

# Basic Super Duty Greenhouse Installation

!!!! CAUTION: Tube ends may be sharp !!!!

Read directions completely before beginning assembly.



**Growers  
Solution**

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## Step 1 - Ground Stakes

- Square the corner stakes with each other.
- Drive corner stakes and then drive the rest of the stakes on **4 ft centers**(Fig 1.1).

**Note:** Use a large bolt and washer, or 2x4 on top of stakes to drive them in.

- The stakes should be approx 24 inches below ground. The section above ground will be the height of your sidewall(Fig 1.2.).

**About 3 ft for Super Duty Side**

**Note:** Use a string level to keep ground stakes level.

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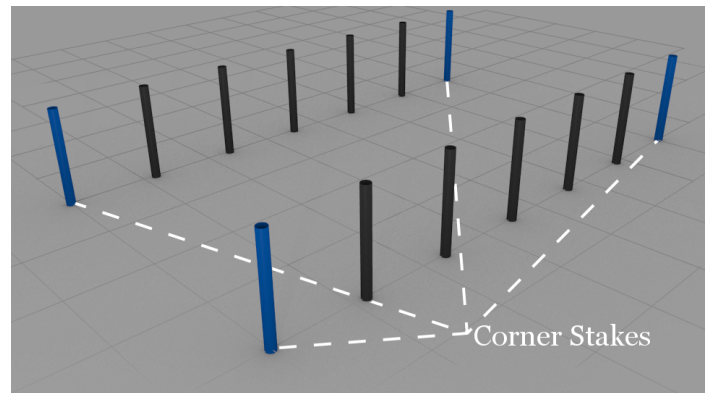


Fig 1.1 Ground Stakes

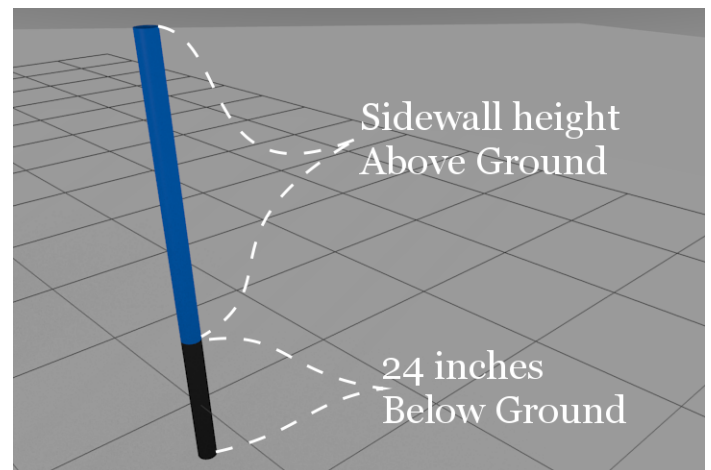


Fig 1.2 Ground Stake Depth

## Step 2 - Bow Assembly

- Place bow sections on flat ground(Fig 2.1).
- Slide sections together, and secure at joints with self-tapping screws(provided).

**Note:** Bow is 4 pieces. Two dog leg bends and two regular bends.

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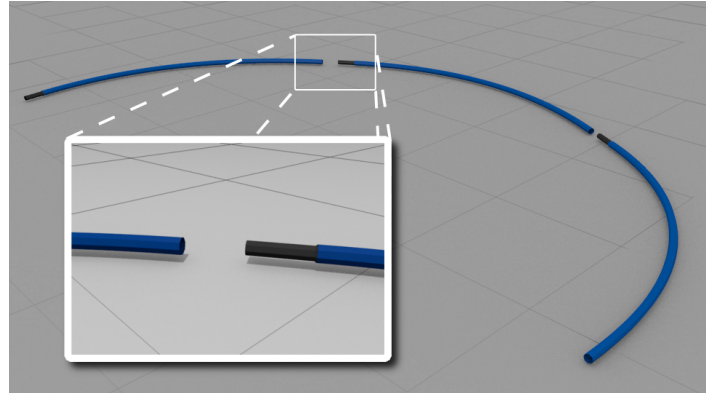


Fig 2.1 Bow Assembly

## Step 3 - Bow Installation

- After bows have been assembled, raise upright and place ends in ground stakes(Fig 3.1).

