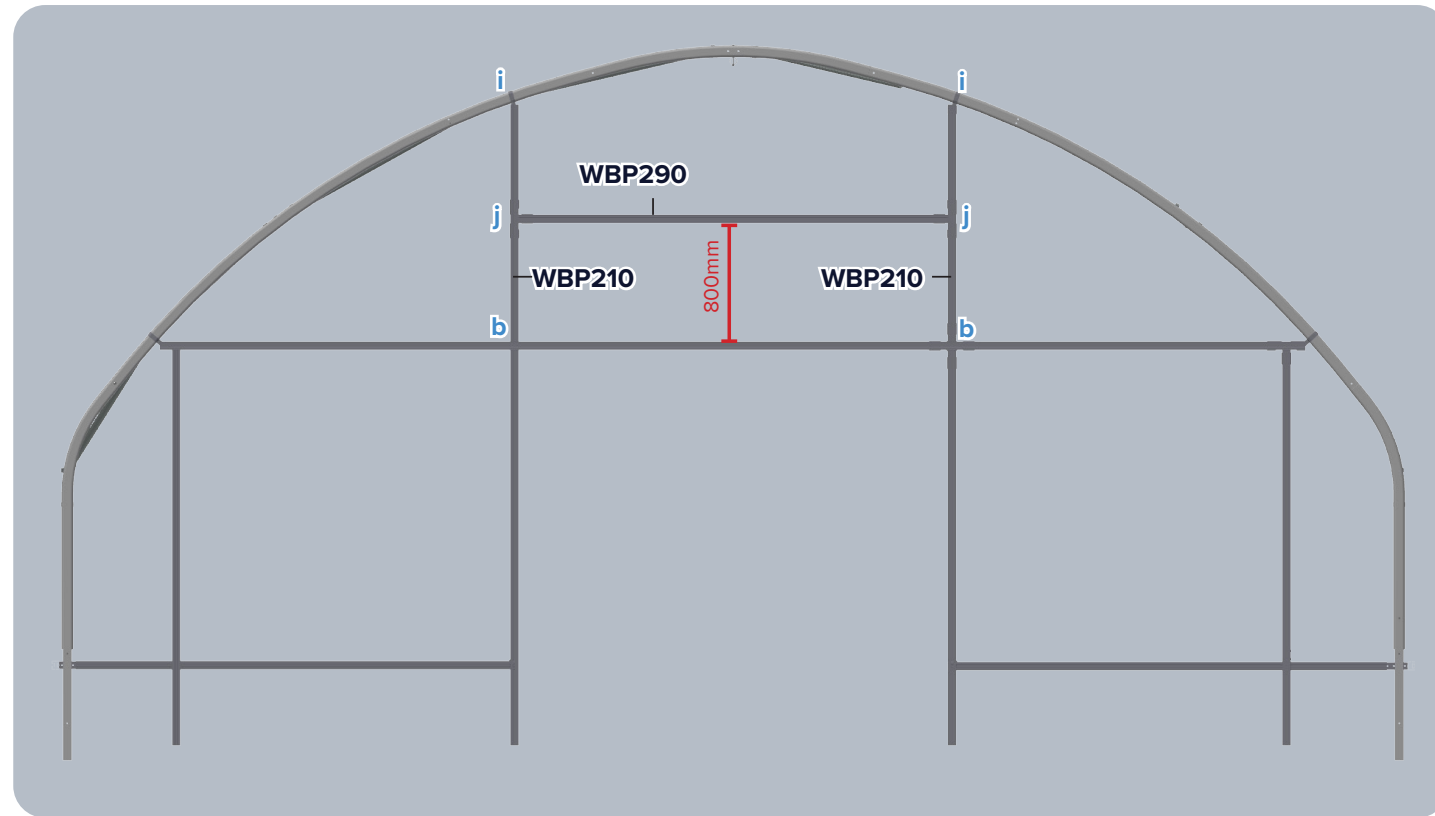
Attach to upright



Attach gable end side rail to upright at position **d** using a T bracket. You should have two loose cotters in the upright from an earlier step.

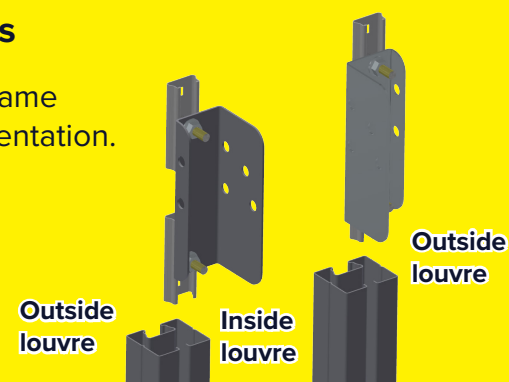
8. Install H frame

Only applies to 8m, & 9m wide tunnels.



⚠ If installing louvres

Install bracket to each H frame upright. Ensure correct orientation.



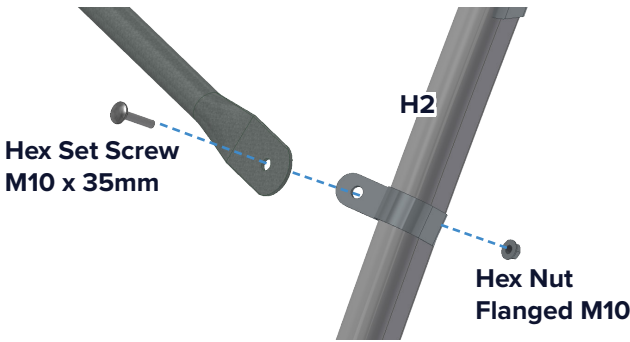
Install Lintel Brace Bar

The lintel brace bar goes from the second hoop (**H2**) to the lintel at position **b**. Depending on your structure spec, position **b** will either be a T or cross bracket.

Lintel Brace Bar Parts

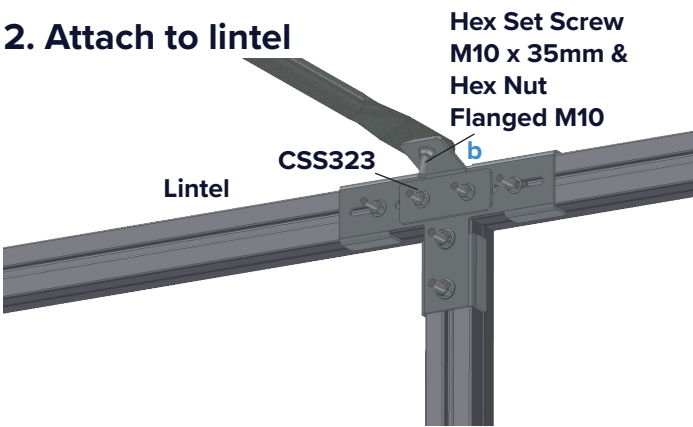
Width	Lintel Brace Bar
5 metre	FB3244-FF
6 metre	FB3252-FF
7 metre	FB3210-FF
8 metre	FB3233-FF
9 metre	FB5255-FF

1. Attach to hoop

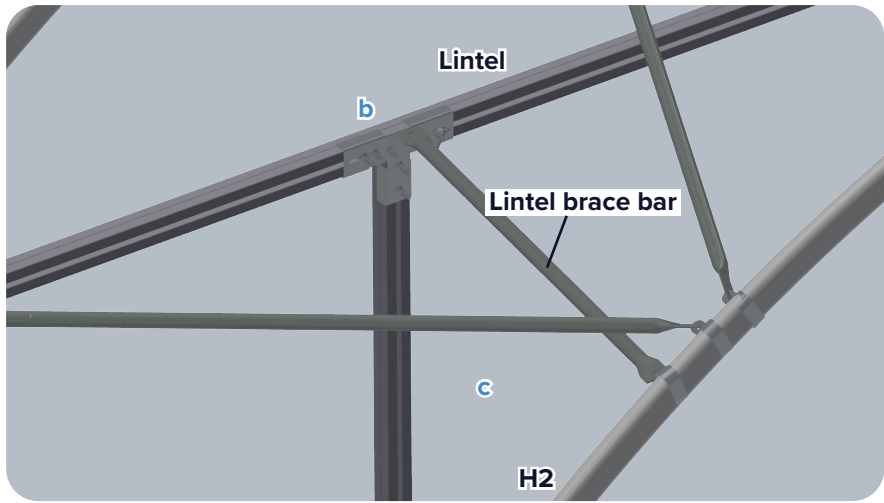


Attach lintel brace bar to hoop **H2**.

2. Attach to lintel

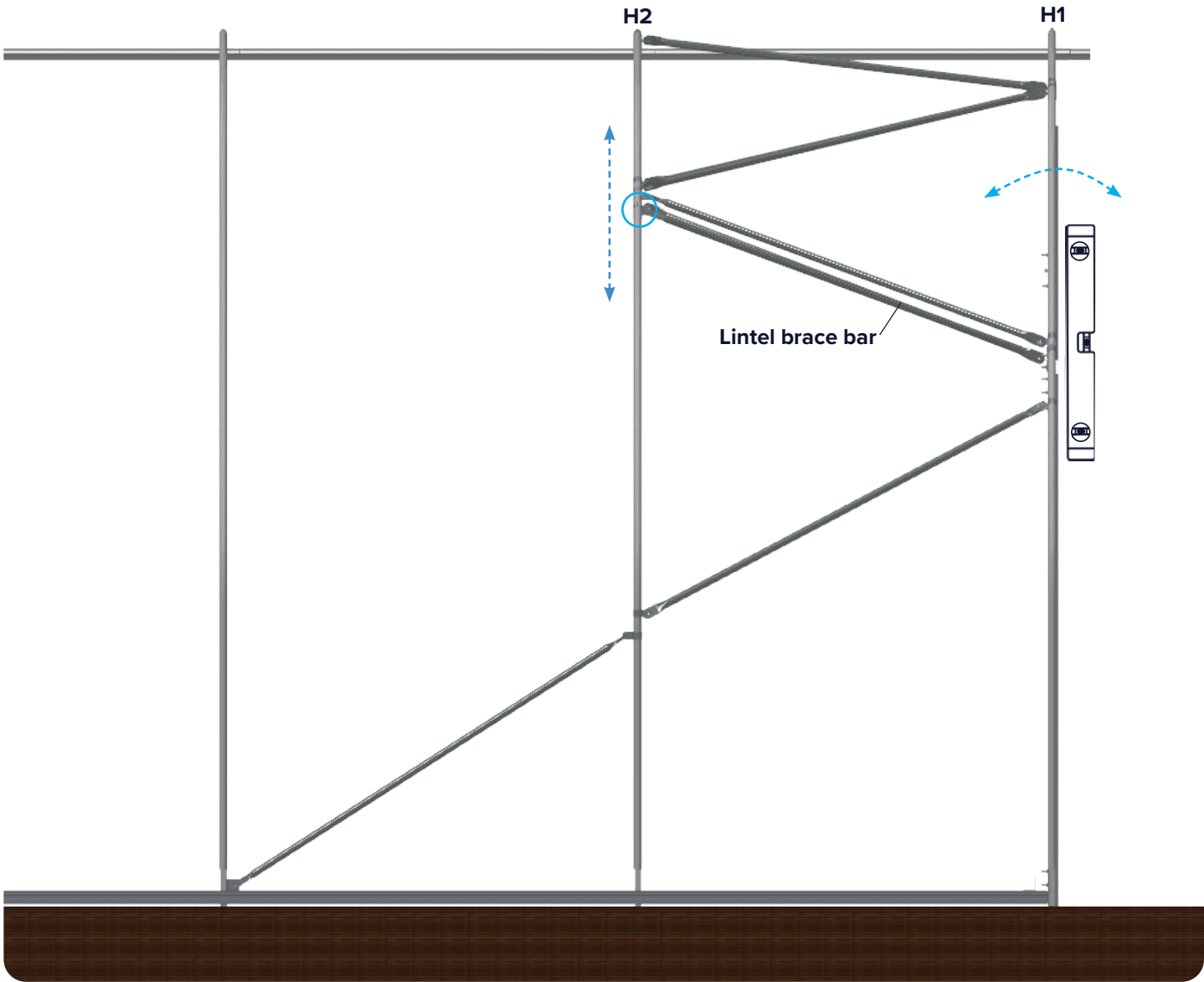


Attach to bracket (CSS323) at positions **b**.



4. Adjust lintel brace bar position

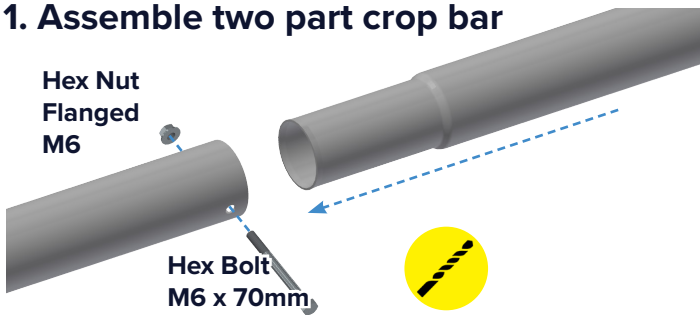
As you push the brace bar up and down the hoop it will push the end frame in and out.



Crop Bar V Hanger Configuration

Width	Crop bar	A
5 metre	CBP217 CBP174	FB3120-FF
6 metre	CBP174 CBP291	FB3140-FF
7 metre	CBP291 CBP278	FB3160-FF
8 metre	FB5320-FP FB5320-FS	FB3180-FF
9 metre	FB5210-FS (x2) EPG539	FB3233-FF

1. Assemble two part crop bar



Connect two part crop bar. Drill and secure with nut and bolt.

2. Attach crop bar to hoop

At positions a.

