

The image shows a close-up of a wooden deck installation. In the foreground, a dark grey metal joist system is laid out on a green lawn. The joists are connected by small metal brackets. Above the joists, several light-colored wooden planks are laid out, showing how they fit into the system. In the background, a stone wall and a large window with a grey frame are visible. The overall scene is bright and clear, suggesting a sunny day.

millboard

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Installation Guide for **DuoSpan™** Joists & Beams

Considerations

Considerations should be made prior to starting installation on the design of the deck:

Does it include edging, a board or Bullnose Board around the perimeter?







Does the design include area to be split up in different sections?

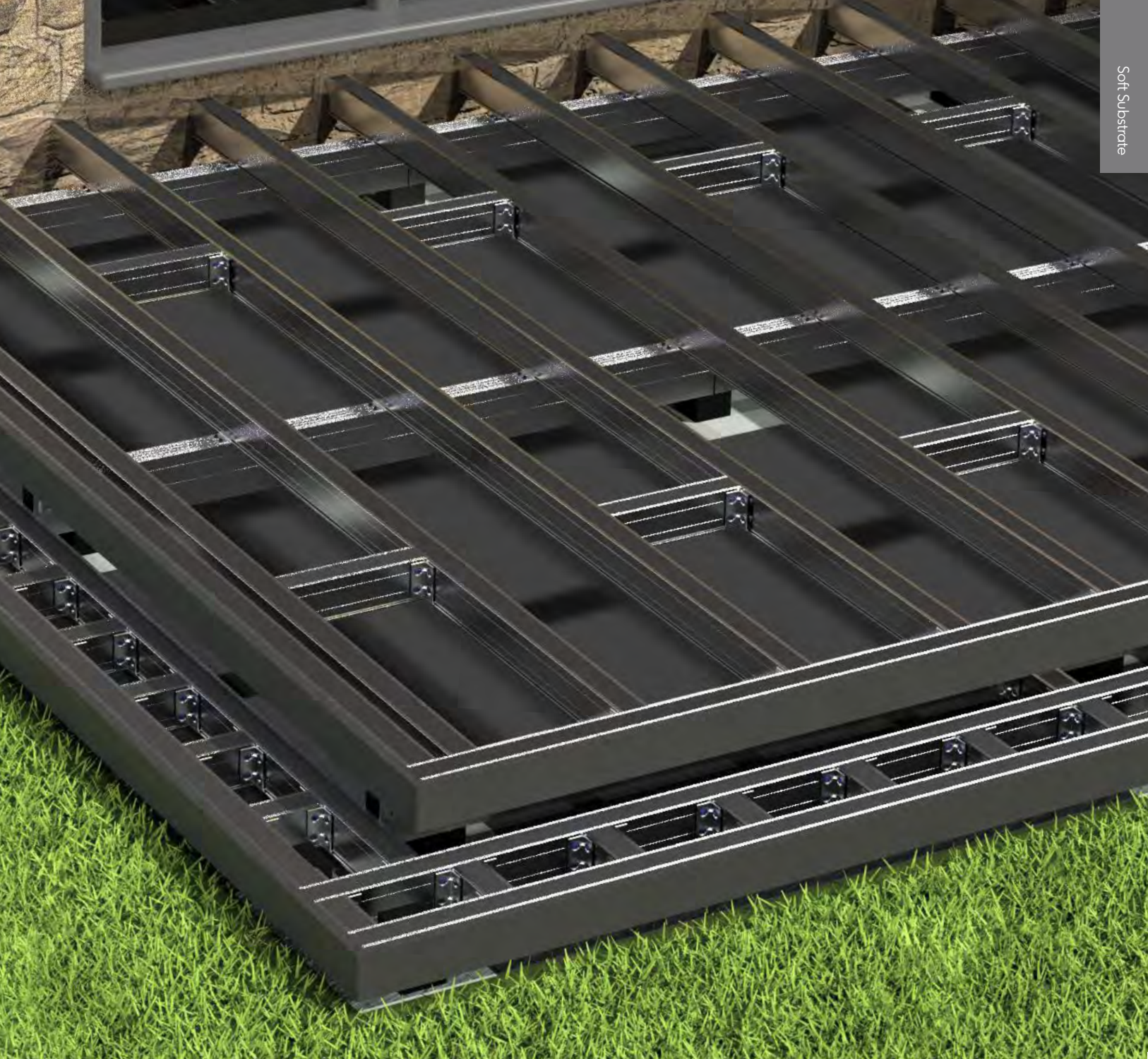
Are the boards being laid at 90 degrees or 45 degrees?

Are the boards being laid with a herringbone or a mitre?

Does the deck have a curve?

Does it need to have access hatches for drainage outlets etc?

		
Picture-board design	Alternative colour inlay design	Herringbone design
		
Mitre or chevron design	Mitre to a board design	Curved design



DuoSpan™ Joists & Beams Installed at ground level (soft substrate)

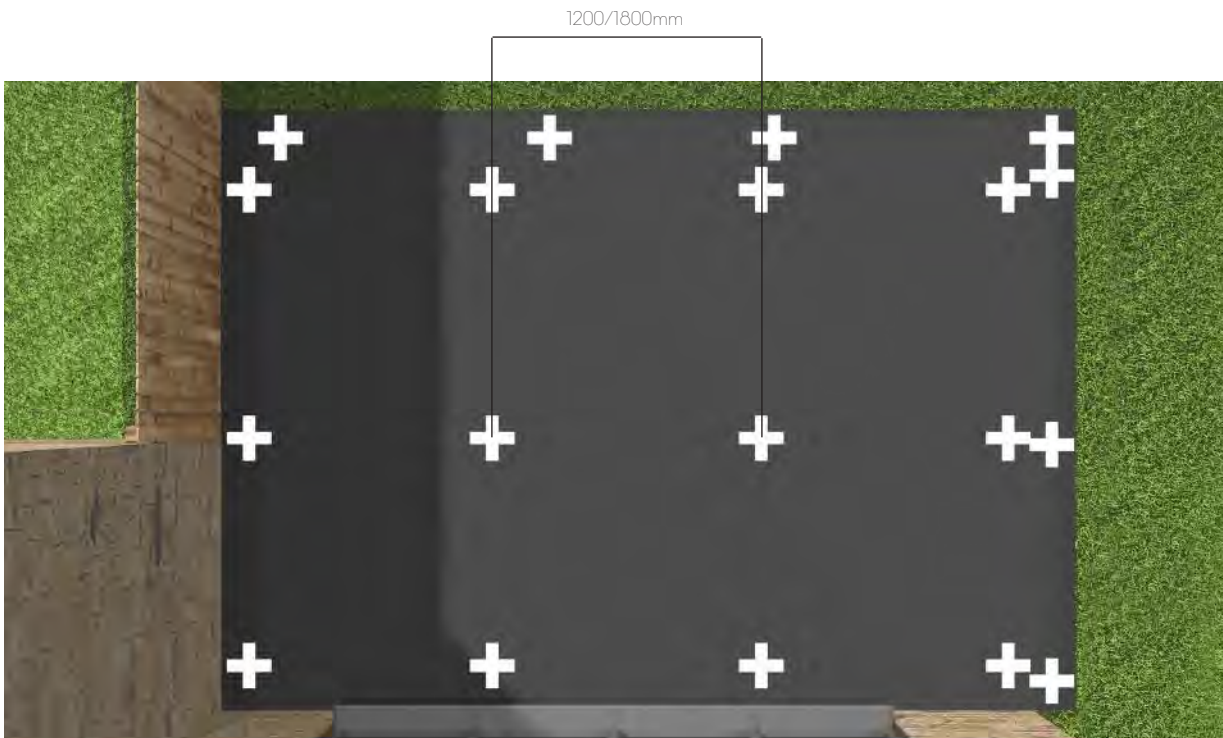
Simple guide for installing DuoSpan 99mm Joists & 136mm Beams with Plas-Pro Posts, to be read in conjunction with the Millboard Installation Guide when using Millboard decking boards.

1



- Excavation of the ground to get to the required height to be carried out first.
- Lay a weed membrane over the area.
- Ground pins will be needed to hold the membrane down.

2



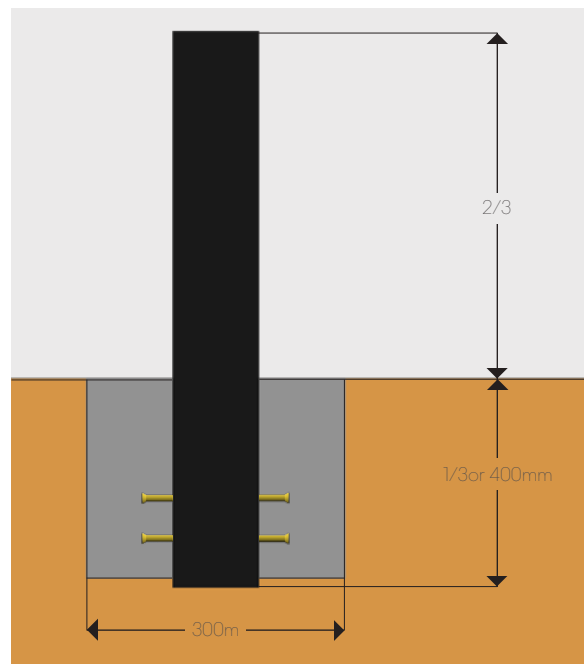
- When the weed membrane is down, mark out your decking area and where the Plas-Pro Posts should be placed.
- If any steps are to be installed, these will need to be factored in at this point.
- Make sure you consider the board dimensions when doing so as this will make the installation easier further down the line.
- If the installation is for a domestic application, then we advise having a maximum of 1800mm gap between the Post centres.
- The maximum recommended span for commercial applications is 1350mm, however as the DuoSpan Joists and Beams are 3600mm long it is more efficient to set the Posts at 1200mm centres.
- Whilst these are our recommended spans full loading tables can be found on - www.millboard.co.uk/duospan

3



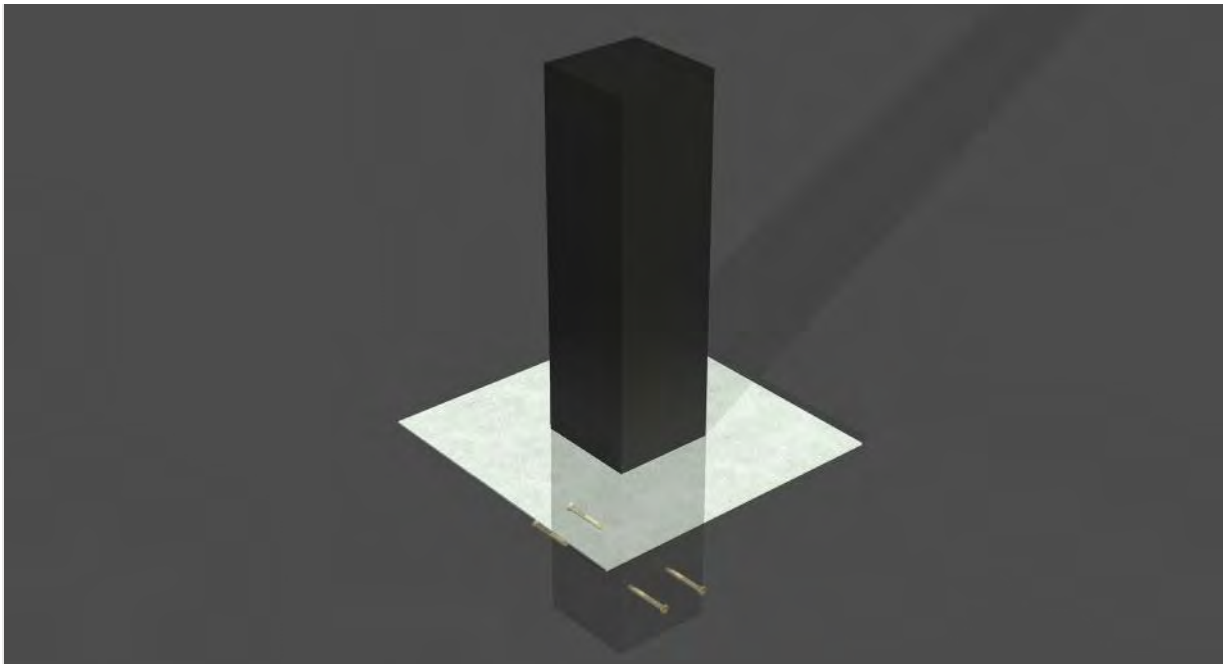
- Cut the weed membrane on the marked area.
- Proceed to dig the holes to house the Plas-Pro Posts, which will support the deck.

