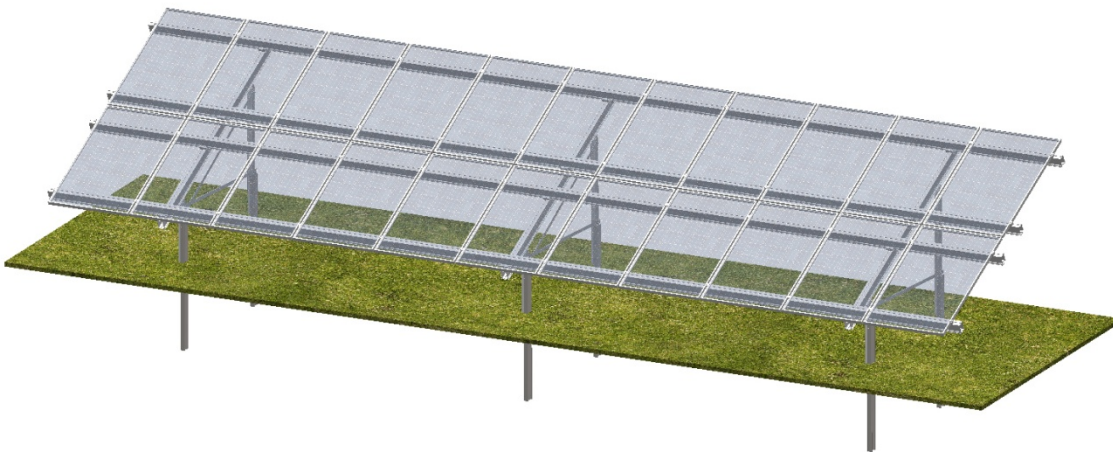


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## 2X11 PORTRAIT ARRAY WITH 6 POSTS ASSEMBLY TIME ESTIMATE



Connection Detail	Time	# Of Connections Per Array	Total (Man Minutes)
Sigma Post Rammed	2 Minutes	6	12 Minutes
Vertical Post Connection	1 Minutes	6	6 Minutes
Place Base Rails	30 Seconds	3	1.5 Minutes
Bearing Block Connection	30 Seconds	6	3 Minutes
Place Top Rails	30 Seconds	4	2 Minutes
Cross Adapters Connection	10 Seconds	48	8 Minutes
Install Modules (Grounded)	20 Seconds	22	7.5 Minutes
End Clamp Connection	20 Seconds	8	1.5 Minutes
Mid Clamp Connection	10 Seconds	40	6.5 Minutes
Diagonal Strap Connection	1 Minutes	6	6 Minutes
<b>Total</b>			<b>54 Minutes Per Rack</b>

\* See website for detailed animation of Landscape Array Construction

<http://www.youtube.com/watch?v=RzjgOvniKlk>

1. Time estimates assume that parts are readily accessible to laborers for rack assembly.
2. Post Ramming Equipment – GAYK HRE Hydraulic Ram or equivalent.
3. Assume the soil is favorable to accept 4 – 8 foot embedment depth of Sigma posts.