3. Attach hanger to hoop

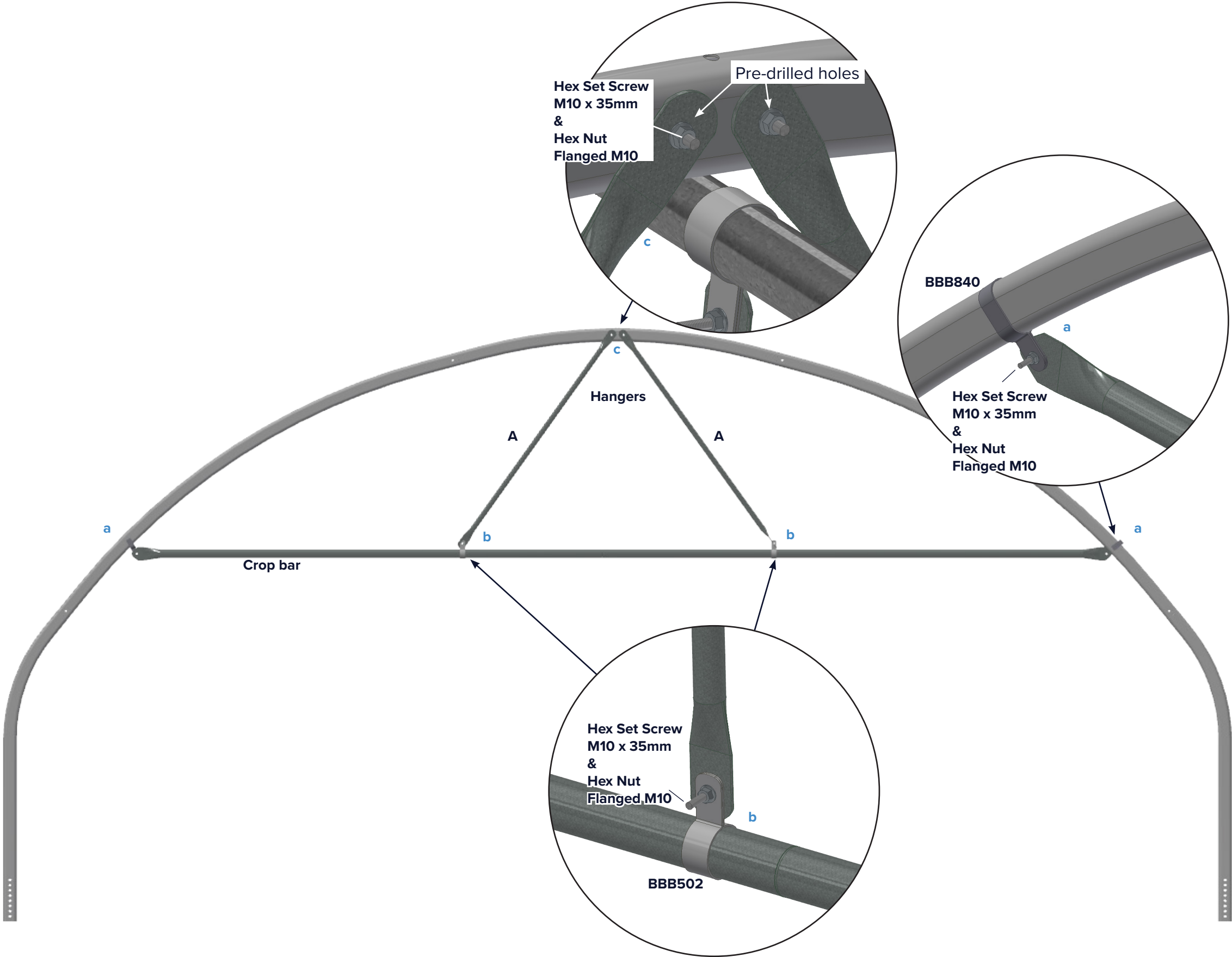
Attach hangers to the hoop (either side of the ridge bar) at position c using the the pre-drilled holes.

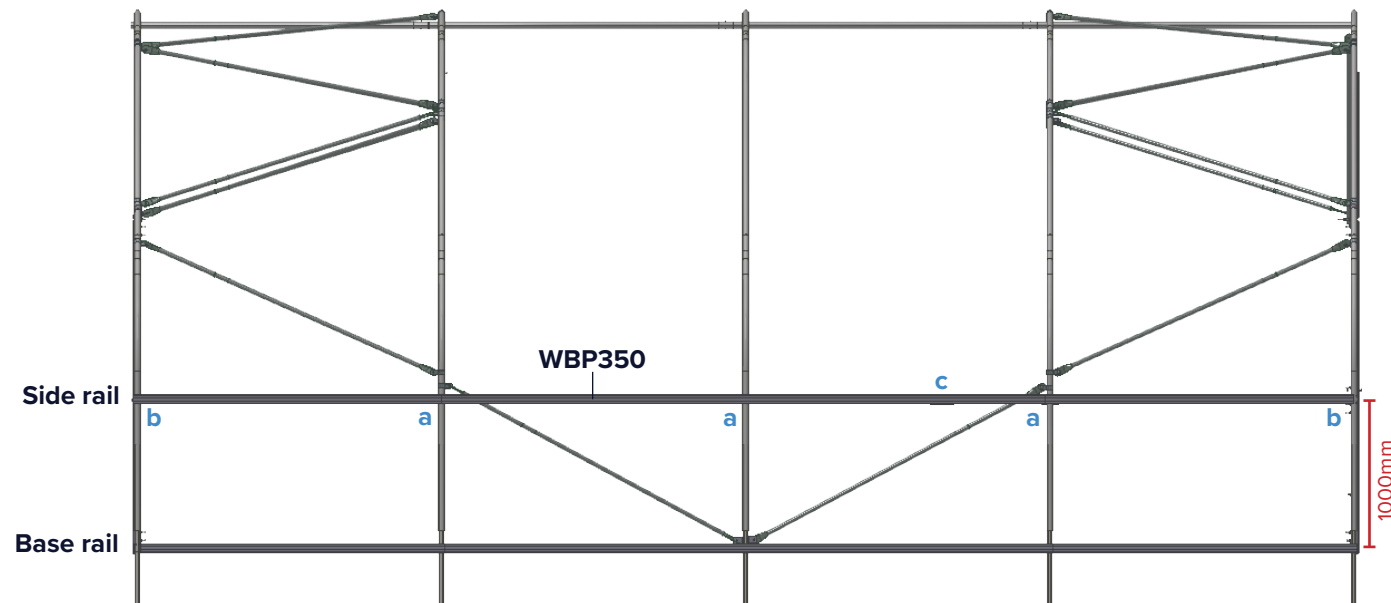
4. Attach hanger to crop bar

At position b.

5. Repeat

Repeat for every hoop.





If your tunnel has side rails, proceed with the following steps.

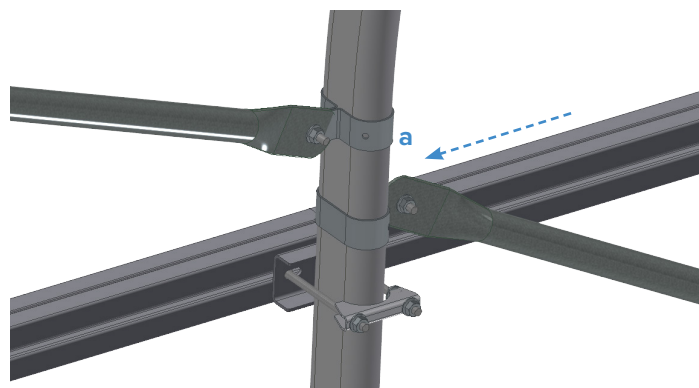
1. Assemble side rail bracket

Loosely assemble side rail bracket around hoop at position **a**.



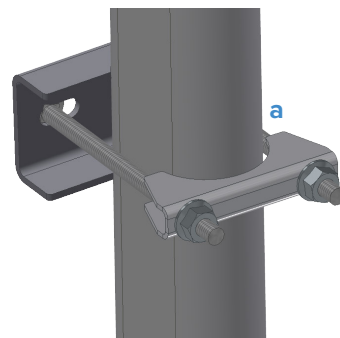
3. Attach side rail to hoops

Starting at one end of the tunnel. Slide side rail profile onto the cotter and bracket at each hoop - pushing the first piece of profile into the corner bracket.



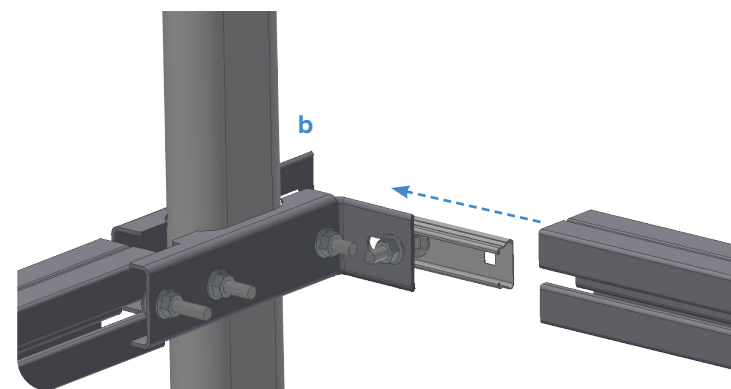
2. Finger tighten

Finger tighten to hold in position, at around 950mm from the base rail.

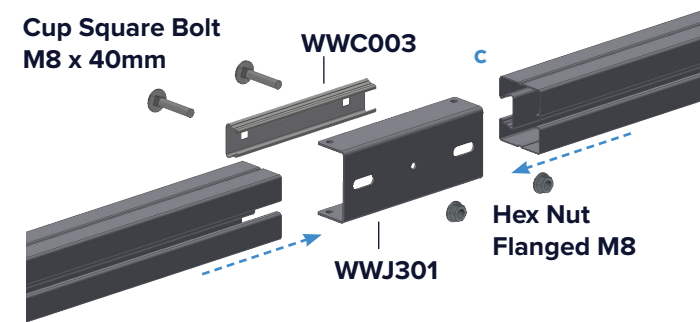


4. Attach to side rail to corner brackets

At each corner (**b**) attach the profile to the corner bracket.



5. Join side rail lengths

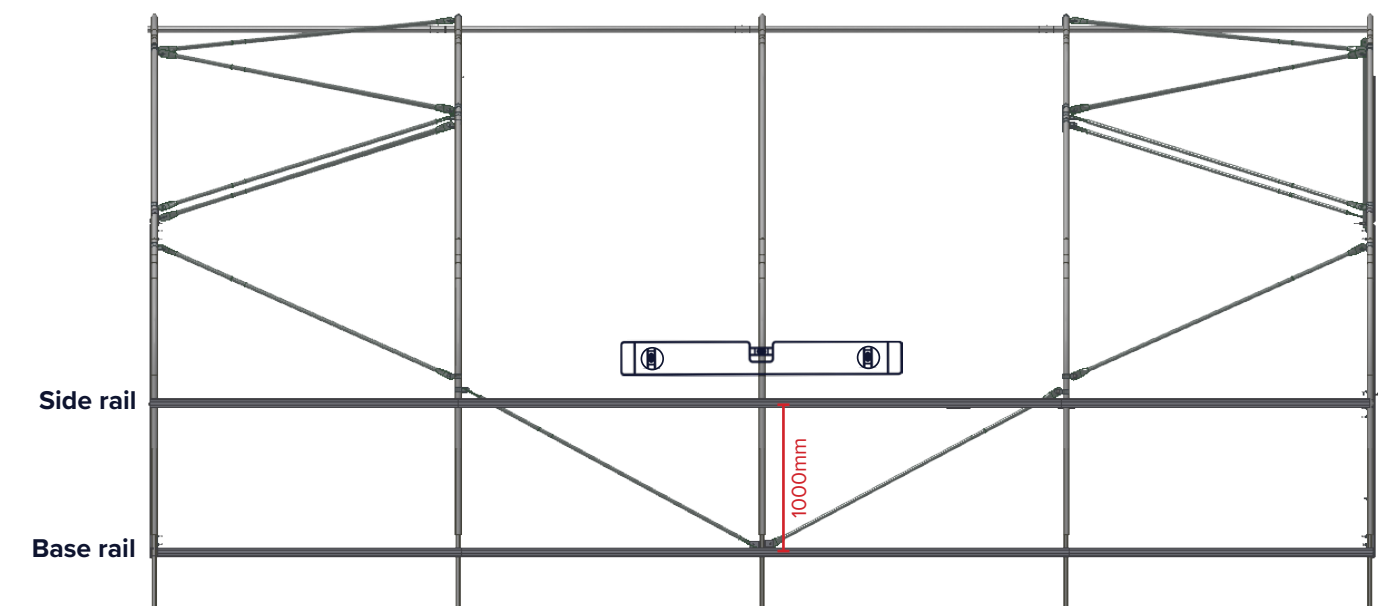


Where side rail profile pieces join, connect them with a bracket.

6. Tighten up



Tighten side rail to form a continuous side rail the full length of the tunnel.



7. Check levels and tighten

Finish side rail assembly by checking level. Ensure distance from base rail is 1000mm (from centre to centre of profile). Tighten all nuts and bolts.

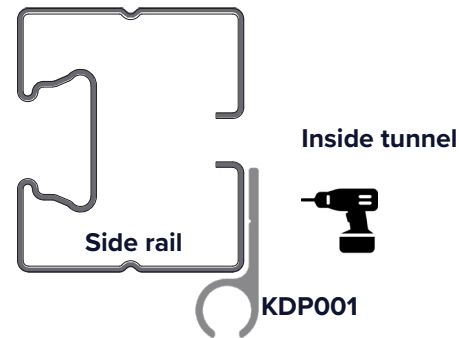
Repeat on sides with side vents.

Installing Curtain

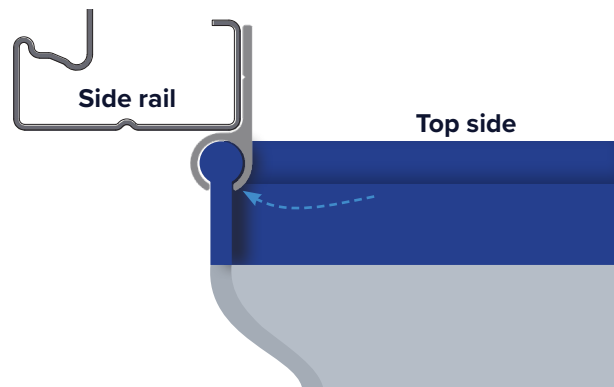
If installing curtain, proceed with the following steps.

1. Attach keder profile (KDP001)

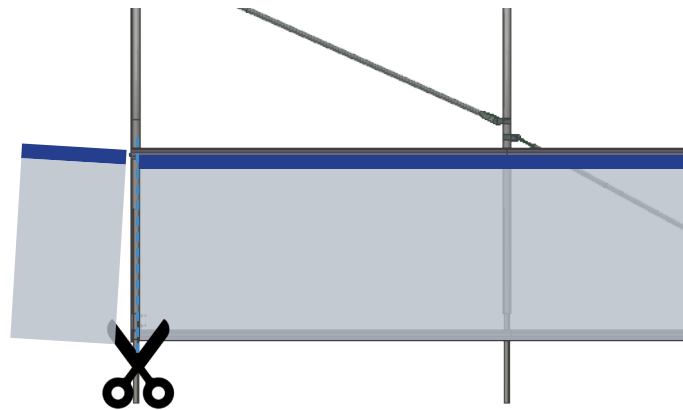
Fix to inside of side rail using tek screws.



