

*Panel Craft*

*Roof System*

*Installation Guide*

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## HORIZON BUILDING SYSTEMS

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# Panel Craft ROOF SYSTEM INSTALLATION GUIDE

NOTES:

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## 1.0 General

### 1.1 Purpose of this manual

This erection manual is provided to Horizon Builders and their erectors as the recommended procedure for the correct assembly of the Horizon Structural Systems (HSS) Panel Craft Standing Seam Roof System.

This manual is intended to be used in conjunction with the project's erection drawings to help plan and organize the installation of the Horizon Panel Craft Standing Seam Roof System. The erection drawings identify the applicable roof conditions and govern specific part arrangements. The instructions will help you identify parts, establish the installation sequence, demonstrate correct assembly, and point out any areas or procedures requiring special emphasis or attention.

This installation manual applies to the standard conditions. Custom roof conditions, including custom details and instructions, will be covered by the erection drawings. **In the case of conflict between this installation manual and the erection drawings, the erection drawings will take precedence.**

The Horizon Panel Craft Roof System can be erected on many different types of construction. However, for this manual we have assumed this roof system will be erected on a pre-engineered metal building.

- A Panel Craft check list is provided at the end of this manual for punching out the roof system. Please review this list prior to erecting the roof.

### 1.2 Buyer's Responsibility

The buyer is responsible for proper installation of the roof in accordance with the erection drawings and this manual, and in accordance with good engineering and construction practices.

The buyer must take the responsibility for selecting a competent erector, insist that the work be performed by qualified and experienced standing seam metal roof installers, and insist that the erector take time to study and understand this manual, then assure that the erector correctly follows the manual's instructions.

Horizon does not guarantee and is not liable for the quality of the erection. HSS is not responsible for building defects that may be attributed to improper erection or negligence of other parties.

Clarification concerning the HSS Panel Craft roof installation should be directed to the Horizon Structural Systems Customer Service Department. The following is a list of addresses and phone numbers for the customer service representative at each division:

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### 1.3 MBMA

This building is designed, manufactured and delivered in accordance with the 2012 M.B.M.A. (Metal Building Manufacturer's Association) metal Structural Systems manual. Consult the information in the "Common Industry Practices" section for more information.

### 1.4 Disclaimer

**THE PRODUCTS AND PROCEDURES IN THIS MANUAL ARE SUBJECT TO CHANGE WITHOUT NOTICE.**

### **1.5 Unloading and Storage**

Check the quantities and condition of all Panel Craft bundles and trim crates on arrival. Note on the delivery tickets any shortages, damage, or discrepancies. HSS shall **not be** liable for damage or shortages that are not noted on the delivery tickets. The customer assumes full responsibility for the condition of this material after deliver by the trucking company.

Extreme care should be exercised when unloading and handling the panel bundles and accessory crates to prevent damage. The weight of the panel bundle is printed on the bundle tag on the end of each bundle. If the tag is not on the bundle, you may calculate the weight of the bundle with the formula: (Qty. of panels x Bundle length x 2.5 pounds per foot).

Bundles up to 25-feet long can be lifted with a forklift. Bundles over 25-feet long shall be lifted with a crane utilizing a spreader bar with 4-inch minimum width nylon straps. Straps should be 15 to 20-feet apart. To avoid damage to the panels, steel cables, chains, or chokers shall not be used.

The HSS panels and accessories shall be stored on high ground, sloped to drain and tarped to protect from moisture formation. The tarp should be open at each end to allow consistent airflow through the bundles. The recommended procedures are outlined in this manual. HSS will not be held responsible for damage or discoloration of panels caused by improper storage.

### **1.6 Erection Sequence**

The Horizon Panel Craft Roof System is designed to be erected from either end of the building. In rare cases, due to the building layout, it may be required to start erection from a specific end. In those cases, this will be noted as such on the roof sheeting plan.

Because the roof can be started from either end, the panel ribs may not be in alignment across the ridge. This is normal practice for the Horizon Panel Craft Roof System.

For buildings with roof translucent panels, in order to align the translucent panels across the ridge, it is suggested to erect the roof panels on both sides of the ridge from the same end of the building, utilizing the same start panel width. Panel runs with translucent panels have been placed as specified in the order documents.

The erector of the Horizon TS-324 Roof System shall exercise great care and attention to the details as shown on the erection drawings and in the Horizon TS-324 erection manual to insure a secure and proper fit of all components. HSS shall not be responsible for supervising and/or coordinating the erection of the TS-324 roof system with other trades.

Due consideration must be given by the erector to the effects of thermal expansion and contraction when erecting a roof tie-in to an existing structure to insure a safe, secure, weather tight condition. Flashing for tie-ins to existing buildings is typically not included as part of the material provided by HSS. Refer to the sections and details for specific materials provided by HSS and does not affect the performance of the roof system.

### **1.7 Coordination with Other Trades**

Supports for the Horizon Panel Craft Roof System shall be provided and are required as shown in the sections and as noted in these specifications. All necessary clearance dimensions for proper elevations relative to the roof panels have been shown. The contractor shall be responsible for coordinating these dimensional requirements with other trades associated with the building roof system.

### **1.8 Erection Care**

The erector must be skilled in the erection of Metal Structural Systems, including roof panels, and is responsible for complying with all applicable local, federal and state construction and safety regulations including OSHA regulations as well as any applicable requirements of local, national, or international union rules or practices.

The erector remains solely responsible for the safety and appropriateness of all techniques and methods utilized by its crew in the erection of the Metal Building System and/or the Horizon Panel Craft Roof System.

The erector and/or contractor is also responsible for supplying safety devices, such as scaffolds, runways, nets, etc. which may be required to safely erect the Metal Building System and/or Panel Craft roof system.



### **1.8 Erection Care (continued)**

The erector of the Horizon Panel Craft Roof System shall exercise great care and attention to the details as shown on the erection drawings and in the Horizon Panel Craft erection manual to insure a secure and proper fit of all components. HSS shall not be responsible for supervising and/or coordinating the erection of the Panel Craft roof system with other trades.

Due consideration must be given by the erector to the effects of thermal expansion and contraction when erecting a roof tie-in to an existing structure to insure a safe, secure, weather tight condition. Flashing for tie-ins to existing buildings is typically not included as part of the material provided by HSS. Refer to the sections and details for specific materials provided by HSS and does not affect the performance of the roof system.

### **1.9 Field Cutting of Panels**

When field cutting or mitering metal panels, non-abrasive cutting tools such as nibblers or tin-snips shall be used. Abrasive cutting tools such as mechanical grinders or power-saws, can damage the Galvalume finish and create excess metal shavings that can corrode the panels. The use of non-approved cutting devices may void the factory warranty.

### **1.10 Trim and Flashing**

NOTE: Trim and/or flashing for transitions to existing buildings is not supplied by HSS.

### **1.11 Engineering and reinforcing Materials.**

Note: HSS does not supply engineering investigations or materials to reinforce existing non-Horizon buildings. These type investigations must be submitted to the project engineer of record.

## 2.0 Design and Performance Criteria

### 2.1 Roof System

The HSS Panel Craft Roof System consists of 24 gage panels with a nominal coverage of 1'-4" and a panel seam that is 2" tall. The flat of the panel will be elevated above the top of the roof secondary member by either 3/8" (if short clips are used) or 1-3/8" (if tall clips are used). Refer to the details and sections on the erection drawings for specific panel clip type.

The Horizon Panel Craft Roof System has two seam type options. The project design and performance requirements govern which seam type is required.

Different seam types may be used on specific areas of a roof. In all cases, refer to the erection drawing roof sheeting plan and details for seam type and location. Also refer to the Seaming Manual for instructions on proper use of the seaming equipment.

### 2.2 Panel Clip Spacing

The Horizon Panel Craft Roof System uses a clip to attach the panels to the roof secondary members. Panel clip spacing is as follows:

For Panel Craft Roof on a Horizon Building:

Clips are required at every purlin and/or joist.

Clips are required at every sub-purlin.

**DO NOT** attach clips to purlin struts.

For Panel Craft Roof on a non-Horizon Building:

Maximum clip spacing is to be 5'-0" for purlin roofs, and 5"-6" maximum for joist roof.

### 2.3 Panel Clip Fastener Requirements

HSS standard clip fasteners are designed to fasten to a steel structural member of .060" minimum thickness (16 gage). A minimum of two fasteners are required to engage to the structural member at every panel clip location. In certain instances, three fasteners may be required per clip. See the final set of erection drawings for your specific clip fastener requirements.

Spread the clip fasteners as far apart as possible. Avoid placing fasteners side by side.

Check fasteners to see if they are securely engaged into the roofs secondary member.

**Do not over-drive screws!** Over-driving can strip the threads.

Use screw gun with torque control set to function properly for the combination of fastener size, hole size, and material thickness.

### DO NOT USE AN IMPACT DRIVER.

Required fastener pullout values are dependent upon project location, size, building code, and loading. Consult Horizon Engineering for project dependent fastener specifications.

### 2.4 Roof Top Units and Curb Supports

The Horizon Panel Craft Roof System and the roof curbs are elevated above the top of the roofs secondary structural members. Roof curb sub-framing is level with the secondary members. If your building has roof curbs, please refer to the respective roof curb erection manual for more information.

The HSS Roof System is designed as a floating system. Curb framing and flashing must be designed accordingly to allow the curb system to float with the Panel Craft roof during thermal movement. Roof curbs shall not span the ridge of a building.

### 2.5 Insulation Requirements

HSS recommends that insulation be used in all Panel Craft roof applications to avoid problems with condensation forming on the underside of the sheeting. This also provides a buffer between the purlins and the Panel Craft roof to eliminate noise and possible damage due to metal to metal contact. HSS can supply a noise reducing foam tape for use in limited applications (canopies, etc.) when included as part of the roof order. Refer to the details for foam tape requirements.

### **3.0 Composite Horizon Panel Craft Roof System**

(Application for Composite Horizon Panel Craft Roof Systems)

#### **3.1 Product Definition**

Refer to the sections and details on the erection drawings for specific clip fastening requirements, insulation thickness requirements, and liner deck type.

HSS recommends the roof secondary members be pre-drilled with 3/16" diameter holes to accept the panel clip fasteners to avoid potential fastener breakage.

Composite Panel Craft roof without the use of a liner deck is not a HSS standard product application. Due consideration must be given by the engineer of record or architect when this occurs to the effects of condensation. In addition, great care must be taken by the erector to insure that the roof system is erected in a safe, quality manner.

#### **3.2 Vapor Barrier**

Vapor barrier/vapor retarder must be used between the liner decking and the rigid board insulation to prevent condensation. Refer to the erection drawing details.

#### **3.3 Insulation**

Rigid board insulation is used in conjunction with a Composite Horizon Panel Craft Roof System. The rigid board insulation must be cut to allow free movement of the back-up plates at panel splices, rake and ridge locations.

### **3.0 Horizon Panel Craft Roof Components with Engineering**

#### **4.1 Components with Engineering Definition**

In a case where HSS is providing the Panel Craft Roof System to be used in conjunction with a non-Horizon structure, HSS refers to that as a "Components with Engineering". This simply means that HSS shall calculate the quantities and lengths for the material required. HSS is performing no engineering study of the existing structure. The engineer of record on the project shall be responsible for coordinating the Horizon Panel Craft Roof System with the other trades of the project to insure a safe, quality, and proper application of the roof system. HSS does not supply clip fasteners to attach to non-Horizon framing materials.

#### **4.2 Diaphragm**

The Horizon Panel Craft roof is designed to accommodate thermal expansion and contraction and will NOT act as a diaphragm for resisting lateral load forces or providing lateral stability to the roof structural members. Due consideration for this must be addressed by the project engineer of record. In addition, the Panel Craft roof, because it is designed to float, will not support structural member laterally. When replacing an existing screw down roof, additional bracing may be required to laterally support the members. Engineering and material for these uses shall not be provided by HSS.

#### **4.3 Clip Fastening Requirements**

Refer to Section 2.3 – "Design and Performance Criteria" for Panel Craft roof panel clip fastening requirements.

## 5.0 Receiving & Handling Roof Materials

### 5.1 Field Storage of Materials

Upon acceptance of the shipment, the buyer or his representative is responsible for proper handling, storage, and security of the roof materials. HSS is not liable for damage, injury, or loss as a result of improper storage and/or handling.

The roof panel bundles should be stored on the job site in accordance with the following recommendations.

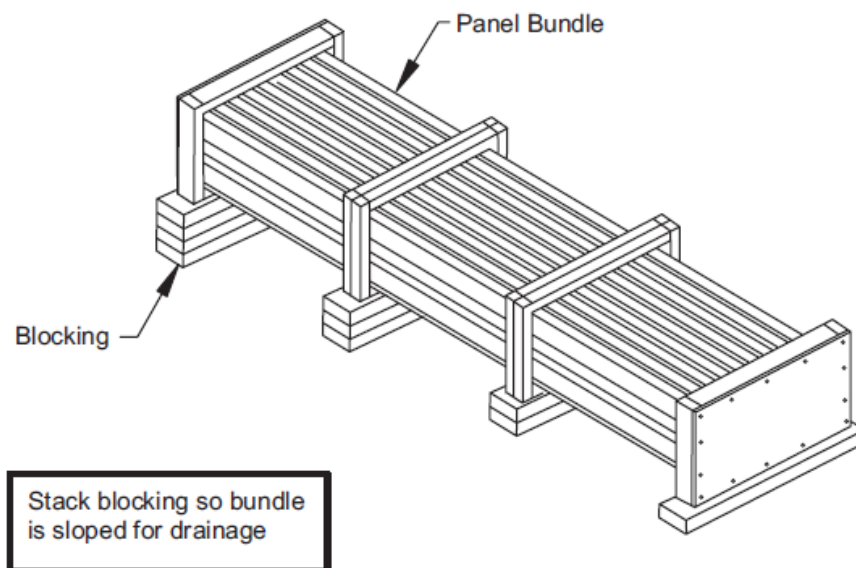
- a. Store panels in a protected area, out of standing water and drifting snow, etc. Panel bundles and trim crates should be blocked 12-inches above grade.
- b. Elevate panels with blocking to allow air circulation under the bundle to occur.
- c. Slope panels for drainage of moisture from the panels.
- d. As necessary, cover panels with waterproof tarp, allowing for air circulation (do not wrap tarp under panel bundle or restrict air movement).
- e. Inspect panels daily for moisture accumulation.
- f. If panel bundles contain moisture, the panels should be dried and re-stacked. Use care in re-stacking to avoid damage to panels.
- g. Opened or re-stacked panel bundles should be secured to prevent wind damage.
- h. Bundles should be located over primary structural frame lines, not in the middle of the bay. Blocking should be used between the purlins/joists at the panel bundle locations. This blocking is not supplied by HSS.

When moving panel bundles, extreme caution should be taken to prevent damage to the panel edges. Uncrated panels should be supported at each end and at 8' (maximum) spaces.

All bundles or loose panels on the roof should be secured to the roof secondary members at the end of each workday. On steep sloped roofs, provisions should be taken to prevent panels, panel bundles, and/or trim crates from sliding off of the roof. Be sure to set panel bundles on the roof in the proper direction for the installation sequence.

Trim and accessories should be stored in a secure area and protected from damage, weather, and theft. Fasteners, mastics, closures, etc. should be stored out of the weather and protected from contamination.

**IMPORTANT NOTE:** The finish on these panels may not perform as intended if not erected within 90 days from receipt at the job site. The finish is also subject to severe damage if moisture, debris, or dust is allowed to get between the panels; therefore, panels **MUST BE STORED UNDER COVER** with one end elevated to allow for drainage and protection against moisture, dust, or debris until erected. The manufacturer will not accept claims for non-performing panels if not properly stored at the job site. The customer assumes full responsibility for the condition of this material after deliver by the trucking company.



### 5.1 Field Storage of Materials

As necessary, cover panels with waterproof tarp, allowing for air circulation (do not wrap tarp under panel bundle or restrict air movement).

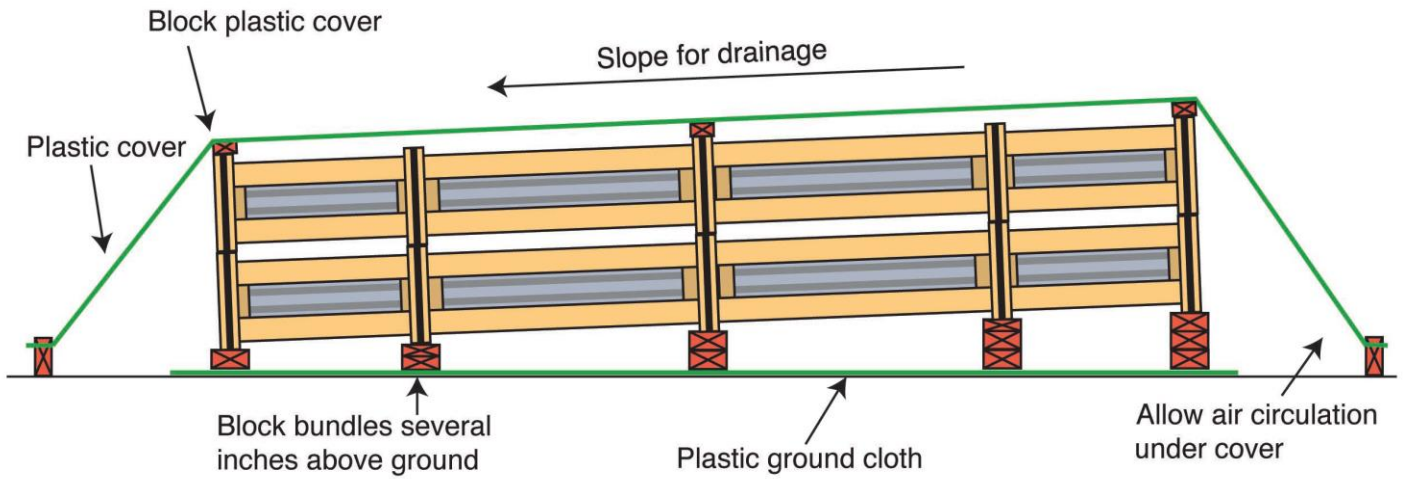
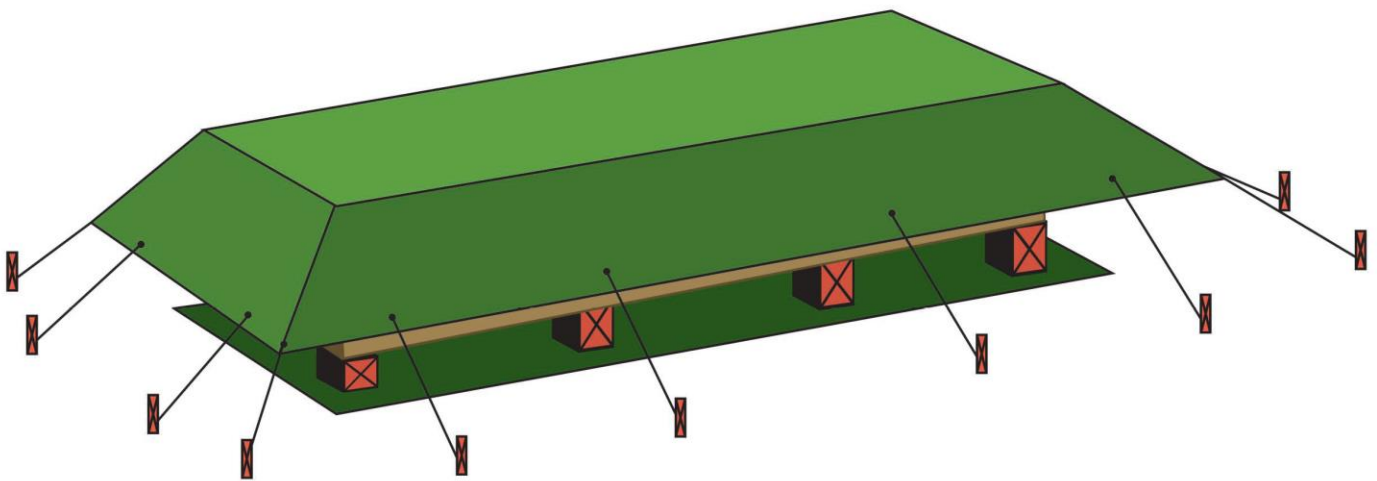


Illustration of Proper storage and tarp covering.



## 5.2 Handling Individual Roof Panels

To lift individual panels, lift one side of the panel by the seam, letting it hang naturally to prevent buckling. Pick-up points should not be more than 10' apart. Do not pick-up panels by the ends only, or in a flat position. Do not use any type of steel or cable slings.

