



Cooper  
*stairworks*

PREASSEMBLED STAIRS

AND PREFIT RAIL SYSTEMS



# Cooper *stairworks*

INTEGRATING  
TRADITION AND  
INNOVATION  
SINCE 1974

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For nearly five decades, Cooper Stairworks has been at the forefront of blending centuries-old methods of stair building with state-of-the-art design and construction techniques. As you peruse this product catalog, you will discover our commitment to offering a complete stair system for the most selective buyers. Starting with the finest kiln-dried lumber, we seamlessly combine old-world joinery, cutting-edge computer technology, innovative production equipment, and years of experience to craft strong, beautiful, and cost-effective stairs. Step into the world of Cooper Stairworks, where timeless craftsmanship meets modern excellence.

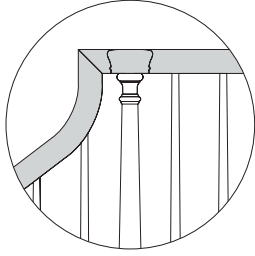




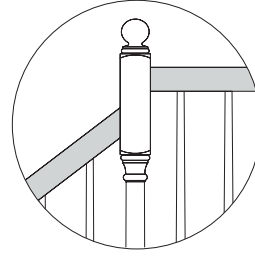
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# THE ANATOMY OF A STAIR



**OVER-THE-POST**  
Handrail runs over the newels using a series of fittings. This design provides a continuous handrail.



**POST-TO-POST**  
Handrail runs between a series of newels.



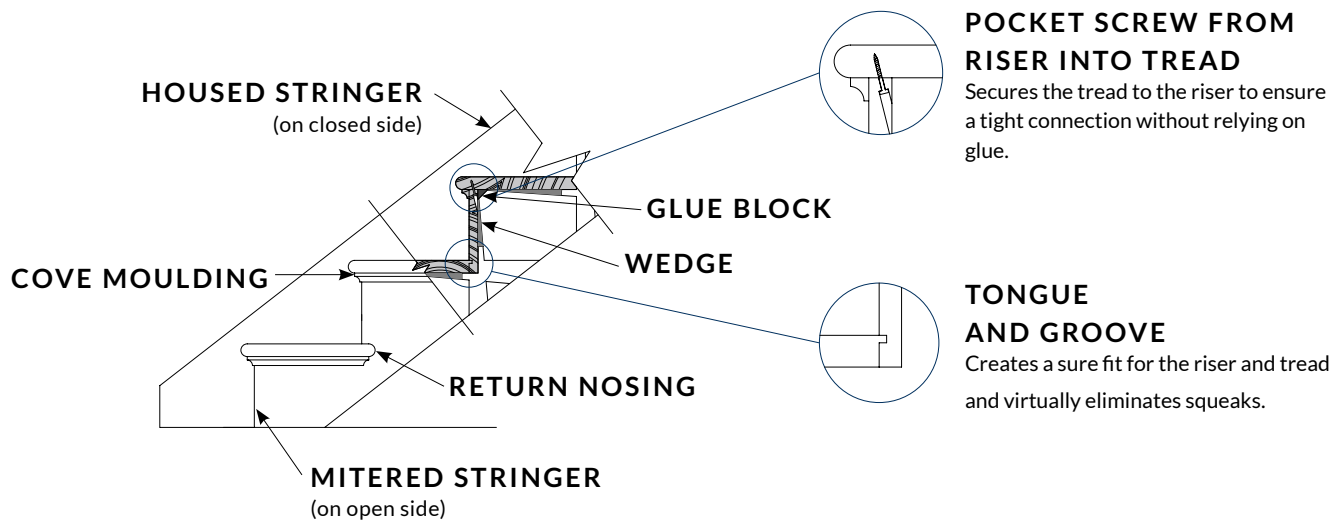
Volute  
Newel Post  
Wrought Iron Baluster  
Railing



Starting Step  
Tread  
Riser  
Box Newel  
Wood Baluster  
Gooseneck  
Stringer



## THE COOPER DIFFERENCE IS IN THE DETAILS





## WHY CHOOSE PREASSEMBLED?

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Cooper Preassembled Staircases are the pinnacle of efficiency in stair building. With a streamlined production process, our preassembled stairs are expertly crafted in our woodworking shop in Somerset, MA, saving valuable time and resources during installation on the job site.

### NAVIGATE BUILDING CODES WITH EASE

Cooper Preassembled Staircase embody both beauty and safety. We prioritize safety throughout the design process, ensuring compliance with various building codes across different states, while also educating our customers. At Cooper Stairworks, our experts are well-versed in the intricacies of rise and run ratios, baluster spacing, handrail graspability, headroom clearances, and more, and can provide valuable guidance throughout the decision-making process. Trust us to create a staircase that is not only beautiful, but also prioritizes safety and compliance at every step.





## FROM SIMPLE TO EXTRAORDINARY

Whether you're in need of a practical utility stair for a basement, or a magnificent staircase to make a grand impression in a foyer, our preassembled stairs can be tailored to meet your specific requirements, ensuring both functionality and architectural elegance.





## STAIR LAYOUTS

With a simple understanding of the number of risers you need, you may choose a layout that fits your space and determine the scale and balance so critical to the overall preliminary design phase.

The curved layouts shown walk safely with a 10" or 9" run at the walk line and are designed to meet residential building codes in most areas of the country.