3. Feed PVC curtain into keder profile

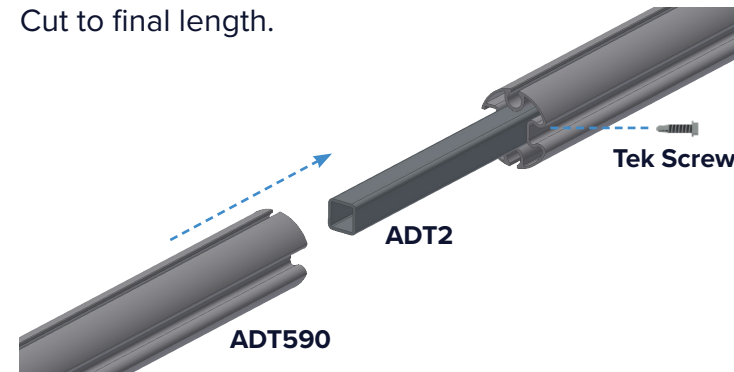


5. Cut away excess curtain

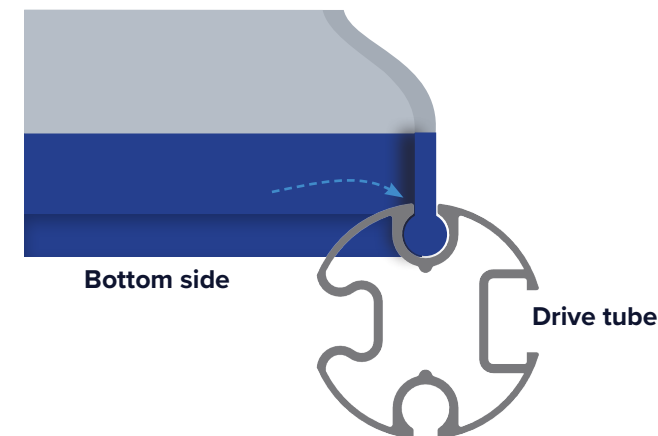


2. Assemble drive tube

Use drive tube joiners and fix with tek screws. Cut to final length.



4. Feed curtain onto drive tube



Manual Winder

1. Attach bottom bracket (SVB001)

Slide bottom bracket onto winch tube and fasten with a tek screw.

2. Slide on manual winder (MWD001)

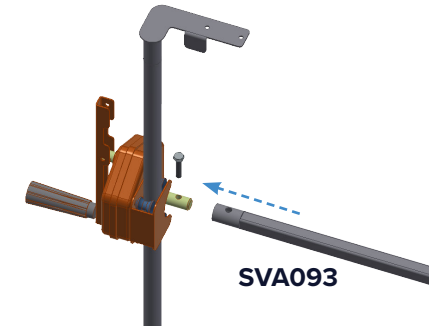
Onto winch tube.

3. Attach top bracket (SVB002)

Onto winch tube.

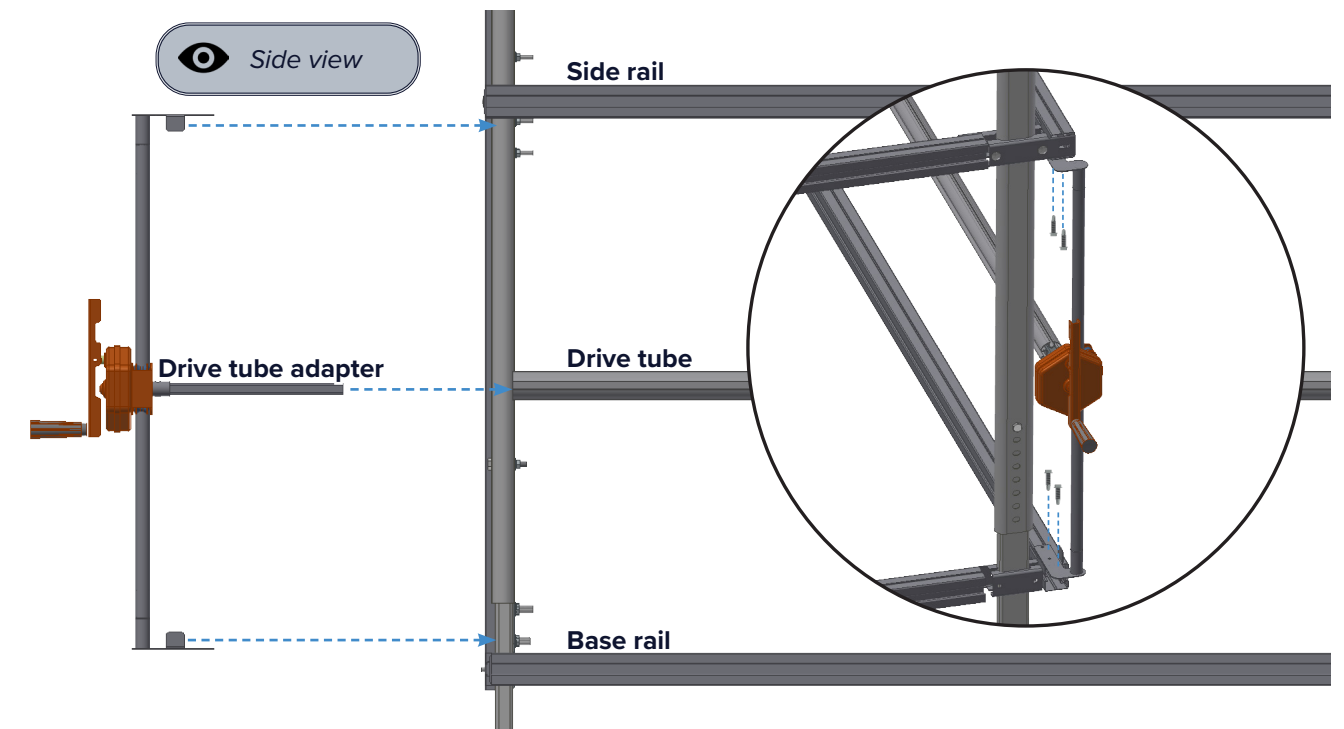
4. Attach drive tube adapter (SVA093)

Fix in place with a bolt.



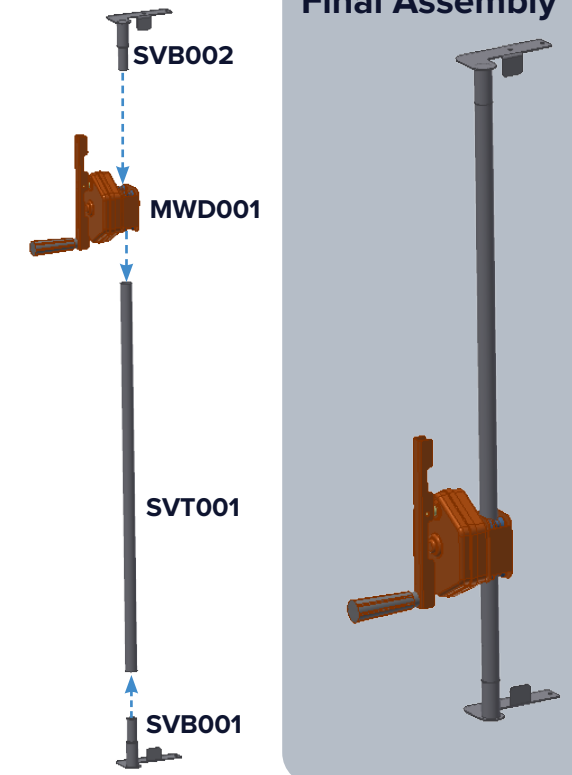
5. Fit manual winder assembly to drive tube

Attach manual winder assembly to the structure. Slide drive tube adapter into drive tube and fix winder assembly to base rail and side rail with two tek screws.



6. Test operation and leave in rolled up position

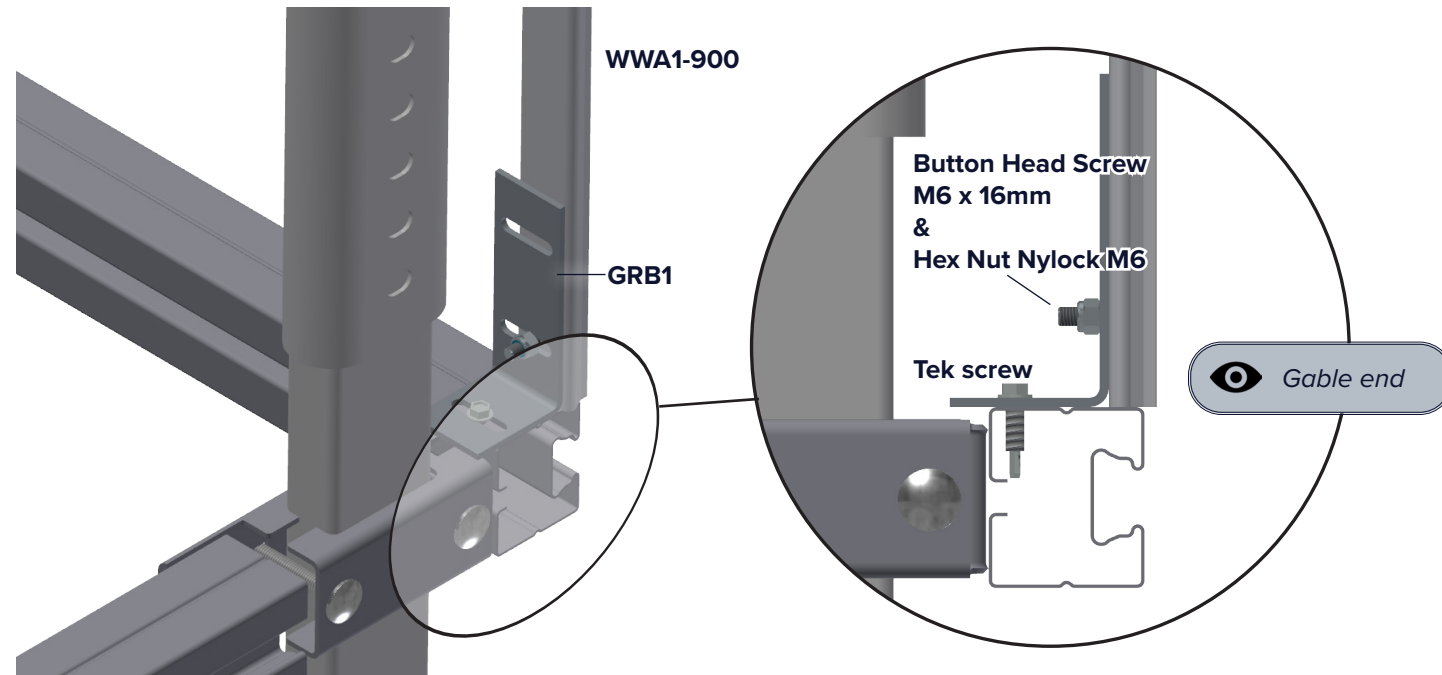
Final Assembly



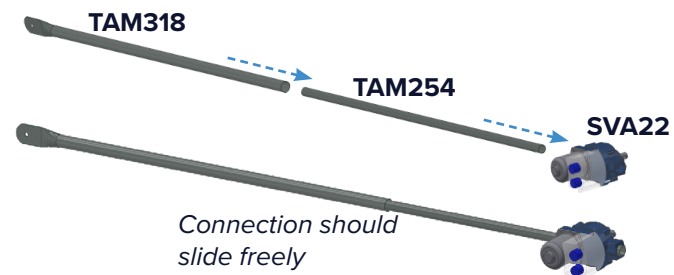
Motorised Winder

1. Attach wiggle wire channel

Fix with tek screw to base rail. Use nut and bolt (nut facing inside tunnel)

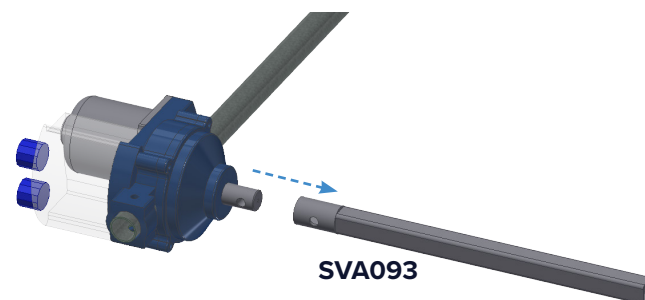


2. Assemble motorised winder



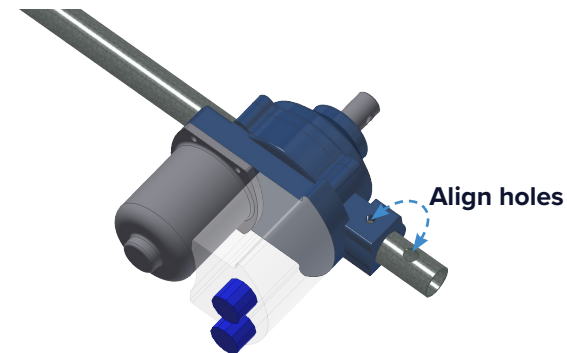
4. Attach drive tube adapter

Fasten with bolt.



3. Fix motor to arm

Align holes with tube and secure with bolt.