4



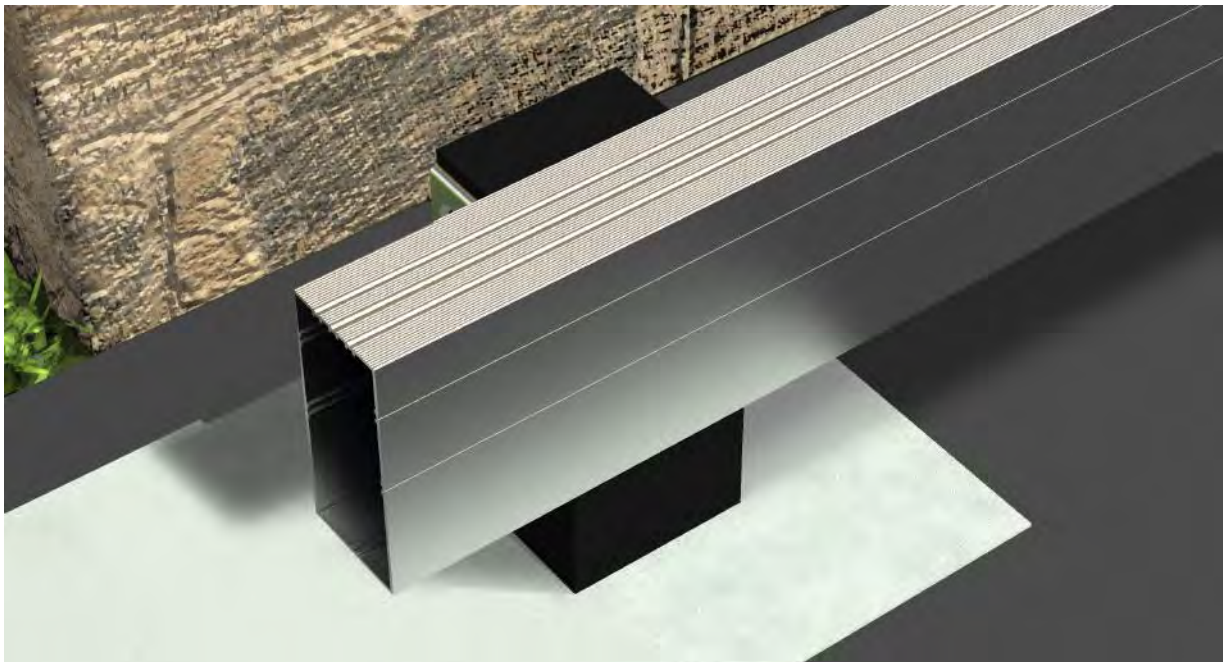
- The Plas-Pro Posts should be two thirds above ground and one third, or a depth of 400mm, in the ground, whichever is greatest.
- We recommend the hole is three times the width of the Post, i.e. 300mm x 300mm for a 100mm Post.
- It is best to oversize the post length slightly then cut once it has been secured in place.
- Plas-Pro Posts can be cut using a normal mitre saw, preferably with a TCT blade that has fewer teeth.
- When cutting it is advised to wear safety glasses, gloves and ear defenders.

5



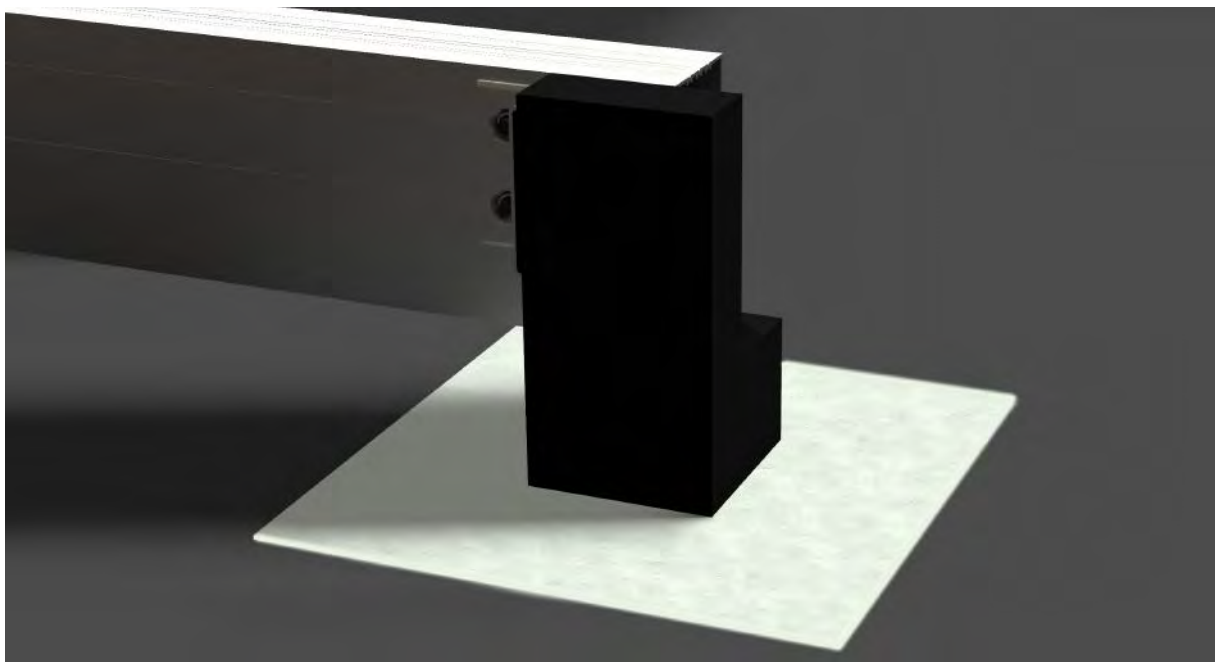
- At this point you could choose to add postcrete to secure the Plas-Pro Posts in place, they may need supporting in position whilst this sets.
- Alternatively, you could support the Posts in place to allow continual work on the deck frame and apply the postcrete at a later stage, this would be typical of an elevated deck over 600mm in height.
- To prevent the Plas-Pro Post from lifting out of the concrete, screws can be put in to the four sides of the base of the Post to create a hold in the concrete.

6



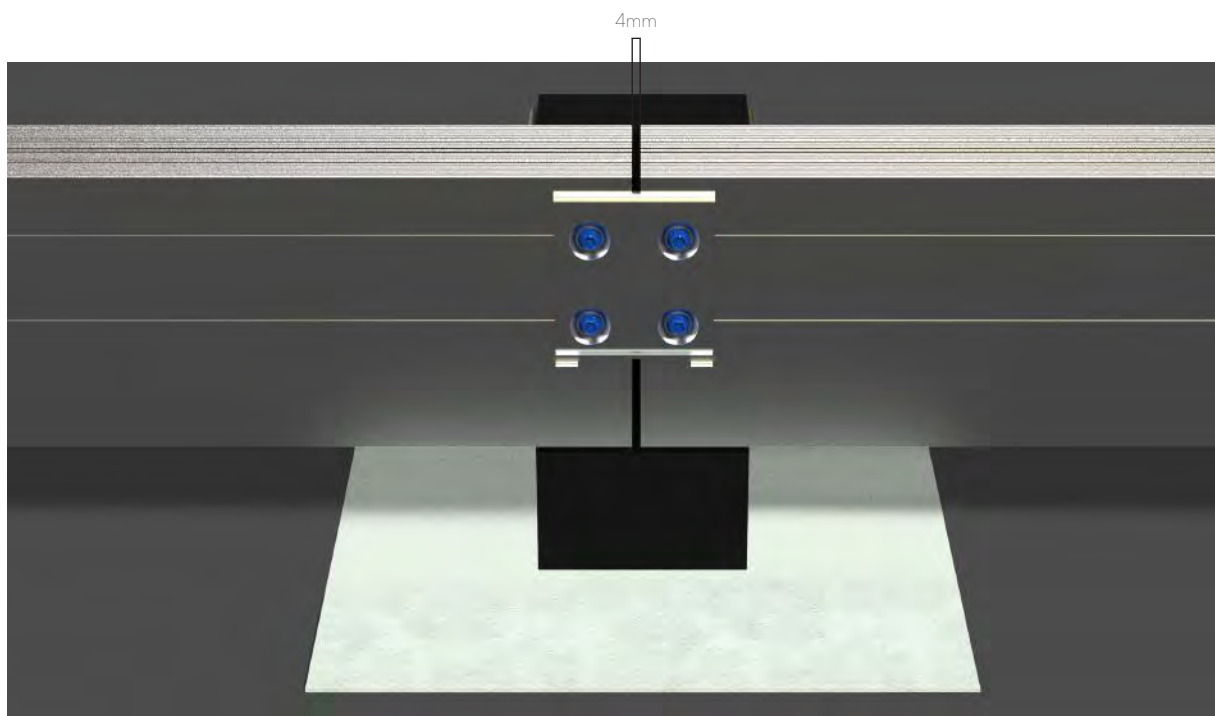
- The first DuoSpan Beam to be installed is the one nearest the house, we recommend this first Beam is set 200mm from the house supported by Plas-Pro Posts into the ground.
- The Beams need to be set so the three grooves are at the top, this will aid installation later.
- The DuoSpan Beams & Joists can be cut using a mitre saw with an aluminium cutting blade.
- Alternatively they can be cut in situ with a disc cutter with an aluminium cutting disk, do not use the same disk that has been used to cut steel as this could shatter the disk.
- When cutting the DuoSpan Joists & Beams we recommend that FFP3 dust masks, gloves, goggles, and noise-reducing ear pieces are worn.

7



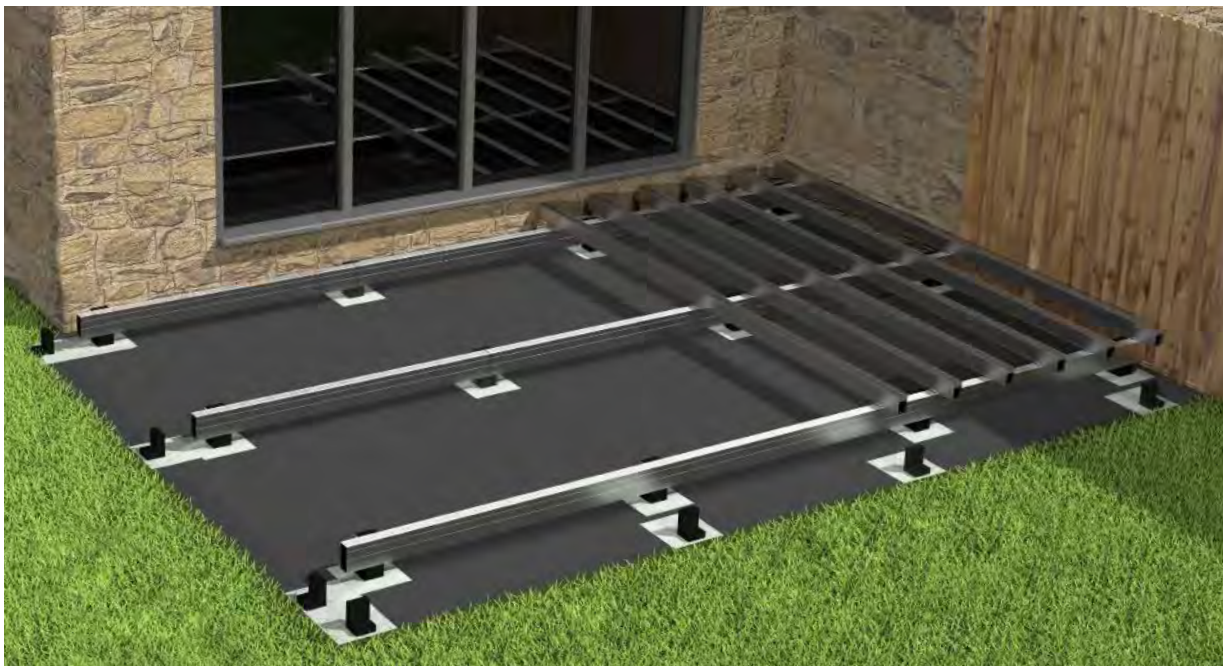
- Continue to fix the DuoSpan Beams to the Plas-Pro Posts, parallel to the first Beam at the correct centres.
- It is best practice to take a 130x60mm notch out of the top of the Posts to sit the Beam in, then use the DuoSpan 99 Flexible Bracket to either side of the Post, fixing to the Post using the DuoSpan Pan-head Screws provided. A reciprocating saw can be used to cut the notch to the top of the Post.

8



- Where two DuoSpan Beams meet on a Plas-Pro Post, a 4mm gap needs to be left to allow for potential movement.
- A DuoSpan 99 Straight Connector can be fixed to the side of both Beams to hold at the same level.

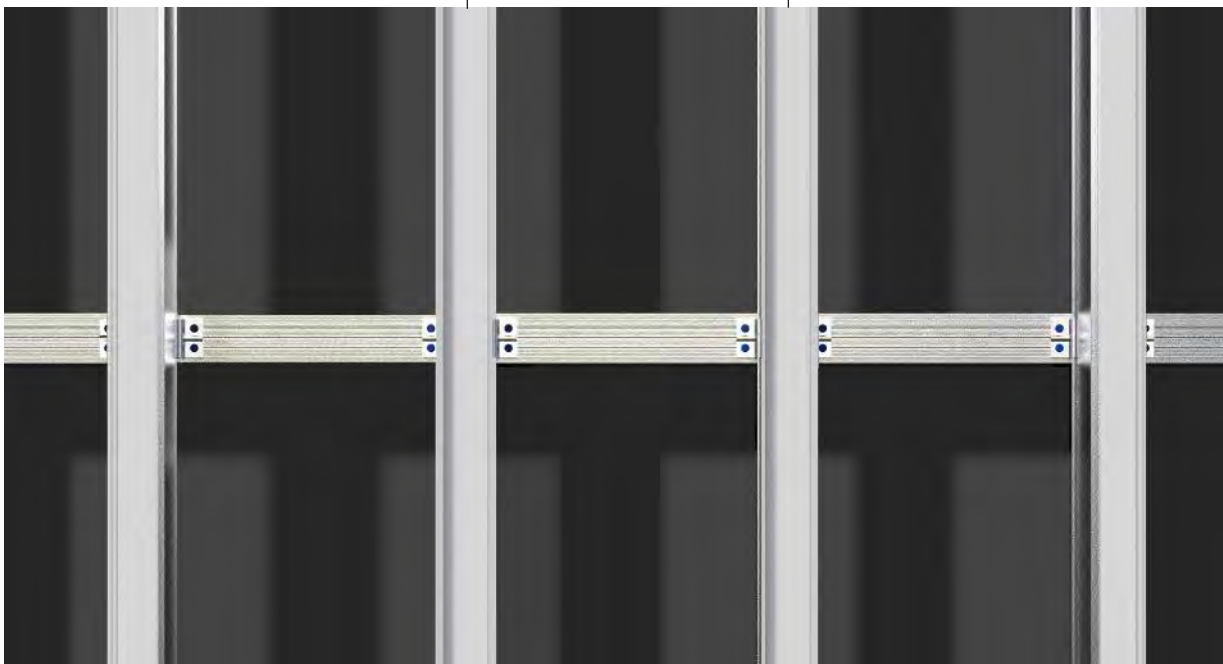
9



- Now the DuoSpan Beams are in place DuoSpan 99mm Joists can be installed across the top.
- The Joists are installed with a DuoSpan Hold-down Clip on either side.