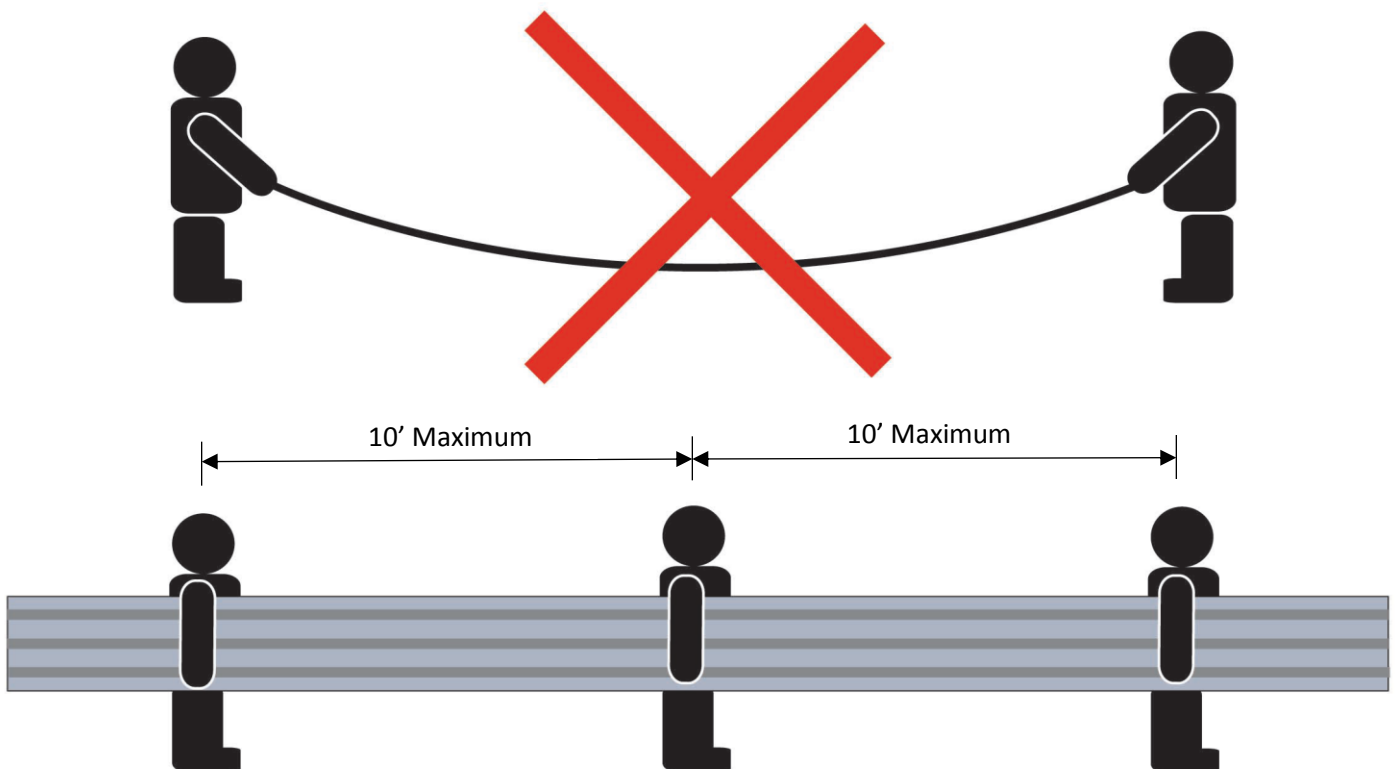
If the individual panels are to be lifted to the roof by hand line, the common method is to use the vice grip "C" clamps. Position the clamps on the flat of the panel as close as possible to one edge so the panel is lifted in a vertical position. The jaws of the vice grips must be padded to prevent damage to the panel surface. The clamps should be uniformly spaced, no more than 10' apart and the hand lines must be pulled in unison so that uneven lifting does not buckle the panel. Be sure the clamps are tight on the panel and the hand line is secure to prevent dropping the panel, which can result in personal injury and property damage.

## 5.3 Handling Roof Materials in Strong Winds

Do not attempt to move panels in strong winds. Wind pressure can easily cause a person to lose balance and fall. Strong wind uplift on a panel can lift the weight of the person carrying the panel.

Loose, wind borne panels are very dangerous and can cause severe injury and damage.

Secure stacks of panels with banding or tie-downs, so wind will not blow the panels off the roof. Clamp individual unsecured panels to the roof secondary members. Clamp or block panel bundles and trim crates to prevent them from sliding down the roof slope.



#### 5.4 Material Inventory

Your material is carefully inspected and packaged before leaving the plant and accepted by the transportation company as being complete and in satisfactory condition. It is the carrier's responsibility to deliver the shipment intact. Note any damage or discrepancies on the delivery tickets **before** signing as receiver.

Conducting a material inventory at the time of delivery is essential. By conducting the materials inventory, the erector is able to identify any material shortage or damage and avoid stopping installation later because of such shortage or damage. All claims must be filed with HSS Customer Service Representatives **prior** to any field modifications or purchases that may result in a charge to HSS.

It is imperative that any shortages or damages of the delivered materials be noted at once and clearly marked on the bill of lading before signature of acceptance. Notify HSS immediately of any conflicts. HSS will not be responsible for shortages or damages unless they are noted on the bill of lading. HSS is not responsible for items accepted in questionable condition.

In the case of packaged components (such as clips, fasteners, and mastics, etc.), the quantities are marked on their container and should be checked against the bill of materials.

#### 5.5 Equipment for Unloading and Lifting

Hoisting equipment is necessary to unload and position the panels and accessory crates for site storage and installation. The equipment must have sufficient capacity and reach to place the material where it is required for efficient installation.

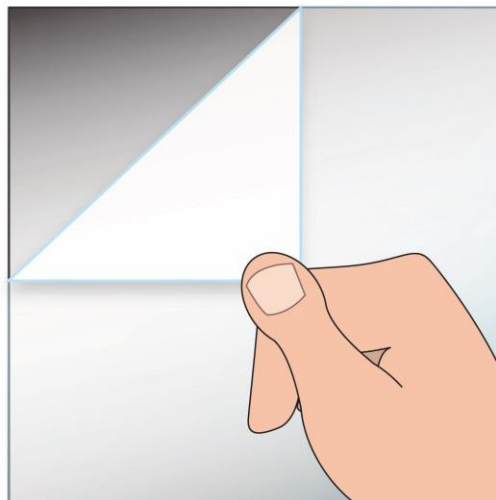
Nylon slings will be required to minimize panel damage. Horizon recommends a minimum 4" wide nylon sling be used. HSS Panel Craft panels are crated and banded. No exterior cover sheets are used, so care must be taken to prevent damage.

A spreader bar will be required for the longer panel bundles to assure correct sling spacing and uniform lifting. The spreader bar must be large enough to handle the maximum panel bundle weight and length.

Trim crates are to be handled in the same manner as panel bundles.

Panel bundle weights can be found on the I.D. tag. Maximum weight is 4000 pounds. Steel chokers, cables or chains shall not be used.

NOTE: Panels and trim with strippable film will require that UV exposure and minimizing exposure to high heat and moisture be avoided so the masking can be easily removed after installation. Strippable film **MUST** be removed immediately after installation or it may become difficult or impossible to remove.

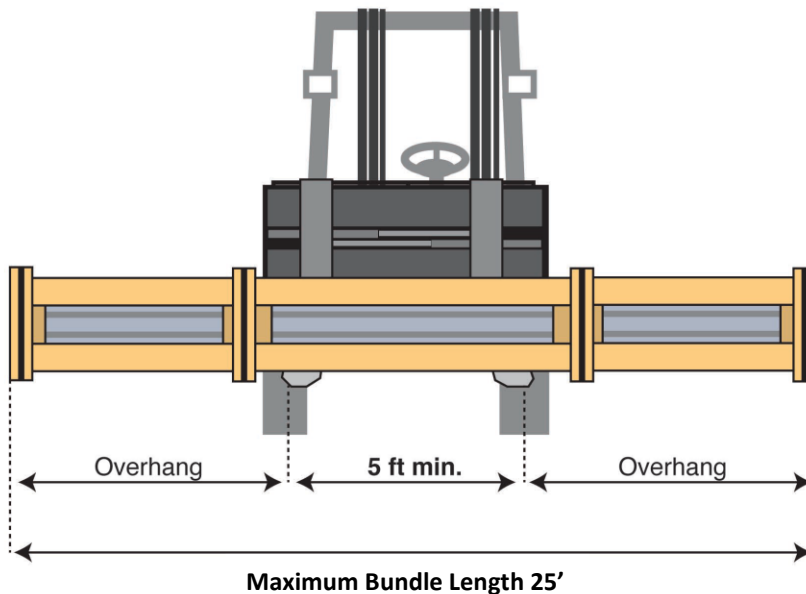
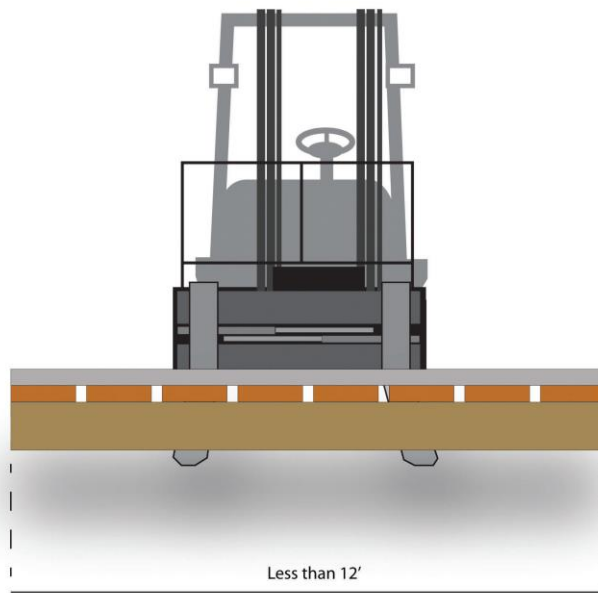


### 5.6 Lifting Roof Panel Bundles

Bundles over 25-feet long should be handled with a crane using a spreader bar and nylon slings. Lifting should occur at center of gravity. Locate slings at  $\frac{1}{4}$  points of the length of the panel bundle from each end of the bundle.

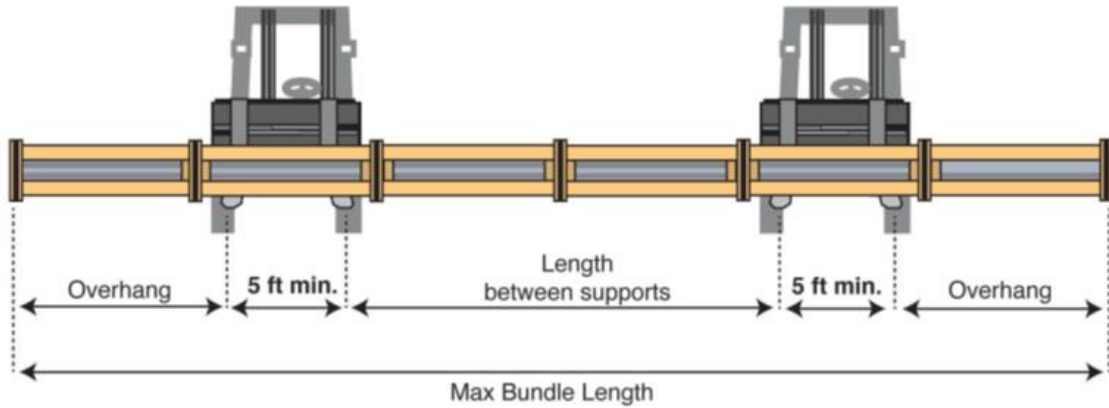
Loads should always be checked for secure hook-up, proper balance, and lift clearance. Tag lines should be used if to control the load during lifting, especially if operating in the wind.

Panel crates less than 25' long may be lifted with a forklift only if the forks are spread at least 5' apart and blocking is used to prevent panel damage by the forks.

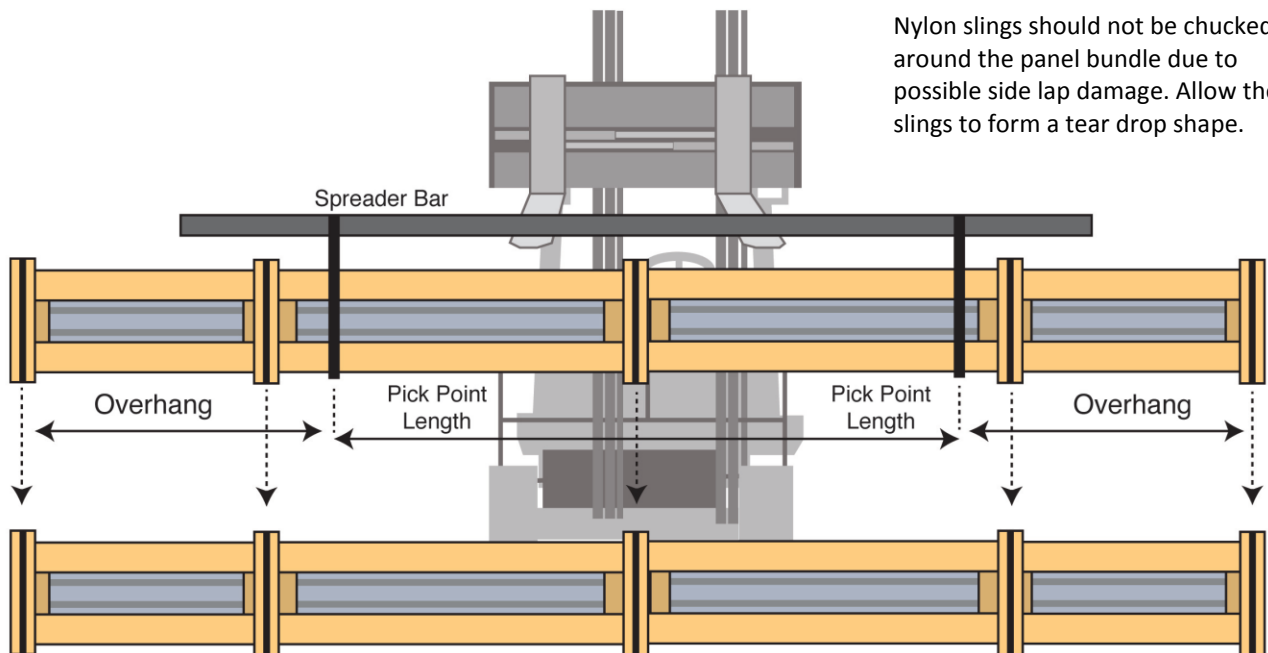




## 5.6 Lifting Roof Panel Bundles



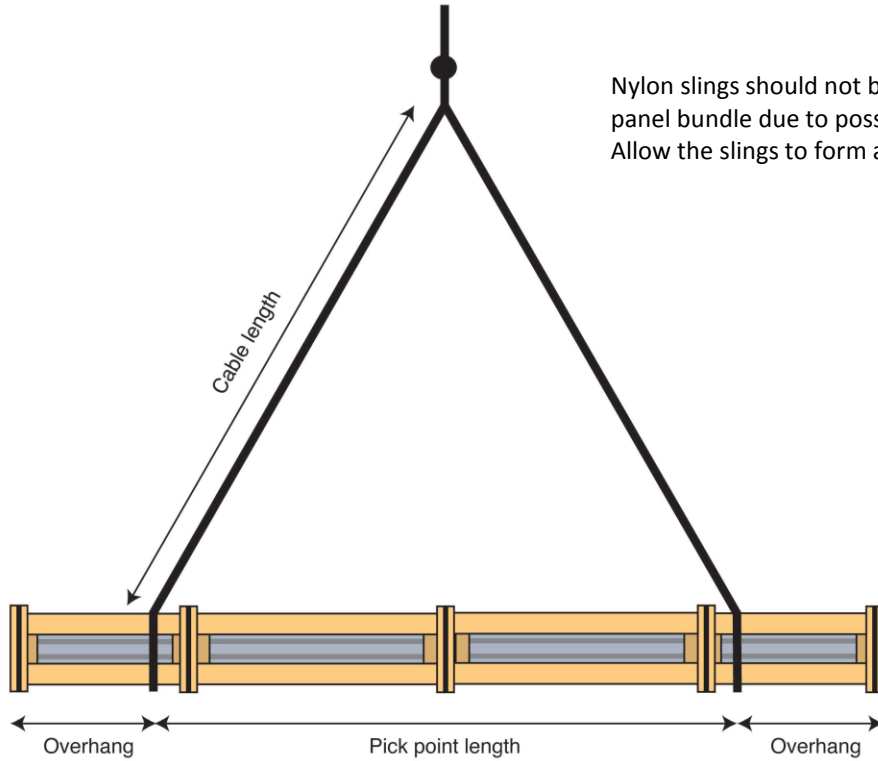
| Overhang and Span Limits for Lifting Panel Bundles |                        |  |   |
|--|------------------------|--|---|
| Panel Class  | Maximum Overhang (ft.) | Maximum Length Between Supports or Pick Points | Maximum Bundle Length Handled by One Forklift |
| Non-Structural Panels                              | 5'                     | 10'  | 15'   |
| Structural Panels                                  | 10'                    | 20'  | 25'   |



Nylon slings should not be chucked around the panel bundle due to possible side lap damage. Allow the slings to form a tear drop shape.

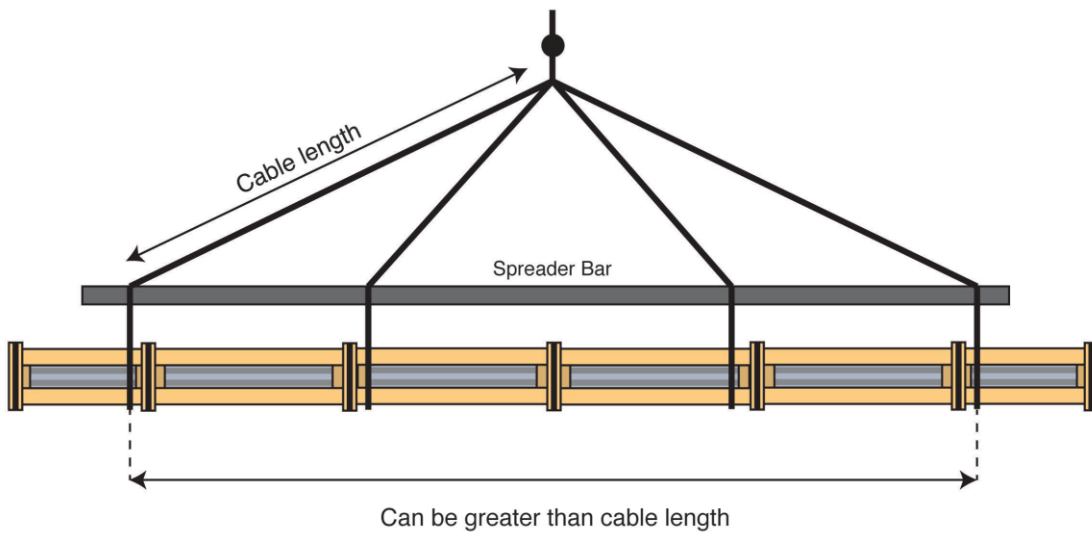
NOTE: Stack bundles so banded wooden frames are supported by banded sections on the bundle underneath.

## 5.6 Lifting Roof Panel Bundles



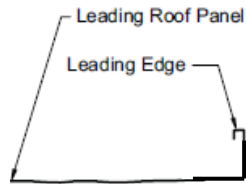
Nylon slings should not be chucked around the panel bundle due to possible side lap damage. Allow the slings to form a tear drop shape.

3 Equal Spaces When Panel Length is 35' or Less  
4 Equal Spaces When Panel Length is More Than 35'

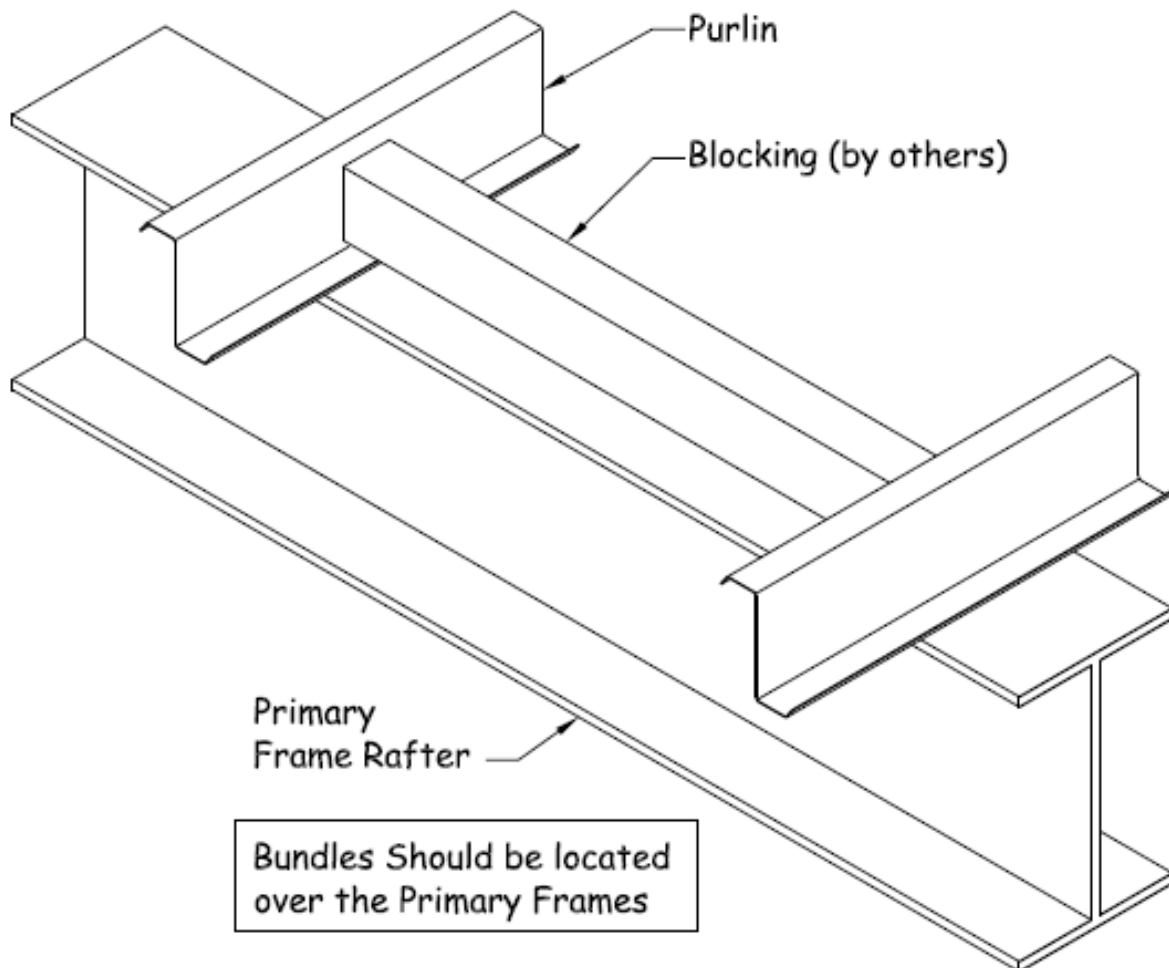


### 5.7 Placing Panel Bundles on the Roof Framing

Locate the bundles on the roof secondary framing according to the erection sequence. The male leg of the roof panel is the leading edge.



The bundles should be located over the primary structural frame lines, **not** in the middle of a bay. Blocking should be used between purlins at the bundle locations as shown in the detail below. This blocking is not provided by HSS.