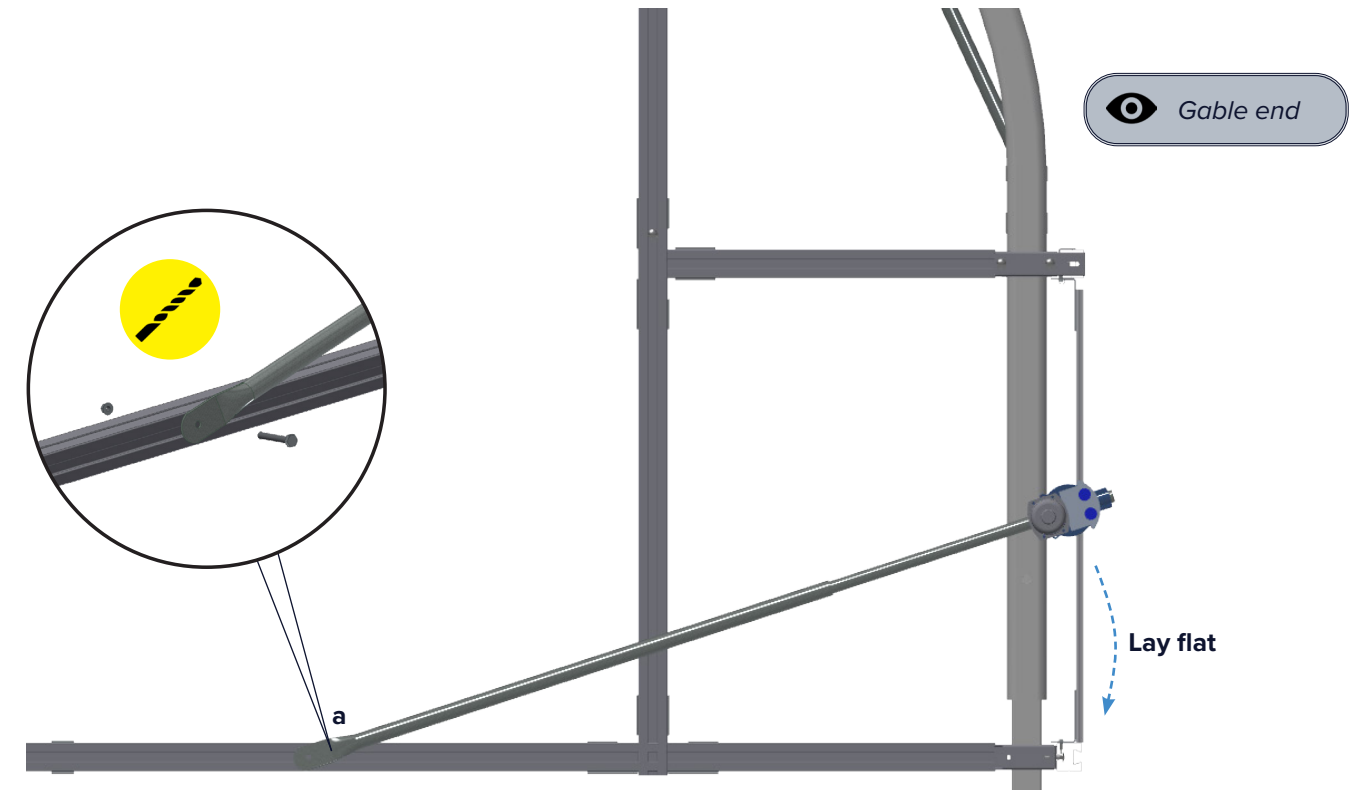
5. Connect motor to drive tube

Slide onto drive tube and fix with tek screw.



7. Attach arm to base rail

Lay motor assembly on the floor with telescopic arm in shortest position. Mark position **a** on base rail and drill hole. Fix telescopic arm with nut and bolt. The middle connection should slide freely.

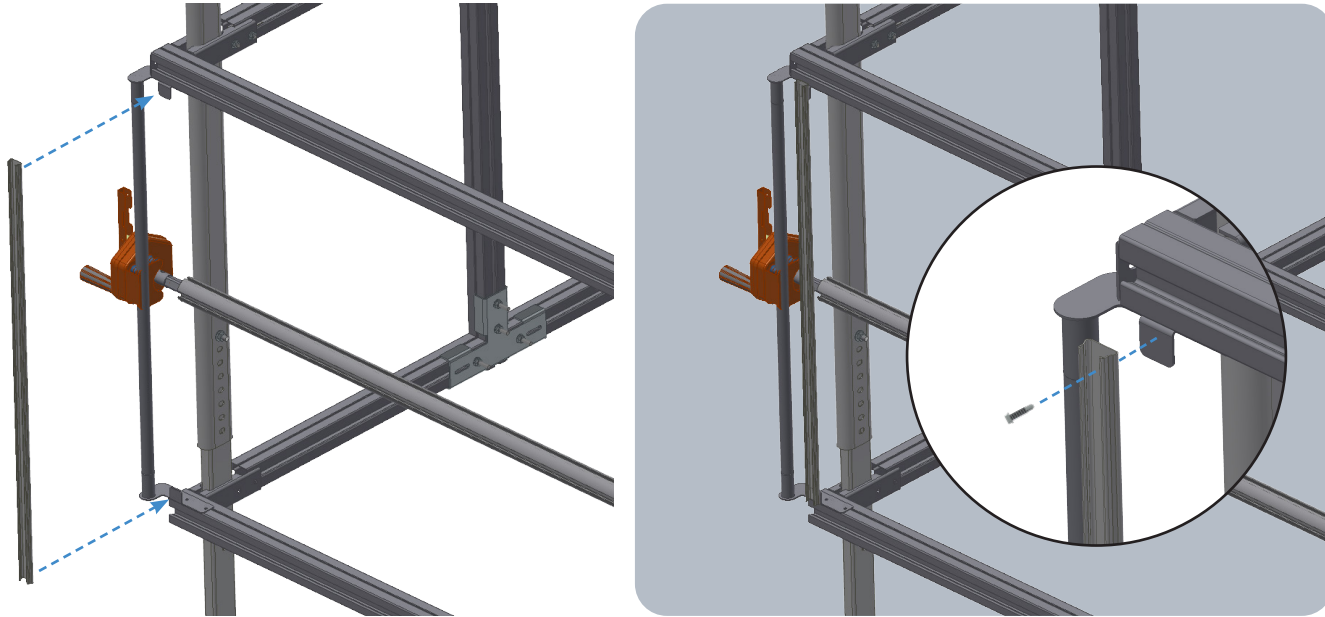


8. Test operation and leave in rolled up position

Before fixing side vent netting, install wiggle wire profile uprights, if not already in place.

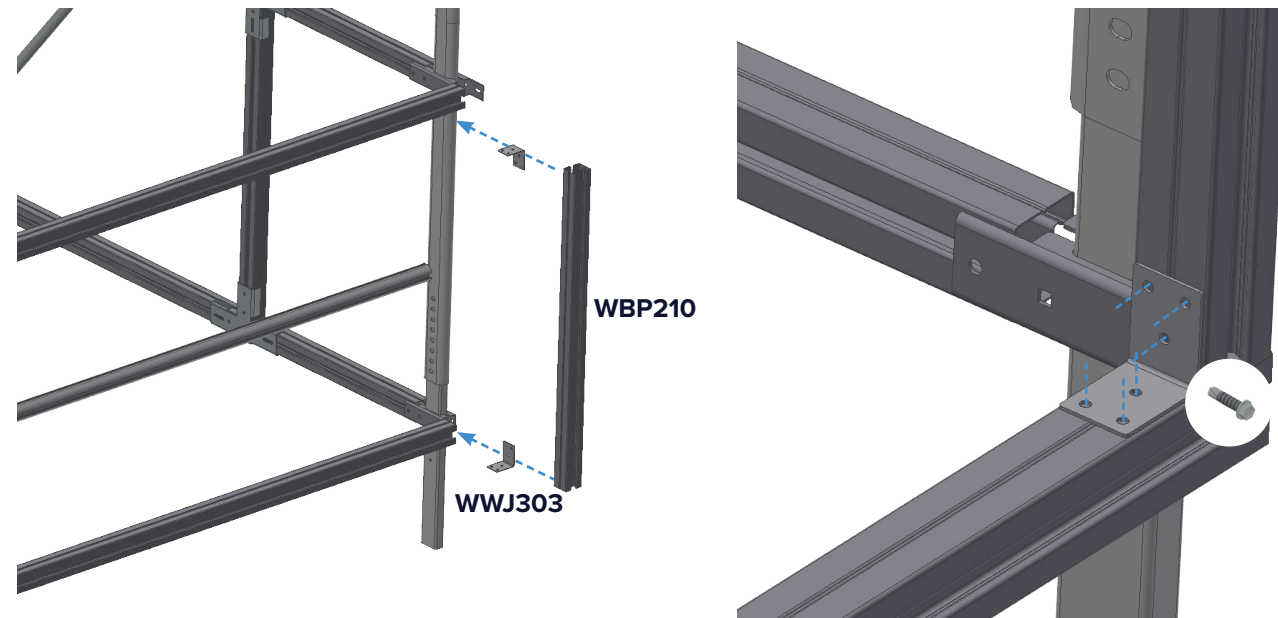
For ends with curtain winder

Attach a length of wiggle wire channel to the winder assembly bracket using tek screws.



For ends without curtain winder

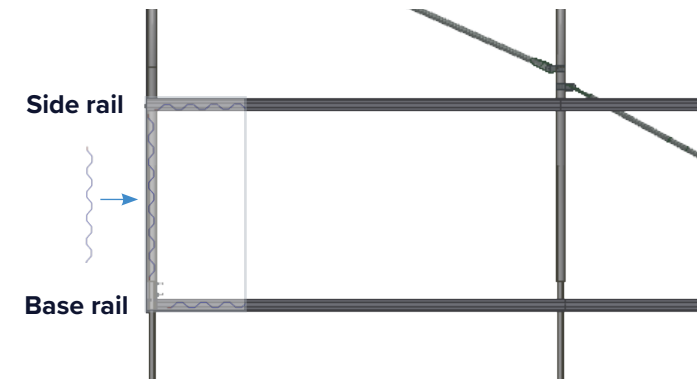
Attach a length of steel profile between the side rail and base rail. Use L bracket and tek screws to fix to rails.



! If you've installed a curtain. Ensure curtain is in rolled up position before fitting net.

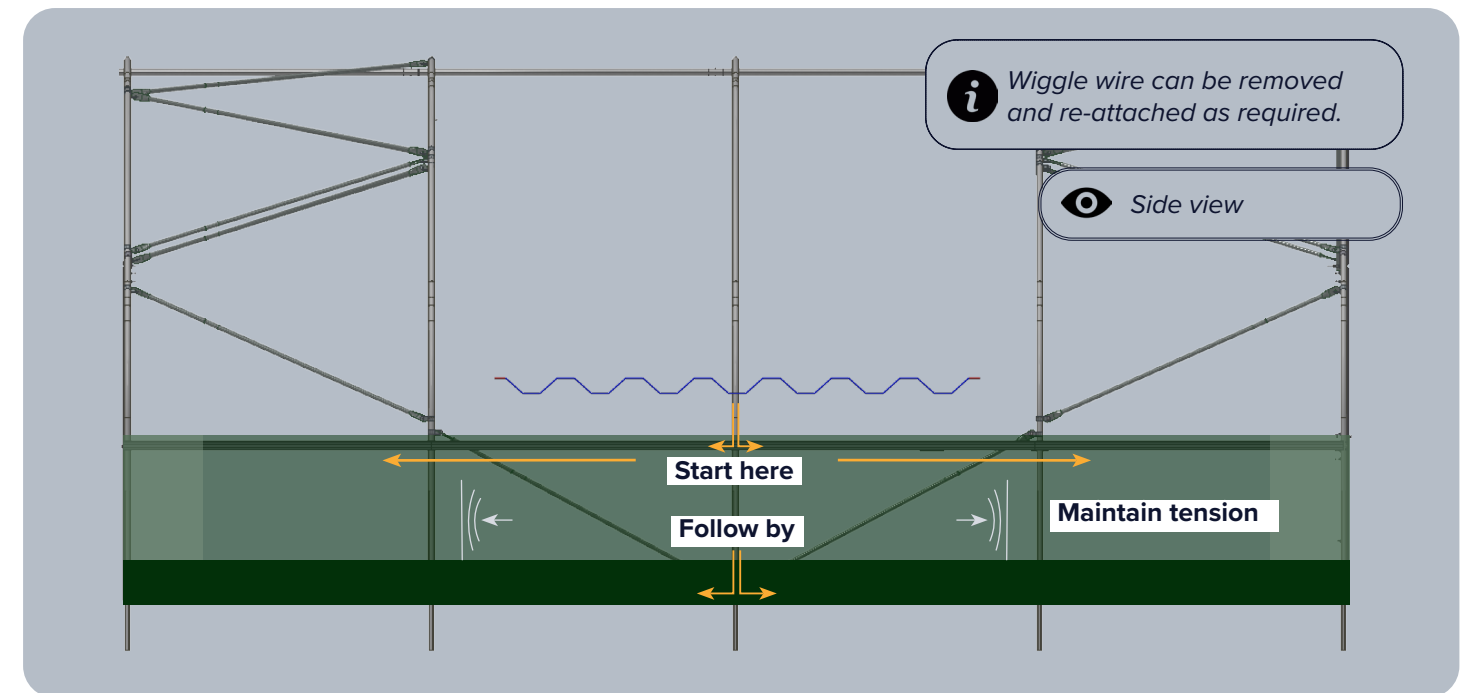
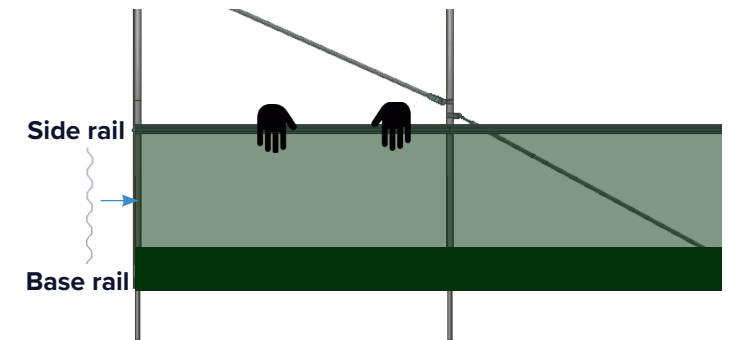
1. Fit draught exclusion panels

Install one for either end of curtain.



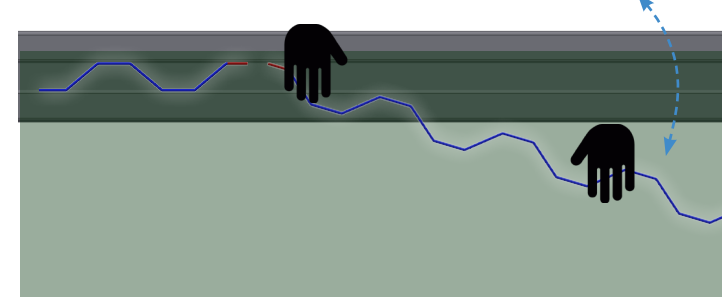
2. Position net and hold in place

Attach either end with a piece of wiggle wire pulling tight down the length.