300/400mm

10



- For a residential application we recommend the DuoSpan 99mm Joists are set at 400mm centres.
- For a commercial application we recommend the joist centres are reduced to 300mm.
- This is based on the boards being set at 90 degrees to the Joists, if they are at 45 degrees to the Joists the joist centres need to be reduced to 300mm and 240mm respectively.
- Please note these are the recommendations if Millboard decking is being used, if an alternative decking product is being used the joists spacing may be different according to their specifications.

11



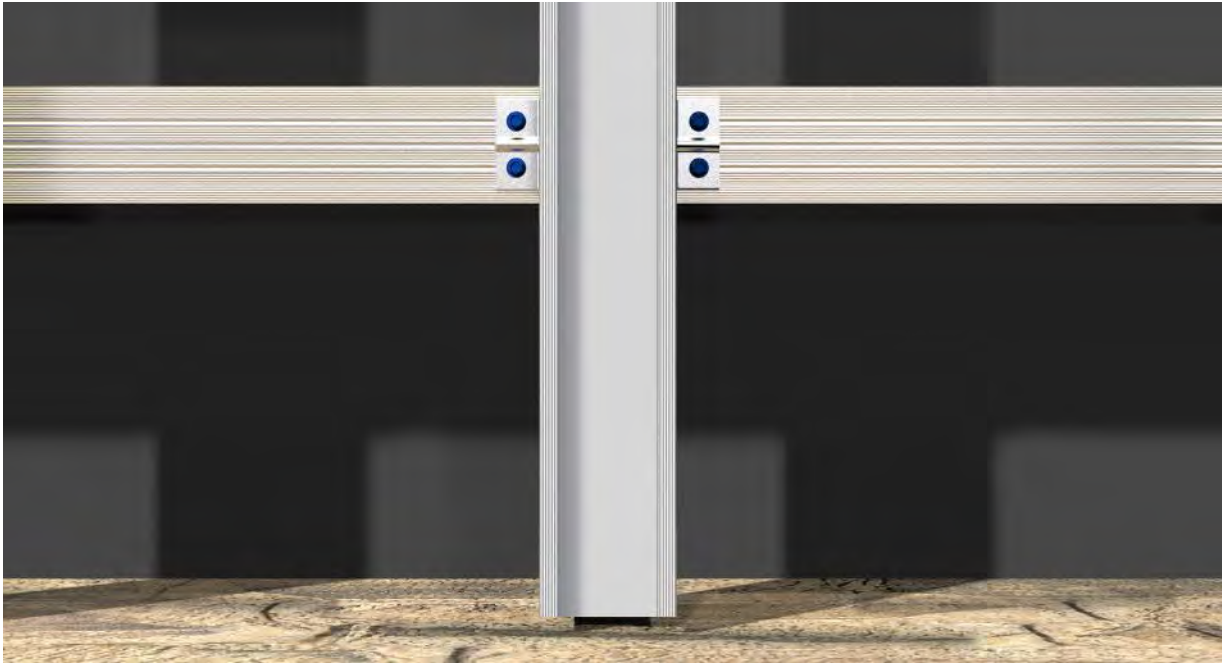
- Consideration should be taken at this point on whether the deck will have a board around the outside as a picture frame or a Bullnose Board, as the back of this board will need to be supported.

12



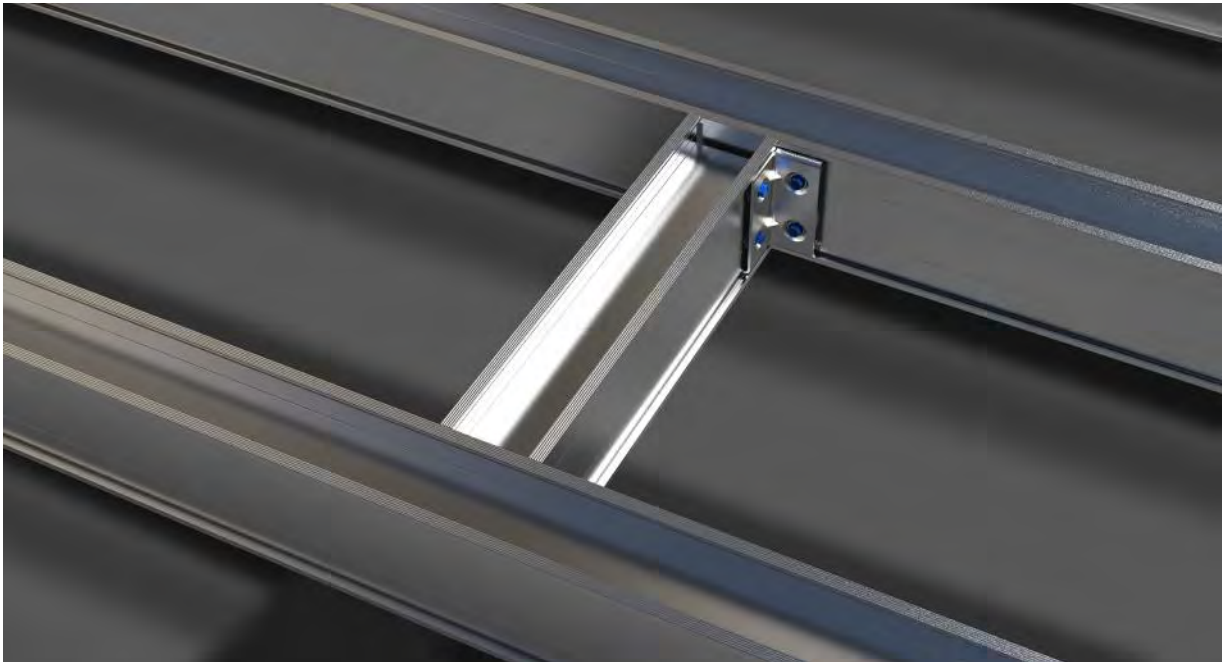
- DuoSpan Joists around the edge without a DuoSpan Hold-down Clip on both sides will need DuoSpan 51 90° Angle Brackets to the underside, attached to the DuoSpan Beam or additional noggins between the last and second to last joist to prevent any twisting.

13



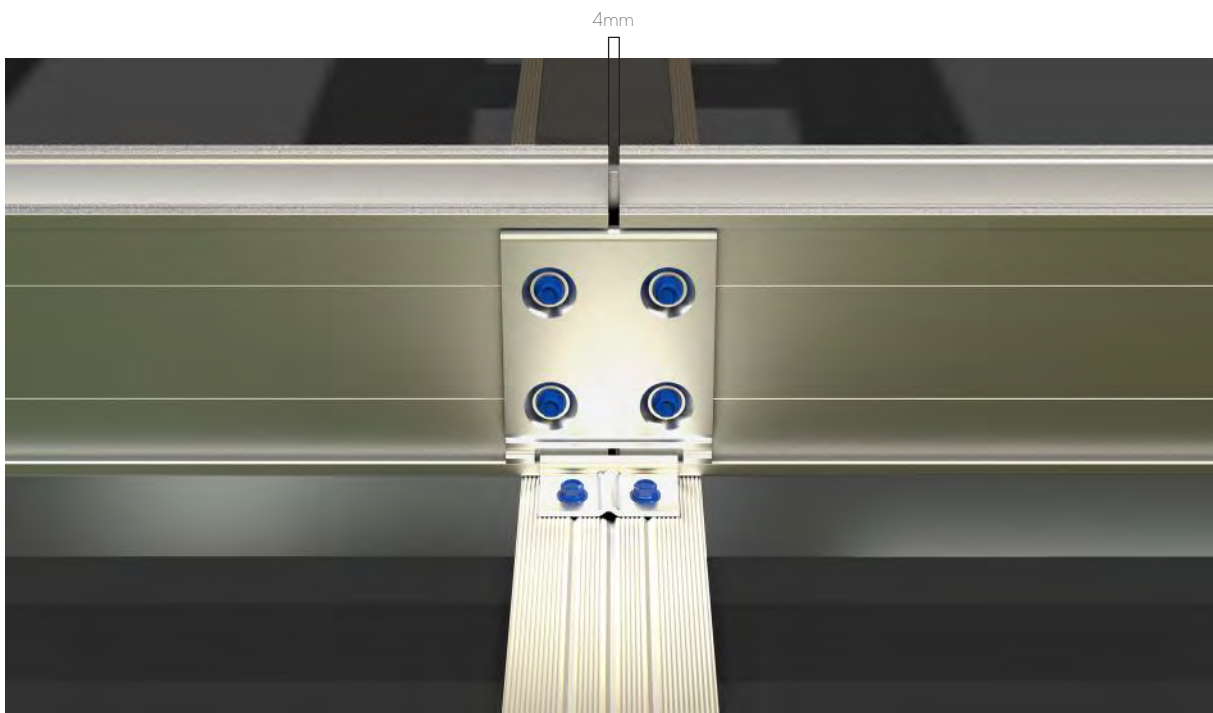
- The Joists need to be spaced 10mm from any fixed item (walls, door sills).

14



- We recommend that noggins are added to the DuoSpan Joist construction, these should be added half way along the joists at alternate joist centres.
- The noggins are installed with DuoSpan 99 90° Angle Brackets either side of the noggin.

15



- When joining two lengths of DuoSpan 99mm Joists a DuoSpan 99 Straight Connector should be used with a 4mm gap between butt ends.
- These joins must be supported underneath by the DuoSpan 136mm Beam except if used around the outside edge.

16



- The DuoSpan 99mm Joists can be attached to an outer frame using the DuoSpan 99 90° Angle Brackets for 90° joints, or the DuoSpan 99 Flexible Brackets.

17



- If the design incorporates a curve the Plas-Pro Fascia Support can be used to create the curve, the DuoSpan Joists can be fixed into this using the DuoSpan 99 Flexible Brackets.
- Noggins may be needed at the furthest point of this curve to hold it in place.
- To aid the installation of curves, pieces of Plas-Pro can be fixed into the cavity of the DuoSpan Joists for the Plas-Pro Fascia Support to be fixed to. The DuoSpan 99 Flexible Brackets must also be used in conjunction with this.

18



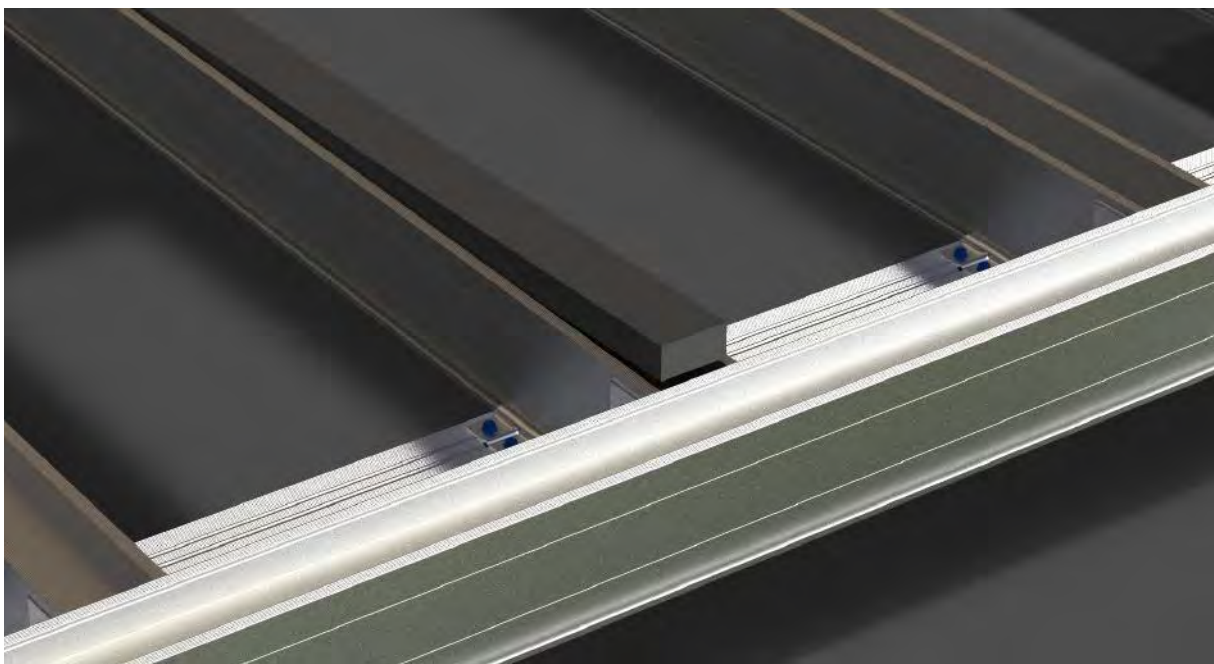
- The steps are built by constructing an outer frame first of DuoSpan Joists and inserting Joists along at the appropriate intervals.
- These frames are then attached to the Plas-Pro Posts in the ground and attached back to the DuoSpan Beams using DuoSpan 99 90° Angle Brackets.