## 6.0 Safe Roof Installation

### 6.1 Regulations

Regulations set forth by the Occupational Safety and Health Act, local, state, and/or federal agencies should be adhered to at all times. HSS is not responsible for injury, damage, or failure, which may be the result from failing to meet any of these regulations.

In compliance with the Hazard Communication Rule 1910:1200, Material Safety Data Sheets (MSDS) have been provided for your use and safety. These data sheets should be made available to all personnel that come in contact with these products. These data sheets will give you the necessary information to properly handle such materials and what to do in case of an emergency. (The MSDS sheets are located in one of the warehouse boxes or you can contact the office for a copy).

### 6.2 Erector's Responsibility

The erector of the roof system is responsible for the safe execution of this manual. These instructions are intended to describe the sequence and proper placement of parts. They are not intended to prescribe comprehensive safety procedures. The procedures in this manual are believed to be reliable. However, HSS shall not be responsible for injury, damage, or failure due to the misapplication of these procedures, improper erection techniques, or negligence.

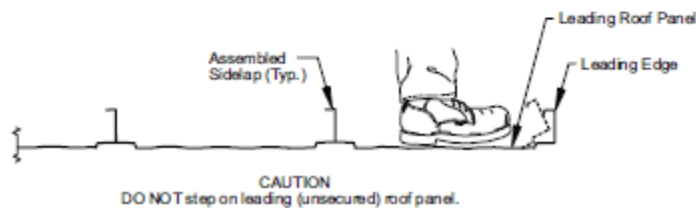
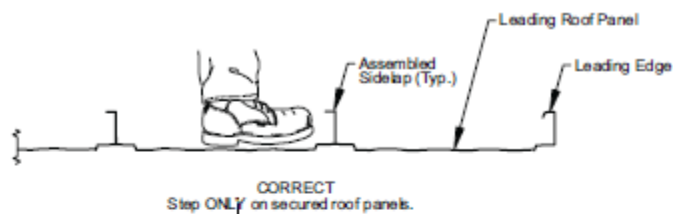
### 6.3 Walking and Working on Roof Panels

DO NOT place bundles of panels on the roof structure without first verifying the structure will safely support the concentrated weight of the panels and the weight of the installation crew. Some roof structures may not be designed to support the weight of a full panel bundle without additional structure support.

DO NOT use a roof panel as a working platform. An unsecured panel could collapse under the weight of a person standing between purlins or at the panel end.

DO NOT walk on the last installed panel run, as the unsecured edge could collapse under a person's weight. When installing panel clips or making end lap connections, etc., stand where the roof structure will support your weight.

An approved and safe walking platform should be used in high traffic areas to prevent the roof panel from being deformed, scratched, or scuffed.



#### 6.4 Safety Equipment

The use of safety equipment for the roof panel installation is recommended at all times during the installation process. However, when using lanyards, ensure that the clasp, belt hooks and wire cables are covered in such a manner that they will not scratch the panel surface if accidentally dragged along the panel.

#### 6.5 Crew Size

The length of the individual roof panels should be considered when determining crew size. It is recommended that under normal conditions, there be one person for every ten feet of panel length, plus one.

#### 6.6 Panel Overhang

**DO NOT** stand on the end of unsupported (cantilevered) panels at the eave or ridge. Standing on the cantilever portion may result in panel collapse.

#### 6.7 Point Loads

When properly supported by the structural steel, panels are designed to support uniform loads, which are evenly distributed over the panel surfaces. Point loads that occur in small or concentrated areas, such as heavy equipment, ladder, or platform feet, etc., may cause panel deformation or even panel collapse.

#### 6.8 Slick Surfaces

Panel surfaces and structural steel surfaces are hard, smooth, and non-absorbent, which causes these surfaces to be very slick when wet or covered with snow or ice. Even blowing sand or heavy dust can make these surfaces difficult to walk on without slipping.

Unpainted panel surfaces are often coated with oil to accommodate the panel-fabrication process. Although designed to wash away or evaporate during normal weather, the oil on new panels can be extremely slick, especially during periods of light rain and dew.

Caution must be exercised to prevent slipping and falling onto the roof surface or even sliding off of the roof. Non-slip working platforms are recommended.

#### 6.9 Electrical Conductance

Metal panels are excellent electrical conductors. A common cause of injury is the contact of metal panels with power lines

during handling and installation. The location of all power lines all must be noted and, if possible, flagged. The installation process must be routed to avoid accidental contact with power lines and high voltage services and equipment. All tools and power cords must be properly insulated and grounded and the use of approved ground fault circuit breakers is recommended.

#### 6.10 False Security of Insulation

Blanket and rigid board insulation block the installer's view of the ground below the roof. Serious injury can occur when the installer gets a false sense of security because he cannot see the ground and steps through the insulation.

#### 6.11 Sharp Edges

Some edges or panels and flashing are razor sharp and can cause severe cuts if proper protective hand gear is not worn. Be careful not to injure others while moving panels and flashing.

#### 6.12 Safe Roof Installation Summary

- **Extreme caution should be exercised when walking on roof panels.**
- **Oils used during the roll forming process and/or natural moisture may cause the panels to become slippery.**
- **Do not step on panels with creased edges.**
- **Do not step on or near the edge of a panel.**
- **Do not step within 5-feet of the end of a panel.**
- **Do not use loose panels as work platforms.**
- **Do not walk on unsecured panels.**
- **Do not walk on translucent panels.**
- **Secure all loose panels at the end of the work day.**
- **Use extra care when working on steep slopes.**
- **When installing clips, walk only over the purlin/joist lines.**
- **At the end of each workday, all full panel runs should be hand crimped into a TripleLok seam profile at the low eave, end lap, high eave, and every clip location.**

**In compliance with the hazard communication rule 1910:1200, material safety data sheets have been provided for your use and safety. These data sheets should be made available to all personnel that come in contact with these products. These data sheets will give you the necessary information to properly handle such materials and what to do in case of an emergency.**

## 7.0 Checking the Structure

### 7.1 Completed and Braced

Before placing materials and workers on the roof structure to start roof installation, it must be confirmed that the structure is designed to accommodate the material and erection loads as well as the appropriate live loads and wind uplift loads.

It also must be determined that the structure is complete and structurally sound with all structural connections and bracing (permanent and temporary) in place and secure.

### 7.2 Lateral Stability

The sliding clip method of attaching roof panels to the roof secondary members provides only limited lateral stability and diaphragm bracing to the roof secondary members.

Before placing materials on the roof and starting the roof installation, confirm that the necessary roof bracing and sag angles or bridging is in place and secured.

### 7.3 Alignment

Prior to installation, roof secondary members should be checked for overall dimensions and evenness or plane. The roof secondary members should also be checked to verify the roof system can be installed without interference. Also, roof secondary members nearest the panel end laps, ridge, or high eave should be checked for correct location to properly accommodate the roof components.

### 7.4 Tolerances

To assure the roof systems correct fit-up and designed weather tightness, the structure must be aligned within the following tolerances; also refer to the MBMA manual for common industry standards.

**OUT OF SQUARE** – The roof system can only accommodate 1/8" of "saw-tooth" of the roof panel ends and the eave, ridge, and panel splices. This means the allowable out of square of the rake line relative to the eave line and ridge line is 1/8" for each 40' of rake run.

**STRUCTURE WIDTH AND EAVE STRAIGHTNESS** – The roof system is designed to accommodate +/- 1" of overall structure width error, or +/- 3/4" of eave straightness error at each eave.

To assure that the accumulation of the structure width error and eave straightness error does not exceed the roof systems tolerance, the structure width should be measured from eave line to eave line at each rake at the first frame line from each rake and at each point where there is a significant error or change in eave straightness. (This usually occurs at a frame line or at a wind column.)

**STRUCTURE LENGTH AND RAKE STRAIGHTNESS** – The roof system is designed to accommodate +/- 2" of overall structure length error, or +/- 1" of rake straightness error at each rake line.

To assure that the accumulation of the structure length error and rake straightness error does not exceed the roof systems tolerance, the structure length should be measured from rake line to rake line at each eave, at the ridge and each point where there is a significant error or change in rake straightness. (This usually occurs at a rafter end splice.)

### 7.5 Measuring

Structure length and width may be measured with a steel measuring tape from the face of the eave or rake member to the face of the opposite eave or rake member. The measuring tape must be parallel to the relative eave or rake line and must be stretched taut. Eave and rake straightness may be determined by measuring deviations from a string line, which is stretched taut along the eave or rake line.

### 7.6 Aesthetic Acceptance

Although these structure alignment tolerances will allow for reasonable roof component fit-up and ease of installation, the extremes of these tolerances may be aesthetically objectionable and should be confirmed with the customer or end owner before starting the roof installation.

### 7.7 Corrections

Any structure alignment error, which exceeds the above stated tolerances, **must** be corrected before roof installation can begin. If it is decided that the structure alignment errors cannot be corrected, alternate roof details may have to be developed. The alternate details may require additional materials, modified parts (with additional cost, fabrication and delivery time) and additional installation time. HSS cannot assure the performance of such alternate details.

## 8.0 Installation Basics

### 8.1 Proper Tools

Before starting the roof installation, be sure that the proper equipment and tools are on hand. The tools must be in good operating condition and operators should adhere to safety precautions at all times.

The following tools and equipment should be considered for efficient installation of the HSS Panel Craft Roof System. Actual tools and equipment required may vary due to variations in building type and construction:

- HSS Panel Craft End Lap Clamp
- HSS Panel Craft Modularity Clamp
- HSS Panel Craft Manual Crimping/Seaming Tool
- Motorized Seaming Machine
- Screw Guns – designed for use with self-drilling screws
- Socket Extensions – 6” for screw guns
- Hex Socket Heads – 5/16” w/magnet inserted
- Electric Drill
- Drill Bits- assortment
- Sheet Metal Cutter – or power shears or nibblers
- “C” Clamps – vise grip type
- Pop Rivet Tool – 1/8” capacity
- Sheet Metal Shears – left and right cut
- Hack Saw – with metal cutting blade
- Steel Measuring Tapes – 12’, 50’ 100’ and 120’
- Nylon String Lines
- Blue Chalk Line (NOT red)
- Brooms
- Marking Pens (DO NOT use pencils)
- Caulk Guns – for 1/10 gallon mastic tubes
- Power Source and Extension Cords – capable of handling the total equipment requirement, including 20-amp seaming machine, without power drop due to extension cord length.

### 8.2 Mastic

#### TEMPERATURE EFFECTS

Temperature extremes must be considered during installation of the roof due to the sensitivity of mastics. The recommended installation temperature range is 20 – 120 degrees Fahrenheit. At colder temperature, the mastic stiffens resulting in loss of adhesion and compressibility. At hotter temperatures, the mastic becomes too soft for practical handling. On cold but sunny days, the panel surface may become warm enough to accept the application of heated mastic even though the air temperature is below 20 degrees Fahrenheit.

When overnight temperatures fall below freezing, the mastic should be stored in a heated room so it will be warm enough to use the following day. On hot days, the mastic cartons should be stored off the roof in a cool and shaded area. While on the roof, mastic rolls should be kept shaded until actual use.

In very cold weather, it is recommended that the fasteners be tightened slowly and only tight enough that the mastic is in full contact with the panel or flashing. Then on the next sunny day, complete the tightening process after the sun warms the panel and flashing surfaces.

#### CONTAMINATION

To assure proper adhesion and sealing, the mastic must have complete contact with adjoining surfaces. Contaminants such as water, oil, dirt, and dust prevent such contact. The panel and flashing surfaces must be dry and thoroughly cleaned of all contaminants. Before applying tape mastic, the mastic should be checked for contaminants. If the mastic surfaces are contaminated, it must not be used.

During cool weather, condensation or light mist can accumulate on the panel and flashing surface and not be easily noticed. It is recommended that the mastics always be kept under protective cover and that the panel and flashing surfaces be wiped dry immediately before installation.

Tape mastic is provided with a protective paper to reduce contamination. Incomplete removal of the protective paper will prevent the mastic adhesion to the panel or flashing surfaces. Always check that the protective paper is completely removed. DO NOT remove the protective paper until immediately before the panel or flashing is installed over the mastic.

#### COMPRESSION

To assure proper compression and seal, the tape mastic must be completely and continuously compressed between the panel and flashing surfaces with firm and uniform pressure. In most cases, the required pressure is applied by the clamping action of screws pulling the adjoining surfaces together. However, the tape sealants resistance to pressure becomes greater in cold weather.

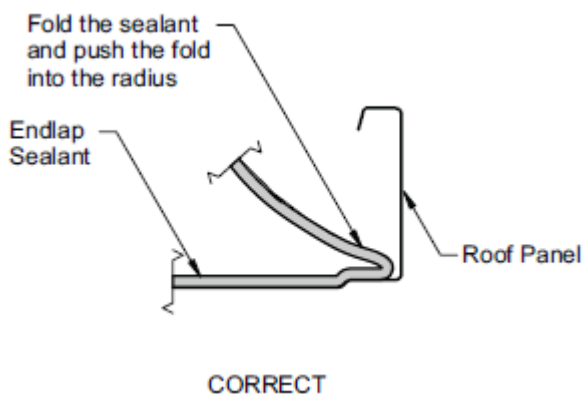
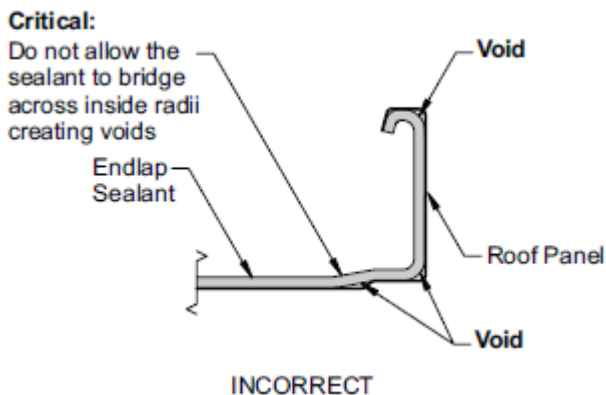
During cold weather, the fasteners must be tightened slowly to allow the mastic time to compress. If the fasteners are tightened too fast, the fasteners may strip out before the mastic compresses adequately, or the panel or flashing may deform in the immediate area of the fastener, leaving the rest of the mastic insufficiently compressed.

## 8.2 Mastic

### INSIDE CORNERS

An inside radius, such as where the panel flat meets a rib, is usually the MOST critical area to seal. A common mistake for the installer is to bridge the mastic across the inside radius.

When the lapping panel or flashing is pushed into place, the bridged mastic is stretched and thinned. The mastic may then be too thin to adequately seal this critical area. When tape mastic is applied at an inside radius, it is recommended that the mastic be folded back, then push the mastic fold into the radius.



## 8.3 Fasteners

### SCREW GUNS

Use torque control screw guns for driving self-drilling screws. 2000-2500 RPM screw guns with torque adjustable clutch are necessary to attain efficient drilling speeds. High tool amperage (6-7 AMP) is required to achieve the proper torque for secure fastening. **Do not use impacting tools. Also note that cordless screw guns are not recommended.**

To assure proper voltage to the tool, extension cords should be checked for proper wire size and cord length:

- 16 ga. Wire, max. cord length = 100'
- 14 ga. Wire, max. cord length = 200'
- 12 ga. Wire, max. cord length = 300'

### SOCKETS

Use good quality magnetic sockets. Good fitting sockets reduce wobble and stripping of the screw heads. They also minimize objectionable paint chipping and scuffing on colored screws and minimize damage to the protective coating on unpainted screws.

Magnetic sockets collect drill shavings, which will build up and eventually prevent the socket from seating properly on the screw heads. One method of removing the drill shavings is to roll up a ball of tape mastic and push the socket into the mastic.

When the socket is removed from the mastic, most of the drill shavings will be embedded in the mastic thereby cleaning the socket. This process should be repeated as often as needed to keep the socket clear of drill shavings.

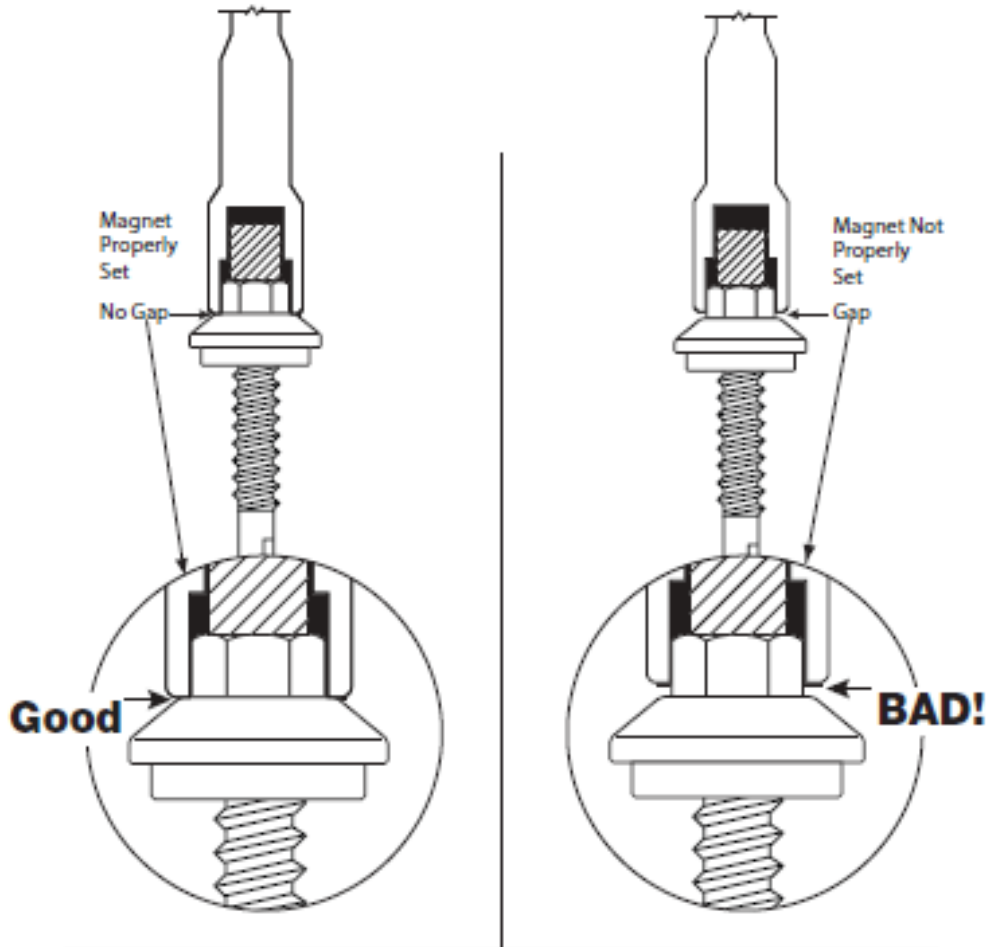
### SOCKET EXTENSIONS

A 4" or 6" socket extension is recommended for installing the panel clip screws. With the extension, the screw can be driven straight down without tilting the screw gun to clear the panel or clip.



**IMPORTANT: Read First**

# SET YOUR MAGNET!



A Magnet **NOT** Properly Set Can Cause:

- Wobble
- Paint and Fastener Head Damage
- Damage To Your Nutsetter
- Installation Difficulty

### 8.3 Fasteners

#### INSTALLATION

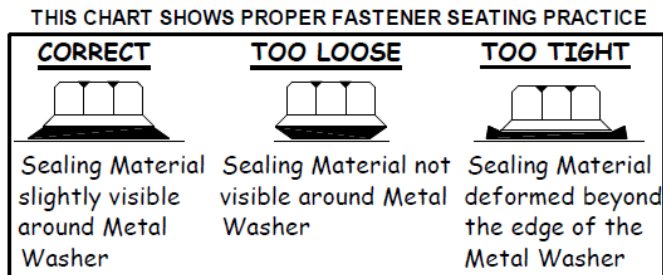
Before starting the screw, the materials to be joined must be pressed together with foot or hand pressure. The pressure must be maintained until the screw has drilled through all the materials and the threads have engaged.

Most self-drilling screws require 20 pounds of pressure to maintain the drilling action and to start the thread cutting action. Also, applying such pressure before starting the screw gun will usually prevent tip walking or wandering. If too little pressure is applied, the drill point may not cut into the metal and the point will heat up and become dull. If the pressure is too heavy, the bottom material may be deflected away, causing a standoff condition, or the drill tip may be broken or split. Screws must be held perpendicular to the panel or flashing surface during starting and driving.

For proper seating of the fastener-sealing washer, the panel or flashing surface must be clean and drill shavings must be removed from under washers before seating. The fastener must be driven perpendicular to the panel surface so that the washer can seat level without warping or cupping.

Do not over-drive screws. Over-driving can strip the threads and/or damage the sealing washer. Use a screw gun with torque control set to function properly for the combination of fastener size, hole size, and material thickness.

The fastener should be driven tight enough to uniformly compress the washer but not so tight that the washer splits or rolls out from under its metal dome. The recommended procedure is to tighten the fastener until the sealing washer just starts to visually bulge from under the metal dome. Refer to the chart for a proper fastener-seating diagram.



Upon stripping or breaking a screw, the screw must be immediately removed and replaced with the next larger diameter screw. Do not defer the screw replacement to be remembered and later fixed, or to be found by the clean-up crew. The majority of such screws are easily overlooked until they cause leak problems later.

### 8.4 Field Cutting of Panels and Flashing

#### ABRASIVE SAW PROBLEMS

Abrasive saws (circular saws with friction disks) are not recommended for cutting roof panels or flashing. Abrasive saws create heat that may burn away the protective cladding from the panel edge, causing the edge to rust.

Also, abrasive saw dust contains fine, hot steel particles which accumulate on panel and flashing surfaces where they rust and can cause staining and rusting of those surfaces.

Rust caused by abrasive saw damage or abrasive dust particles are excluded from warranty claims.

#### SHEARING METHODS

It is recommended that panels and flashing be cut with shears or nibblers to provide a clean, undamaged cut. On shear cut edges, the protective cladding extends to the edge of the cut and is often wiped over the edge to further protect the base metal. Whenever possible, fit the material so that the factory cut edge is exposed and the field cut edge is covered.

When field cutting complex shapes, it is usually easier to cut out a 1-inch wide strip using both left and right hand shears. The 1-inch cutout provides clearance to smoothly cut the flats and the clearance to work the shears around tight corners.