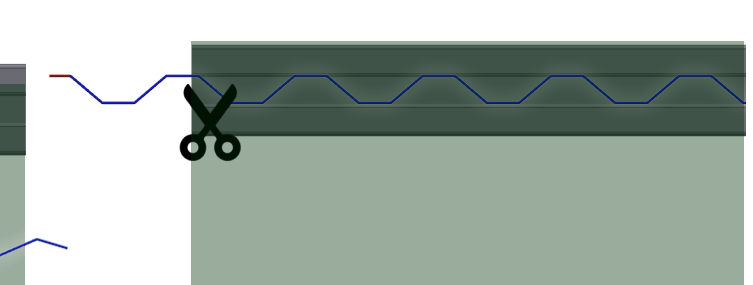
3. Attach net with wiggle wire

Start from the centre of the side rail working outwards. Then attach to the base rail.



4. Cut wiggle wire to length

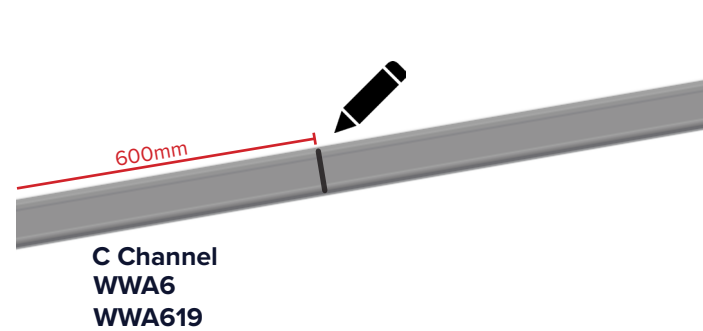
Using a pair of wire snips.



Please refer to instructions INS440, INS388, and INS068

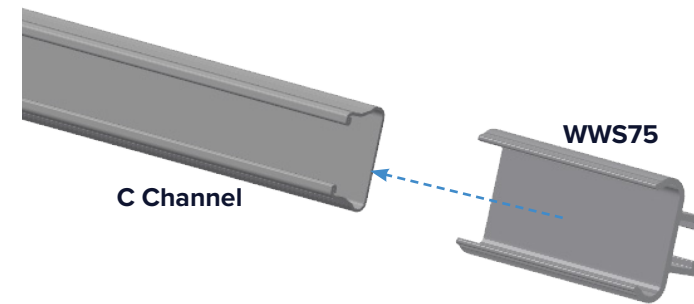
1. Mark C channel every 600mm

Use tape or a marker pen.



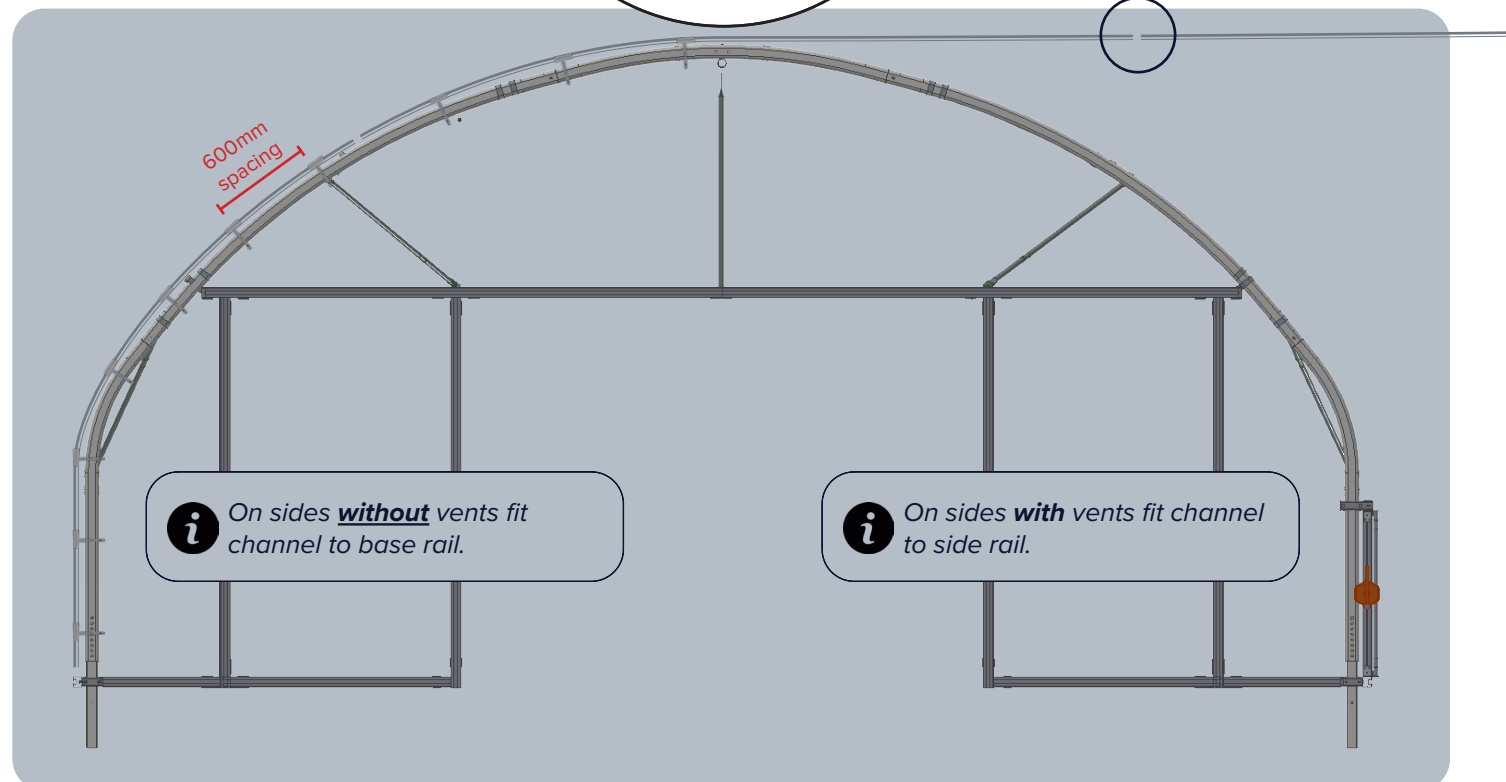
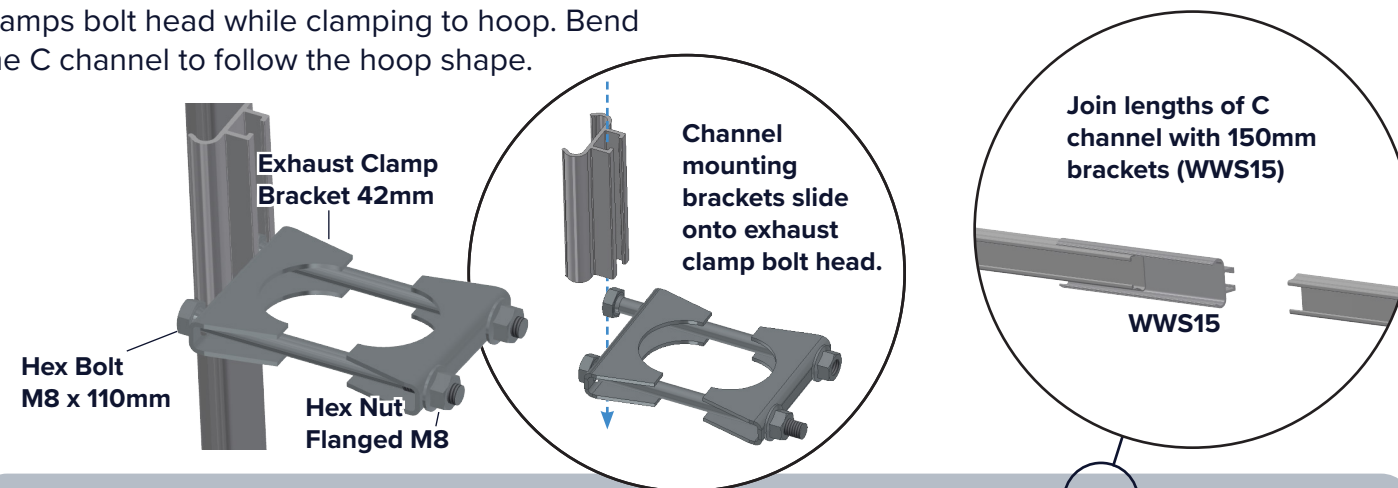
2. Slide channel mounting brackets

Onto C Channel. One for each mark.



3. Attach C channel to hoop

Slide channel mounting brackets onto exhaust clamps bolt head while clamping to hoop. Bend the C channel to follow the hoop shape.



Assemble Louvre

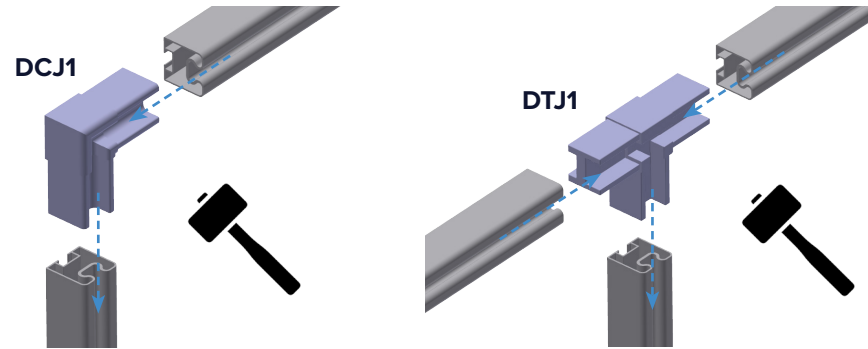
1. Slide brackets onto outer uprights

Ensure correct orientation.

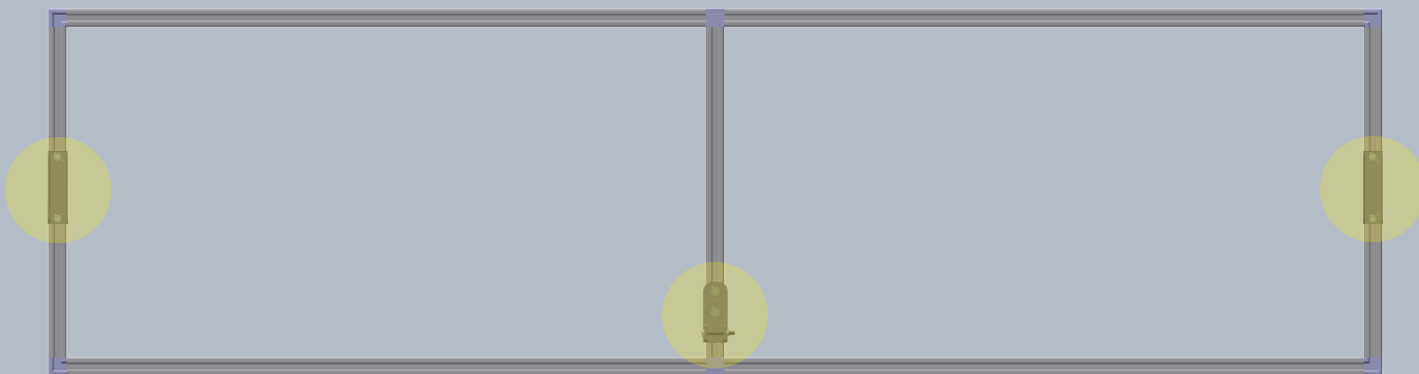


3. Complete frame using corner and T joiners

Use mallet to secure.



Final Assembly

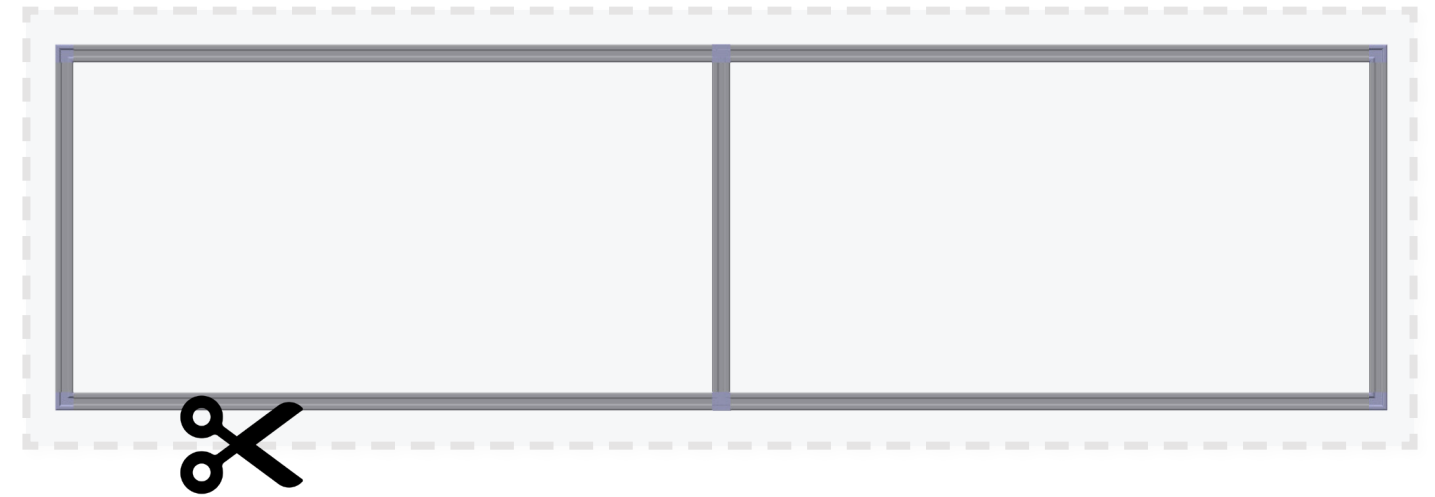


Roughly position brackets (highlighted) and leave finger tightened to allow for adjustment.