19



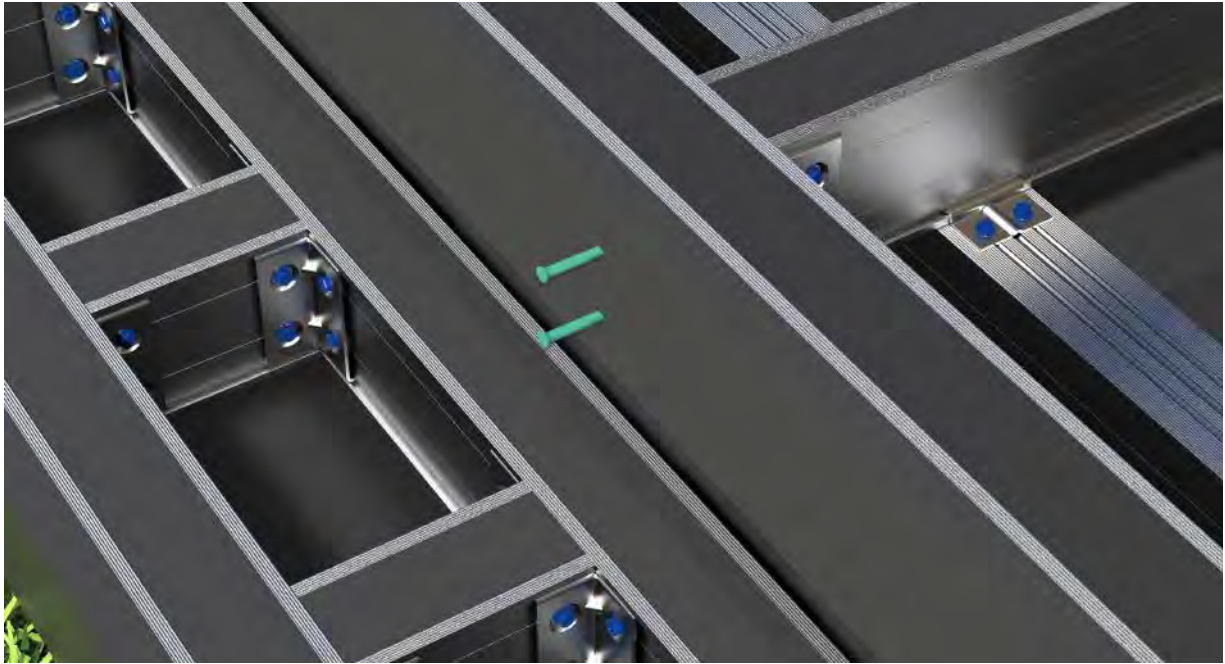
- If the front of the deck is more than 1 step high and requires more than 1 fascia board, the framework should be adequate to support this.

20



- Once all of the DuoSpan Joists are laid out with the noggins the DuoSpan Joist Insert can be laid inside the channel.
- The channels may need to be cleared to prevent any dirt lifting the insert.
- The DuoSpan Joist Insert is tapered, it is important that these Joist Inserts are put into the Joist with the tapered part at the bottom.
- If the project is exposed to high wind loads we recommend screwing the Joists Inserts in to the Joists at the end using the Plas-Pro to DuoSpan Screws.

21



- Plas-Pro Fascia Support should be fixed to the outer Joist to fix the fascia and edging profiles to a 6.5mm hole should be pre-drilled through the Fascia Support with a HSS bit.
- The Plas-Pro to DuoSpan Screws should be used to fix to the Joists, with two fixings every 600mm along the Plas-Pro.

22



- When two lengths of DuoSpan Joist Insert or Plas-Pro Fascia Support come together a 10mm expansion gap must be left at butt ends.



- Now you have installed the subframe you can begin to install the boards.
- When fixing Millboard to the DuoSpan framework Durafix 4.5x45mm fixings must be used to fix the boards down. Durafix 4.5x35mm fixings must be used to fix the fascia to the Plas-Pro Fascia Support.
- As the DuoSpan profiles are made from aluminium this may be visible in the gaps between the boards, over time these will become less visible. 100mm DPC can be applied to the top of the Joists so the Joists can't be seen in the gaps between the boards.

Other Considerations:

- Where lighting is needed on the deck, any access holes in the Joist need to be done where the Joist is over the top of the Beam, access holes in the Beam need to be where the Beam is supported by the Plas-Pro Post.
- Where the framework will be touching or near to electricity cables, the framework will need to be earthed suitably.

DuoLift

DuoLift unpacked

Contents	Box Quantity	Heights	Material	Box code
A DuoLift Joist Cradle	10	15 - 60mm	Glass filled nylon	PMCP010
B DuoLift Self-Levelling Joint	10	20mm	Glass filled nylon	PMLP010
C DuoLift Riser	10	45mm	Glass filled nylon	PMRP010
D DuoLift Foot	10	45mm	Glass filled nylon	PMFP010
E DuoLift Acoustic Separation Pad	10	3mm	Agglomerated cork & rubber	PMAP010



A



B



C



D



E

DuoSpan

DuoSpan profiles

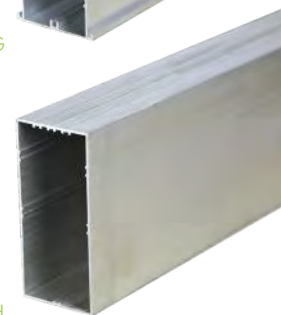
Contents	Dimensions	Material	Code
F DuoSpan 51mm Joist	51 x 68 x 3600mm	Aluminium	K5168J360
G DuoSpan 99mm Joist	99 x 68 x 3600mm	Aluminium	K9968J360
H DuoSpan 136mm Beam	136 x 63 x 3600mm	Aluminium	K1363B360



F



G



H

DuoSpan insert

Contents	Dimensions	Material	Code
I DuoSpan Joist Insert	25 x 50 x 3000mm	Recycled plastic	K0205B300



I

Plas-Pro

Contents	Dimensions	Material	Code
J Plas-Pro Fascia Support	100 x 25 x 3000mm	Recycled plastic	P0210B300
K Plas-Pro Post	100 x 100 x 3000mm	Recycled plastic	P1010B300



J

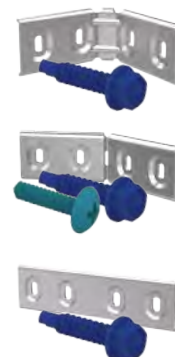


K

Accessories and fixings

Joist bracket sets for DuoSpan 51mm Joist

Contents	Quantity	Dimensions	Material	Box code
DuoSpan 51 90° Angle Bracket	10	–	Aluminium	K51RP010
DuoSpan Hex-head Screw	42	5.5 x 25mm	Cathodic barrier coated s/s	
DuoSpan 51 Flexible Bracket	10	–	Aluminium	K51FP010
DuoSpan Hex-head Screw	42	5.5 x 25mm	Cathodic barrier coated s/s	
DuoSpan Pan-head Screw	20	5 x 25mm	Cathodic barrier coated s/s	
DuoSpan 51 Straight Connector	10	–	Aluminium	K51LP010
DuoSpan Hex-head Screw	42	5.5 x 25mm	Cathodic barrier coated s/s	



Joist bracket sets for DuoSpan 99mm Joist

Contents	Quantity	Dimensions	Material	Box code
DuoSpan 99 90° Angle Bracket	10	–	Aluminium	K99RP010
DuoSpan Hex-head Screw	42	5.5 x 25mm	Cathodic barrier coated s/s	
DuoSpan 99 Flexible Bracket	10	–	Aluminium	K99FP010
DuoSpan Hex-head Screw	42	5.5 x 25mm	Cathodic barrier coated s/s	
DuoSpan Pan-head Screw	20	5 x 25mm	Cathodic barrier coated s/s	
DuoSpan 99 Straight Connector	10	–	Aluminium	K99LP010
DuoSpan Hex-head Screw	42	5.5 x 25mm	Cathodic barrier coated s/s	



Hold-down clip

Contents	Quantity	Dimensions	Material	Box code
DuoSpan Hold-down Clip	30	–	Aluminium	K48CP030
DuoSpan Hex-head Screw	63	5.5 x 25mm	Cathodic barrier coated s/s	



Plas-Pro profile fixings

Contents	Quantity	Dimensions	Material	Box code
DuoSpan Bracket to Plas-Pro Screw	100	5 x 25mm	Cathodic barrier coated s/s	FD25P100
Plas-Pro to DuoSpan Screw	100	5 x 50mm	Cathodic barrier coated s/s	FD50P100



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The background of the entire page is a photograph of a modern outdoor deck. In the foreground, there are several wooden planks of a light brown color, laid out in a staggered pattern. Below these planks, the metal joist system is visible, featuring grey channels and black plastic spacers. In the background, there is a large glass railing with grey frames, and beyond that, a stone wall and more of the deck structure. The lighting is bright, suggesting a sunny day.

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Installation Guide for **Duo**SpanTM Joists & **Duo**LiftTM Joist Supports

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Does it include edging, a board or Bullnose Board around the perimeter?




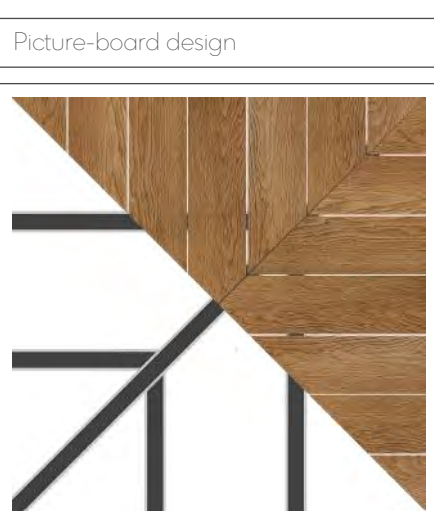


Does the design include area to be split up in different sections?

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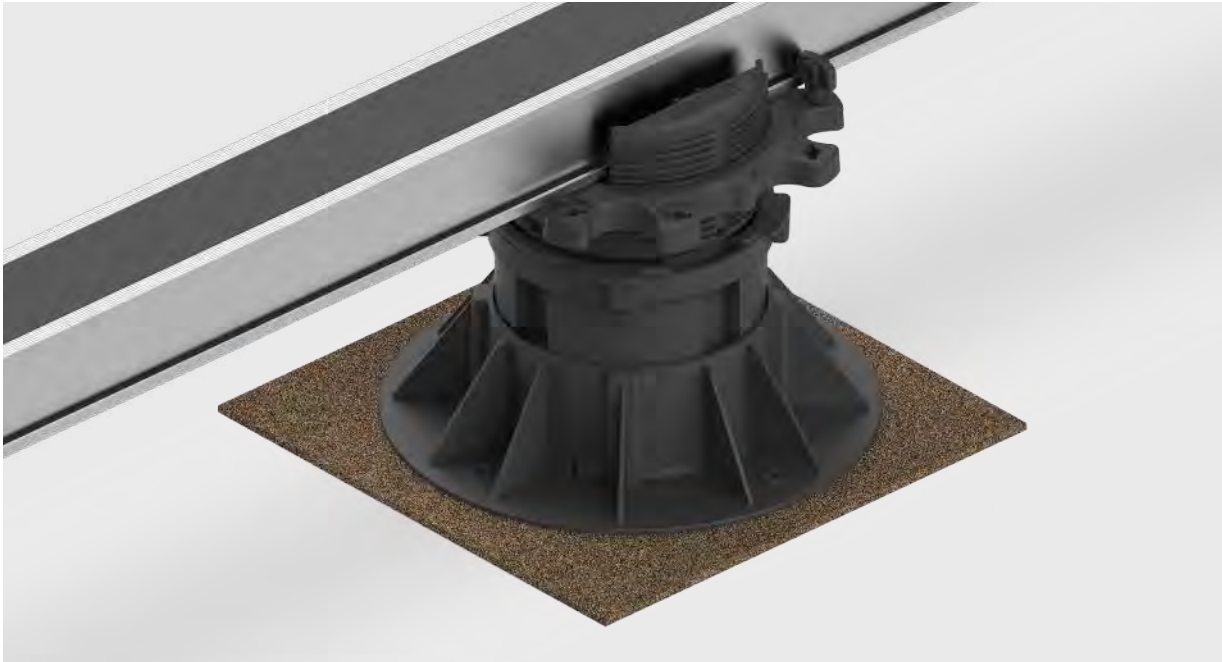
		