When making repetitive cuts (such as cutting panels at a hip condition) it is recommended that a template be made from a piece of drop-off panel or flashing to provide fast and accurate marking of the field cut. When using panel material for the template, cut off the top portion of the panel ribs so that the template is easily laid onto the panel being marked.

#### MARKING PANELS

Avoid marking the panels for cutting, etc., in a manner that will leave visible markings, stains, etc., on the finished surface. Use chalk or felt tip ink markers. Consider using clothes pins attached to the panel seam to mark problem/unfinished areas.

**DO NOT USE GRAPHITE (LEAD) PENCILS ON UNPAINTED PANEL SURFACES; THE GRAPHITE WILL CAUSE RUSTING OF THE SURFACE.**

### 8.5 Sheeting Direction and Modularity

Although the Horizon Panel Craft Roof System is designed so it can be installed either direction (left to right or right to left), there may be roof conditions that require a specific sheeting direction. Check the erection drawings to determine if a specific sheeting direction is required. The required installation sequence is to complete each panel run from eave to ridge **before** starting the next panel run. This sequence will help ensure straight runs and allow the insulation to be installed immediately ahead of each panel run.

During installation of the roof, considerations must be made for maintaining panel width modularity. By maintaining panel width modularity, proper roof coverage can be obtained and the standard perimeter parts will fit properly without necessity of field modifications or reordering of parts, etc.

For proper fit-up between the panel, mastic and closures or end lap parts, the panels must be held to the 16-inch coverage dimension (within a 1/8-inch tolerance per panel). The accumulated coverage (start panel to finish panel) tolerance is determined by the ability to keep the panels parallel and to correctly fit and assemble the finish rake condition.

If the roof panel has conditions such as fixed location penetrations, parapets, firewalls, etc., the accumulated panel coverage may require tighter tolerances for proper fit-up and weather tightness of the roof system.

IN ORDER TO MAINTAIN ROOF PANEL MODULARITY, IT IS REQUIRED TO INSTALL THE OUTSIDE CLOSURES IN THE PREVIOUS PANEL RUN. IF THE OUTSIDE CLOSURES ARE NOT INSTALLED IN THE PREVIOUS PANEL RUN, IT WILL BE DIFFICULT TO HOLD MODULARITY AND TO ACHIEVE PROPER WEATHER TIGHTNESS. ALSO, IMPROPER INSTALLATION CAN VOID YOUR WARRANTY. NOT INSTALLING OUTSIDE CLOSURES USING THIS METHOD WILL ALSO ADD A SIGNIFICANT AMOUNT OF FIELD WORK LATER ON.

It is also recommended to use panel modularity clamps and end lap clamps to help hold proper coverage.

It is also recommended to pre-drill the secondary framing to help hold proper panel width coverage.

### 8.6 Layout and Checking Coverage

Recommended for all roofs, but a must for large or complex roofs, is to make a layout of the actual structure (field measured as described in sections 7.4 – 7.5) so that the roof panel start and finish dimensions can be laid out to accommodate any structural misalignments.

Panel coverage is always checked at the eave, ridge, and end laps so that non-parallel seam (or dog-leg) conditions can be detected and corrected before they become objectionable. The coverage check should be one with a measuring tape held taut and measured to the same side of the seam and always parallel to the eave to prevent any measuring error.

Every four to six panel runs should be checked for panel width modularity. This will assure that the panels are maintaining a straight line and proper coverage is being maintained. If the panels are off module, they should be corrected by equal adjustments of the next four to six panel runs.

### 8.7 Appearance Considerations

Although the above stated coverage tolerance will provide for reasonable ease of installation and weather tightness, such visible conditions as non-parallel panel seams, dog-leg of the panel seam at the end laps, non-parallel finish panel width, and mis-match of panel seams across the ridge may be objectionable and should be confirmed with the customer before continuing the roof installation.

### 8.8 Inspection of the Roof Assembly During Installation

#### IMPORTANCE OF INSPECTION

During the roof installation, all areas of the roof system must be frequently inspected to ensure the correct assembly in accordance with the erection drawings and this manual.

**Failure to assemble the roof system correctly will result in roof performance problems that may require costly corrective work, roof replacement and performance and drainage claims, etc. Also, incorrect installation may void the material and weather tightness warranties.**

### 8.9 Inspection List (A Partial List to Review)

The Installation Guide and Erection Drawings MUST be followed.

#### ERECTION DRAWINGS

Check that the erection drawings are available at the job site and have been reviewed for differences with the actual job conditions and differences with the erection manual. Also confirm that the drawings are the latest issue with the latest revisions and additions and are marked "For Construction: Final Drawings".

## **8.9 Inspection List**

### **ROOF LAYOUTS**

Check that the roof start and finish dimensions have been correctly determined based on the erection drawings and the actual structural conditions.

### **STRUCTURAL ALIGNMENT**

Check that the structural mis-alignments were corrected in accordance with section 7.3 of this manual.

### **PANEL LENGTH**

Check that the installed roof panels have the correct overhang at the eave and end laps and have the correct hold back dimension at the ridge or high eave, in accordance with the erection drawings.

### **EAVE SEAL**

Check that the eave mastic is in the correct position on top of the eave plate and that the 3" pre-cut mastic is correctly placed. Check that the eave fasteners penetrate the center of the eave mastic and into the eave plate. Check that the fasteners are not loose or stripped.

Check that the eave mastic is in complete contact with the roof panel and eave plate without any voids or gaps. Confirm that the roof panel and eave plate are clean and dry during installation and that the mastic is not wet or otherwise contaminated.

### **END LAP SEAL**

Check that the roof panel end laps are correctly assembled and that the lapping panels are tightly nested without visible gaps.

Check that the mastic is in the correct position and is in complete contact with the lapped panels without any voids or gaps, especially at the radius between the panel flat and the vertical legs of the panel. Confirm that the panels are clean and dry during installation and that the mastic is not wet or otherwise contaminated.

Check that the end lap fasteners penetrate through the center of the mastic and into the backup plate. Check that the fasteners are not loose or stripped.

Check that the end lap assembly is not bowed down causing water ponding and debris accumulations.

### **RIDGE/HIGH EAVE SEAL**

Check that the outside closure assembly is correctly installed.

Check that the mastic is in the correct position and is in complete contact with the outside closure and the roof panel without any voids or gaps. Confirm that the outside closure and roof panels are clean and dry during installation and the mastic is not wet or contaminated.

Check that the outside closure fasteners penetrate through the center of the mastic and into the backup plate. Check that the fasteners are not loose or stripped.

### **RAKE SEAL**

Check that the mastic between the rake trim and the roof panel is properly installed.

Check that the rake trim end caps are installed properly.

Check that the flashing splices are correctly lapped, sealed and fastened.

Check that all fasteners are seated properly.

### **PANEL CLIP ATTACHMENT**

Check that the panel clips are correctly fitted to the panel without any distortion or damage of the clip tab. On sliding clips, check that the self-centering clip tab is centered on the clip base between the centering tabs. (see next page)

Check that when installing the sliding clips that the self-centering clip tab is dis-engaged and the screws are fully secured to the clip base supports. The top section of the clip MUST be allowed to move during thermal movement.

Check that the clips are located along each panel side lap at each roof secondary member or at the locations specified on the erection drawings.

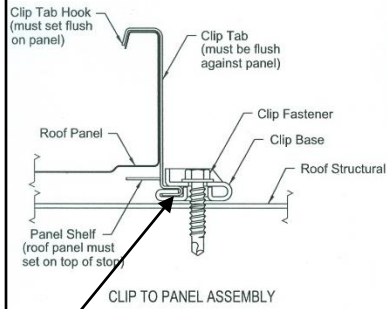
Check that the panel clip fasteners are of the type, size, length, finish and quantity per clip as specified on the erection drawings.

Check that the panel clip fasteners are not loose or stripped. In the case of composite roof construction, verify that the fasteners penetrated and engaged the specified roof secondary member.

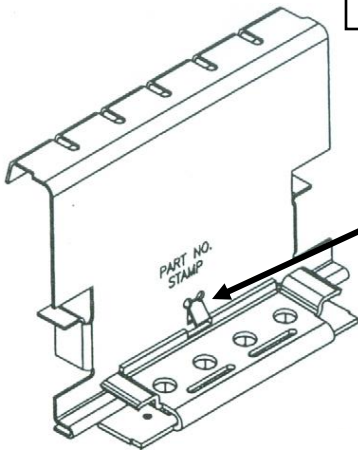
SHOWN IN OPEN POSITION



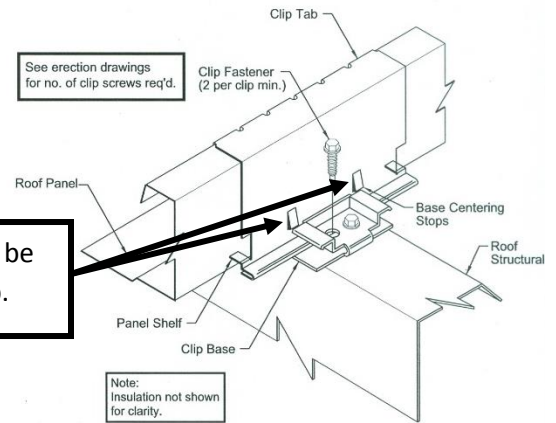
The screws are to be fully engaged allowing the base of the clip to be pressed against the stops or supports to allow the self-centering device to become dis-engaged.



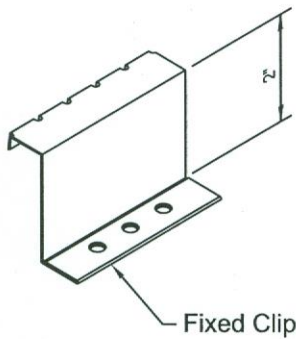
**CAUTION**  
Failure to fully nest the clip flush against the panel can cause faulty seaming and objectionable seam appearance.



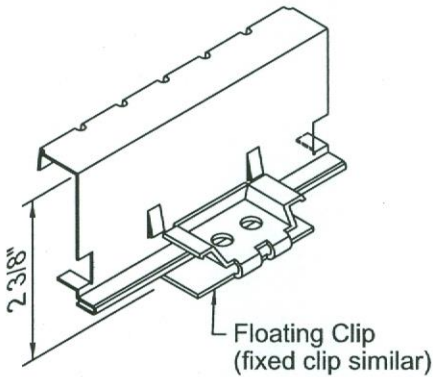
The self-centering device may be either a single or double tab.



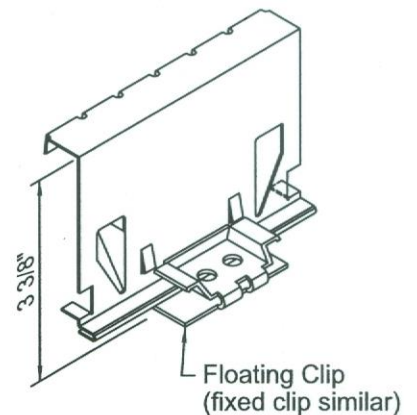
Three types of Panel Craft panel clips.



For 0" Fixed Roof Only



For 3/8" Stand-off Fixed Or Floating Roof



For 1 3/8" Stand-off Fixed Or Floating Roof

## 8.9 Inspection List

### SIDE LAP

Check that the factory installed side lap mastic is in the correct position without voids or interruptions and is not damaged, wet or otherwise contaminated. Replace missing side lap mastic with Butyl tube caulk.

Check that the full length of each side lap is correctly engaged, hand crimped and /or seamed.

Check that the panel coverage tolerance does not exceed 1/8-inch per panel and that the accumulated coverage will allow proper fit and assembly of the outside closures and finish rake conditions such as penetrations, parapets, etc.

### FLASHING AND PENETRATIONS

Check that all flashing (including penetrations) are correctly assembled and tightly fitted. Check that the required mastics are correctly positioned and in complete contact with the adjoining surfaces without voids or interruptions. Confirm that the mastics and adjoining surfaces are clean and dry during installation.

Check that the flashing splices are correctly lapped, sealed and fastened.

Check that the flashing is sufficiently pitched to shed water and eliminate ponding areas, especially at the critical splices, end laps and corners.

Check that the fasteners are of the specified type, size, length, finish and spacing. Check that the fasteners are not loose or stripped. Check that the sealing washers are in full contact with the flashing surface and not distorted, split or otherwise damaged.

Along the rakes, high eave transitions, fixed penetrations, etc., check that the flashing is not constrained and will allow for the roofs thermal expansion/contraction.

### UNSPECIFIED MATERIALS

Use of the wrong materials may cause installation and performance problems and may void the performance and material warranties.

Check that all installed roof system materials, especially mastics and fasteners, are ONLY those which are provided or specified by HSS for your specific project and are used only as specified on the erection drawings and this installation guide.

**HSS cannot be responsible for the performance of roof materials that are not provided, specified or approved by HSS.**

### SURFACE CONDITIONS

Damaged roof system surfaces are subject to corrosion and performance problems and may void the material and performance warranties.

Check that the panel and flashing surfaces are not being subjected to abusive conditions such as: careless handling of panels and flashing, excessive roof traffic, abrasive or contaminated footwear, rough handling of materials, tools and equipment, or contact with abrasive materials or residue, etc.

Check that the panel and flashing surfaces are not being subjected to exposed metal objects and material left on the roof such as: tools, material drop-off, fasteners, wire, staples, drill and nibbler chips, saw and file particles, etc. In the process of rusting, these materials will absorb the panels protective coating, thus leaving the panels exposed to rusting.

Check that the panels and flashings are not being subjected to long term wet conditions such as: standing water, consistent sources of steam, mist, spray, dripping or run-off, wet debris, wet insulation or other moisture holding material.

Check that the panels and flashings are not subjected to direct contact or run-off from corrosive materials such as: copper pipes and flashing, uncured cement, treated lumber, anti-icing chemicals, galvanized materials, strong solvents or other corrosive materials.

Check that graphite (lead) pencils were not used to mark on unpainted surfaces. The graphite marks will cause rusting.

Check that the roof materials are not subjected to damaging heat such as: Cutting torches, abrasive saws, etc.

**Horizon Structural Systems cannot be responsible for the performance of roof materials that are not provided, specified or approved by Horizon Structural Systems.**

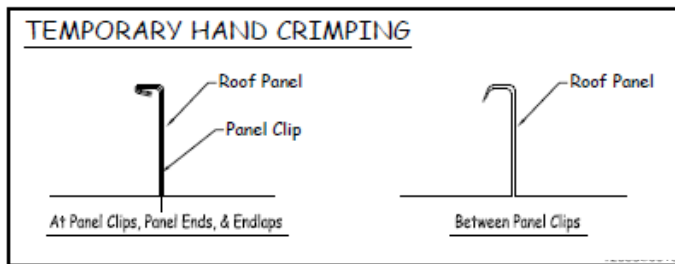
## 8.9 Inspection List

### HAND CRIMPING & MOTORIZED PANEL SEAMING

As the roof installation progresses, **it is required** to hand crimp and/or mechanically seam the previous full panel run. Seaming options differ per project. Refer to the erection drawings for specific seam requirements. Then review the details in sections 10.2, 12.3, and 17.4 of the Seaming Manual.

#### IMPORTANT NOTE:

**As a minimum requirement, the roof should be hand crimped into a RollLok profile (TripleLok) at the low eave, end lap, high eave, and every clip location at the end of each workday. Failure to do so may result in panels coming off of the roof due to high winds. It is also required before the seamer can be operated successfully.**



## 8.10 Roof Leak Troubleshooting & Potential Causes of Roof Leaks

THE ERECTOR DOES NOT LOCATE AND READ THE Horizon Panel Craft ERECTION MANUAL AND ERECTION DRAWING INSTRUCTIONS.

The erection manual defines the standard details required for installing the Horizon Panel Craft Roof System. Reading the erection manual and drawings will actually improve the productivity and quality of your work. HSS has included the benefit of years of testing and feedback from many installers who have installed millions of square feet of Horizon Panel Craft Roof. Be cautious with anyone who tells you that their experience allows them to deviate from the tried and true instructions found in our erection manual and erection drawings.

THE BUILDING INSULATION IS NOT PROPERLY TIED OFF TO FORM A VAPOR BARRIER, ALLOWING THE ROOF TO CONDENSATE.

Condensation occurs when warm moist air comes in contact with colder surfaces such as panels, framing members, etc. The insulation system must be designed to act as a vapor barrier in addition to providing thermal values.

It is the erectors responsibility to install the insulation properly, according to normal and customary industry practices.

THE BACKUP PLATE AT THE END LAP IS NOT PROPERLY INSTALLED OR ALIGNED.

If the tabs on the backup plate are not properly attached over the end of the roof panels, the backup plate will push away and not allow the end lap fastener to engage properly. HSS recommends the panel to be fully seated into the alignment tabs on the backup plate to align the end lap components. Be sure not to penetrate the vinyl insulation backing.

THE 22-INCH PRE-CUT MASTIC AT THE END LAP IS NOT PROPERLY LOCATED.

The center of the end lap mastic is placed in alignment with the factory pre-punched holes on the panels. This allows the fasteners that are installed in the pre-punched holes to properly penetrate the tape mastic.

STRIPPED FASTENERS AT THE END LAPS, JOINTS, RAKE, EAVE, RIDGE, ETC.

It is important that if a fastener is stripped, it is replaced with one of a larger size diameter to ensure the proper tightening and clamping force is achieved.

THE OUTSIDE CLOSURES ARE NOT INSTALLED AS THE ROOF IS PUT DOWN AND/OR THEY ARE NOT PROPERLY SEALED.

If the proper installation procedure is not followed, the coped area of the panel will not be sealed and moisture build up from ice and snow or driving rain may infiltrate the building. Refer to the HSS erection manual section (14.0 – 14.03) for instructions. The outside closures must be installed in the prior full panel run. The outside closures are aligned and fastened together and sealed.

MASTIC IS NOT APPLIED PROPERLY AT THE LOW EAVE.

Mastic is to be placed at the eave of the building. Additionally, care must be taken to ensure the mastic is folded into the eave plate mastic and extended up and over the panel rib.

INCORRECT CAULKING TYPE USED AT THE ROOF LOCATIONS.

The tube sealant is required to be applied at certain locations as directed in the erection drawings and manual.

## 8.10 Roof Leak Troubleshooting & Potential Causes of Roof Leaks

### HOLES IN THE ROOF PANELS

Most of the time, holes in the roof panels are from objects being dropped or thrown onto the panels. These include screw guns, outside closures, backup plates, clips, etc. Small holes can be repaired with a piece of panel material sealed with tape mastic or tube sealant and screwed in place. Large holes should be repaired by replacing the roof panel.

### PRE-CUT MASTICS NOT APPLIED AT END LAPS, OUTSIDE CLOSURES AND LOW EAVE

3-inch pre-cut mastic has been supplied to be applied along the notched rib panel sections at the end lap assembly and at the outside closure assembly along with the low eave. Follow the directions closely during installation of the roof to assure that these mastics are applied.

## 9.0 Standard Hardware Parts

### 9.1 General

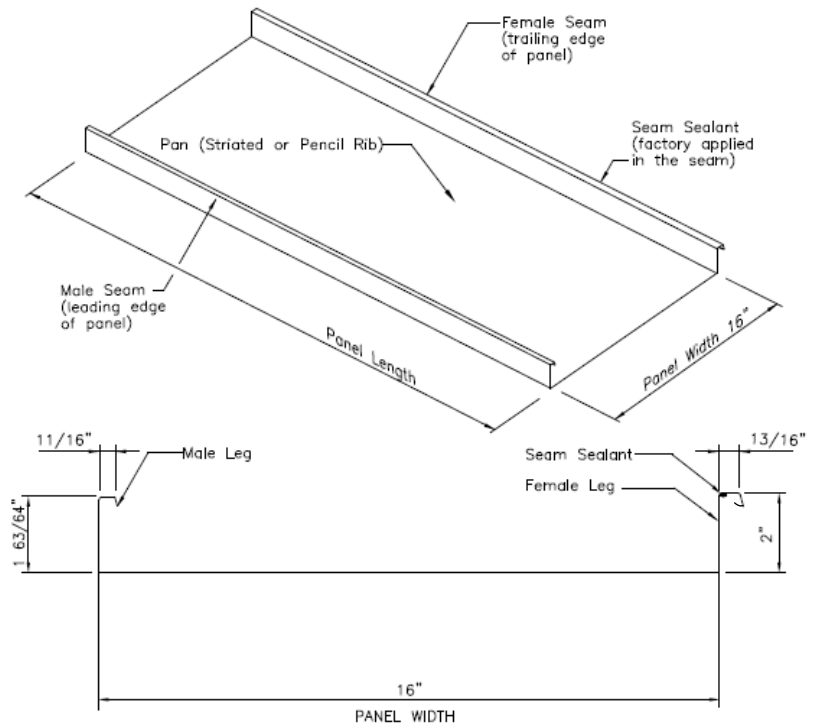
The following details provide a basic description and graphic illustrations of the standard roof assembly parts. The purpose of these details is to assist the erector in the correct selection and identification of parts.

Because of the many variations in conditions, it is important that you review the job conditions to identify the specific parts for your job.

Review the erection drawings for any special parts or parts which are different from the standard parts shown in these details. If differences exist, the erection drawings will take precedence.

For proper fit up, sealing, fastening, and to help ensure the roof assembly is weather tight, structural capability, durability and aesthetically pleasing, the correct parts must be used. Do not use parts other than those specified on the erection drawings.