**Note:** Place swaged(crimped) ends on the same side of the greenhouse. This will keep the bows even, and lined up. Dogleg ends go into ground stakes.

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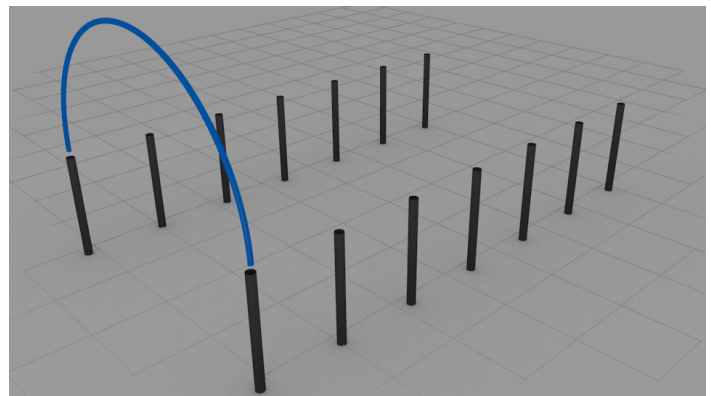


Fig 3.1 Bow Installation

## Step 4 - Purlins

- The straight **purlin pipe** sections connect together, and the assembled purlin is attached to the top of the greenhouse using the **purlin clamps**(Pic 4.1). Trim extra pipe off.

- Install self-tapping screws through each purlin clamp for additional security.

**Notes:** You will also install a purlin at approximately 10 and 2 o'clock on Super Duty.

- Wind braces are used on houses **longer than 48 ft.**
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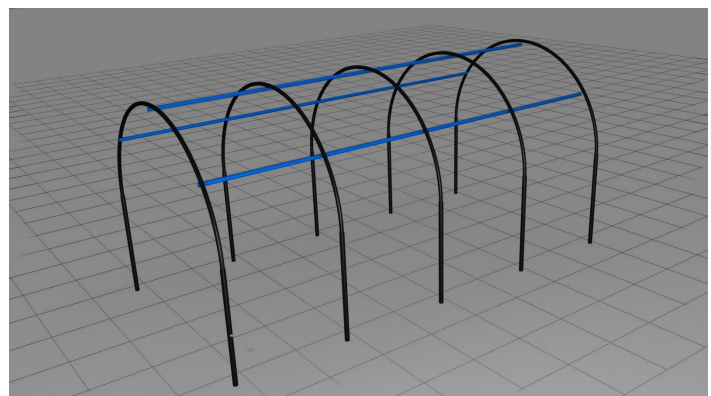


Fig 4.1 Purlins



Pic 4.1 Purlin Clamp

## Step 5 Base/Head Boards

- Attach **head boards**(also called hip boards on Super Duty houses) and **base boards** (2 x 6 pressure-treated recommended) on the top and bottom of the sidewall with 6 inch carriage bolts **or** 2-hole pipe straps.

**Note:** Both fasteners work equally well, it is simply a matter of personal preference(which is why neither is included). You choose.

**Note: For carriage bolts:** drill through ground stake, bow, and 2 x 6 and install carriage bolt.

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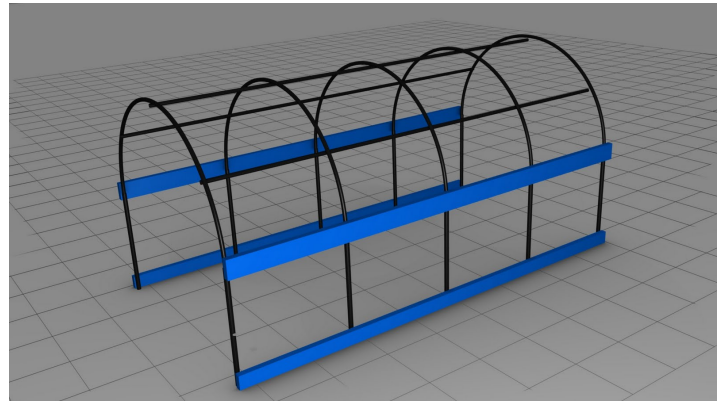


Fig 5.1 Head and Base Boards

## Step 6 - End Walls

For best results, we recommend the use of our [End Wall Kits](#).