Picture-board design	Alternative colour inlay design	Herringbone design
		
Mitre or chevron design	Mitre to a board design	Curved design



DuoSpan™ Joists & DuoLift™ Joist Supports Installed over solid surfaces

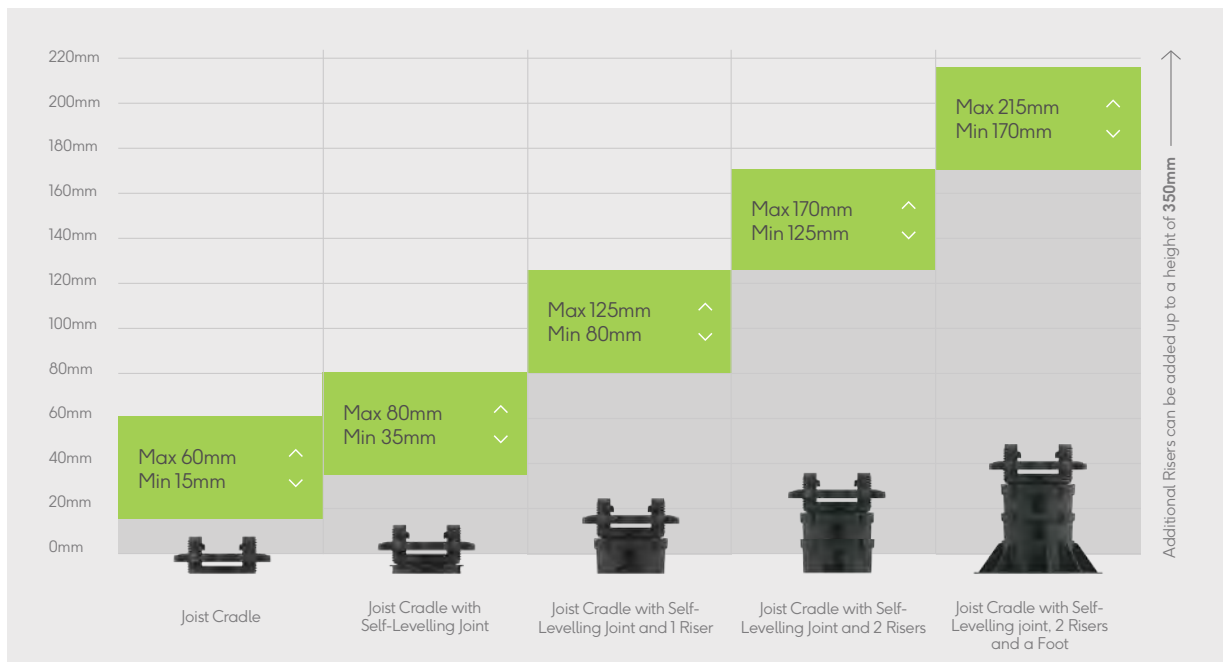
Simple guide for installing DuoSpan Joists with DuoLift Joist Supports, to be read in conjunction with the Millboard Installation Guide when using Millboard decking boards.

1



- DuoLift Joist supports require a substrate that is solid, stable and structural (i.e. suitable roof terrace or concrete base, not directly onto soil).
- If the substructure is a flat roof with a membrane we recommend that a DuoLift Acoustic Separation Pad is laid under the DuoLift support first to protect the membrane.

2



- Firstly decide the correct overall height for the decking from the substrate.
- For an overview of typical heights under the Joist please see the diagram above, the heights stated are from the substrate to the underside of the Joist.
- When using the DuoLift Acoustic Separation Pad, add 3mm onto the height.

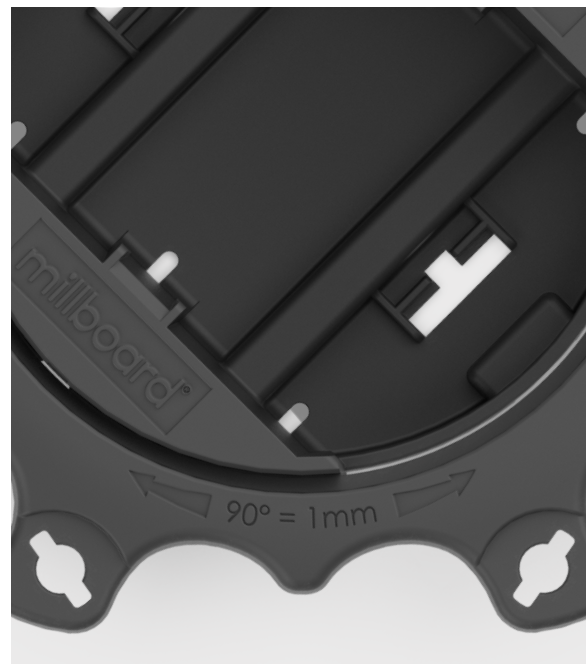
3

15-60mm DuoLift Joist Cradles



- The DuoLift Joist Cradles are assembled by lining the slot on the cradle top with the slot on the adjustment ring **A**, either at the top or bottom of the cradle.

4



- Start turning the ring to roughly the correct height, the cradle has 5mm markings on the side to help achieve the correct height **B**.
- A quarter of a turn is 1mm height adjustment.

5a

20mm DuoLift Self-Levelling Joint



- The DuoLift Joist Cradle is clicked into the dome of the DuoLift Self-Levelling Joint.

5b



- This is then sat into the seat of the DuoLift Self-Levelling Joint.
- This will suit any slope up to 5 degrees or a 1:12 fall in any direction.

6

20mm DuoLift Self-Levelling Joint & one 45mm DuoLift Riser



- The DuoLift Self-Levelling Joint has to be used in between the DuoLift Joist Cradle and the DuoLift Riser or Foot, this is lined up with the Riser or the Foot then turned clockwise to click into place.

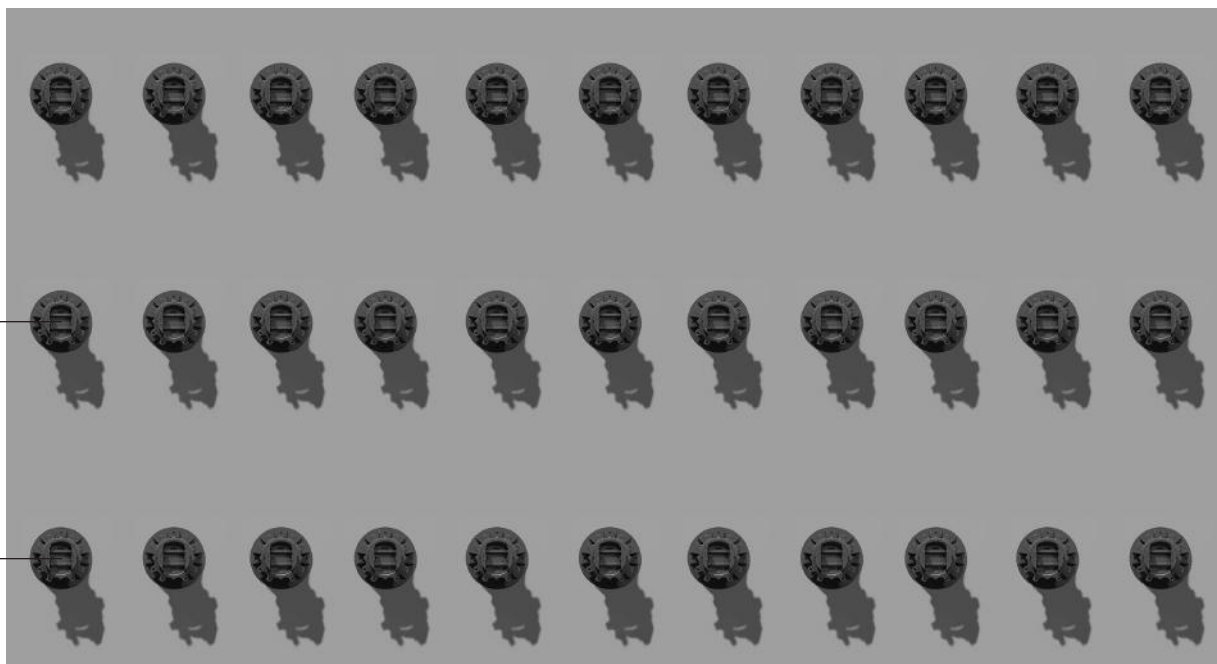
7



- The DuoLift Risers can be used directly on top of each other to a maximum overall height of 350mm.
- For added stability the DuoLift Foot must be used after two Risers are used.
- Once all of the risers are in place the lugs on the outside should be in line **C**.

8

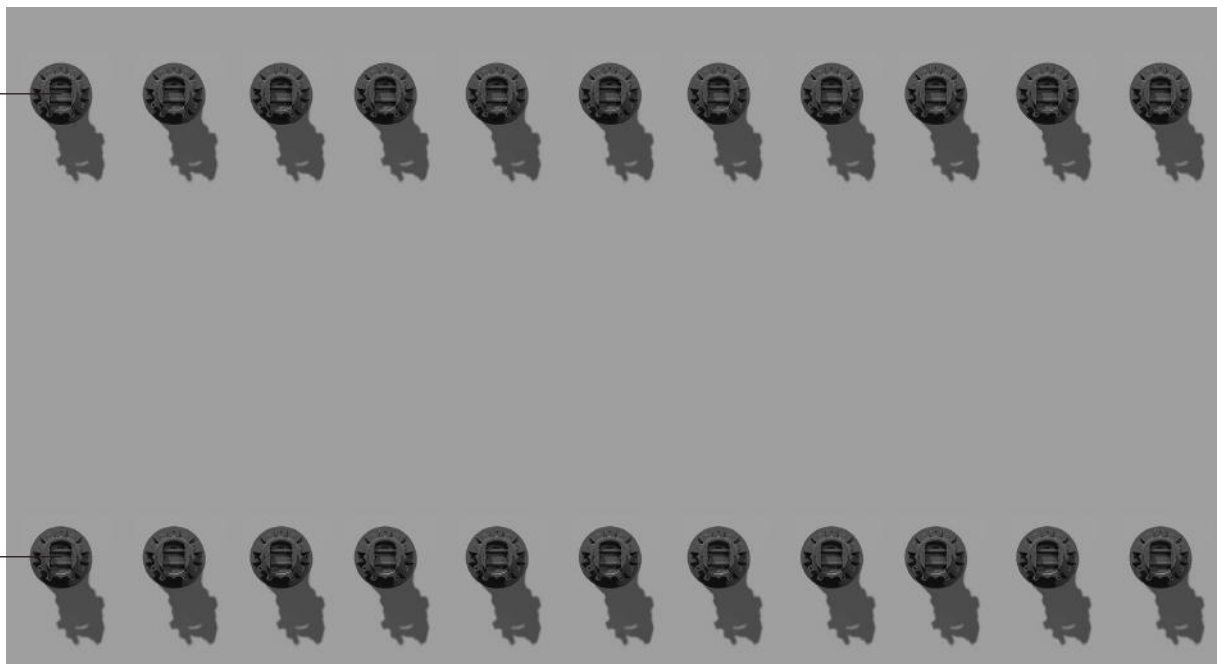
600/900mm



- For the DuoSpan 51mm Joist the DuoLift supports need to be set at 900mm centres along the Joist for residential applications, 600mm centres for commercial applications.