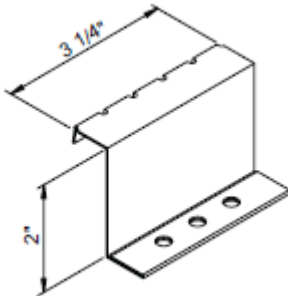
- 216 ROOF PANEL (16" wide panel)
- 22 or 24 gauge Steel
  - Painted or Galvalume Finish
  - Factory notched for endlap





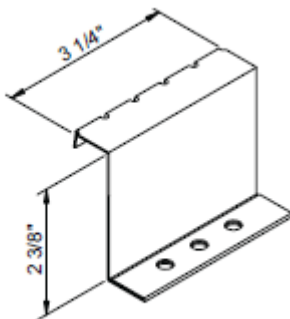
## 9.2 Standard Parts

**FIXED CLIP** (for 0" stand-off) (Utility)  
• 22 ga. Galvanized Steel



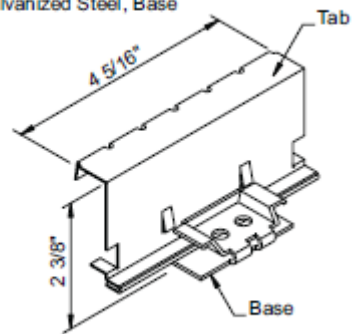
Part No. FC 10200  
Weight - 0.13

**FIXED CLIP** (for 3/8" stand-off)  
• 22 ga. Galvanized Steel



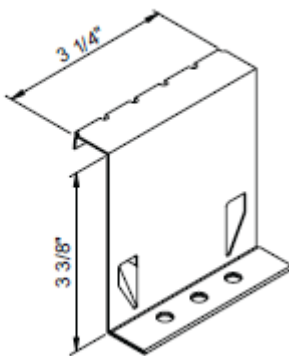
Part No. FC 10203  
Weight - 0.14

**FLOATING CLIP** (for 3/8" stand-off)  
• 22 ga. Galvanized Steel, Tab  
• 16 ga. Galvanized Steel, Base



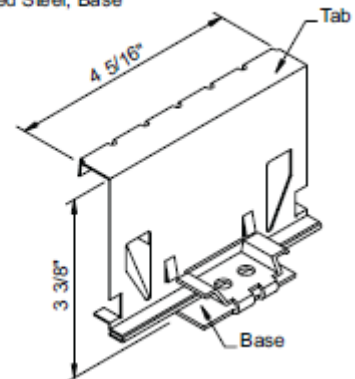
Part No. MC 1203  
Weight - 0.25

**FIXED CLIP** (for 1 3/8" stand-off)  
• 20 ga. Galvanized Steel



Part No. FC 10213  
Weight - 0.17

**FLOATING CLIP** (for 1 3/8" stand-off)  
• 22 ga. Galvanized Steel, Tab  
• 16 ga. Galvanized Steel, Base



Part No. MC 1213  
Weight - 0.28

**9.2 Standard Parts**

**ENDLAP BACK-UP PLATE**

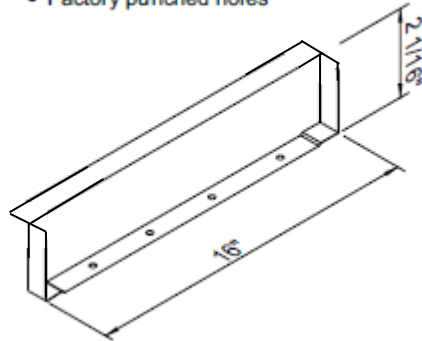
- 16 ga. Red Oxide or Galvanized Steel



Part No. BUP216

**OUTSIDE CLOSURE (for 16" wide panel)**

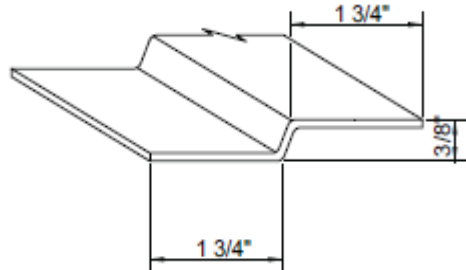
- 24 gauge steel
- Painted or Galvalume Finish
- Factory punched holes



Part No. OSC216 (Specify finish)

**EAVE PLATE (for 3/8" stand-off)**

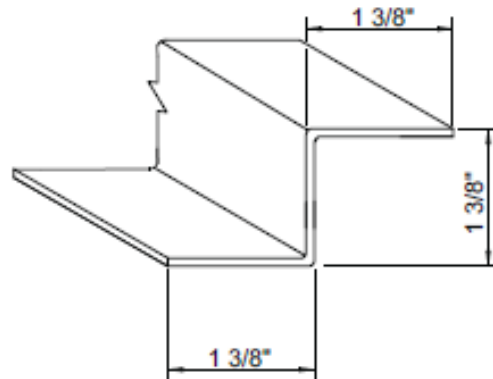
- 16 gauge, Galvanized Steel
- 10'-0" length



Part No. EP038

**EAVE PLATE (for 1 3/8" stand-off)**

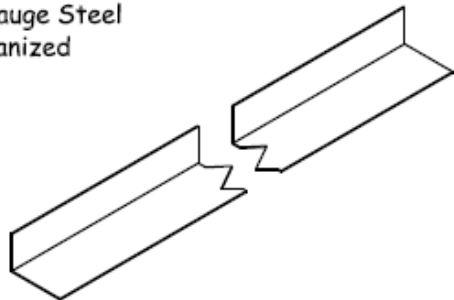
- 16 gauge, Galvanized Steel
- 10'-0" length



Part No. EP138

**RAKE ANGLE**

16 Gauge Steel  
Galvanized

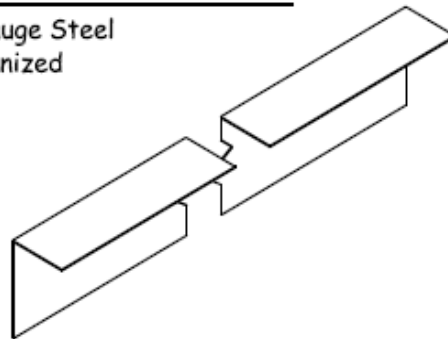


Length = 20'  
Width = 2"  
Height = 4"

Part No. SA1

**WALL RAKE ANGLE**

16 Gauge Steel  
Galvanized



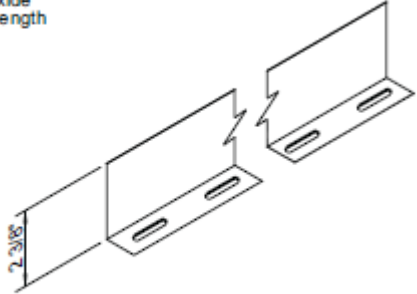
Length = 20'  
Width = 4"  
Height = 8"

Part No. SA3

## 9.2 Standard Parts

### RAKE SUPPORT ANGLE (For 3/8" Stand-Off)

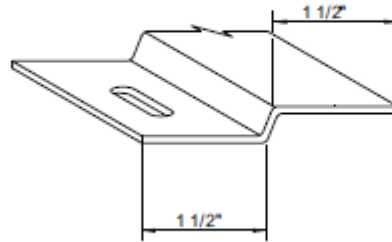
- 16 gauge Steel
- Red Oxide
- 20'-0" length



Part No. RSA238  
Weight - 13.12

### FLOATING RAKE PLATE (for 3/8" stand-off)

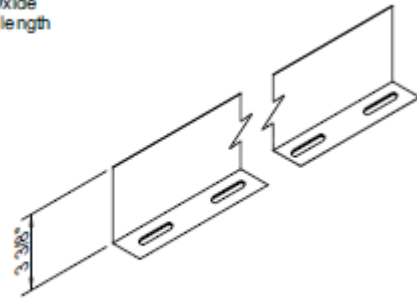
- 16 ga., 50 ksi Galvanized Steel
- 10'-0" length
- Factory punched slots



Part No. RP038

### RAKE SUPPORT ANGLE (For 1 3/8" Stand-Off)

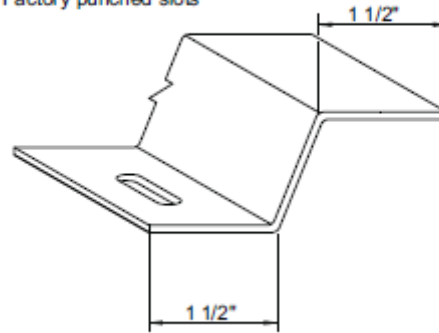
- 16 gauge Steel
- Red Oxide
- 20'-0" length



Part No. RSA338  
Weight - 13.12

### FLOATING RAKE PLATE (for 1 3/8" stand-off)

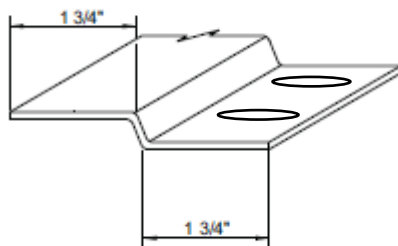
- 16 ga., 50 ksi Galvanized Steel Min.
- 10'-0" length
- Factory punched slots



Part No. RP138

### Floating Eave Plate (for 3/8" stand-off)

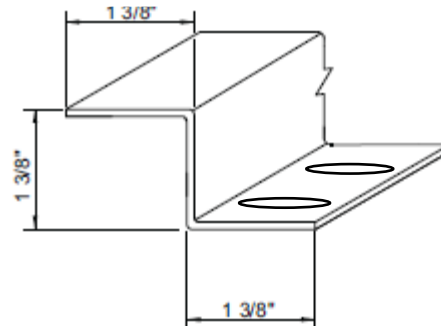
- 16 ga., 50 ksi Steel
- 10'-0" length



Part No. FEP038

### Floating Eave Plate (for 1-3/8" stand-off)

- 16 ga. 50 ksi Steel
- 10'-0" length



Part No. FEP138

## 9.2 Standard Parts

### GUTTER CLIP

- 18 Gauge
- Painted to match panel/gutter
- 10" long

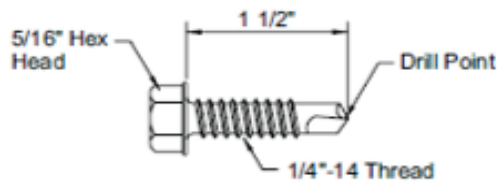


Part No. GC1

### CLIP FASTENER

(for panel clip & eave plate attachment to steel purlins)

- 1/4" - 14 x 1 1/2" hex head, Self Drilling Screw
- Corrosion resistant plating

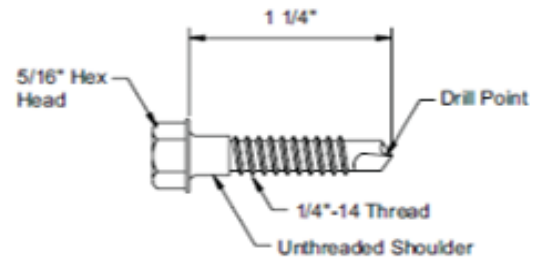


Part No. CF1

### SHOULDER FASTENER

(for rake support angle attachment to steel purlins)

- 1/4" - 14 x 1 1/4" hex head, Self Drilling Screw
- Shoulder feature
- Corrosion resistant plating

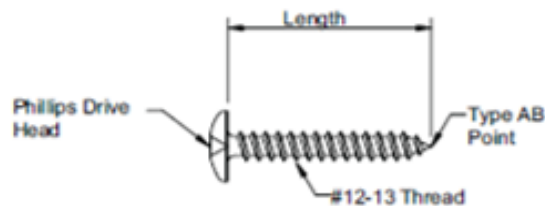


Part No. SF1

### CLIP FASTENER

(for panel clip attachment to metal decking)

- #12 - 13, Phillips drive, Truss Head Screw
- Corrosion resistant coating

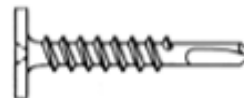


Part No. CF2 (Specify length)

### ROOF FASTENER

(for rake angle to metal purlins)

- #10 - 16 x 1" - Phillips drive, Pancake Head Screw
- Corrosion resistant coating



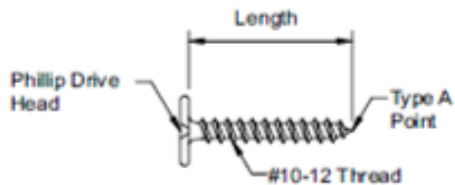
Part No. RF1

## 9.2 Standard Parts

### CLIP FASTENER

(for panel clip attachment to wood decking)

- #10 - 12, Phillips drive, Pan Head Screw
- Corrosion resistant coating

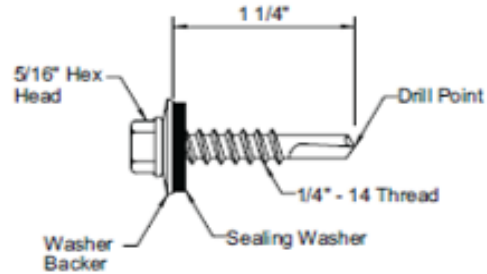


Part No. CF3 (Specify length)

### ROOF FASTENER

(for panel edge attachment) (long life)

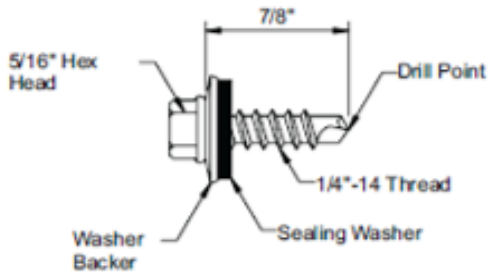
- 1/4 - 14 x 1 1/4" hex head, Self Drilling Screw
- EPDM Sealing Washer
- Corrosion resistant coating or alloy head
- Painted or mill finished head



Part No. RF2 (Specify finish)

### LAP FASTENER (for flashing attachment) (long life)

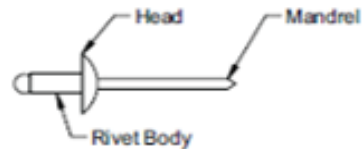
- 1/4" - 14 x 7/8" Self Drilling Screw
- EPDM Sealing Washer
- Corrosion resistant coating or alloy head
- Painted or mill finish head



Part No. RF3 (Specify finish)

### BLIND RIVET (for flashing joints)

- Stainless steel
- 1/8" dia. x 3/16" length



Part No. RF4

### SELF-TAPPING SCREW

No. 17-14x1 1/4" W/ Sealing Washer

"GOOF-SCREW"

LONG LIFE FASTENER - 3/8" HEAD

Recommended Tool Types:

(High Torque, Low RPM) Torque Adjustable Clutch

-DO NOT use Impacting Tools



Used at locations where fastener has stripped out.

Part No.

### INSULATION RETAINER WASHER

1 1/4" Steel Flat Washer with 5/16" diameter hole

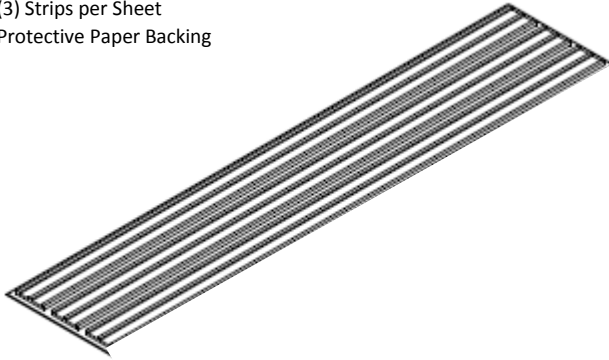


Used with self-drilling screws to attach insulation at the building eave.

Part No.

**9.2 Standard Parts**

22" Pre-Cut End Lap Mastic  
 3/16" X 1 1/2"  
 (3) Strips per Sheet  
 Protective Paper Backing



Width = 1 1/2"  
 Thickness = 3/16"

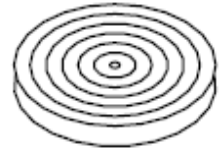
Part No. RS1-22

**TAPE MASTIC**

Isobutylene Tripolymer  
 30'-0" Roll

For over the outside closure and  
 along the low eave

Width = 1 1/2"  
 Thickness = 3/16"



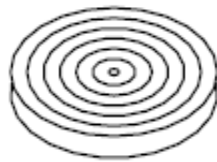
Part No. RS1

**TAPE MASTIC**

Isobutylene Tripolymer  
 45'-0" Roll

For rake, sliding rake and gutter

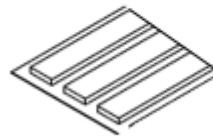
Width = 1/2"  
 Thickness = 3/32"



Part No. ....  
 RS45-H

**3" PRE-CUT MASTIC**

<sup>3</sup> Strips Per Sheet  
 Protective Paper Backing



Width = 1 1/2"  
 Thickness = 3/16"

Part No. RS3

**SELF-DRILLING SCREW**

No. 12-24x 1 1/2" TCP5 W/O Washer  
 5/16" HEAD

Recommended Tool Types:  
 -2000 RPM; Torque Adjustable Clutch  
 -4 Amp or Higher Rated Tools  
 -DO NOT use Impacting Tools



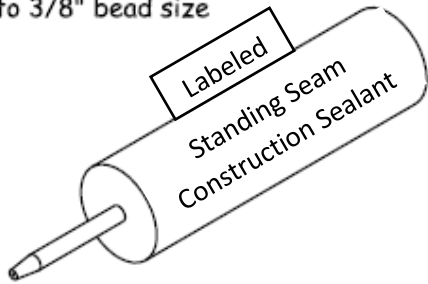
Used to attach panel clips,  
 rake angle clips, and rake angle  
 to joist.

9.2 Standard Parts

**BUTYL TUBE CAULK**

Roof Applications

Provides 23'-0" lineal feet with a 1/4" to 3/8" bead size

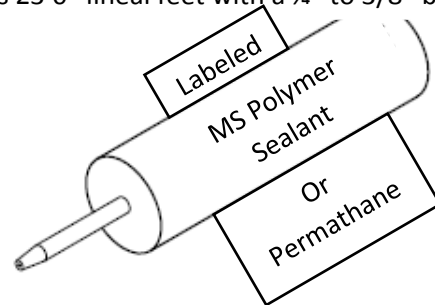


Part No. \_\_\_\_\_

**TUBE CAULK**

For Use at trim Laps and roof penetrations

Provides 23'0" lineal feet with a 1/4" to 3/8" bead size

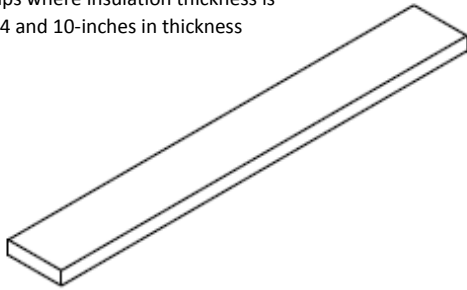


Part No. \_\_\_\_\_

**THERMAL BLOCK**

Expanded Polystyrene

For tall clips where insulation thickness is between 4 and 10-inches in thickness



Length = 23"

Width = 3"

Height = \_\_\_\_\_

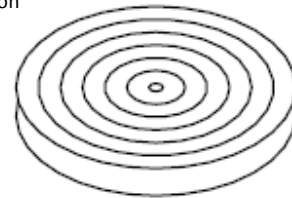
Part No. \_\_\_\_\_

**EPS FOAM SPACER**

Expanded Polystyrene

50'-0" Roll

For when short clips are used with no insulation



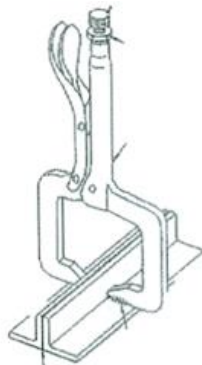
Width = 2 1/2"

Thickness = 1/2"

Part No. \_\_\_\_\_

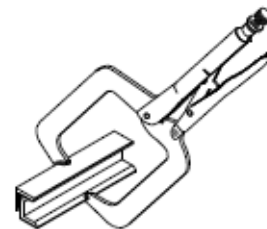
9.3 Accessory Tools

**MODULARITY CLAMP**



BUY-OUT

**ENDLAP CLAMP**



BUY-OUT

Part No. \_\_\_\_\_

## 10.0 Roof Installation Preparation

### 10.1 General

The following details provide graphic illustration of the roof assembly steps. The purpose is to instruct the erector in correct and efficient assembly of the roof system.

Because of the many variations in conditions, it is important that you review the job to identify and isolate the specific installation details required for your job.

Review the erection drawings for differences with these details. If differences exist, the erection drawings have precedence.

These details are arranged in a step-by-step sequence. Following this sequence ensures correct assembly and ensures that the part to be worked on will be readily accessible for the next assembly step.

**DO NOT** shortcut these assembly steps without carefully consideration of the possibility of incorrect or omitted assembly and the resulting corrective rework.

To minimize confusion, the details are always oriented so that the view is from eave to ridge, with the starting rake at the left and finish rake at the right. Refer to the erection drawings to determine the required sheathing direction and rake conditions.

To help ensure weather tightness, the details emphasize proper fit-up, sealing and fastening. It is important that only the specified sealants and fasteners be used for each condition and that they be installed correctly as shown on the details and the erection drawings.

Be sure that these critical instructions are reviewed often and the roof assembly is checked at each assembly step.

### 10.2 Orientation and Explanation

The details in this section will show the installation of the eave plate, eave mastic, rake angle, rake support angle, and the first run of insulation. These are the parts that **must** be installed **before** the roof panel installation can begin.

The view on the next page shows the roof system oriented for a left-to-right sheathing direction. For right-to-left sheathing direction, reverse the parts orientation. The panel erection sequence **must always** be started from the low eave corner working toward the high eave or ridge. The full panel run from eave to high eave or ridge **must** be installed before the next panel run can be started.

In the case of a building with a roof step, the lower level panels **must** be installed before the upper level panels. Install six lower panels ahead of the upper panels.