Our manufacturing system allows us to build each stair to your unique conditions and dimensions with no additional labor or setup. Unlike curved stair

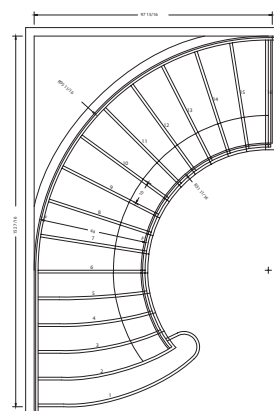
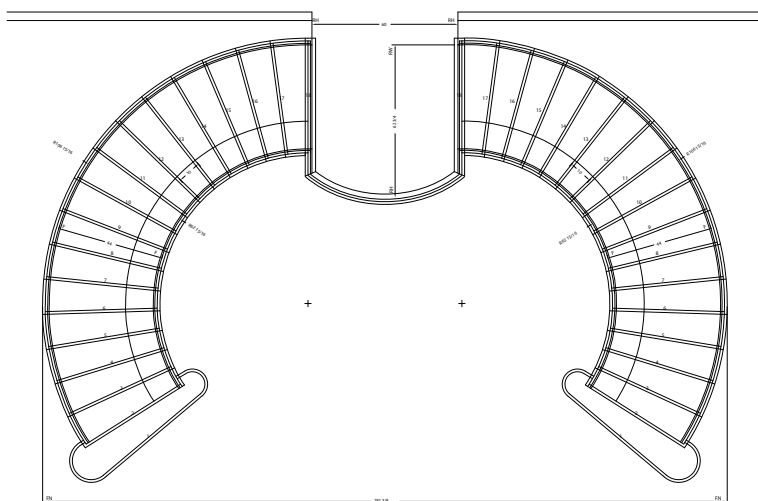
manufacturers with fixed bending forms, our processes allow complete dimensional flexibility, making custom sizes affordable.

Each layout can be: Constructed in any width, made opposite hand, treads can be added at either end, and be built with or without supporting walls

For an expanded collection of layouts, visit our website [www.cooperstairworks.com](http://www.cooperstairworks.com) or call for technical assistance 508.235.4397

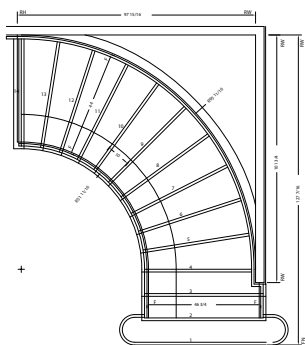
# CURVED STAIRS

Cooper Stairworks has revolutionized the traditionally labor-intensive process of building curved staircases. We have transformed what was once a challenging endeavor into a streamlined and efficient process. With our expertise and innovation, builders can now easily incorporate the opulence of a curved staircase into any project, expanding the possibilities of home designs.

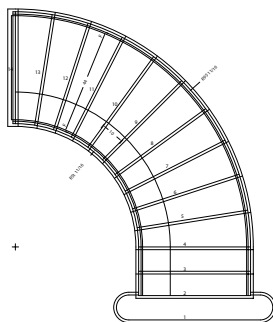


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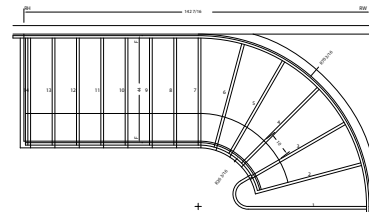
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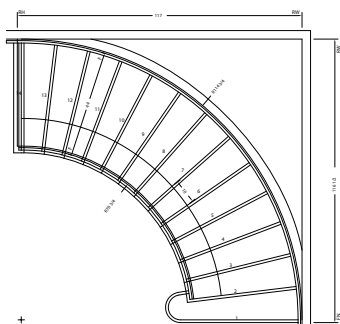
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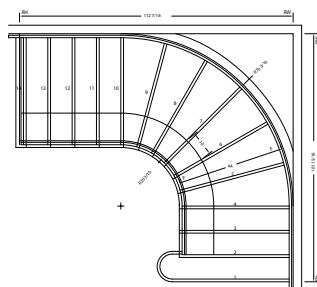
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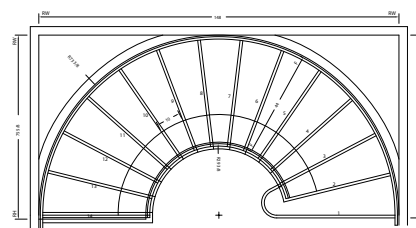
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CS-06