Cover Louvre

1. Roughly cut polythene to size

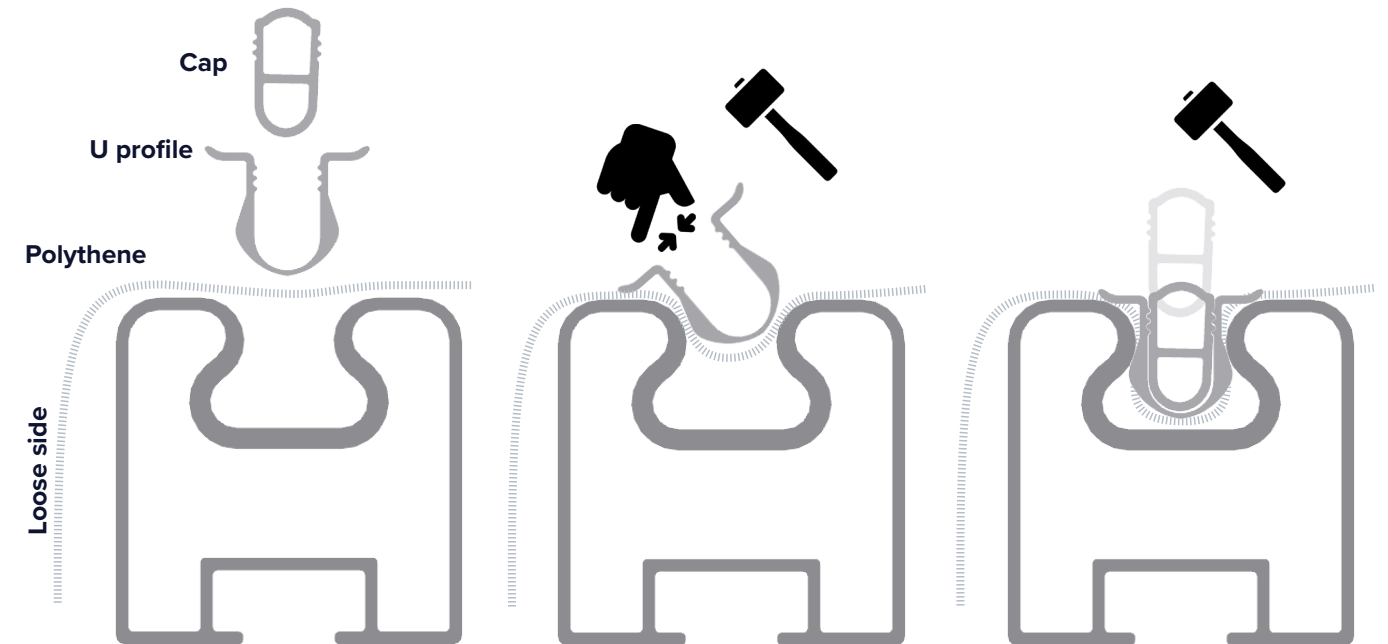
Allow approximately 30cm excess of polythene on all sides to allow for U profile to be pushed into position.



2. Fix polythene to frame

Attach polythene to frame perimeter using ali trap, ensuring polythene is tight. See below for guidance using ali trap.

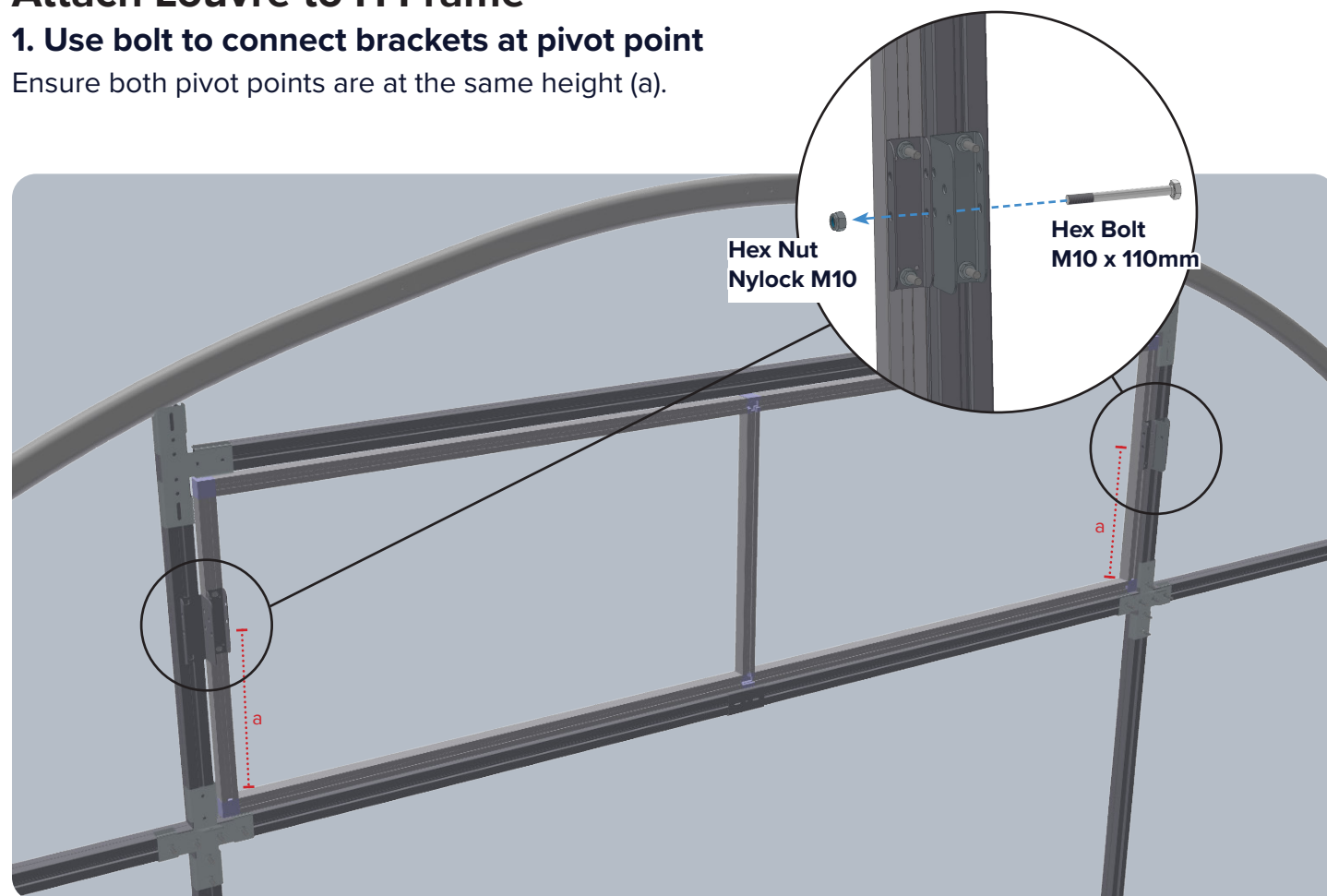
! Do not fix polythene to centre upright.



Attach Louvre to H Frame

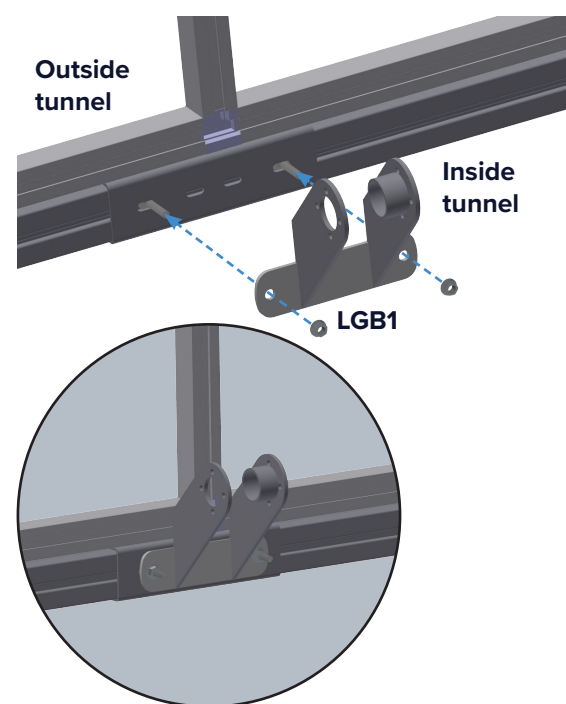
1. Use bolt to connect brackets at pivot point

Ensure both pivot points are at the same height (a).