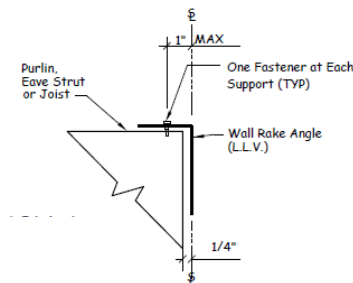
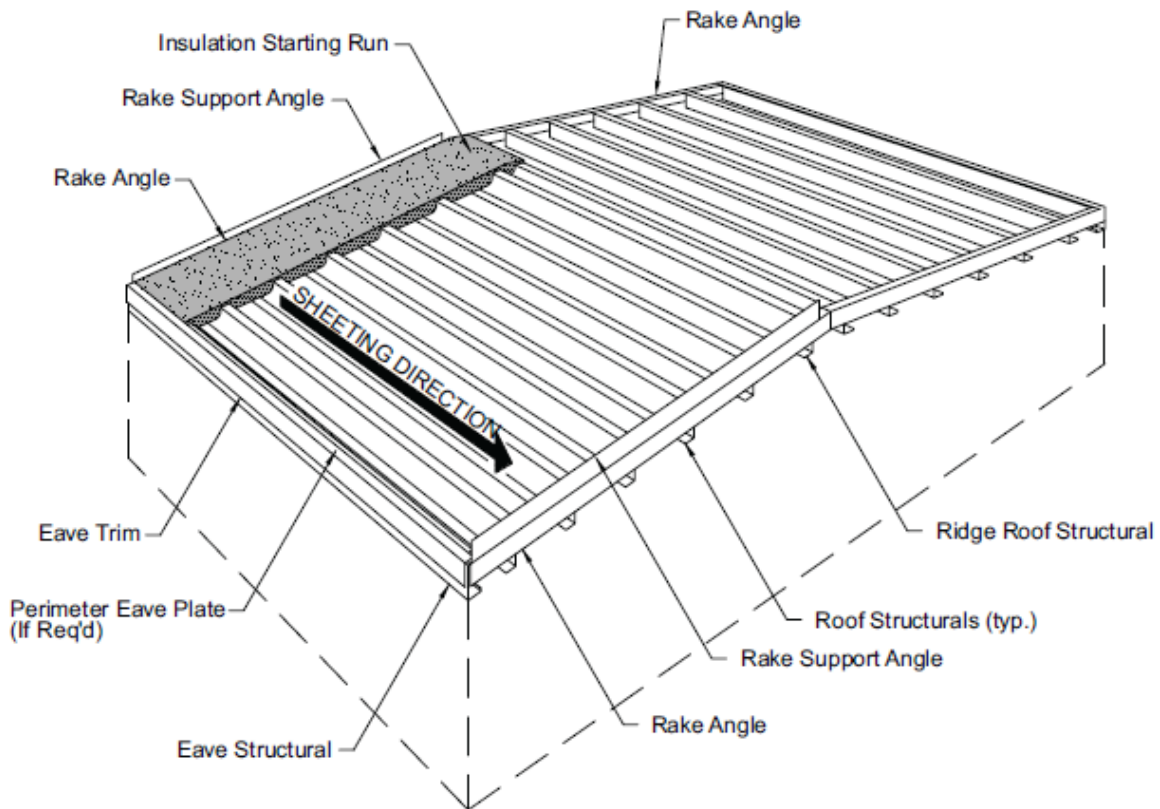
### 10.3 Wall Rake Angle Attachment

Start the wall rake angle (SA1) flush with the edge of the eave member (long leg vertical) as shown below. Place the angle  $\frac{1}{4}$ " away from Steel Line and attach to each secondary support member with (1) RF1 fastener for purlins or (1) Tek 5 fastener for joists. Fastener placement not to exceed 1" from Steel Line.

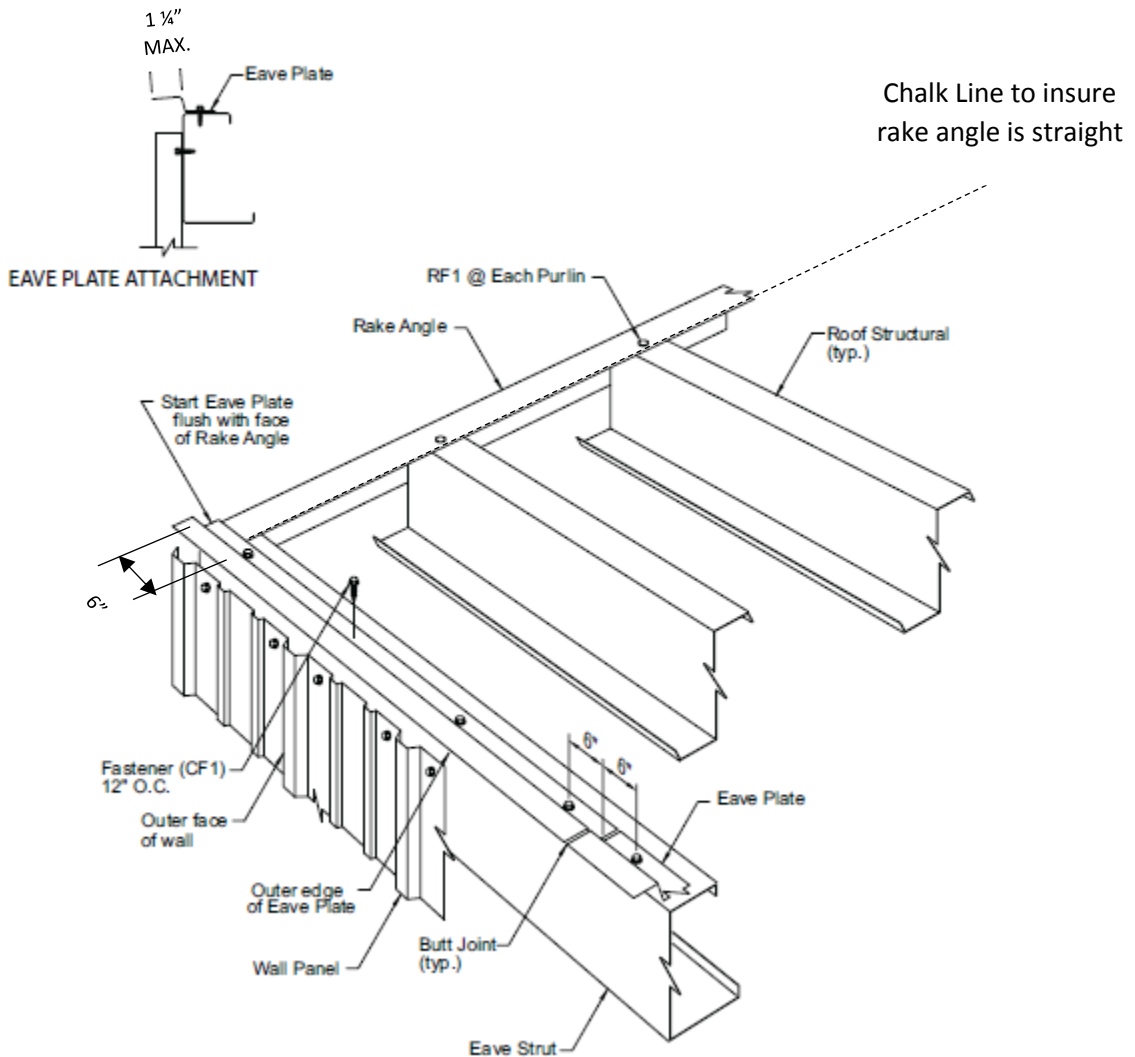
The use of a string line or chalk line will insure that this angle is straight which assists in plumbing the gable ends of the wall panels with the girts. The straight line also assists with starting off straight with the rake support angle.

On this view, the starting and finish rakes are shown with rake support angles for both start and termination panel. Some buildings may require two rake support angles at the starting and/or finish rakes. Refer to the erection drawings for the required rake conditions

**The rake support angles are to be installed on top of the insulation after it has been placed on the rake angle.**



## 10.4 Eave Plate Attachment



Refer to the erection drawings roof line trim details for the required eave plate part number.

The eave plate provides a solid attachment surface for the low eave end of the roof panel and the roof insulation.

The eave plate **must** be installed before the roof insulation is placed over the roof secondary members.

**Before installing the eave plate, check that the eave secondary members are in straight alignment from rake to rake and that the building is square.**

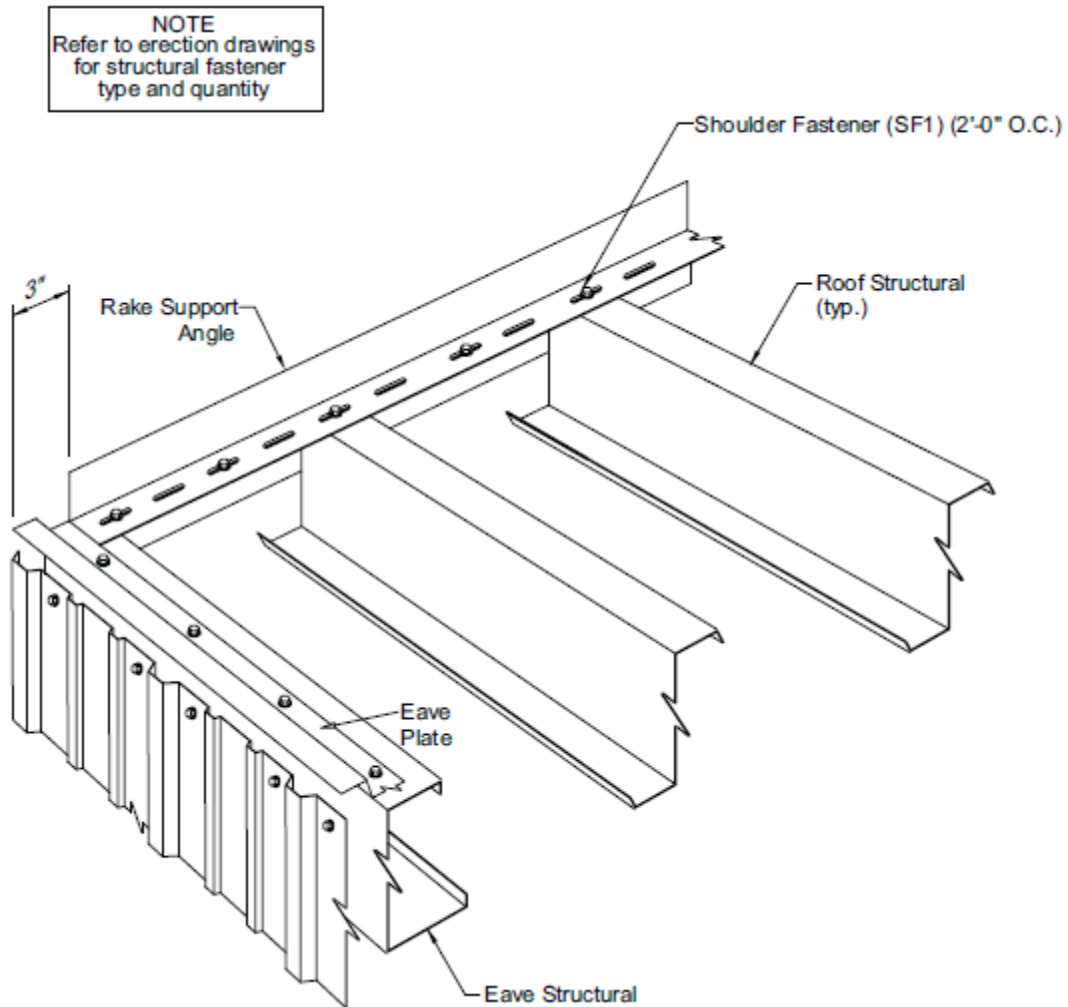
Install the starting and finishing ends of the eave plates flush with the outer face of the rake angle.

Place the eave plate at the edge of the eave secondary member. The top leg of the eave plate will extend past the low eave steel line (1 1/4" maximum) or flush with the outside face of the wall panel.

Fasten the eave plate with CF1 fasteners 12"- O.C. Tightly butt join the eave plate ends together.

See the erection drawings for sculptured eave trim installation instructions.

## 10.5 Rake Support Angle Installation



Refer to the erection drawing details for the required rake support angle part number. (RSA338 or RSA438 for example)

Refer to the erection drawings and the structural layout to determine the start dimension.

The position of the rake support angle establishes the starting roof panel alignment. It is very important that the angle is installed in a straight line, parallel to the rake line and rake angle.

See erection details for locations of all angles.

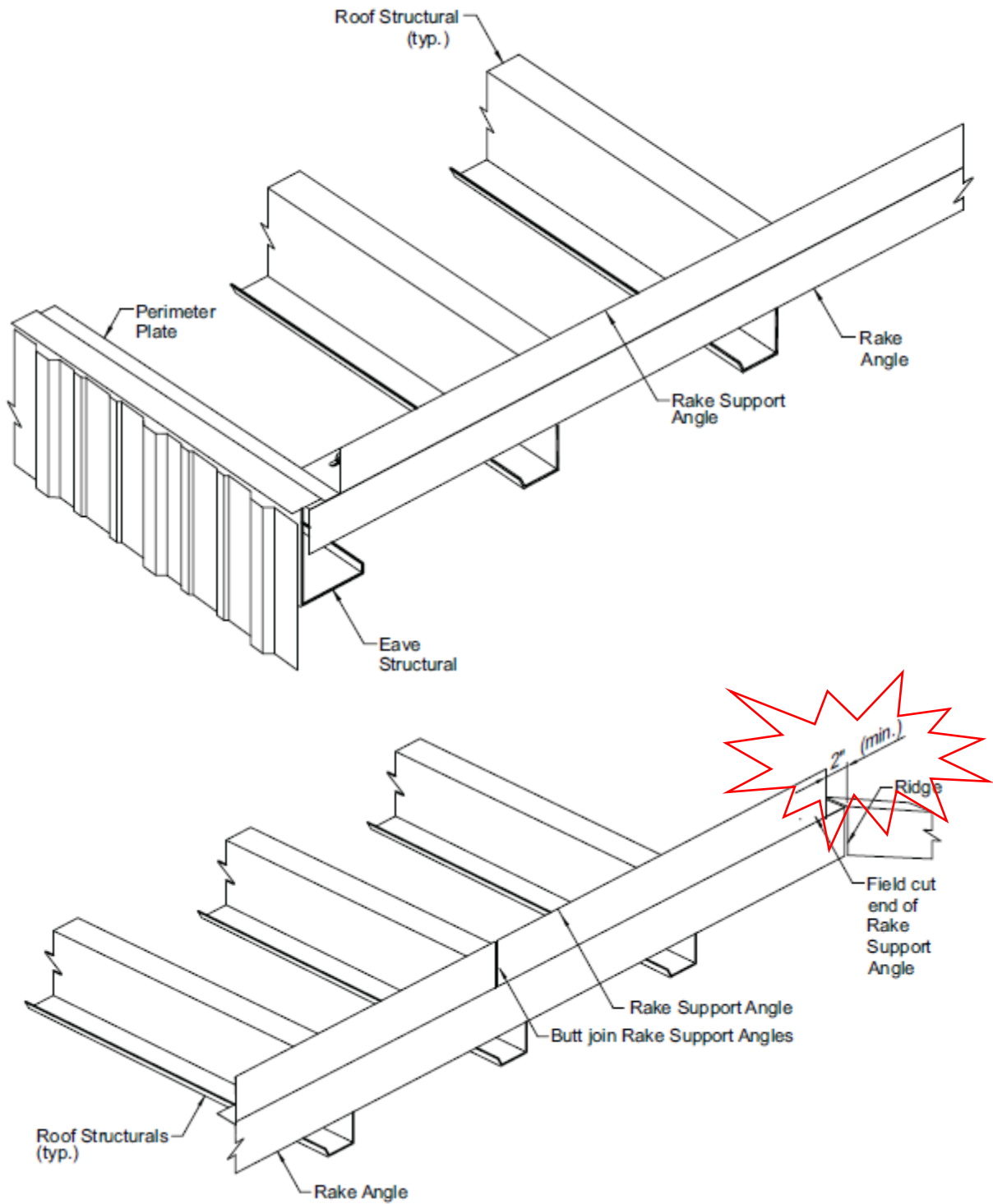
Start the rake support angle 3" from the sidewall steel line.

If the rake support angle is not true and square, a chalk line should be used to guide the installation.

Secure the starting end of the rake support angle to the rake angle with a SF1 fastener in the first slot.

Locate the shoulder fasteners (SF1) at the spacing shown. These fasteners **must** be located in the center of the pre-punched slot to allow for thermal movement.

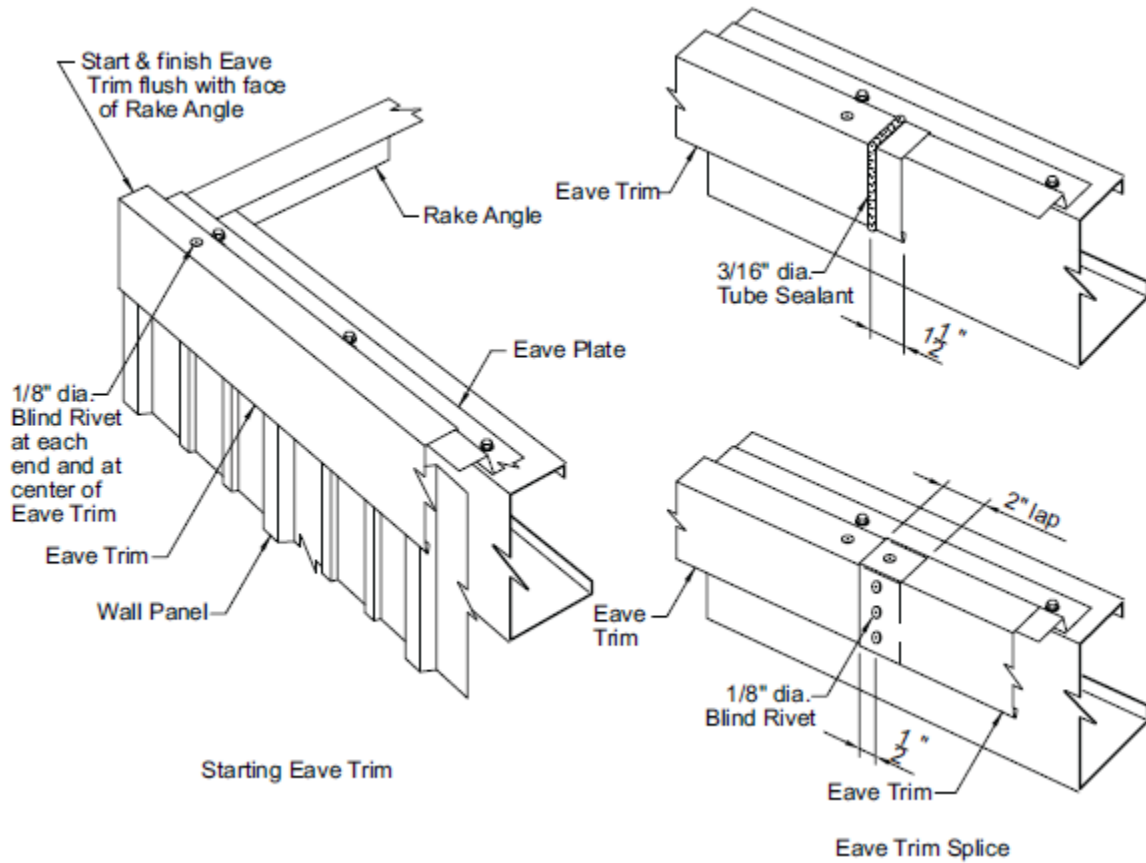
### 10.5 Rake Support Angle Installation



Butt join the ends of the rake support angle. Install shoulder fasteners (SF1) in the slots on either side of the butt joints.

Field cut the rake support angle two-inches (2") from the ridge line or high eave line for thermal expansion/contraction.

## 10.6 Eave Trim Installation



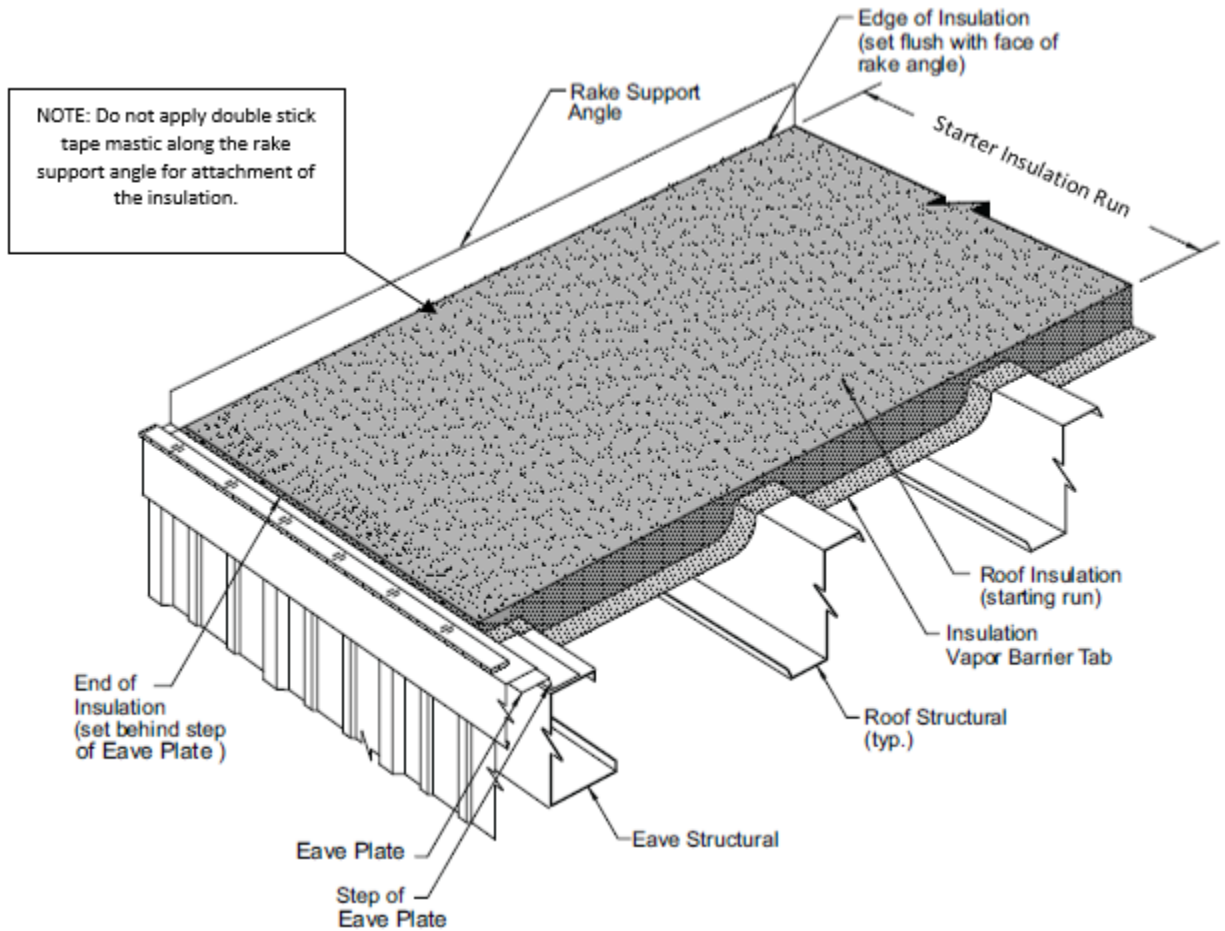
Place the upper horizontal lip of the eave trim over the eave plate as shown and align the vertical face of the eave trim with the face of the wall panel.