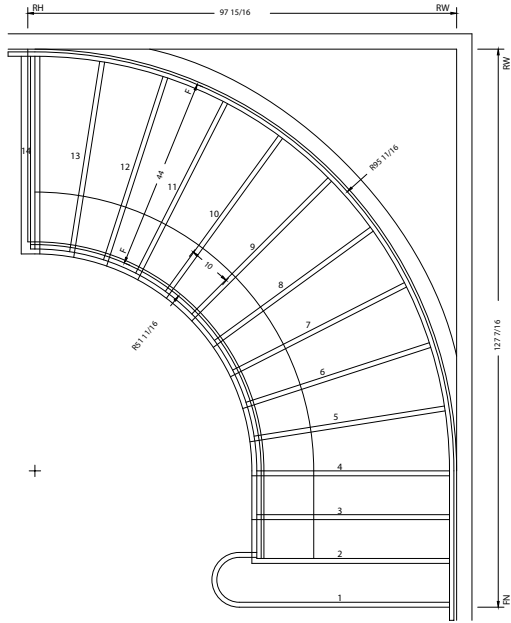


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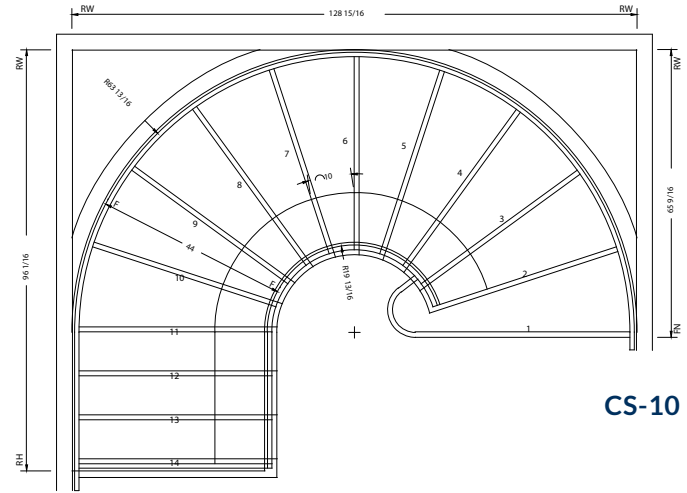


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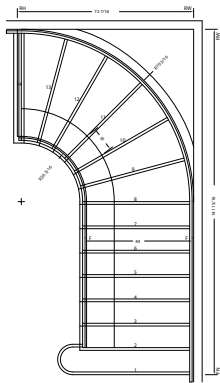
# MORE CURVED STAIRS



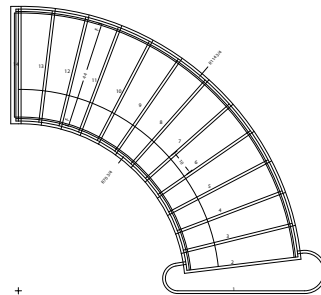
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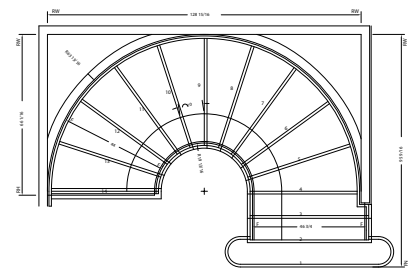
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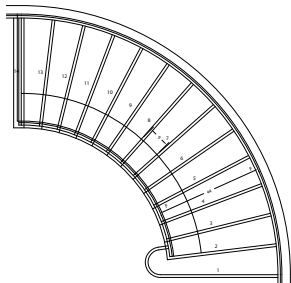
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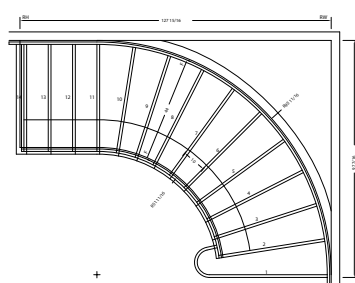
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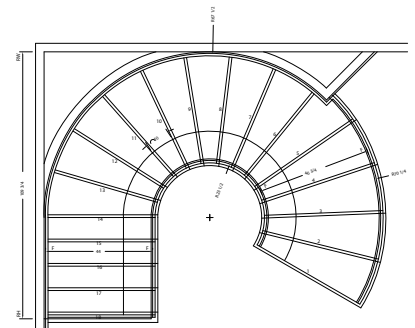
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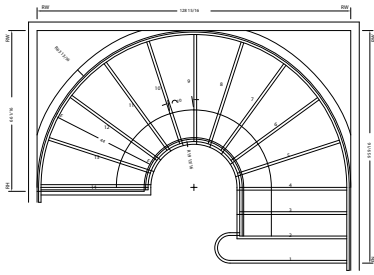
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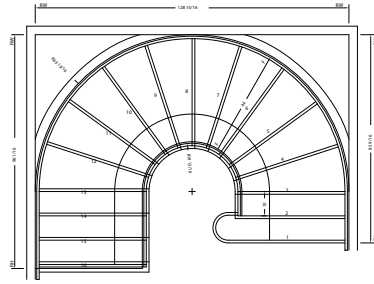
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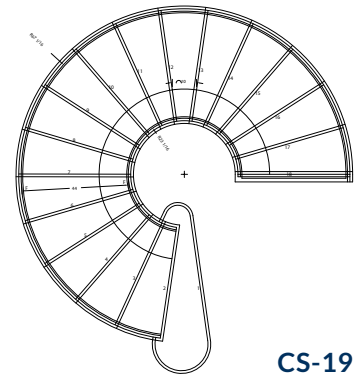
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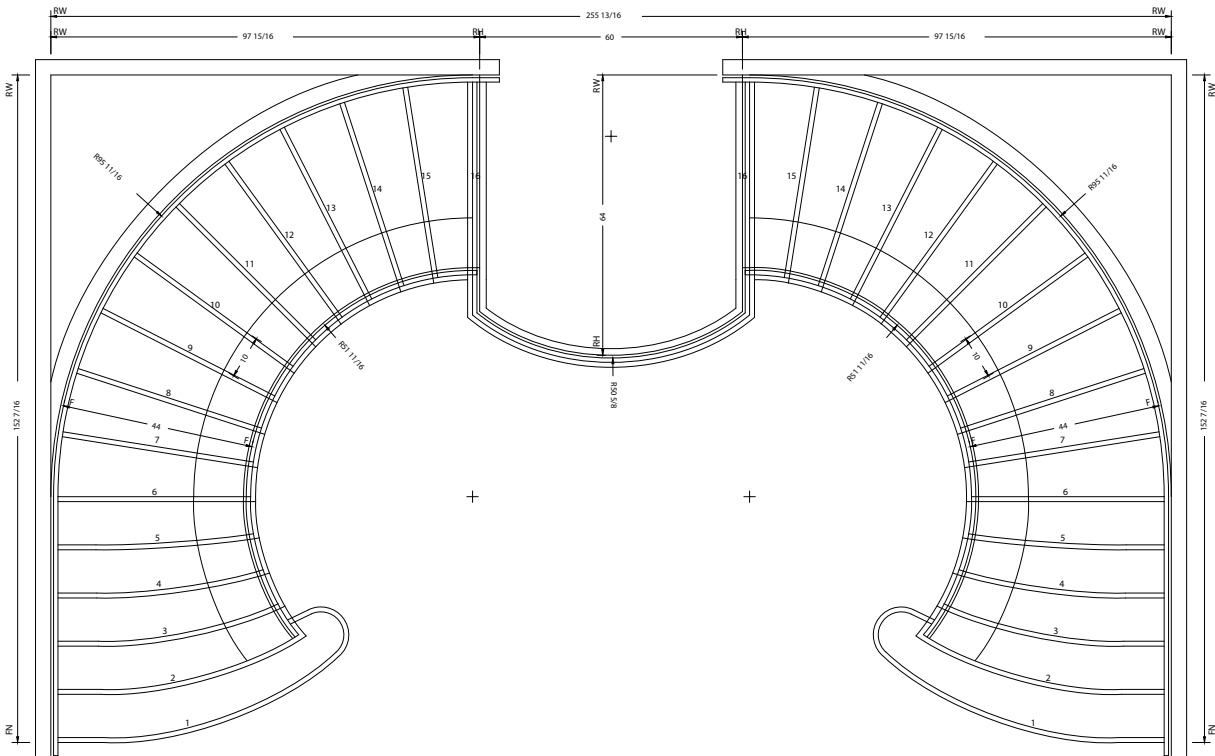
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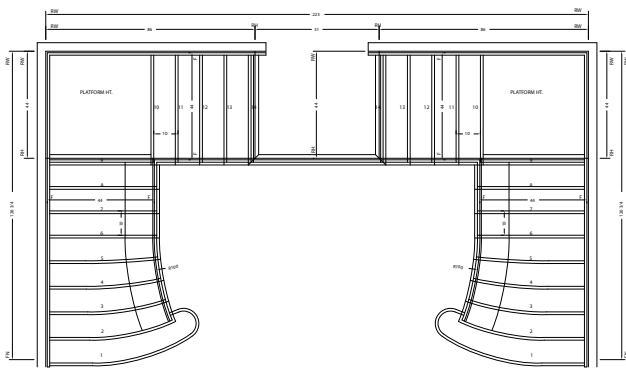
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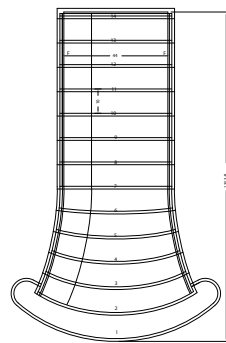
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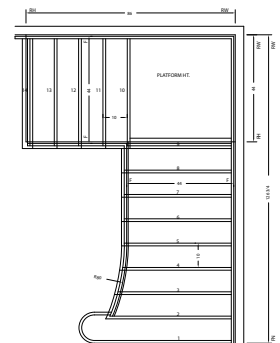
CS-20