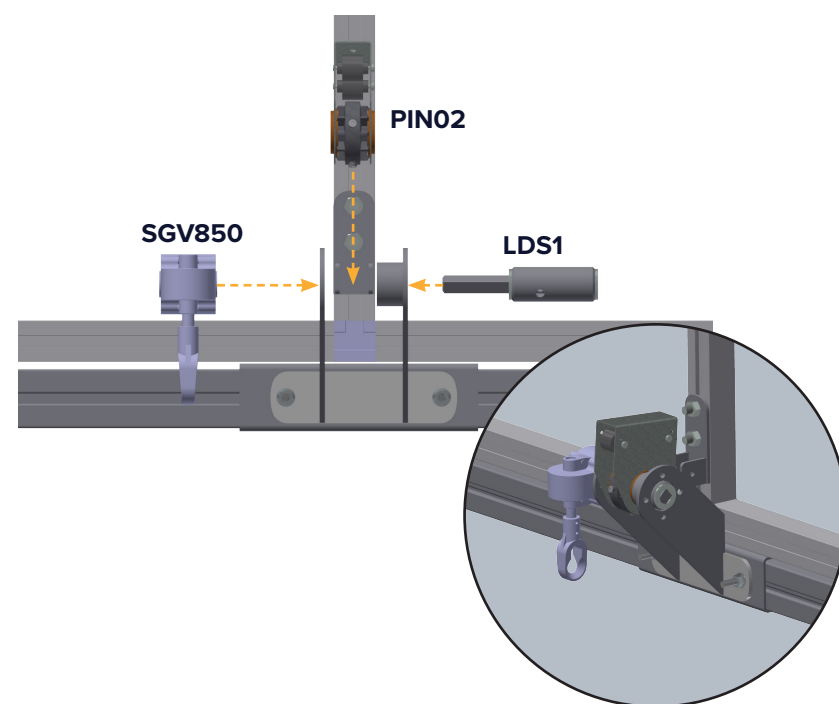


Connect Rack and Pinion

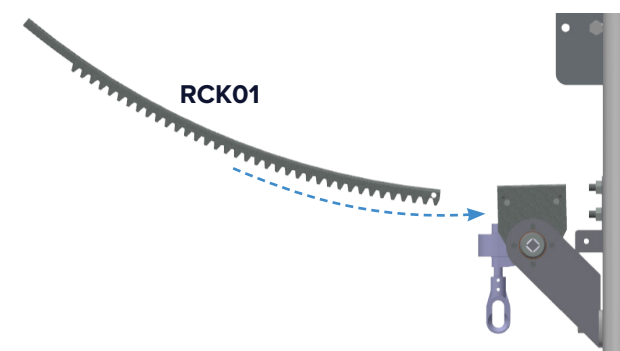
1. Attach bracket to lintel



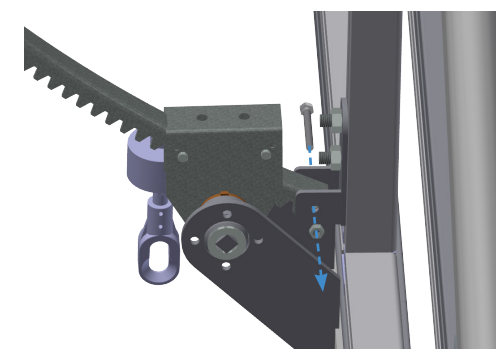
2. Assemble motor



3. Slide rack into motor assembly

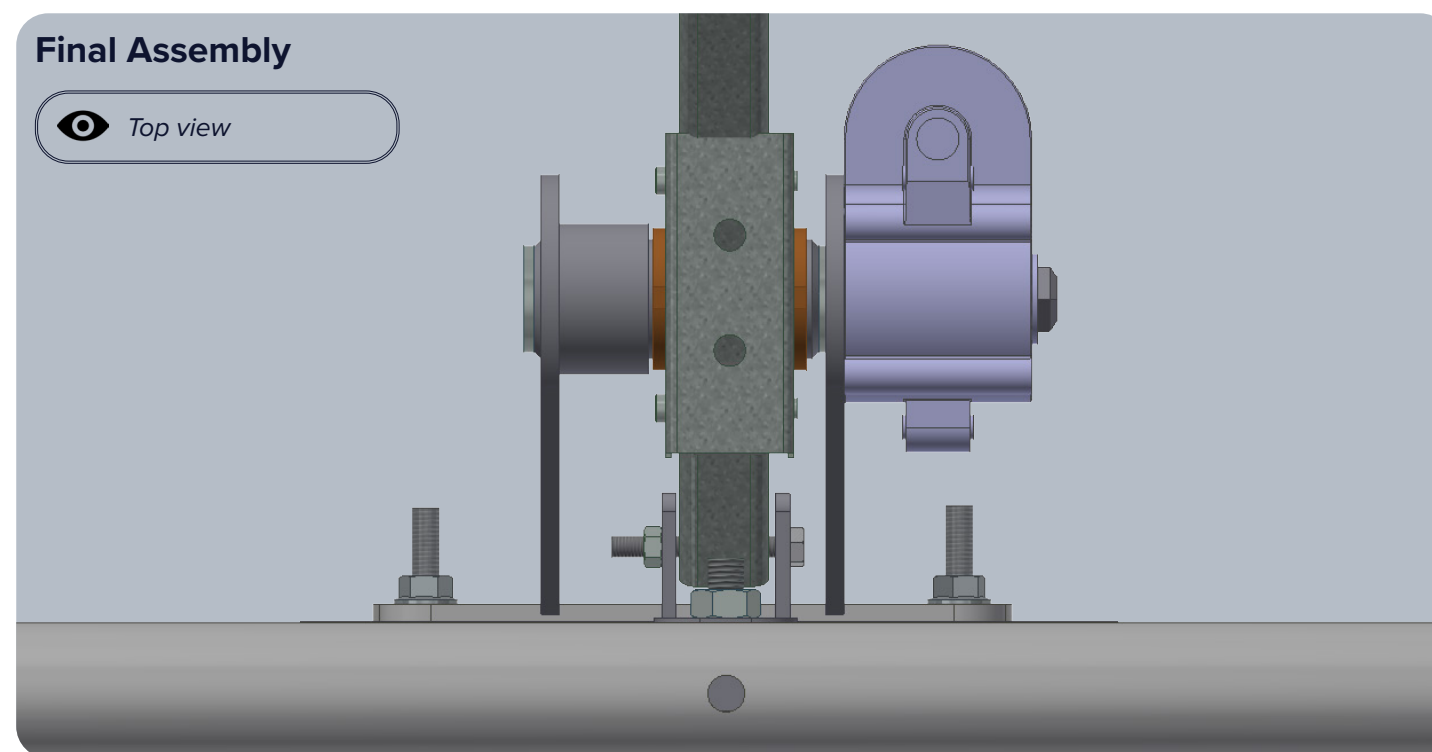


4. Attach rack to louvre bracket



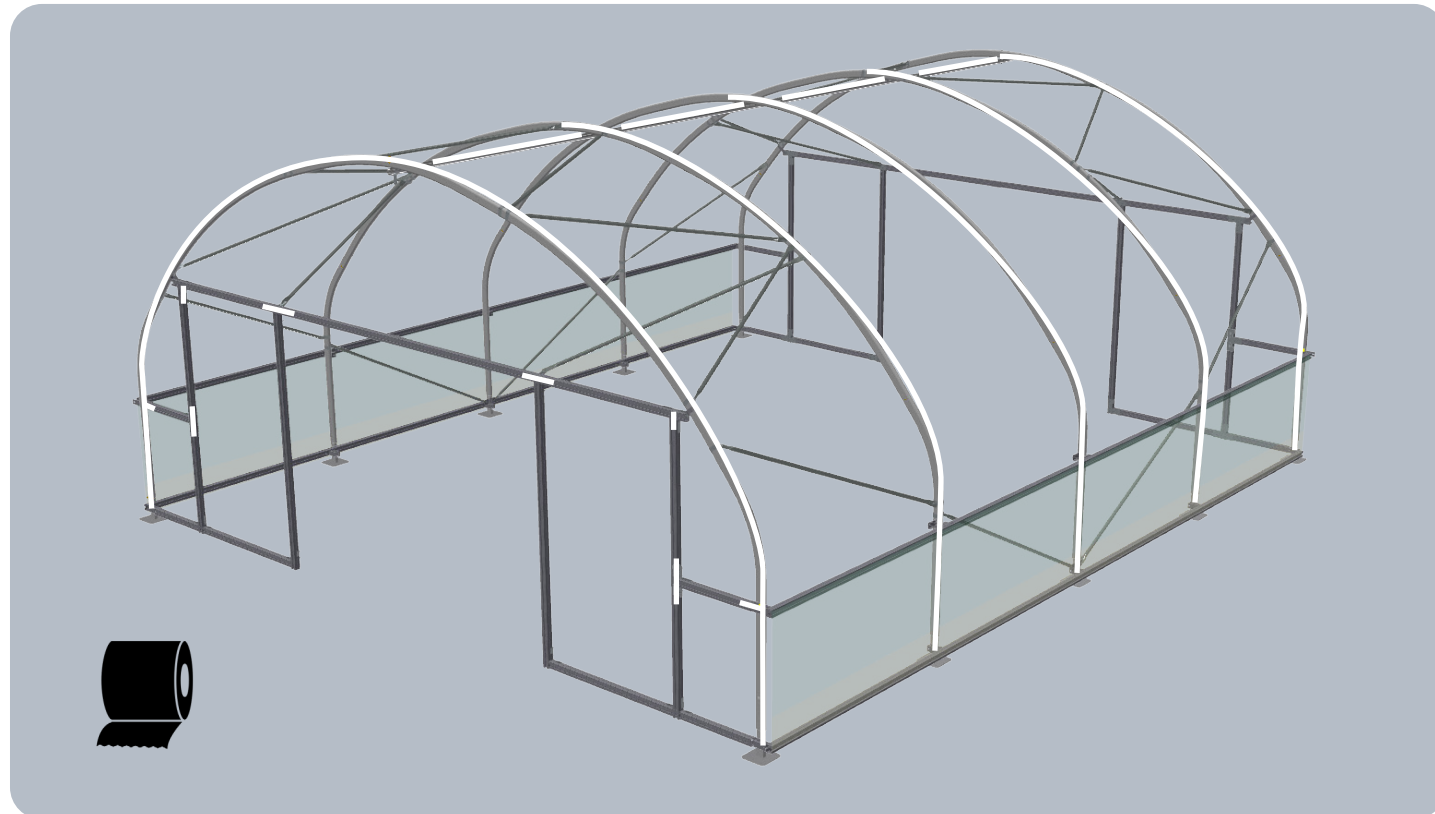
Final Assembly

Top view



Applying Anti Hot Spot tape

Use anti hot spot tape to cover hoops and ridge bars, as well as any sharp edges before covering your tunnel.



Prepare Polythene

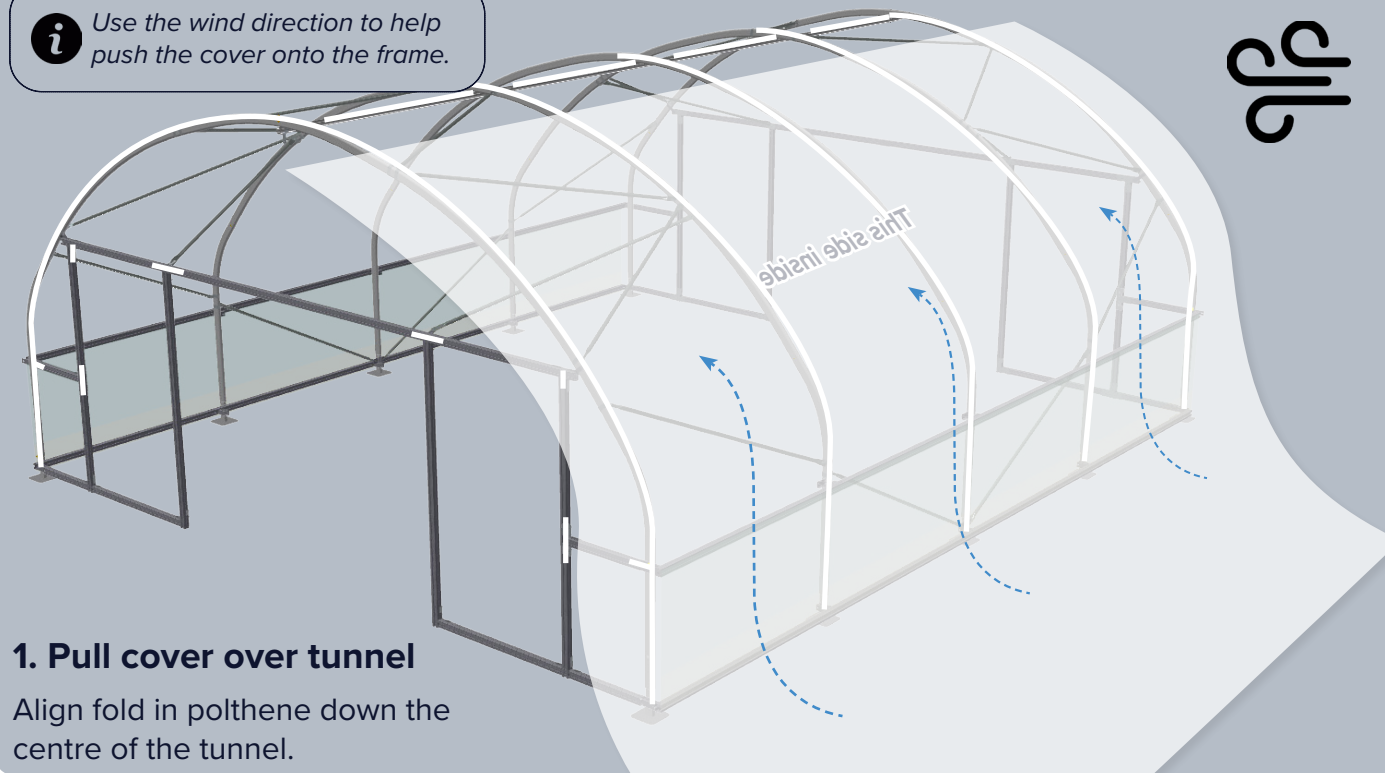
Unroll or unfold your polythene. Polythene is folded widthways. Ensure your polythene is the right way round - you should be able to read the text from the inside.



Covering Polytunnel With Wiggle Wire Over Hoop

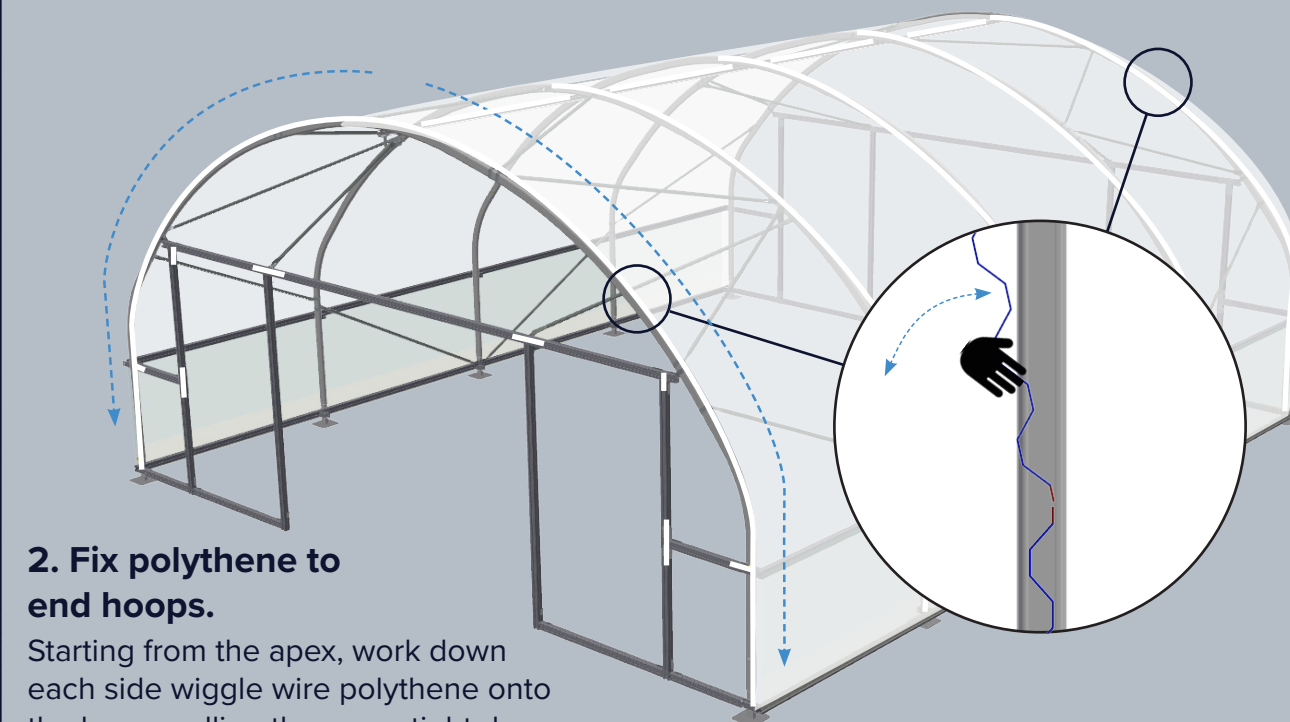
! Do not attempt if wind speed exceeds 15mph.

i Use the wind direction to help push the cover onto the frame.



1. Pull cover over tunnel

Align fold in polythene down the centre of the tunnel.

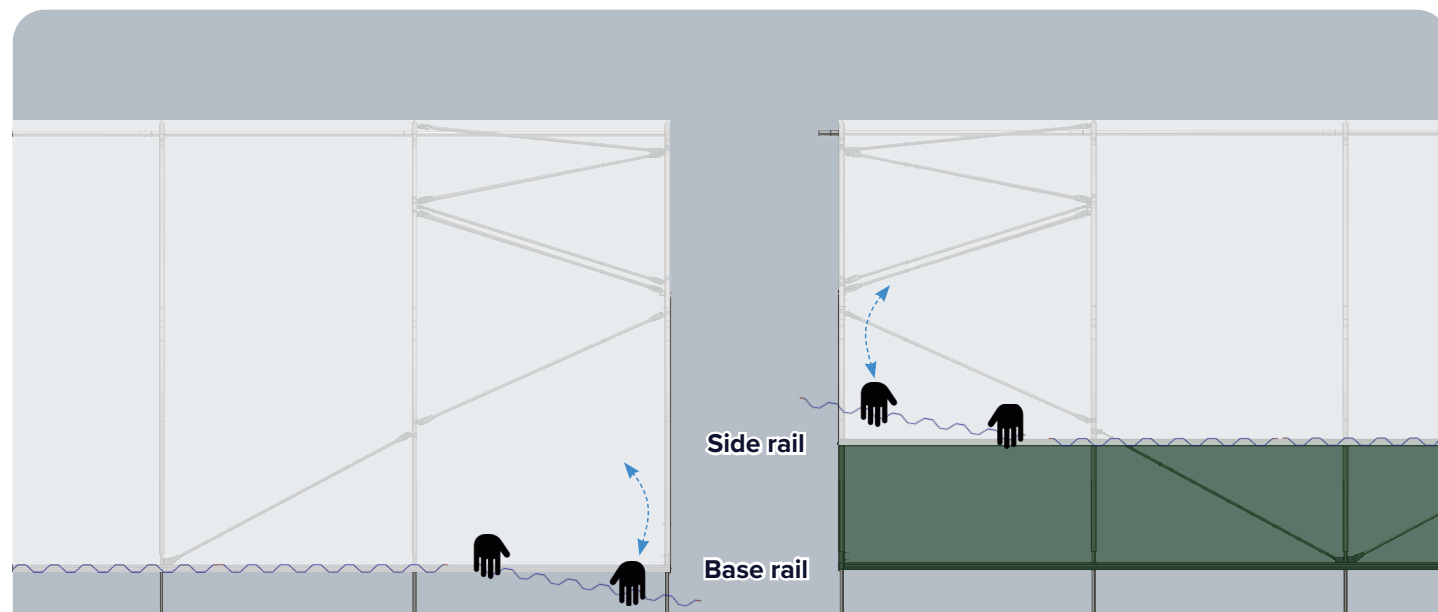


2. Fix polythene to end hoops.

Starting from the apex, work down each side wiggle wire polythene onto the hoop, pulling the cover tight down the length as you go.