Install the start and finish ends of the eave trim flush with the ends of the eave plate.

The eave trim provides a water seal between the roof panel and the wall panels. All laps of the eave trim **must** be sealed with MS Polymer or Permathane tube sealant and rivets as shown to minimize water entry.

Fasten each piece of eave trim to the eave plate with three blind pop rivets. The rivets will hold the trim in position until the roof panels are installed and fastened.

## 10.7 Starter Run of Insulation Installation



Refer to the purchase order to determine the specific insulation required for the project. In all cases refer to the insulation manufacturer's instructions for proper insulation installation and vapor seal assembly. This detail shows fiberglass blanket insulation, which is the most commonly used insulation for metal standing seam roofs.

Use double-faced tape along the backside of the eave strut to hold the insulation in place while the roof panel is being installed.

**Do not** extend the end of the insulation onto the high of the eave plate.

Align the edge of the insulation with the building steel lines at both the rake and eave.

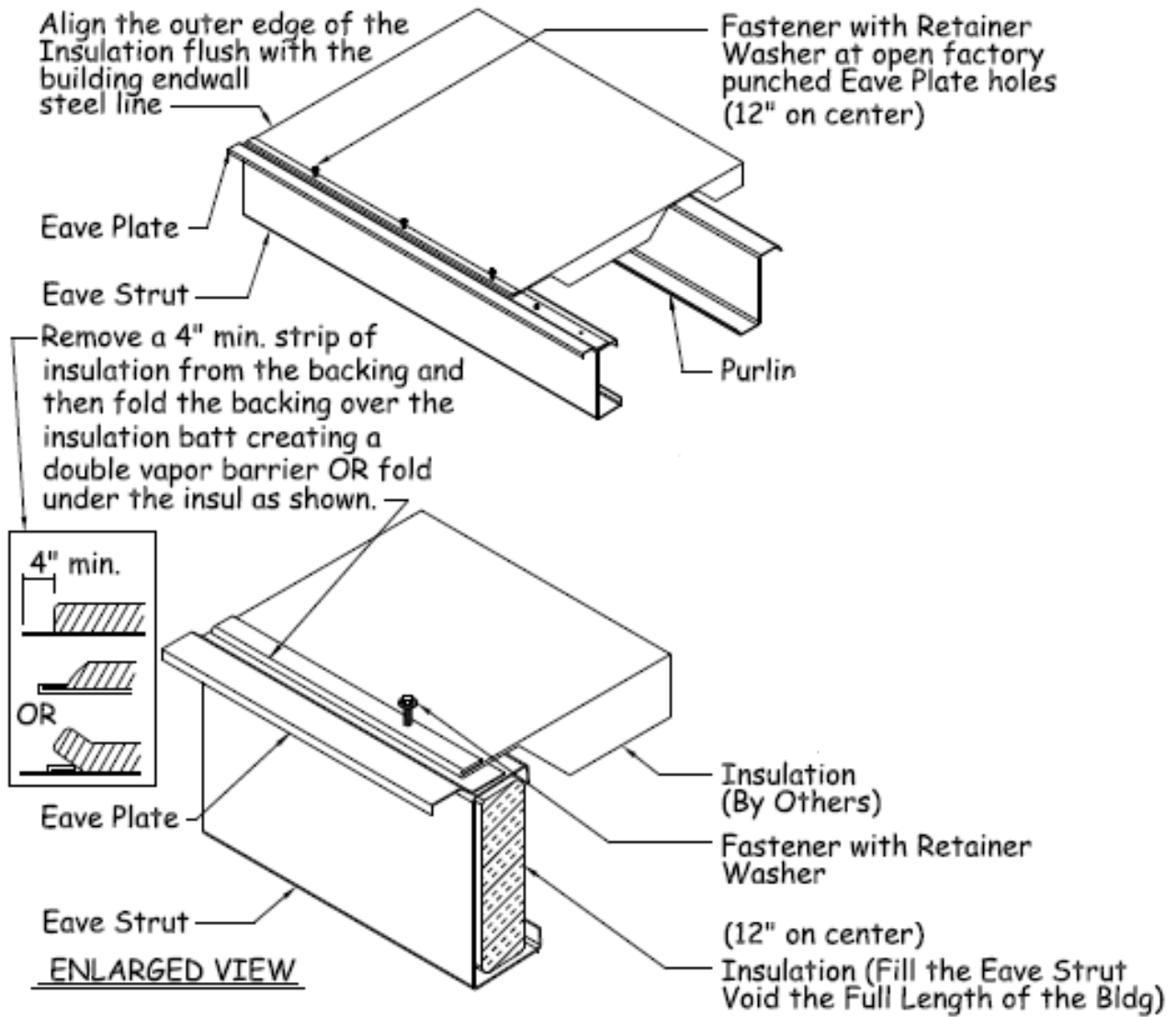
Pull the insulation toward the ridge/high eave so as to create a smooth appearance of the insulation backing.

Consult the insulation manufacturer for proper seaming and taping methods. At the high side/ridge, use fasteners (CF1) with insulation retainer washers placed 12-inches O.C.

At the low eave, remove a 4" strip of insulation from the backing leaving the strip of backing exposed. Fold this strip of backing over the insulation batt creating a double vapor barrier. (see details on next page)

Fasten the insulation to the backside of the eave strut over the double-faced tape using fasteners (CF1) and insulation retainer washers.

10.7 Starter Run of Insulation Installation



### 10.8 Thermal Blocks

Thermal blocks are used **ONLY** with tall panel clips.

Position the thermal block on top of the insulation over each purlin/joist line before installing the roof panels.

Place the thermal block tight against the rake angle and the next panel clip. Thereafter, the blocks will be placed between panel clips.

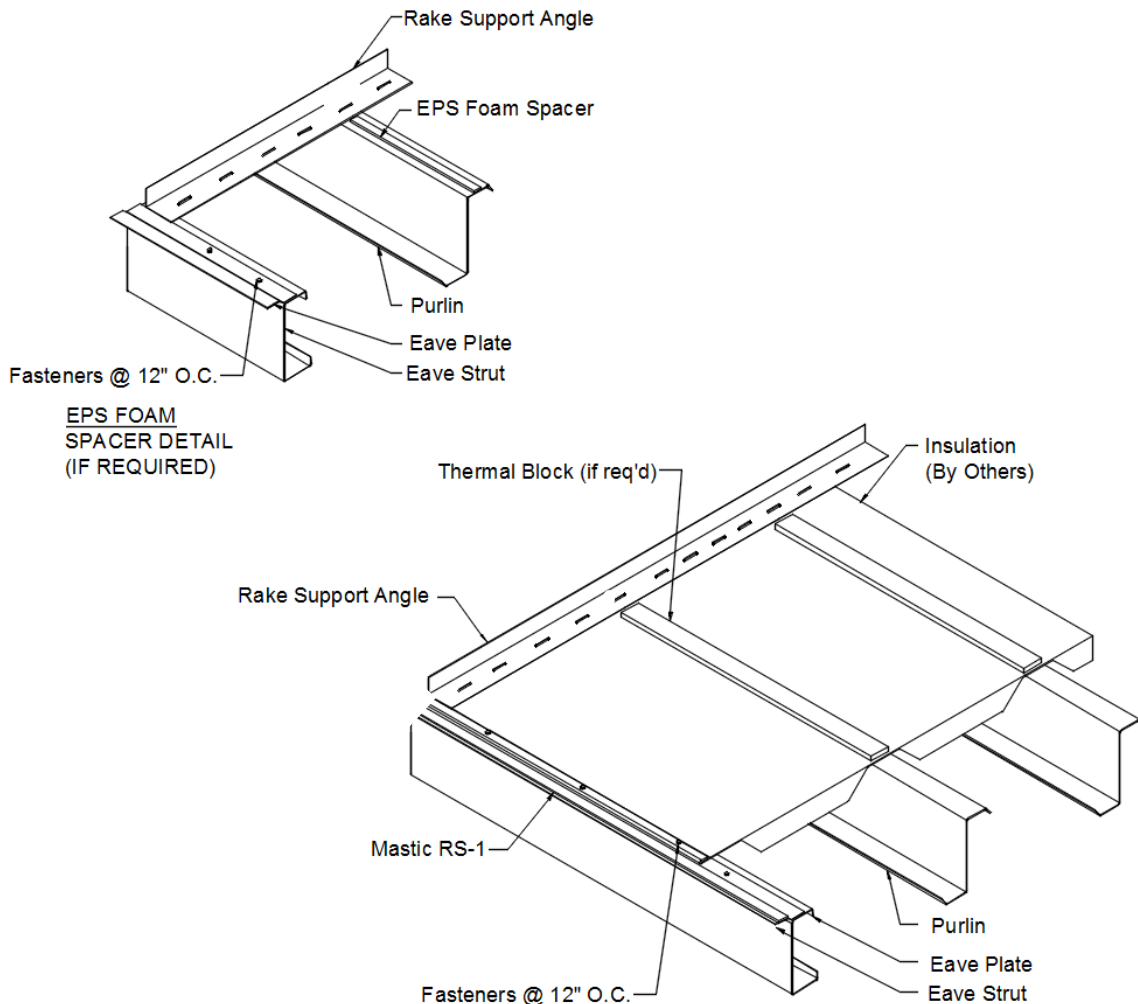
**EPS Foam Spacer has an adhesive backing. Remove the protective paper before rolling it out onto the purlin.**

In the absence of insulation, the EPS Foam Spacer will reduce noise and vibration caused by the wind. It may also help reduce damage caused by metal to metal contact.

### 10.9 EPS Foam Spacer

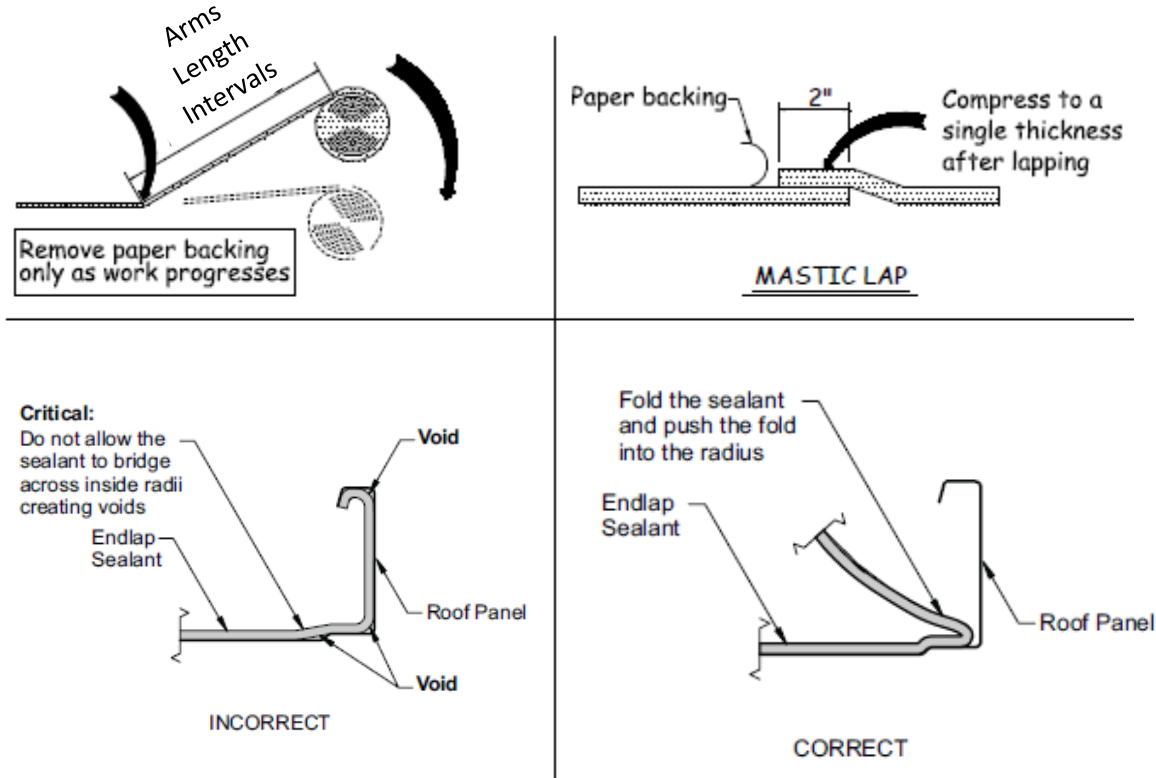
EPS Foam Spacer is used **ONLY** with short panel clips on buildings **WITHOUT** insulation.

EPS Foam Spacer is provided in 50-foot rolls and is placed on top of the purlin leg before installing the panel clips.





**10.10 Proper Mastic Installation Procedures**



**Apply mastic only to clean, dry surfaces.**

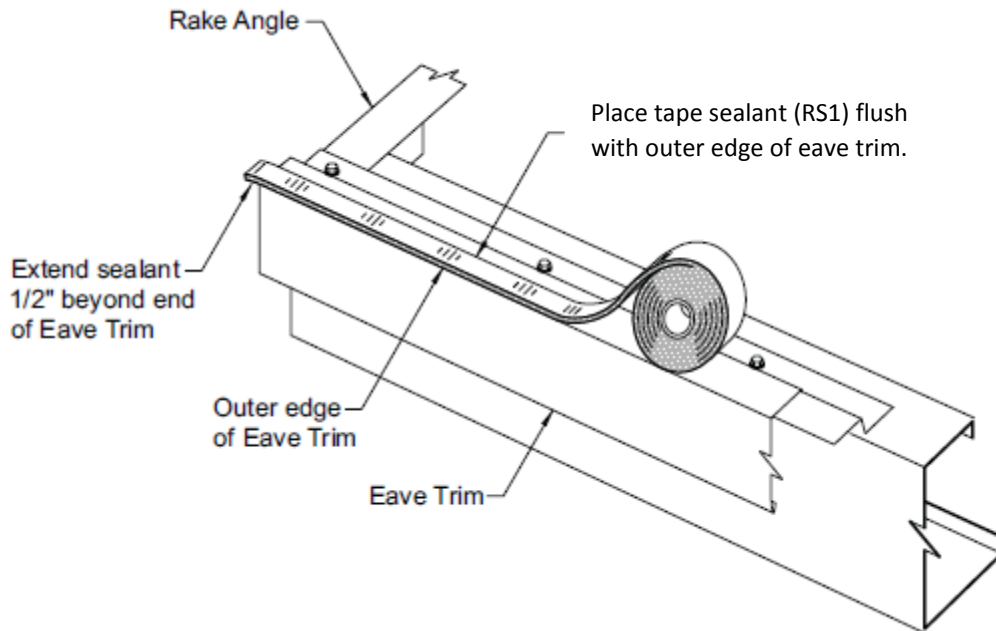
Roll mastic out in arm length intervals. Press the mastic firmly in place making sure it is tightly formed to all bends.

Remove paper backing **only** when ready to install the top component.

Splice mastic with a 2-inch lap. Press lapped pieces of mastic firmly together to form a single thickness.

**DO NOT STRETCH THE MASTIC ACROSS CORNERS. THIS WILL DECREASE THE THICKNESS WHERE IT IS NEEDED THE MOST, AND MAY NOT PERFORM AS DESIGNED.**

### 10.11 Eave Sealant Installation



Apply a **continuous** strip of tape sealant (RS1) along the top edge of the eave trim.

Align the outer edge of the sealant flush with the outer edge of the eave trim.

**Do not** remove the paper backing from the sealant at this time.

Until the roof panels are installed, the eave sealant is vulnerable to damage from foot traffic or dragging material over the eave. **Do not** step on or otherwise damage the sealant.

### 10.12 Final Pre-Panel Installation Detail

Before installing any roof panels, refer to the erection drawing roof sheeting plan and roof details to see if there are any special requirements.

**Make sure** that the eave plate is fastened to the eave member at 12-inches O.C. with CF1 fasteners.

**11.0 Eave Start Panel Installation**

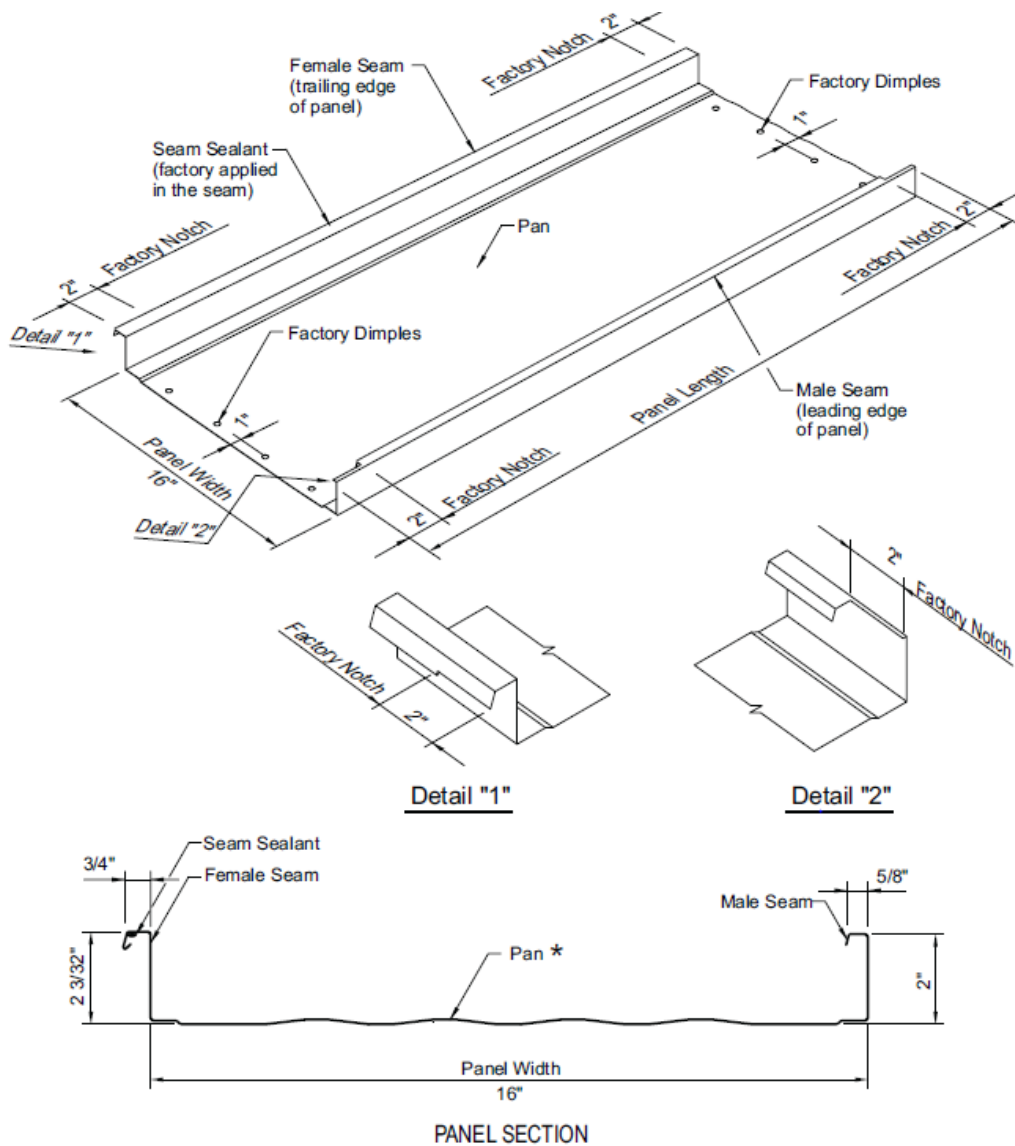
**11.1 Panel Section, Description and Nomenclature**

Throughout this manual the reference to the panel will be made using the terms in the illustration below.

The Horizon Panel Craft Roof panel is designed so it can be installed in either direction (left-to-right) or (right-to-left). Check the erection drawings and job conditions to determine if the roof must be installed in a specific direction.

The leading edge of the roof panel is the edge toward the installation direction. On the Horizon Panel Craft Roof panel, the male seam is always the leading edge.