FL-01



FL-02

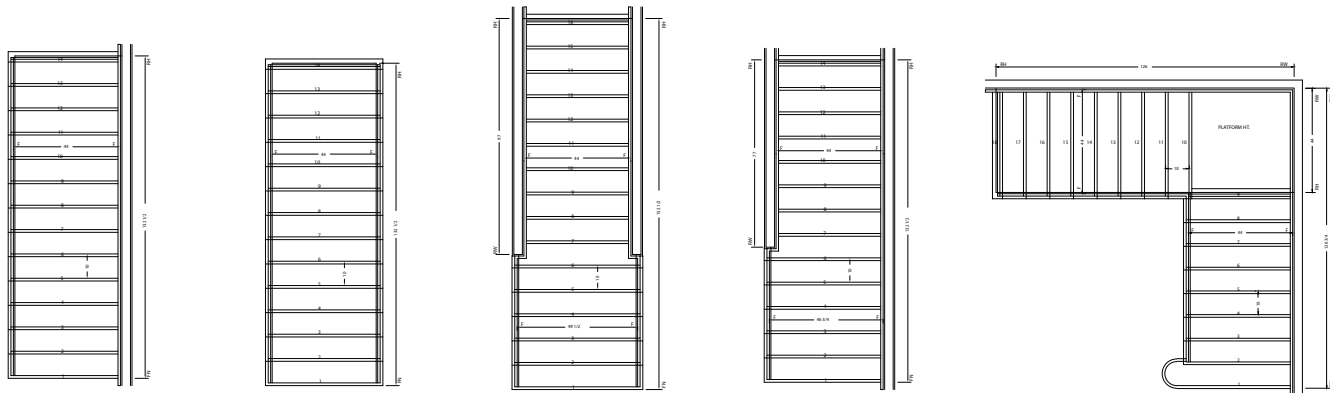


FL-03



# STRAIGHT STAIRS

Discover the versatility of straight stairs with Cooper Preassembled Staircases. Our range extends beyond the conventional straight design, encompassing shapes such as L-shaped, U-shaped, scissor-shaped, and more. Straight stairs can be just as captivating as their curved counterparts.