For "Covering Polytunnel Pleating Gable Ends Method" see page 59

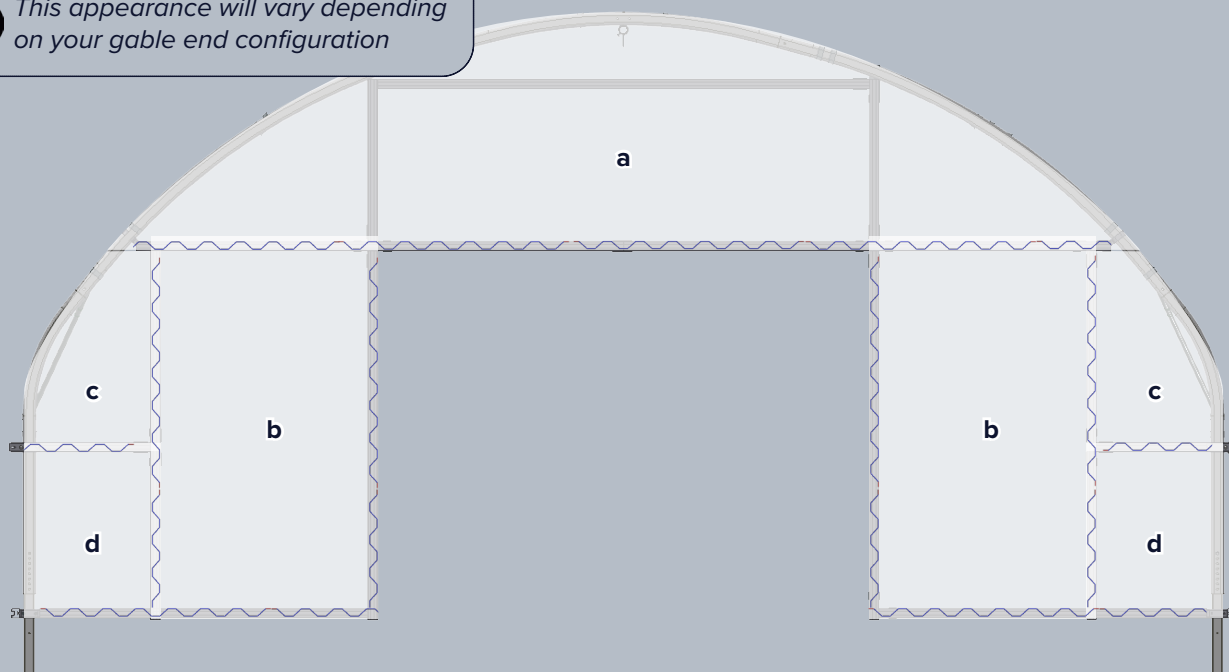




3. Fix polythene to polytunnel sides

For sides with vents attach to side rail.
For sides without vents attach to base rail.
Start from the middle and work outwards.

i This appearance will vary depending on your gable end configuration

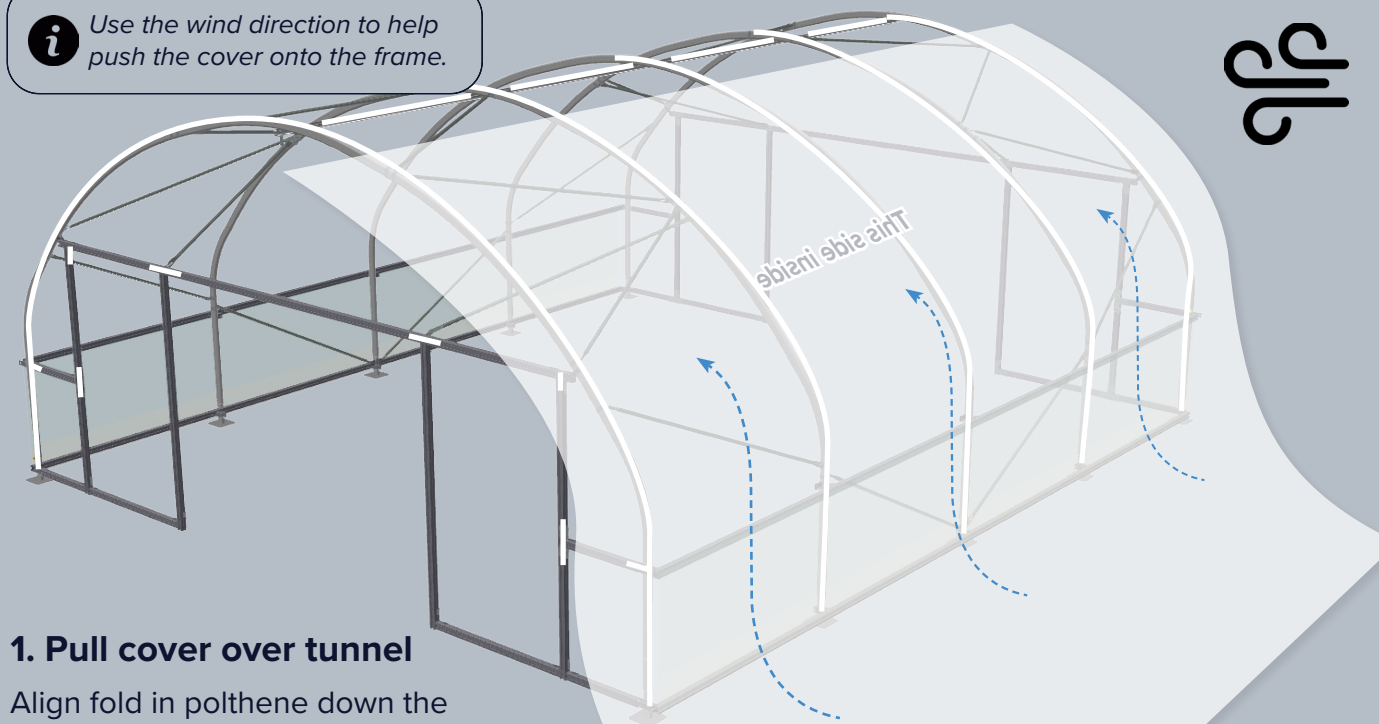


4. Fix Gable end panels

Cut polythene roughly to size to fit each section. Wiggle wire each piece into the gable end frame box profiles. Attach the panels to the wiggle wire channel on the hoop. Wiggle wire can be layered to accommodate multiple sheets.

Covering Polytunnel Pleating Gable Ends Method

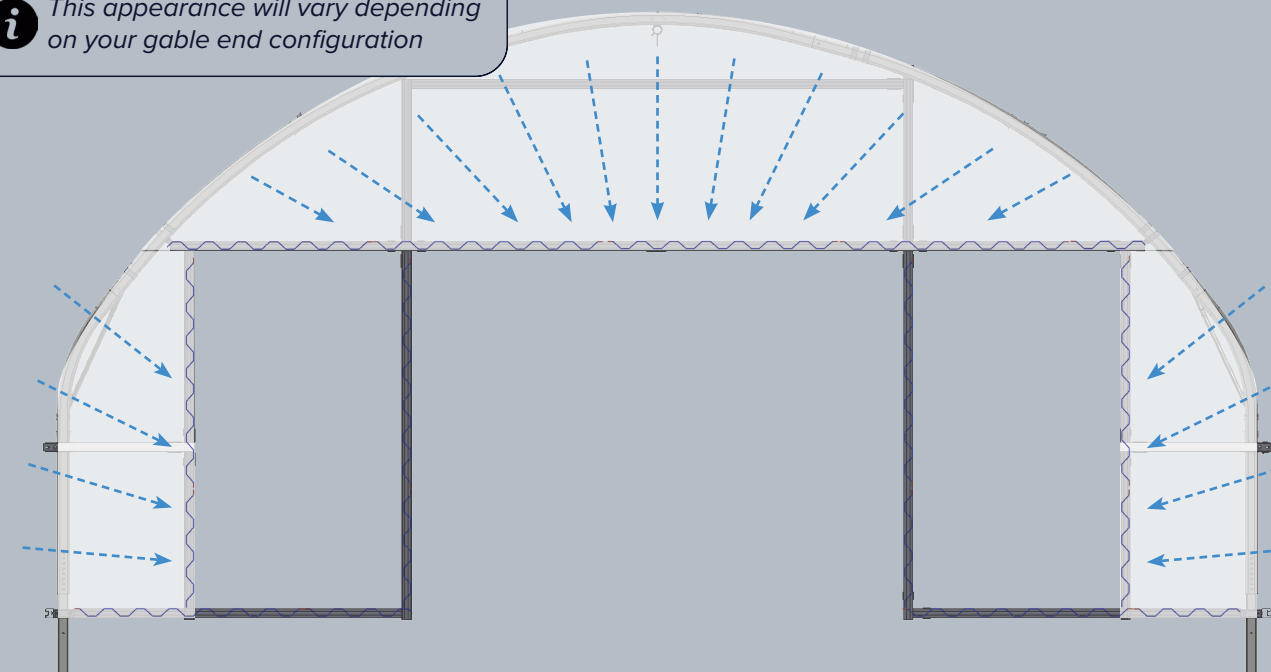
i Use the wind direction to help push the cover onto the frame.



1. Pull cover over tunnel

Align fold in polythene down the centre of the tunnel.

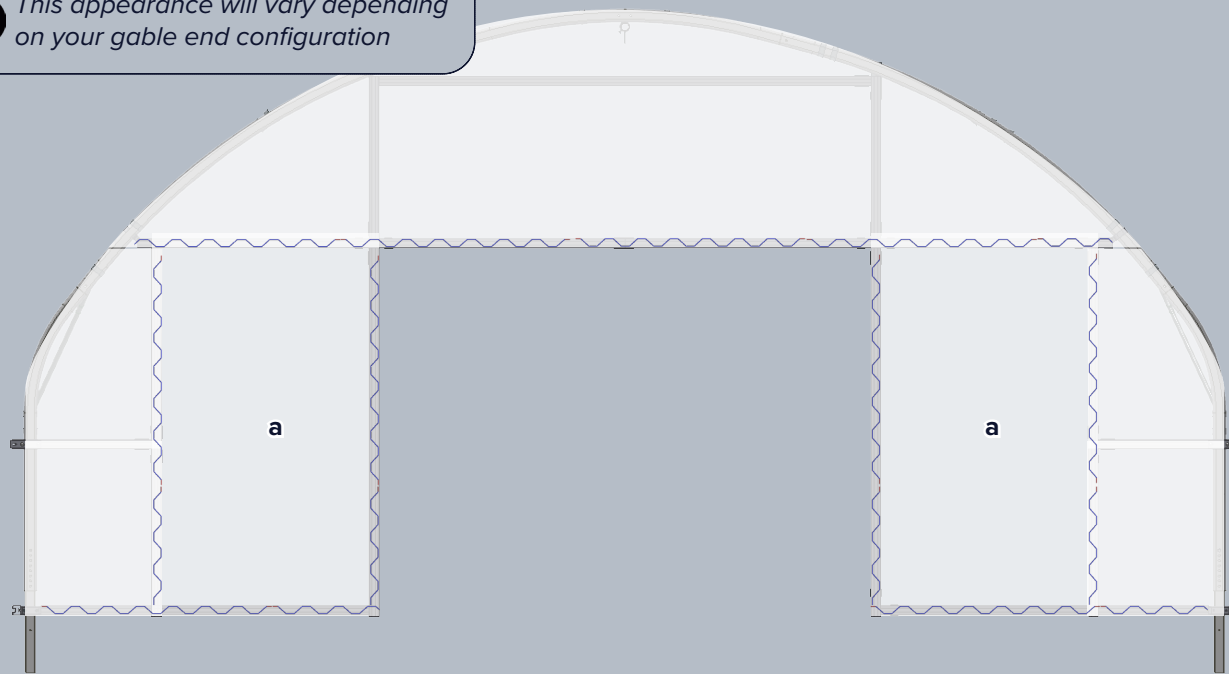
i This appearance will vary depending on your gable end configuration



2. Pleat cover into lintel and uprights

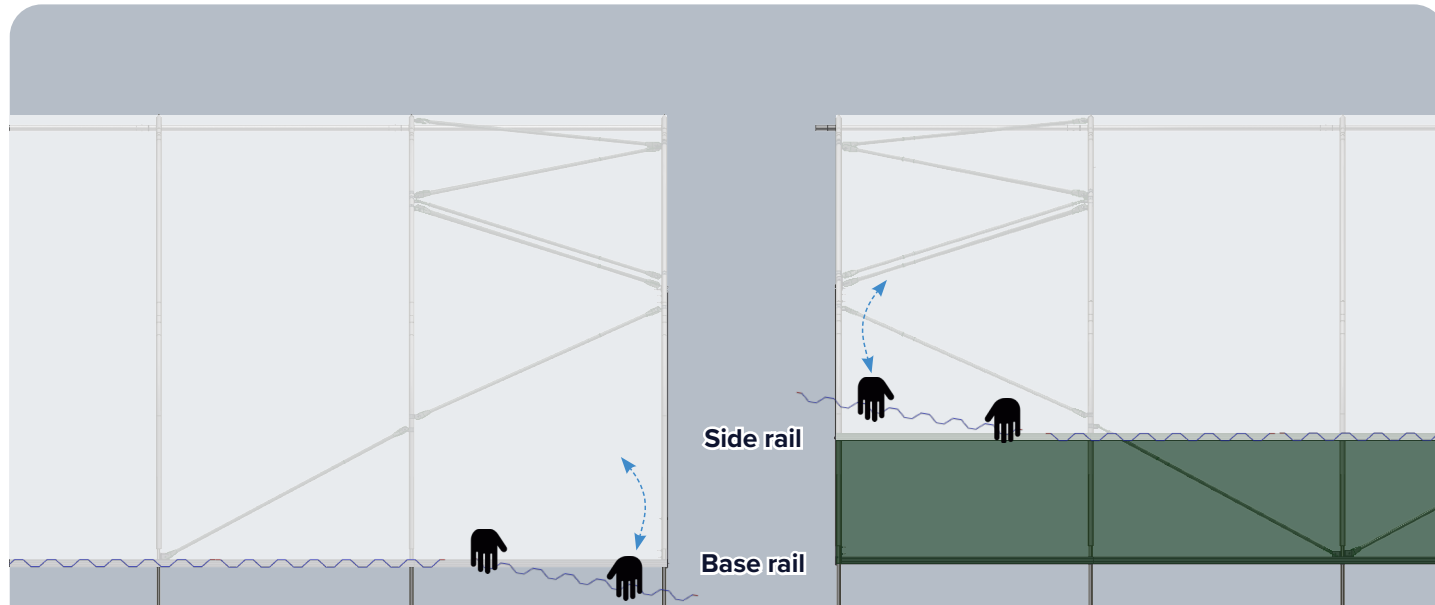
Pull the polythene round the gable end and pleat neatly into the lintel and uprights.

i This appearance will vary depending on your gable end configuration



3. Add side panels

Cut in separate pieces to panel in at positions **a** and fix with wiggly wire.



4. Fix polythene to polytunnel sides

For sides with vents attach to side rail.
For sides without vents attach to base rail.
Start from the middle and work outwards.

We're Always Looking To Improve

If you have any feedback on:

- Delivery
- Design
- Build quality
- Instructions
- Support & customer services

Please email: marketing@npstructures.co.uk

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Help & Advice



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