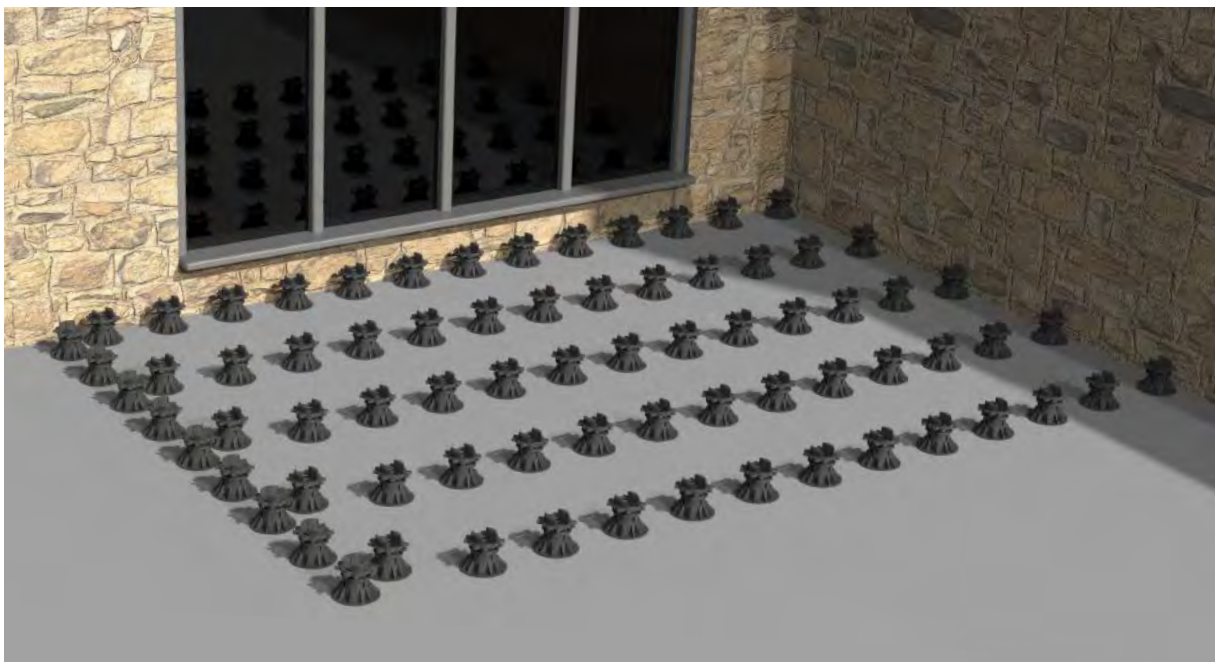
9

1200/1800mm



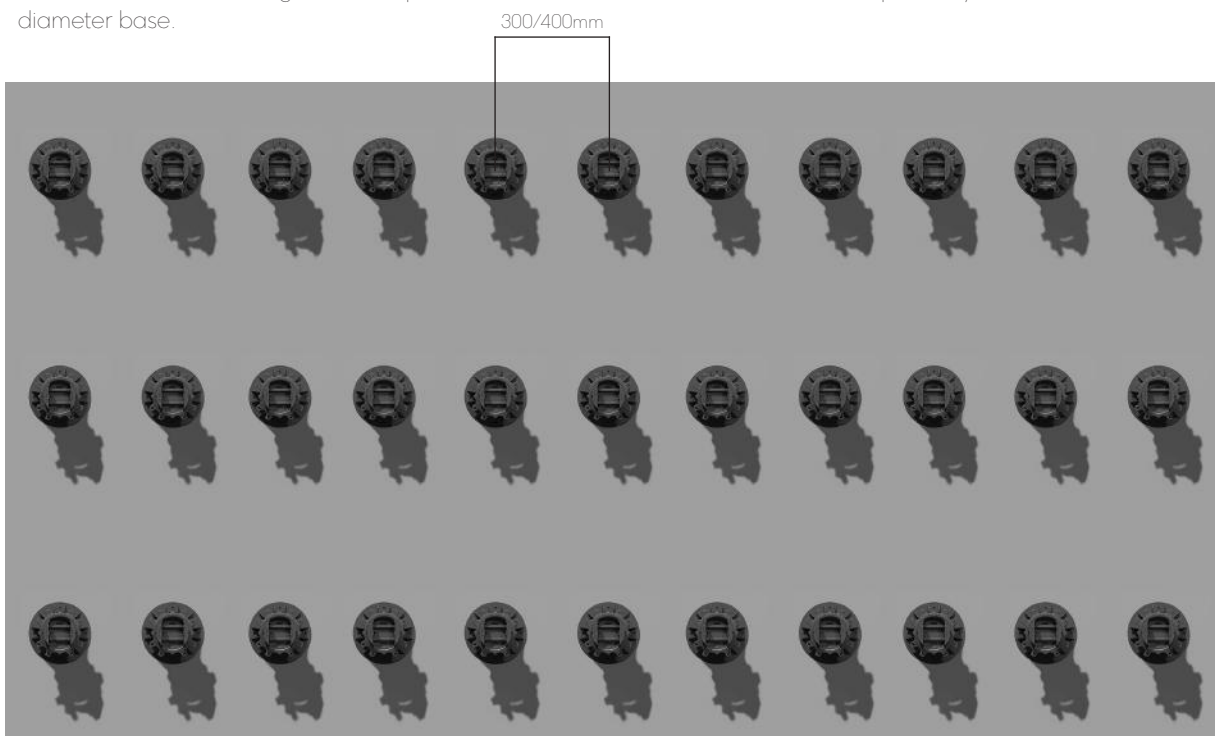
- For the DuoSpan 99mm Joist the DuoLift supports need to be set at 1800mm centres along the Joist for residential applications.
- The maximum recommended span for commercial applications is 1350mm, however as the Joists are 3600mm long it is more efficient to set the DuoLift supports at 1200mm centres.
- Whilst these are our recommended spans full loading tables can be found on - www.millboard.co.uk/duospan

10



- When installing on a roof terrace/balcony, point loading on the membrane/insulation should be taken in to consideration when using the DuoSpan 99mm Joist.
- As the DuoLift Joist Cradle, Self-Levelling Joint and Riser all have a 114mm diameter base, we would suggest the spans are reduced to 900mm for residential and 600mm commercial.
- If the DuoLift Foot is being used the spans can be increased to 1800 & 1350mm respectively due to its 220mm diameter base.

11



- For a residential application we recommend the Joists are set at 400mm centres, for a commercial application we recommend the Joist centres are reduced to 300mm.
- This is based on the boards being set at 90° to the Joists, if they are at 45° to the Joists the Joist centres need to be reduced to 300mm and 240mm respectively.
- Please note these are the recommendations for if Millboard decking is being used, if an alternative decking product is being used the Joists spacing may be different according to their specifications.

12



- The DuoSpan Joists can then be laid into the DuoLift supports, with the channel part of the Joist at the top.
- The DuoSpan Joists can be cut using a mitre saw with an aluminium cutting blade.
- Alternatively they can be cut in situ with a cut off saw with an aluminium cutting disks, do not use the same disk that has been used to cut steel as this could shatter the disk.
- When cutting the Joists we recommend that FFP3 dust masks, gloves, goggles, and noise-reducing ear pieces are worn.

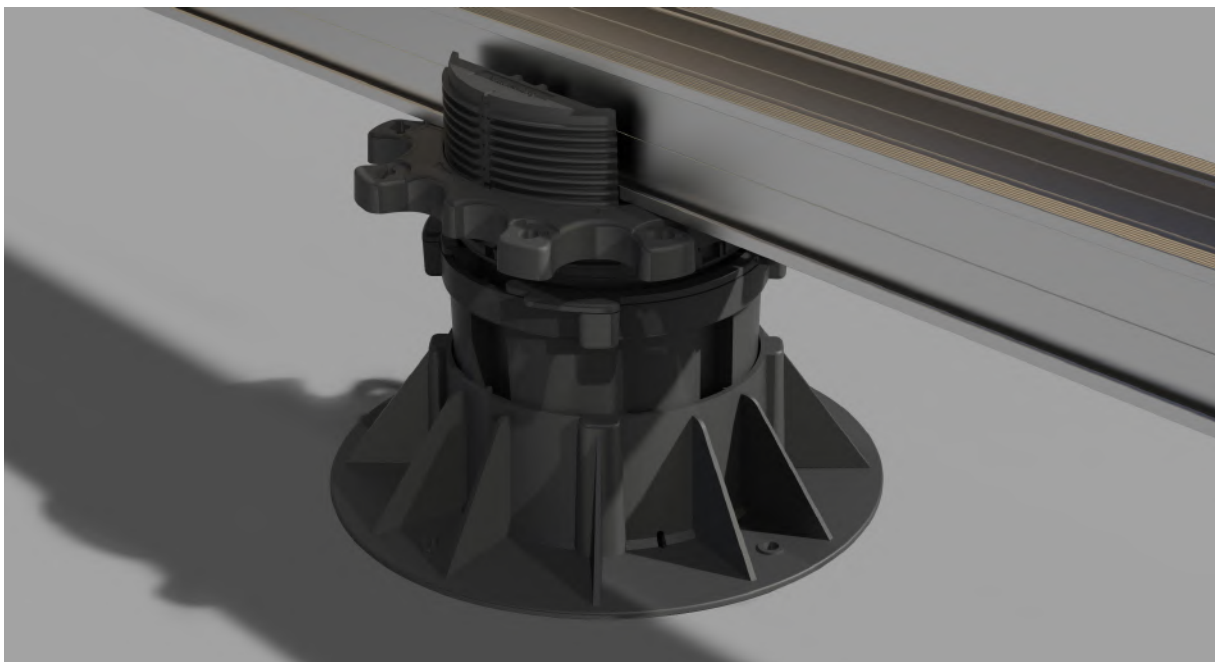
13

10mm



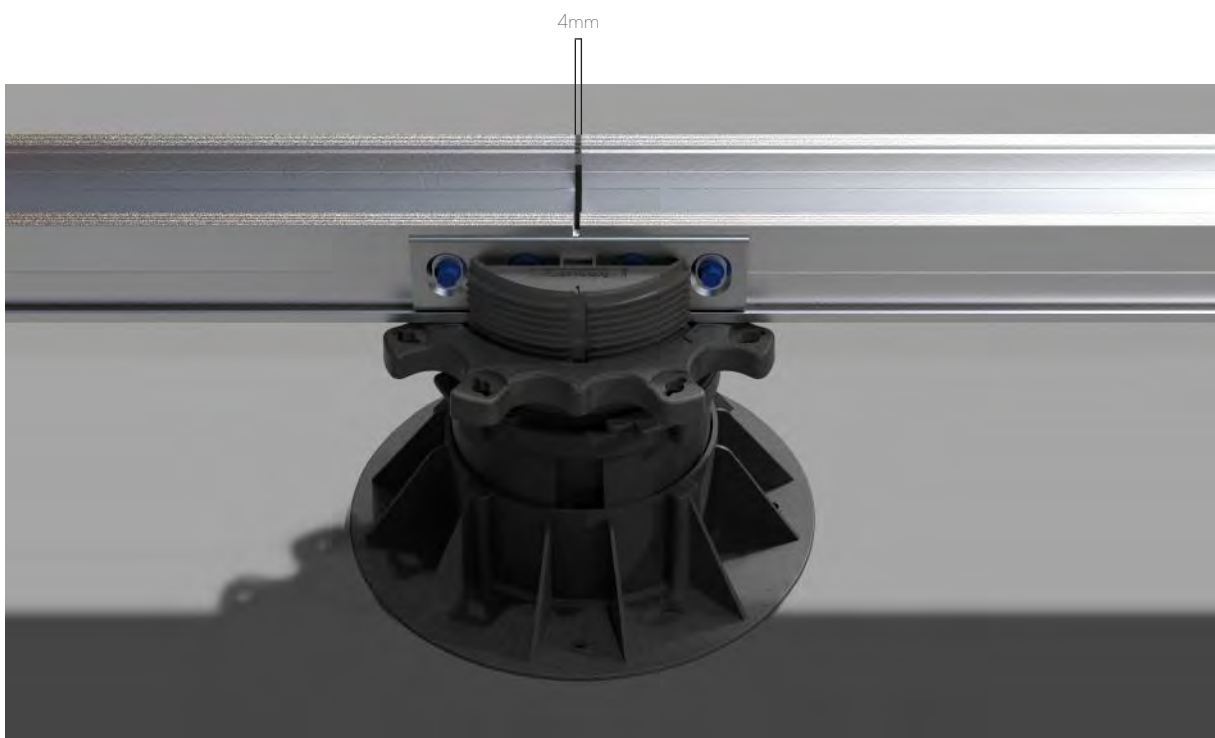
- The DuoSpan Joists need to be spaced 10mm from any fixed item (walls, door sills).
- The Joist can be fixed into a wall for stability if required using stainless steel frame fixings (maintaining the 10mm gap).

14



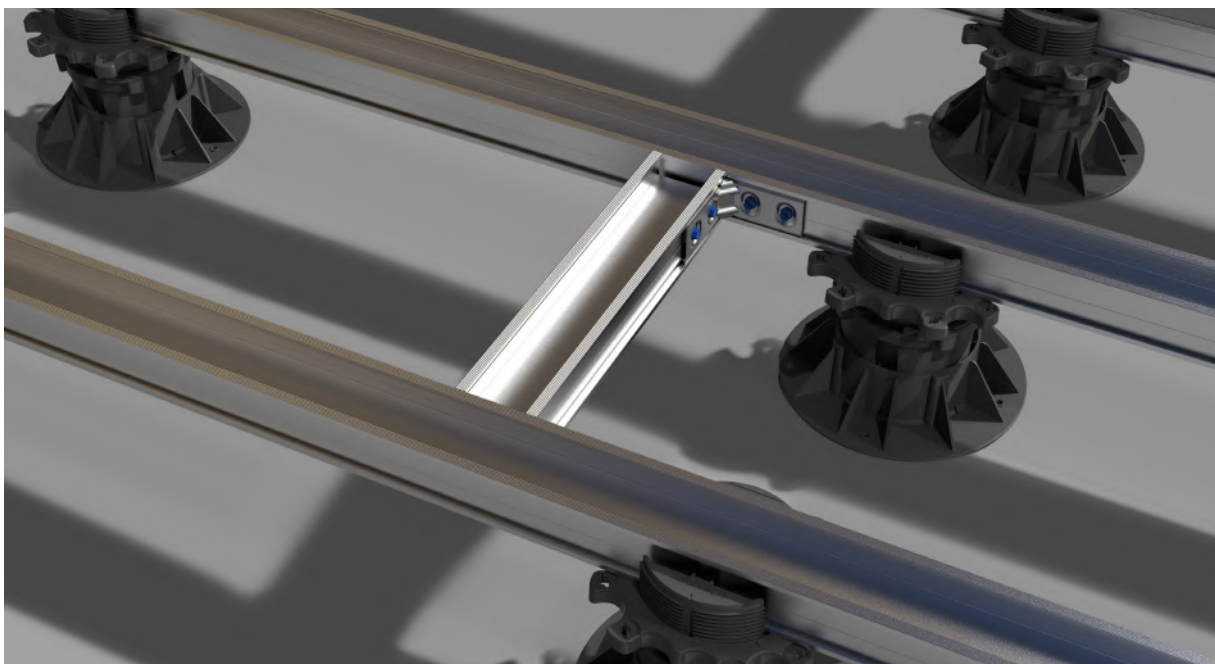
- As the Joists are laid out check the heights of the DuoLift supports – if necessary turning the adjustment ring up or down.