**SS-01**

**SS-02**

**SS-03**

**SS-04**

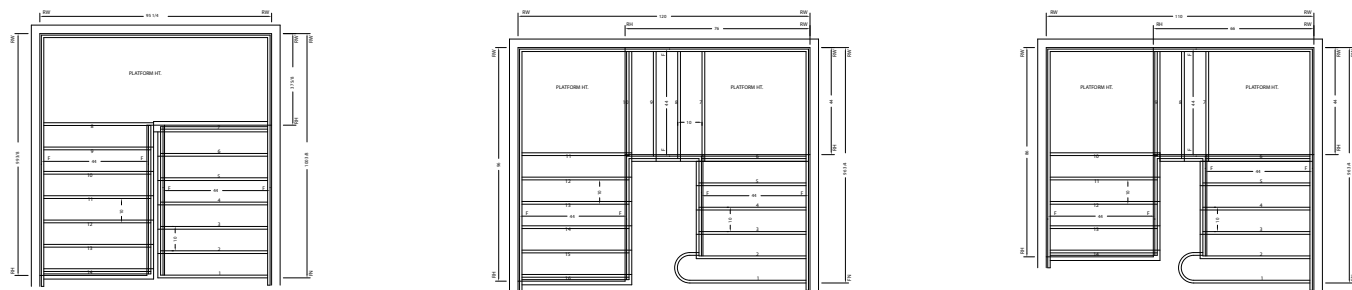
**LS-01**



**SC-01**

**LS-02**

**US-01**



**SC-020**

**US-02**

**US-03**

# PREFIT RAIL SYSTEMS

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Efficiently combine Cooper Prefit Rail Systems with our preassembled stairs to simplify your project. Choose from a variety of stock or custom balustrade styles, as our professional stair builders expertly configure and prefit the correct parts to ensure a seamless installation. Streamline your railing needs with our precise and hassle-free solution.



Introducing the game-changing ZIPBOLT™ UT Rail Bolt, now featured on all Cooper Preassembled Stairs. As a key component of our comprehensive range of fasteners and connectors designed specifically for the stair industry (see Cooper Stair Parts brochure), the ZIPBOLT™ UT Rail Bolt eliminates the hassle of dealing with multiple pieces like nuts, washers, and specialized wrenches. With its innovative design, the ZIPBOLT™ UT Rail Bolt securely fastens rail parts together using a standard hex-style driver, offering unparalleled convenience, speed, and strength.







## PREFIT RAIL SYSTEM DETAILS



Post is notched for exact location and height.



Stair is notched for post.



Treads are drilled for balusters, and inserts are installed.



One end of rail is precut for quick field installation with post to post rail systems. Opposite end is cut to fit in field.



Rake rails on stair are drilled for easy baluster insertion, up into rail and down into tread.



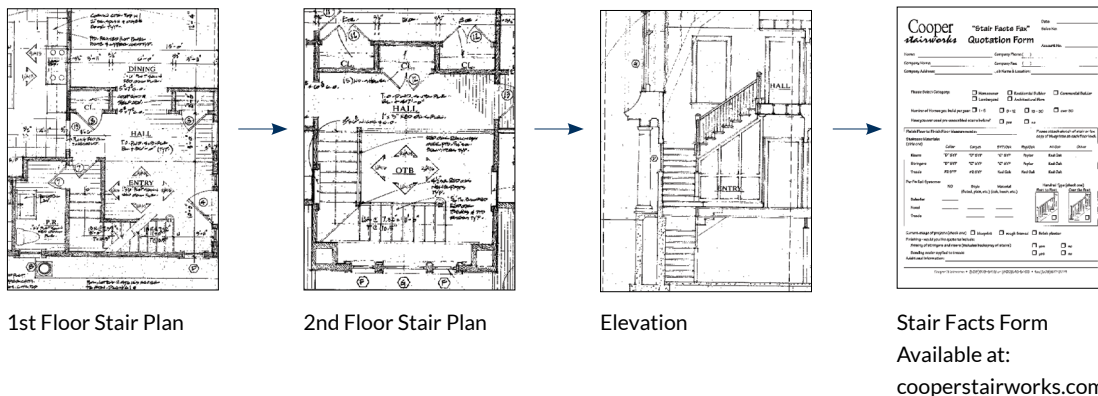
## EXPERT STAIR DESIGNERS AT YOUR SERVICE

Designing a staircase can be an intricate and overwhelming process, demanding a delicate balance between aesthetics and functionality. A well designed staircase not only becomes the centerpiece of a home but it must also be structurally sound and building code compliant. At Cooper Stairworks, we take great pride in our exceptional team of skilled stair designers and builders who excel in this challenging endeavor.

# HOW TO ORDER

## WHEN DO I START?

It's best to reach out to us to plan your stair during the initial stages of the building design process. By doing so, you'll maximize your options and avoid costly framing changes down the line.