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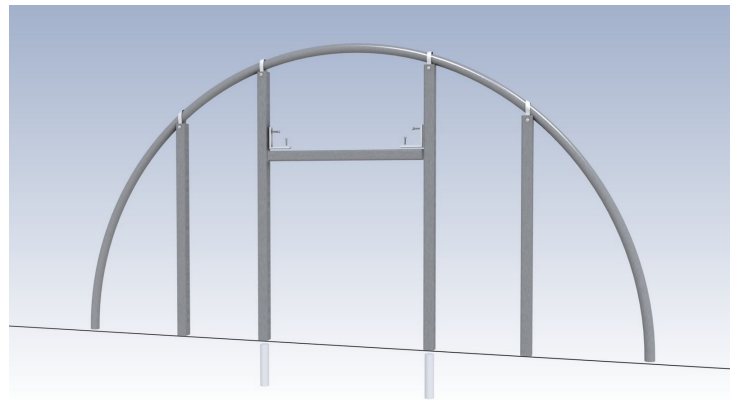


Fig 6.1 End Wall Kit

## Step 7 - Wire Lock

**Note:** Not all Houses use wirelock. Some use batten tape and staples.

- Attach the Wire Lock **channel** on the top of the first bow and last bow using TEK screws(included) every 18 inches.

- Attach the Wire Lock **channel** on either the **head or base boards**(depending on whether you're using roll-up sides) all the way around the base of the greenhouse in the same manner.

**Note:** See the [slideshow online](#) for more information.

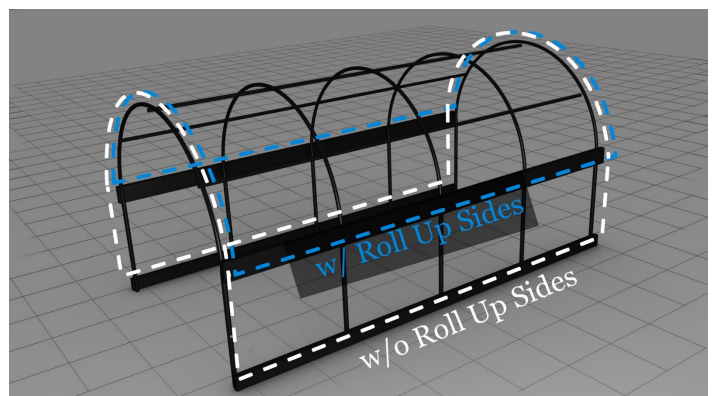


Fig 7.1 Wire Lock Channel Installation

## Step 8 - Film Installation

- Pull film over the greenhouse (on a non-windy day!)

**Note:** Plastic normally has 12" or larger overhang on all sides.

- Lay film over the Wire Lock channel, and fasten the plastic into the channel by placing the wiggle wire into the channel on top of the plastic (Fig 8.1).

**Note:** Please [watch the video online](#) for more information.

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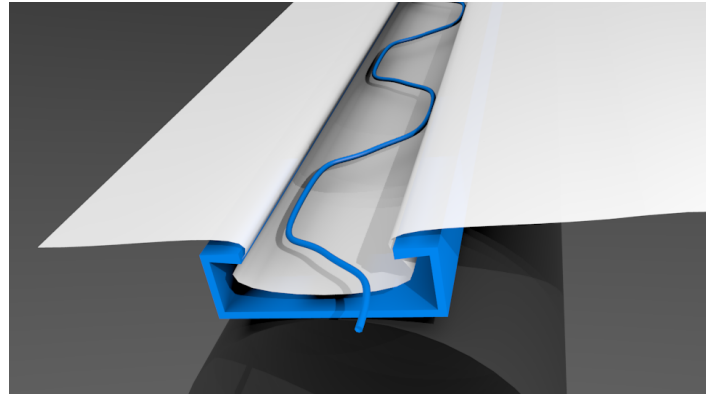


Fig 8.1 Wire Lock / Film Installation

Have more questions? Take a look at our ever expanding resources at [GrowersLearning.com](http://GrowersLearning.com). If that still doesn't answer all your questions, feel free to call us at 931-528-3390