15



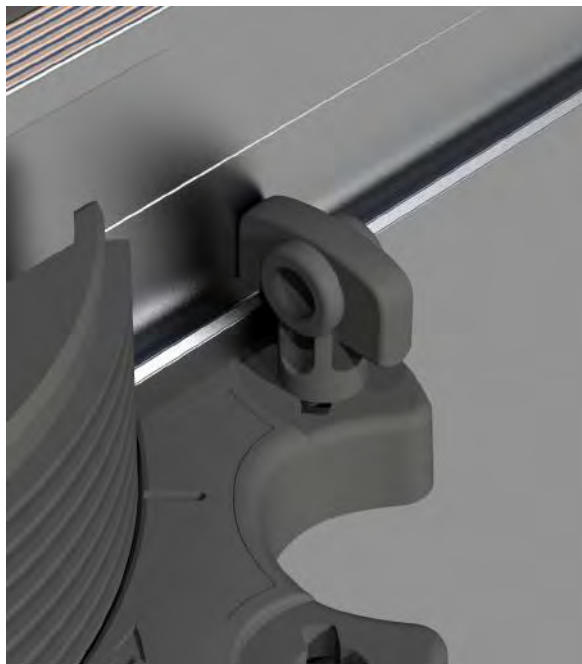
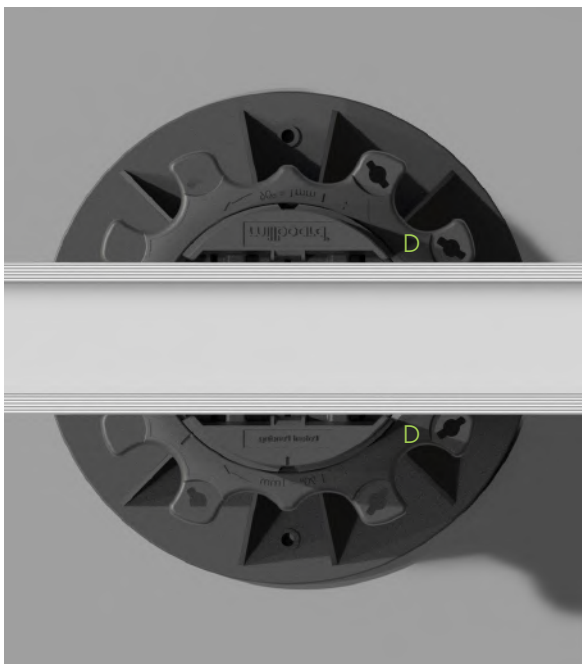
- When joining two lengths of DuoSpan Joists together a DuoSpan Straight Connector is needed, with a 4mm gap between butt ends.
- These joins must be supported underneath by the DuoLift support unless used around the perimeter.

16



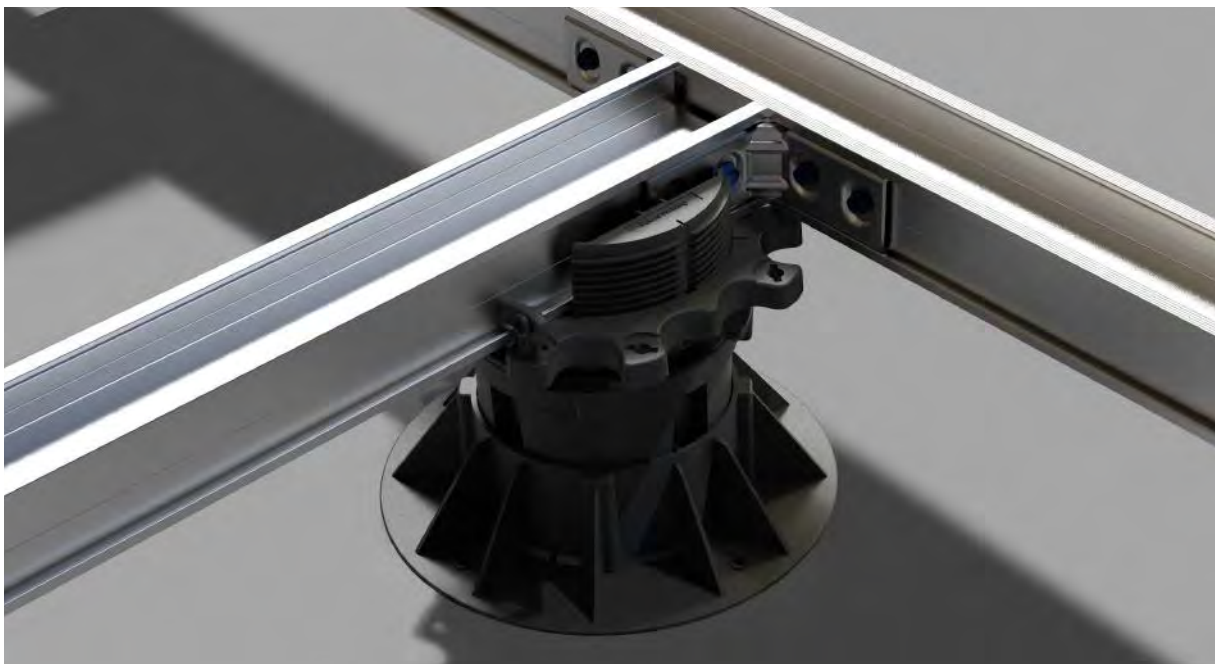
- We recommend noggins are used to stabilise the frame, these should be added at half way along the Joists at alternate Joist centres.
- The noggins are installed with a DuoSpan 90° Angle Bracket either side of the noggin.

17



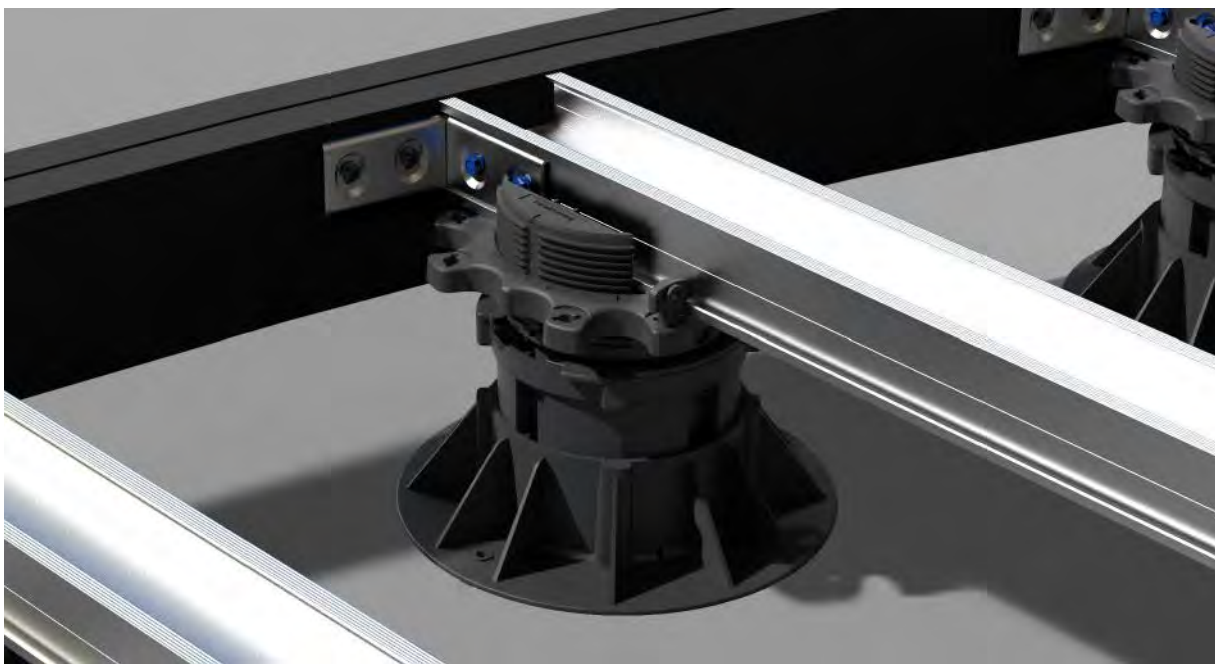
- Once the DuoSpan Joist is fully supported and in-between the shaded areas on the ring **D**, the locking tabs should be inserted into the adjustment ring with one either side of the joist.

18



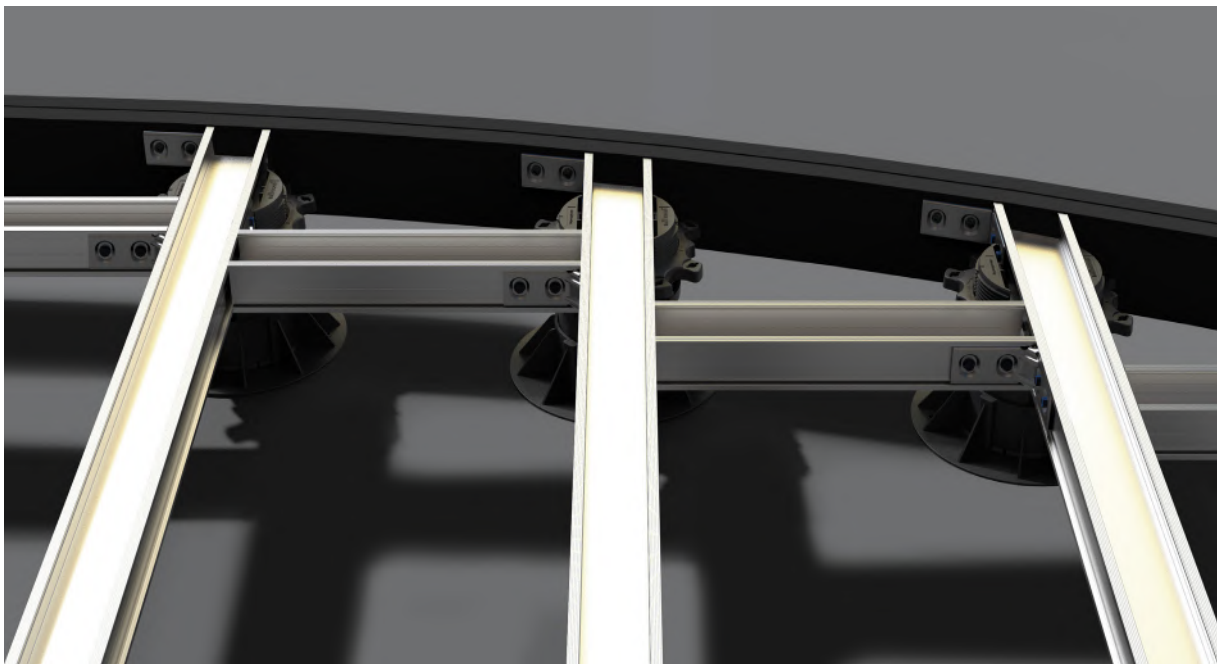
- The Joists can be attached to an outer frame using the DuoSpan 90° Angle Brackets.

19



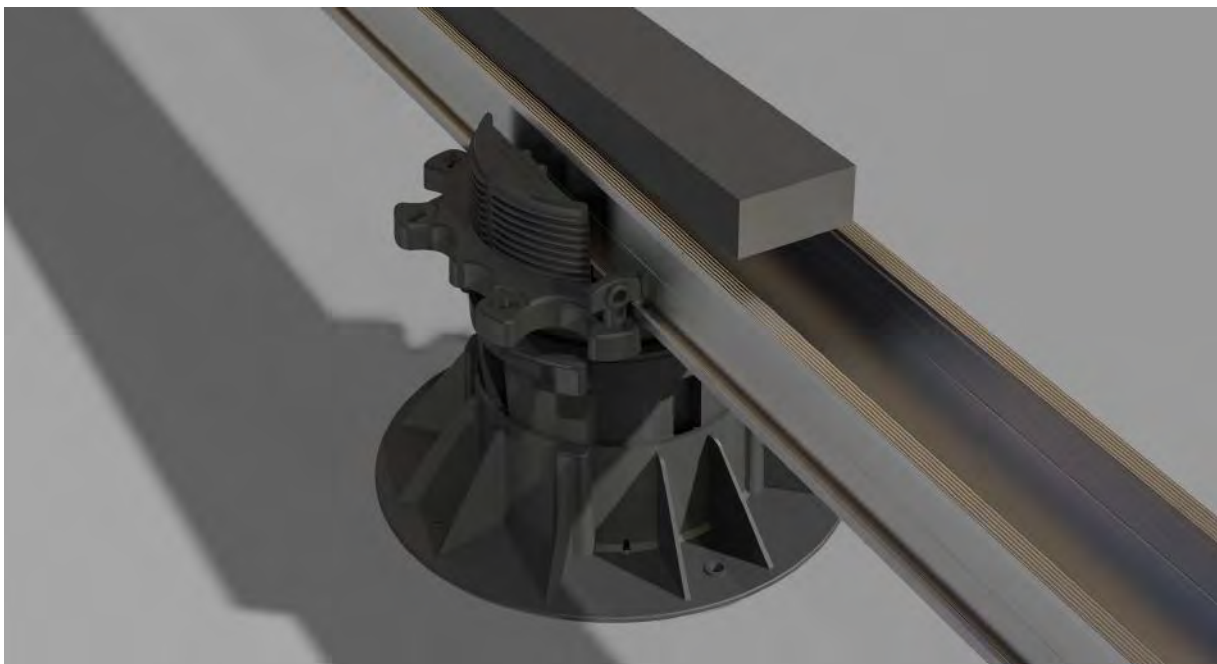
- If the DuoSpan Joists are joining at a different angle to 90° the DuoSpan Flexible Brackets can be used to fix to the outer frame.