## HOW DO I START?

Submit a copy of your plans in the area of the stair at each level and provide the height from floor to floor. You may request literature or view our website for our offerings to consider your rail and baluster preferences. Our "Stair Facts" form is available online to guide you through the planning process. We will send you a quotation for the complete stair system with your choice of balustrade or one we have recommended to meet your budget.

## HOW DO I ORDER?

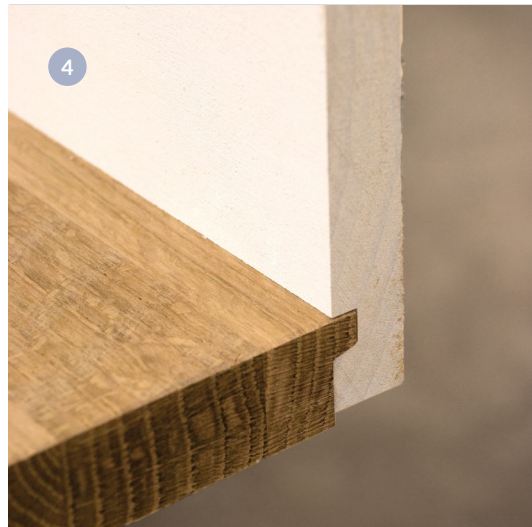
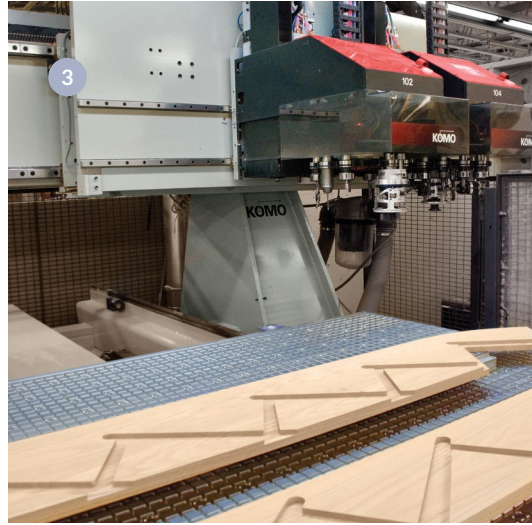
Simply approve the quotation. We will finalize the details and send a contract for you to sign. A shop drawing will follow for approval and if you are within reach of our service areas, a field technician will confirm field dimensions. If you have purchased a curved stair system we provide the curved wall plates, curved floor templates and a positioning diagram to coordinate the fit of the stair system while framing. This allows you to complete most of the framing and wall finish prior to taking delivery of the stair and rail system.

## WHEN DOES THE STAIR ARRIVE?

Once the job is weather tight, the stair and rail system will be delivered. The stair will be wrapped with six-mil polyethylene wrap and tread guards will be applied to protect the stair from jobsite traffic. When ready the protective wrap may be turned back and the rail system unpacked and applied. Complete installation is available within service areas.

## WHY CHOOSE COOPER STAIRWORKS? FEATURES + BENEFITS

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### 1 FIELD MEASUREMENT

In our direct service area all our Tech people field measure the job completely, make recommendations as needed, and work with a Project Manager from beginning to end.

### 2 CAD SUPPORT

Not all stair projects require CAD support, but when necessary we provide very detailed drawings of the project for review.

### 3 STATE-OF-THE-ART TECHNOLOGY

We have invested in the latest technology available. Automatic stair design software is used to support two CNC routers with 4 and 5 axis machining capabilities.

### 4 TONGUE & GROOVE CONSTRUCTION

This superior method of assembly creates a sure fit for the riser to the tread and virtually eliminates squeaks.

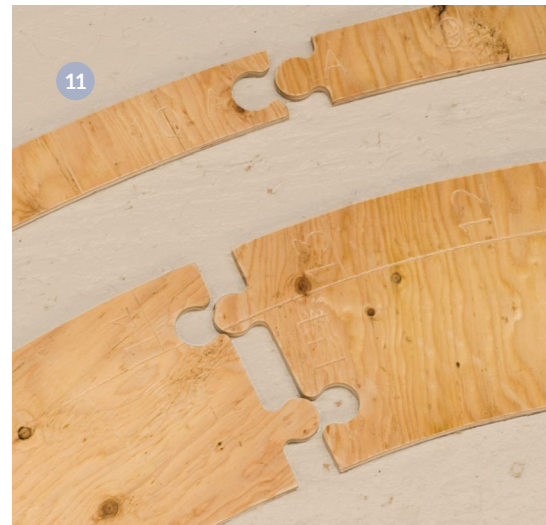
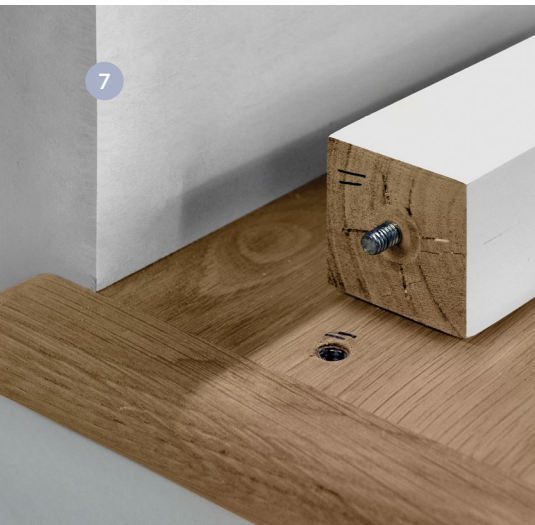
### 5 NOTCHED NEWELS

With our prefit rail system, all newels are notched to the proper height to comply with code in conjunction with the rail system. They are dry fitted and marked for location.

### 6 ZIPBOLT™ UT RAIL BOLT

All our rail joint connections are made using the ZIPBOLT™ UT Rail bolt. Easier, Faster, and Stronger. Tighten joints in seconds.

Our goal is to make it easy for you every step of the way. Beginning with the basic elements: treads, risers and rail systems, we will help you determine the best layout for your home. We will take into account all of your design parameters and with our many years of experience, provide you with a completely coordinated stair and rail system to meet your unique needs,



**7** **THREADED INSERTS**

On wooden, turned, tapered-top balusters, we use a threaded insert in the tread and a machine/lag screw in the baluster for superior strength and ease of installation.

**8** **FAS-N-FAST**

A strong machine screw style connector is used to connect all pin bottom newels to the starting step.

**9** **BLIND FASTENERS**

When we apply a return to a stair tread, all work is done on the backside so fasteners are never visible on the finish face and edge of the tread.

**10** **PACKAGING**

The stair is wrapped in clear plastic with custom water resistant double thick cardboard tread and riser guards applied for protection during construction.

**11** **PLYWOOD TEMPLATES**

Plates are provided for framing balcony sections and supporting walls. Stairs are assembled back in our shop using exact duplicates of these templates.

**12** **EASY INSTALLATION**

As soon as the project is weather tight, the stair is normally installed in less than half a day so it can be used during the construction process.



# PRESTIGE MONOSTRINGER STAIRS

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Introducing Prestige Monostringer Preassembled Stairs, a stunning addition to the Cooper Stairworks Preassembled Stair line up. These stairs, created in partnership with Prestige Metal, offer a unique and sleek design for modern style homes. With their floating steps and minimalist aesthetic, monostringer stairs are a work of art that seem to defy physics. They are the ideal choice when space is limited, providing a compact yet visually striking solution. Crafted with precision and expertise, Prestige Monostringer Preassembled Stairs combine innovation, advanced engineering, and high-quality materials to create a durable and aesthetically pleasing staircase that looks breathtaking from any angle.

**Prestige Metal**  
GARDE-CORPS | RAILINGS





**OUR SIGNATURE  
THICK HARDWOOD TREADS**

Our signature thick hardwood treads are skillfully handcrafted in our woodworking shop in Somerset, MA. These substantial treads harmonize flawlessly with Prestige's robust steel stringer, culminating in a mesmerizing visual experience of weightlessness. With each step effortlessly ascending to the next, the finished staircase exudes architectural excellence.



## UNSUPPORTED STAIRS

Unsupported Staircases, also known as a 'flying' or 'gallery' staircases, shoot up from the center of an open space and are unsupported on either side and open underneath. The unsupported staircase makes a dramatic impact, both in the room as a whole and on the person ascending the stairs. Some designs are difficult to construct properly from scratch on-site. The unsupported staircase is just one of our many specialties.



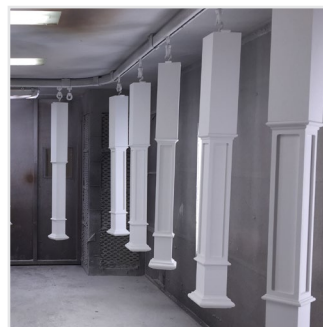
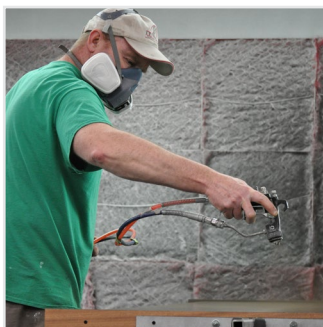


## LET US SAVE YOU A STEP

# FACTORY PREFINISHING

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Enhance the quality and efficiency of your project with the expertise of our skilled professionals in the prefinishing department. Using our state-of-the-art Fortress coatings systems, they will meticulously sand and flawlessly apply primer to your stringers, risers, balusters, or newel posts. Enjoy the benefits of time and cost savings, while reveling in the unmatched beauty that can only be achieved through a factory-applied spray finish.



## 5 YEAR WARRANTY

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North Atlantic Corp. takes great pride in its workmanship and undertakes to manufacture the very best preassembled staircase product possible. This commitment to quality allows us to offer a Five Year (5) Warranty limited to the original contractor/consumer purchaser covering only defects in material or workmanship. The warranty period shall commence from date of delivery providing all recommendations are followed as noted in our Use & Care Guide. Natural variations in color and grain of wood shall not be considered defects. Defects resulting from or attributed to normal wear, abuse, or alteration shall not be covered. Defects resulting from installation shall be covered only when installation is provided by North Atlantic Corp and its subsidiaries. Upon written notification of a claim describing a possible defect and presentation of this certificate we will inspect the staircase within 5 business days. If after such inspection we determine there to be a defect, we will repair or replace it, unfinished, FREE OF CHARGE.