20



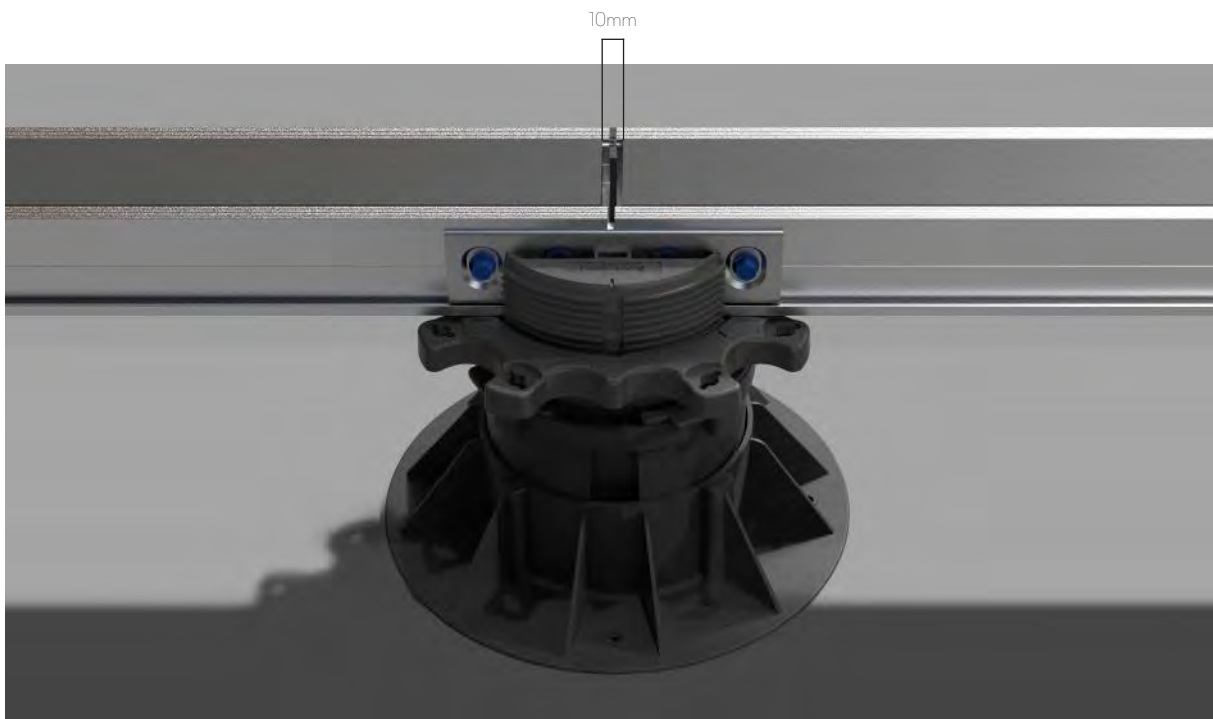
- If the design incorporates a curve the Plas-Pro Fascia Support can be used to create the curve, the Joists can be fixed into this using the DuoSpan Flexible Brackets.
- Noggins may be needed at the furthest point of this curve to hold it in place.
- To aid the installation of curves, pieces of Plas-Pro can be fixed into the cavity of the DuoSpan Joist for the Plas-Pro Fascia Support to be fixed to.
- The DuoSpan Flexible Brackets must also be used in conjunction with this.

21



- Once all of the DuoSpan Joists are laid out with the noggins the DuoSpan Joist Inserts can be laid inside the channel.
- The channels may need to be cleared to prevent any dirt lifting the insert.
- The DuoSpan Joist Insert is tapered, it is important that these Joist Inserts are put into the Joist with the tapered part at the bottom.
- If the project is exposed to high wind loads we recommend screwing the Joist Inserts in to the Joist using the Plas-Pro to DuoSpan Screws.

22



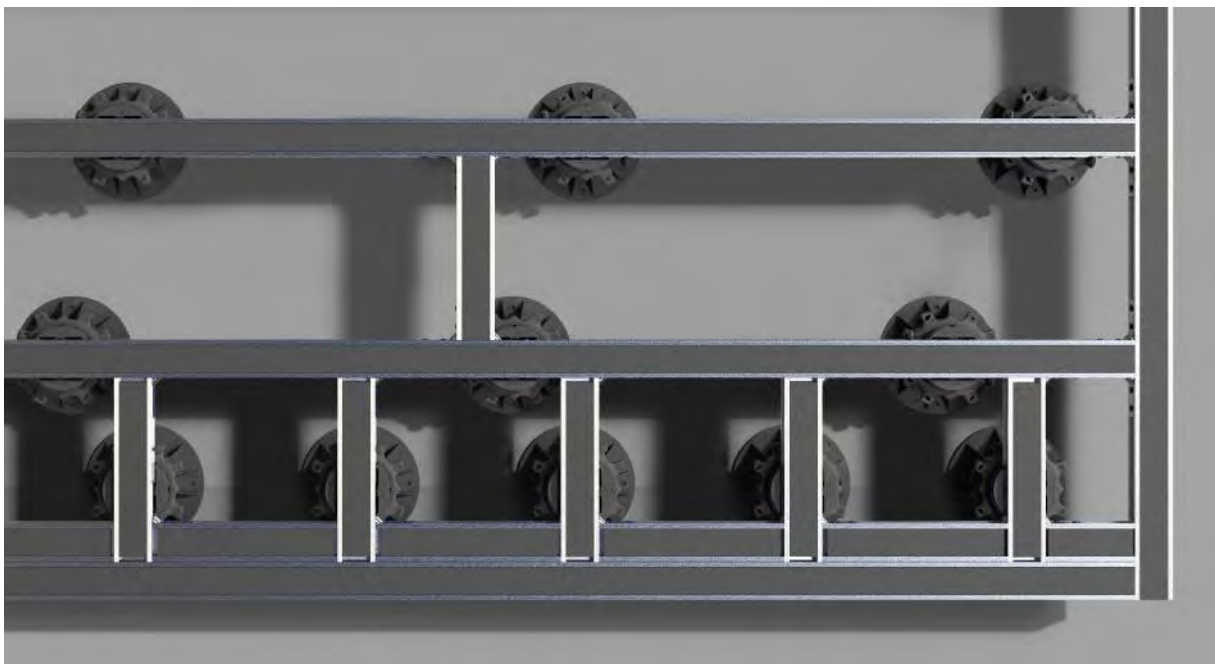
- When joining two lengths of DuoSpan Joist Inserts together a 10mm expansion gap must be left at butt ends.

23



- The DuoLift support is **not** to be screwed into a membrane on a roof terrace or balcony as this will cause leaks.
- The system can be screwed to a concrete base using suitable concrete fixings.

24



- If fascia boards are used the DuoLift supports need to be set in from the outside edge, either to the DuoSpan Joists or to the noggins.

25



- Where fascia boards or 50mm edging profiles are to be used on the front face, Plas-Pro Fascia Support needs to be fixed to the face of the DuoSpan Joists using the Plas-Pro to DuoSpan Screws.
- The holes should be pre drilled through the Fascia Support with a 6.5mm HSS bit.
- Two fixings should be used every 600mm along the Fascia Support.



- Now you have installed the subframe you can begin to install the boards.
- When fixing Millboard to the DuoSpan framework Durafix 4.5x45mm fixings must be used to fix the boards down. Durafix 4.5x35mm fixings must be used to fix the fascia to the Plas-Pro Fascia Support.
- As the DuoSpan profiles are made from aluminium this may be visible in the gaps between the boards, over time these will become less visible. 100mm DPC can be applied to the top of the Joists so the Joists can't be seen in the gaps between the boards.

Other Considerations:

- Where lighting is needed on the deck, any access holes in the Joist need to be done where the Joist is supported by the DuoLift.
- Where the framework will be touching or near to electricity cables, the framework will need to be earthed suitably.

DuoLift

DuoLift unpacked

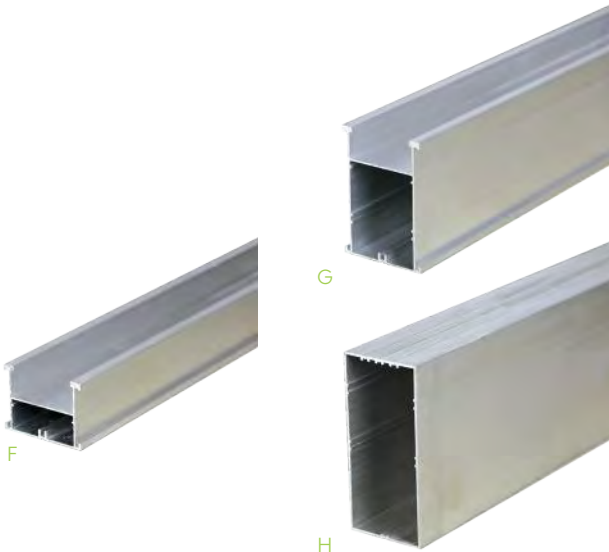
Contents	Box Quantity	Heights	Material	Box code
A DuoLift Joist Cradle	10	15 - 60mm	Glass filled nylon	PMCP010
B DuoLift Self-Levelling Joint	10	20mm	Glass filled nylon	PMLP010
C DuoLift Riser	10	45mm	Glass filled nylon	PMRP010
D DuoLift Foot	10	45mm	Glass filled nylon	PMFP010
E DuoLift Acoustic Separation Pad	10	3mm	Agglomerated cork & rubber	PMAP010



DuoSpan

DuoSpan profiles

Contents	Dimensions	Material	Code
F DuoSpan 51mm Joist	51 x 68 x 3600mm	Aluminium	K5168J360
G DuoSpan 99mm Joist	99 x 68 x 3600mm	Aluminium	K9968J360
H DuoSpan 136mm Beam	136 x 63 x 3600mm	Aluminium	K1363B360



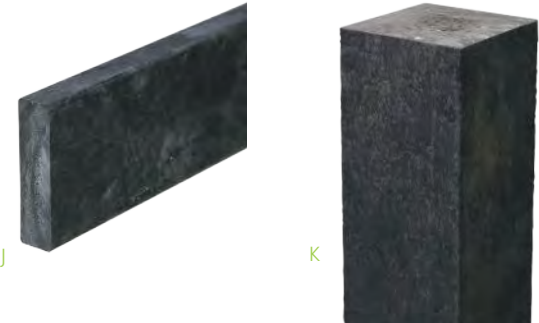
DuoSpan insert

Contents	Dimensions	Material	Code
I DuoSpan Joist Insert	25 x 50 x 3000mm	Recycled plastic	K0205B300



Plas-Pro

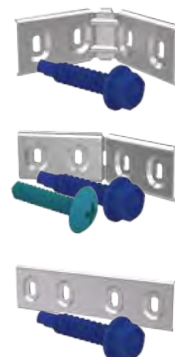
Contents	Dimensions	Material	Code
J Plas-Pro Fascia Support	100 x 25 x 3000mm	Recycled plastic	P0210B300
K Plas-Pro Post	100 x 100 x 3000mm	Recycled plastic	P1010B300



Accessories and fixings

Joist bracket sets for DuoSpan 51mm Joist

Contents	Quantity	Dimensions	Material	Box code
DuoSpan 51 90° Angle Bracket	10	–	Aluminium	K51RP010
DuoSpan Hex-head Screw	42	5.5 x 25mm	Cathodic barrier coated s/s	
DuoSpan 51 Flexible Bracket	10	–	Aluminium	K51FP010
DuoSpan Hex-head Screw	42	5.5 x 25mm	Cathodic barrier coated s/s	
DuoSpan Pan-head Screw	20	5 x 25mm	Cathodic barrier coated s/s	
DuoSpan 51 Straight Connector	10	–	Aluminium	K51LP010
DuoSpan Hex-head Screw	42	5.5 x 25mm	Cathodic barrier coated s/s	



Joist bracket sets for DuoSpan 99mm Joist

Contents	Quantity	Dimensions	Material	Box code
DuoSpan 99 90° Angle Bracket	10	–	Aluminium	K99RP010
DuoSpan Hex-head Screw	42	5.5 x 25mm	Cathodic barrier coated s/s	
DuoSpan 99 Flexible Bracket	10	–	Aluminium	K99FP010
DuoSpan Hex-head Screw	42	5.5 x 25mm	Cathodic barrier coated s/s	
DuoSpan Pan-head Screw	20	5 x 25mm	Cathodic barrier coated s/s	
DuoSpan 99 Straight Connector	10	–	Aluminium	K99LP010
DuoSpan Hex-head Screw	42	5.5 x 25mm	Cathodic barrier coated s/s	



Hold-down clip

Contents	Quantity	Dimensions	Material	Box code
DuoSpan Hold-down Clip	30	–	Aluminium	K48CP030
DuoSpan Hex-head Screw	63	5.5 x 25mm	Cathodic barrier coated s/s	



Plas-Pro profile fixings

Contents	Quantity	Dimensions	Material	Box code
DuoSpan Bracket to Plas-Pro Screw	100	5 x 25mm	Cathodic barrier coated s/s	FD25P100
Plas-Pro to DuoSpan Screw	100	5 x 50mm	Cathodic barrier coated s/s	FD50P100



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