# EXPLORE MORE

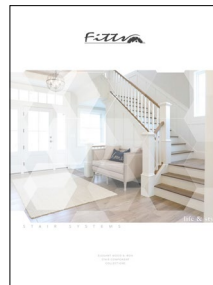
Learn about our other stair products from North Atlantic Corp. at [cooperstairworks.com](http://cooperstairworks.com)



Cooper Stairworks  
Stair Parts



House of Forgings  
Metal Balusters



Fitts Stair Parts



Rintal Spiral Stairs

## PHOTO REFERENCE GUIDE

### Front Cover

Custom unsupported open tread stair w/White stringers + risers, w/Plain Sawn White Oak treads w/plank nosing, 2" Square Satin Black Steel posts, 5/8" Diameter Satin Black Steel balusters, custom White Oak N-3415 handrail.

### Page 1

Custom curved, open one side, balusters: House of Forgings Harmony Collection Arch, 6088 white oak handrail.

### Pages 2-3

Custom buttress style U Shaped stairs w/3" thick stringers, Character grade White Oak treads, 6014 Sapele Mahogany Handrail w/custom Volute capping a custom welded steel balustrade system w/Bronze Finish.

### Page 4

Left: scissor style, treads: red oak, risers: primed, stringers: primed, balusters: Fitts FI5512, FI5515 wrought iron, rail: Fitts 6010 red oak, posts: Fitts 4410 and Fitts 4454 red oak, starting step: 8010 style.

Right: L-shaped stairway with custom starting step, treads: red oak, risers: primed poplar, stringers: primed poplar, balusters: Fitts 5415 fluted primed, rail: 6014 red oak, posts: custom red oak box newels.

### Page 5

Flare stair, open one side, treads: recycled heart pine, risers: primed, stringers: primed, balusters: 5060 primed, rail: 6009 sapele, posts: 4092BD box newel with sapele cap.

### Pages 6-7

Custom buttress style curved stair w/4-1/4" thick stringers, Custom 2-7/8" White Oak treads w/ custom nosing detail, Glass risers, 6008 White Oak top rail, 2" round 6041 secondary handrail. Square brushed square newels, glass balustrade system.

### Page 8

Custom unsupported Buttress style curved stair w/2-1/2" Painted stringers + risers, w/Rift + Quarter Sawn White Oak treads, 2" round Brushed Stainless Steel posts, 5/8" Diameter Brushed Stainless Steel balusters, custom Sapele N-3415 handrail.

### Page 12

Open one side stair, White Oak treads, Primed risers: primed and stringers, primed F5911 balusters, F4910 Sapele Mahogany pin top newels w/6014 Sapele Mahogany over the post rail.

### Pages 14-15

Custom curved winder/open tread stair w/White stringers + risers, w/Quarter Sawn White Oak treads, custom turned 1-1/2" round base balusters, custom Sapele Mahogany handrail.

### Page 16

Custom buttress open riser style stair w/4-1/4" thick stringers, Custom 3-1/4" White Oak treads, 6000 White Oak top rail, 2" Square black Powder Coated newels, Cable balustrade system.

### Pages 20-21

Top: Custom white powder coated mono stringer w/4-1/8" thick Rift + Quarter White Oak treads/Platforms, glass balustrade system capped with 6000 White Oak top rail.  
Bottom: Custom black powder coated mono stringer w/Red Oak treads w/safety riser, 2" Square black Powder Coated newels, glass balustrade system, 6000 red oak handrail.

### Page 22

Straight, unsupported, treads: American cherry, risers: American cherry, stringers: American cherry, rail: 6009 American cherry, posts: custom American cherry newels, balusters: 1/2" square black iron.

### Page 25

Series of three elliptical stairs starting at the basement level and continuing to the third floor. The 1st to 2nd, and 2nd to 3rd floor stairs were achieved with minimal support and do not have any walls under either stair. Treads: quarter sawn white oak, risers: poplar painted, stringers: buttress style poplar painted, balusters: solid 5/8" stainless steel, newels: 2" stainless steel, rail: custom white oak.

### Back Cover

Custom buttress style curved stairs w/primed stringers, Reclaimed White Oak Plank style treads, Reclaimed White Oak risers, 2" round 6041 handrail. 1/2" round black iron balusters.

## USE AND CARE GUIDE:

- Staircase must be installed level and square.
- Shim any void between framing and back of stringer (usually wall finish thickness) and screw through stringers into framing at each stud above and below tread. Where walls are not used to support the staircase adequate substringers must be used.
- Use glue under landing tread and glue nailing cleat behind bottom riser or squeak will result in these areas.
- Apply a minimum two to three top coat paint / finish system within 60 days of delivery to effectively seal wood.
- Staircase should be backpainted or ceiling installed underneath to provide vapor barrier from basement, crawl space, or other damp areas to prevent squeaks. Likewise shield under side of stair from heat sources such as water heaters, furnaces, etc.
- Do not subject staircase to extremes of temperature or humidity.
- Intense exposure to direct sunlight such as in sunrooms or windows with southern exposure, especially in enclosed areas, should be avoided.



[WWW.COOPERSTAIRWORKS.COM](http://WWW.COOPERSTAIRWORKS.COM) // 508-235-4397

MANUFACTURED BY NORTH ATLANTIC CORP

Cooper  
stairworks



Learn about our other custom millwork products made in Somerset, MA:



Cooper Stair Parts  
[cooperstairworks.com](http://cooperstairworks.com)



Captiva Custom Wood Doors  
[captivacustom.com](http://captivacustom.com)



Captiva Custom MDF Doors  
[captivacustom.com](http://captivacustom.com)



Captiva Custom Mouldings  
[captivacustom.com](http://captivacustom.com)