**Before loading the panels onto the roof secondary members, orient the panels so that the male seam is the leading edge.**

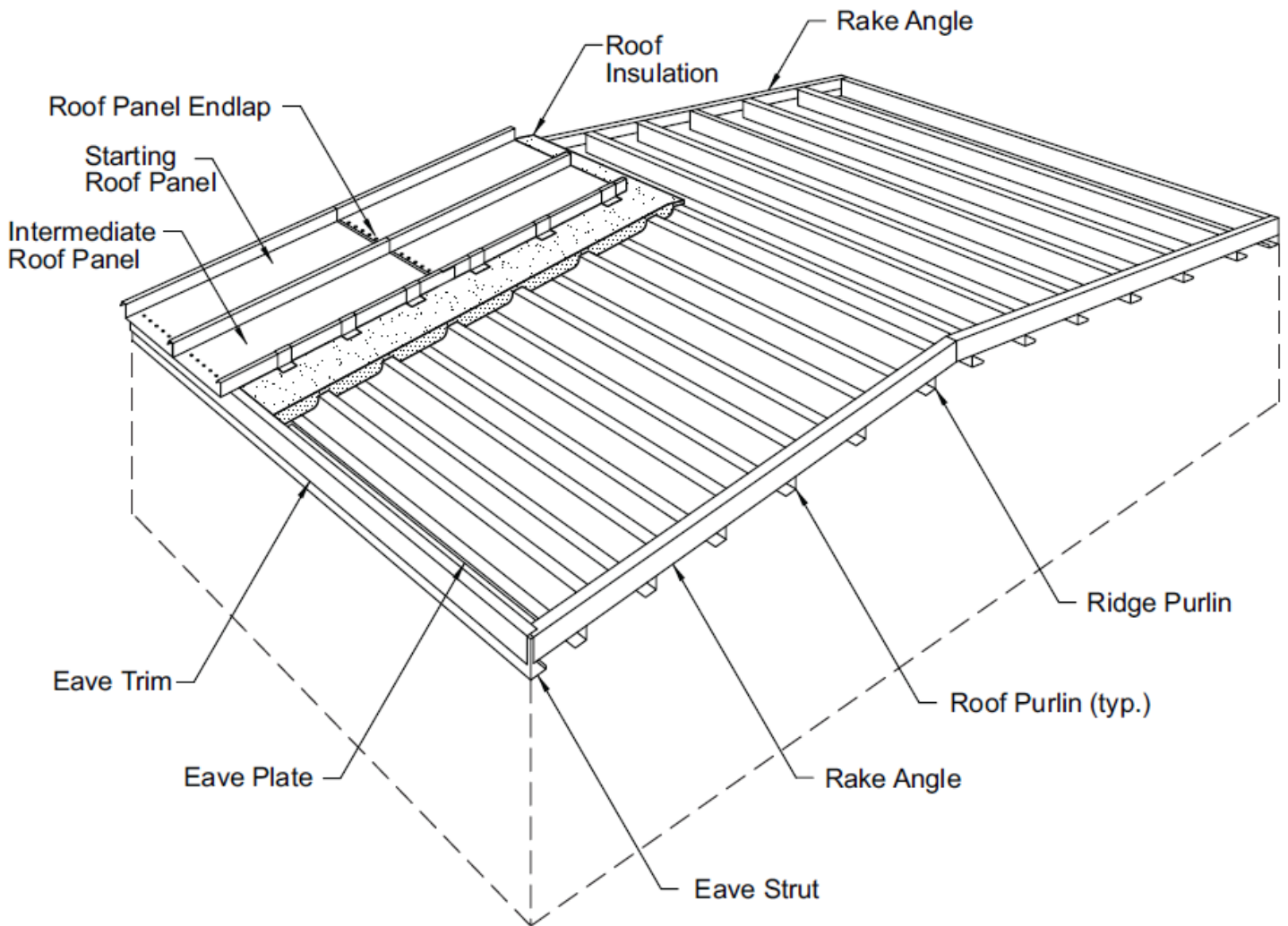


### 11.2 Orientation View

The details in this section show the installation of the starting and intermediate roof panels.

The roof panel end lap details are shown as an integral part of the roof panel installation. If the project does not require roof panel end laps, the end lap details are clearly identified and can be disregarded.

The termination roof panels require specific installation and are shown in a later section.



### 11.3 Roof Panel Installation

The roof panel's eave overhang dimension is critical as it establishes the location of end laps and ridge cover attachment points.

The end of the roof panel extends 3-1/2" beyond the face of the eave strut unless another dimension is specified on the erection drawings.

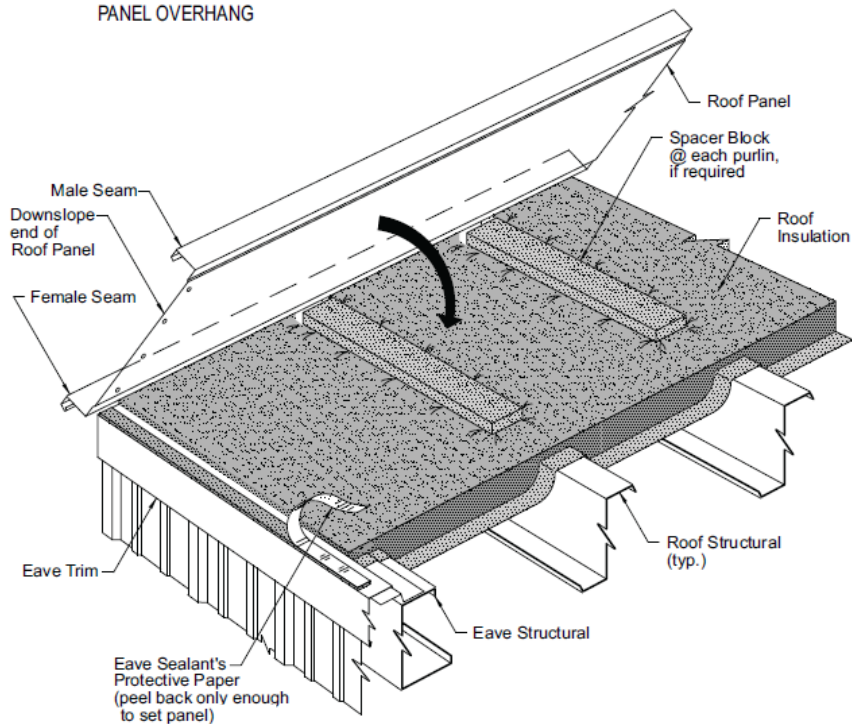
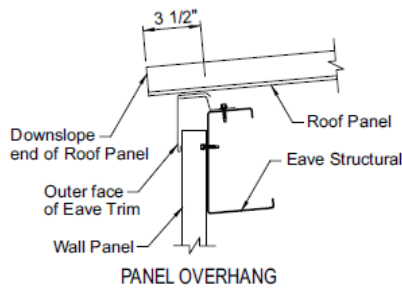
If insulation thermal blocks are required, place the blocks on top of the insulation directly over the roof structurals. Thermal blocks are not required at the eave structural.

Position the female edge of the panel over the rake support angle and position the end of the panel 3-1/2" beyond the web of the eave strut.

Tilt the panel as shown so the female seam can be hooked over the start clips.

Only remove the eave sealant's protective paper enough to set the first panel

**Only remove the eave sealant's protective paper enough to set first panel.**



**NOTE: ANY PROTECTIVE COATINGS OR COVERINGS (PRIMARILY ALONG THE PANEL'S RIB ON PAINTED PANELS) MUST BE REMOVED BEFORE ANY PANEL CAN BE INSTALLED.**

### 11.4 Roof Panel Installation - Installing the Eave Start Panel

Before fastening the roof panel to the eave plate and fastening the leading edge of the panel with the panel clips, check that the panel coverage is correct and the leading edge of the panel is straight and parallel to the rake line.

Fasten the eave end of the panel with roof fasteners spaced as shown on the fastener spacing detail. Position the fasteners to penetrate through the center of the sealant, through the eave trim and into the eave plate.

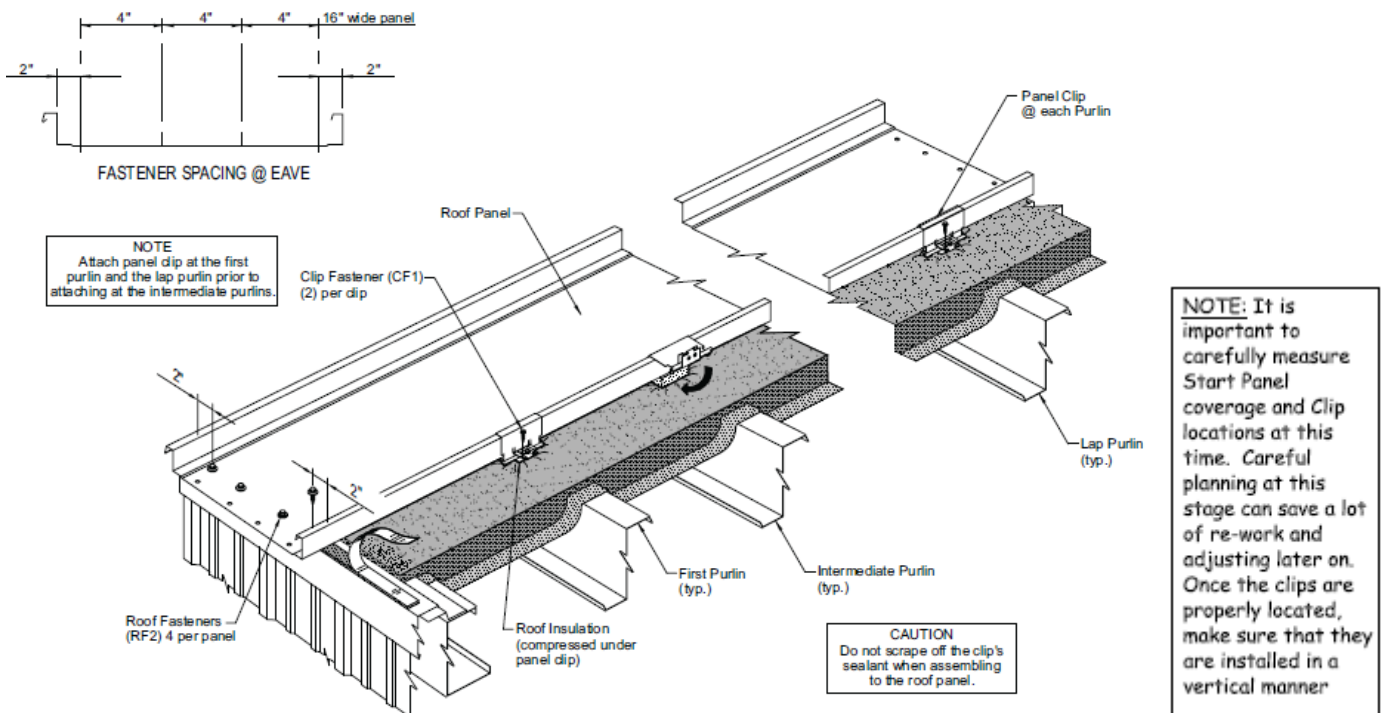
Install roof panel clips to the leading edge of the roof panel at each roof purlin. Install first purlin clip and lap purlin clip before intermediate clips. Panel clips are not required at the eave strut.

To install the clips, tilt the clip so that its tab can be hooked over the edge of the roof panel's male seam. Position the clip's base so that the clip fasteners can be installed through the holes in the base and into the roof structural, then rotate the clip down into the vertical position.

When fiberglass roof insulation is used, the panel clips normally set top of the insulation and the insulation is compressed between the clip's base and the top of the roof structural. In all cases, refer to the purchase order to determine the required insulation assembly and the relationship of the panel clips to the insulation.

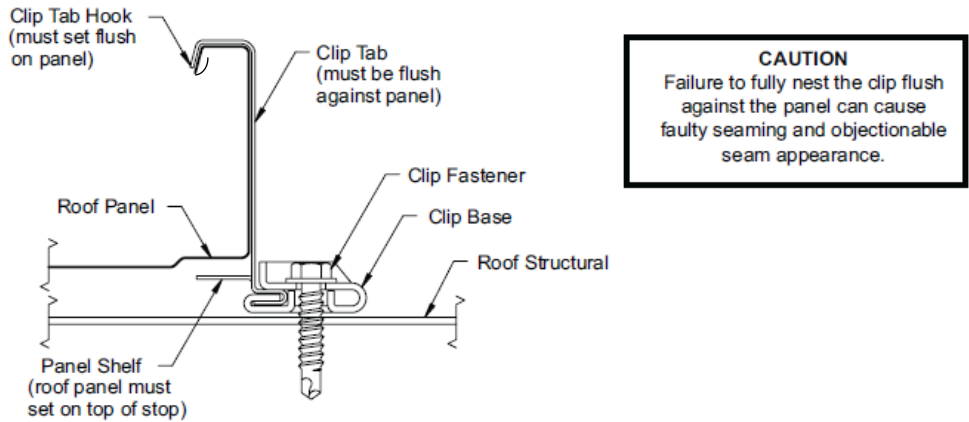
Specific panel clip details are shown on the following page. Only remove the eave sealant's protective paper enough to set first panel.

**NOTE: Once the panel has contacted the mastic, it cannot be moved.** Be sure the start panel is properly positioned before seating.

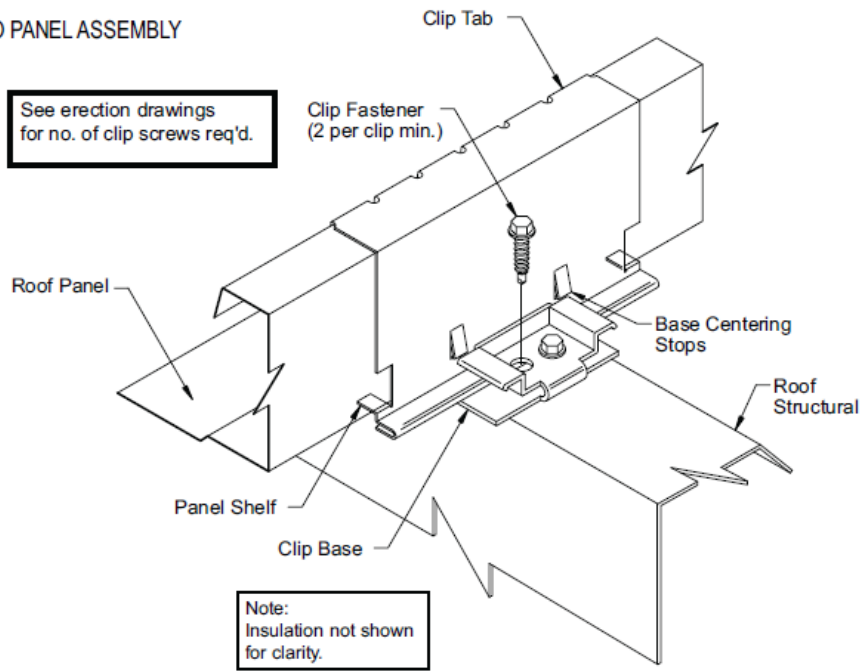


**NOTE: ANY PROTECTIVE COATINGS OR COVERINGS (PRIMARILY ALONG THE PANEL'S RIB ON PAINTED PANELS) MUST BE REMOVED BEFORE ANY PANEL CAN BE INSTALLED.**

### 11.5 Installing the Leading Edge Panel Clips



CLIP TO PANEL ASSEMBLY



Panel clips are available as floating clips or fixed clips and are available in different stand-off heights. Refer to the erection drawings to determine the type of clip and quantity of fasteners required for each roof condition.

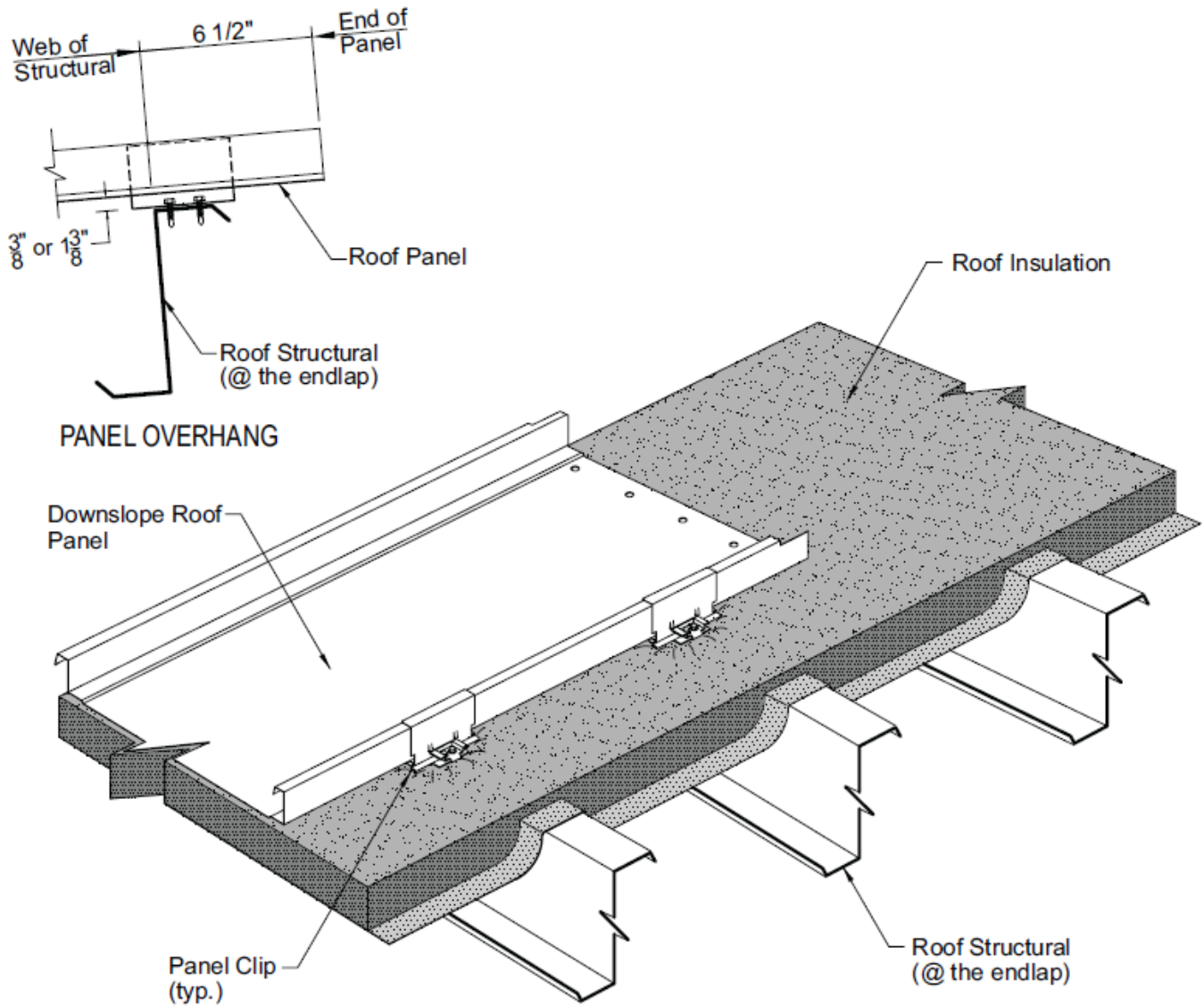
Panel clip fastener type and quantity vary according to the roof structural material and roof load requirements. Refer to the erection drawings for the required type and quantity of panel clip fasteners.

Check that the panel clip's tab is seated tightly around the roof panel's seam.

Check that the clip fasteners are equally spaced through the clip base holes and are securely engaged into roof structural.

Check that the clip's base is vertical and that the base is set square and firmly over the roof structural.

## 11.6 Checking dimensions



With the eave end of the roof panel attached, measure the panel overhang at the end lap roof structural (see illustration).

The panel should extend 6-1/2" (typically) beyond the web of the purlin.

If the panel overhang is not within this range, call Horizon Structural Systems before proceeding with the installation of roof panels.



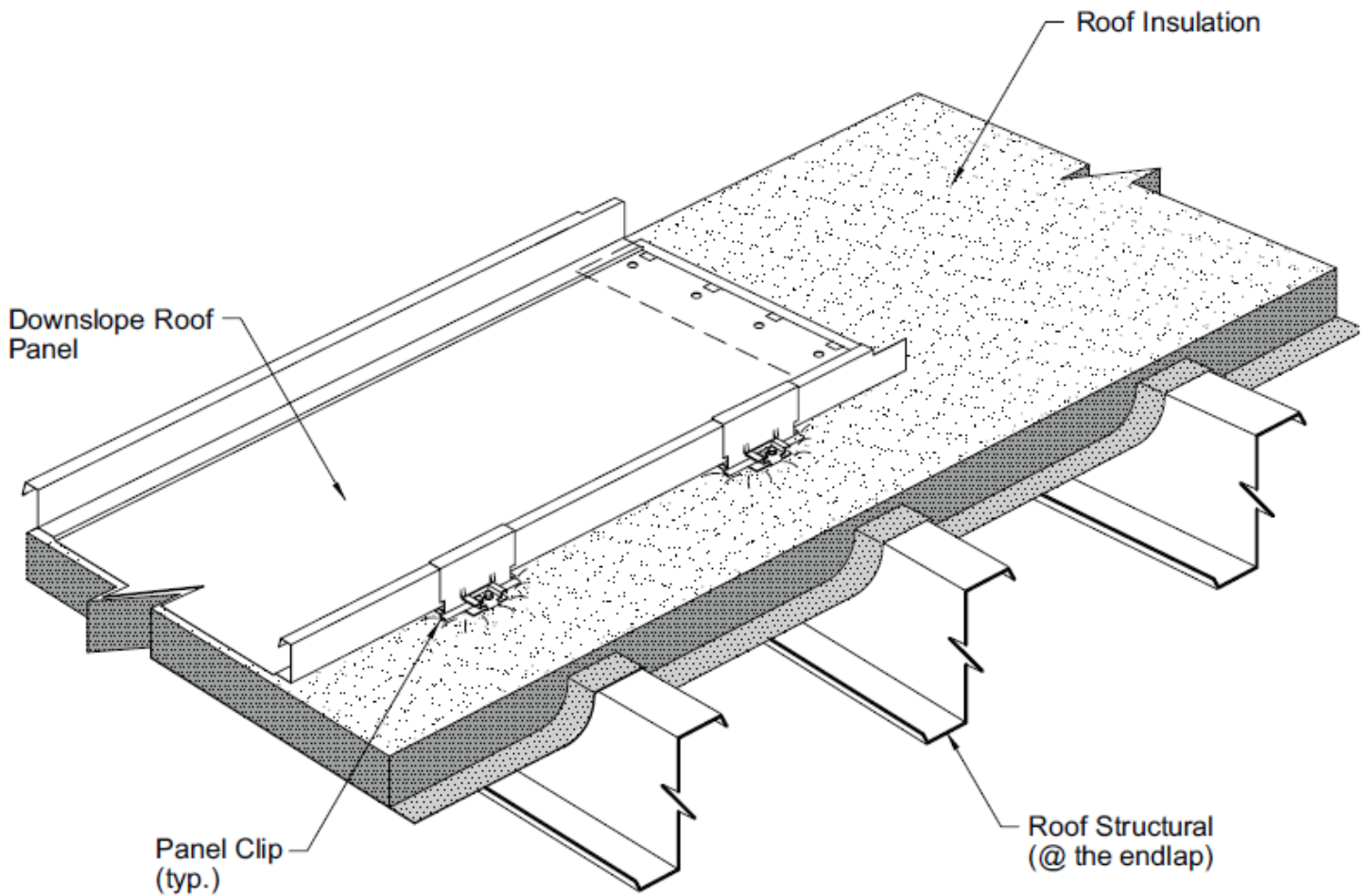
## 12.0 Intermediate Start Panel Installation

### 12.1 Installing a Backup Plate

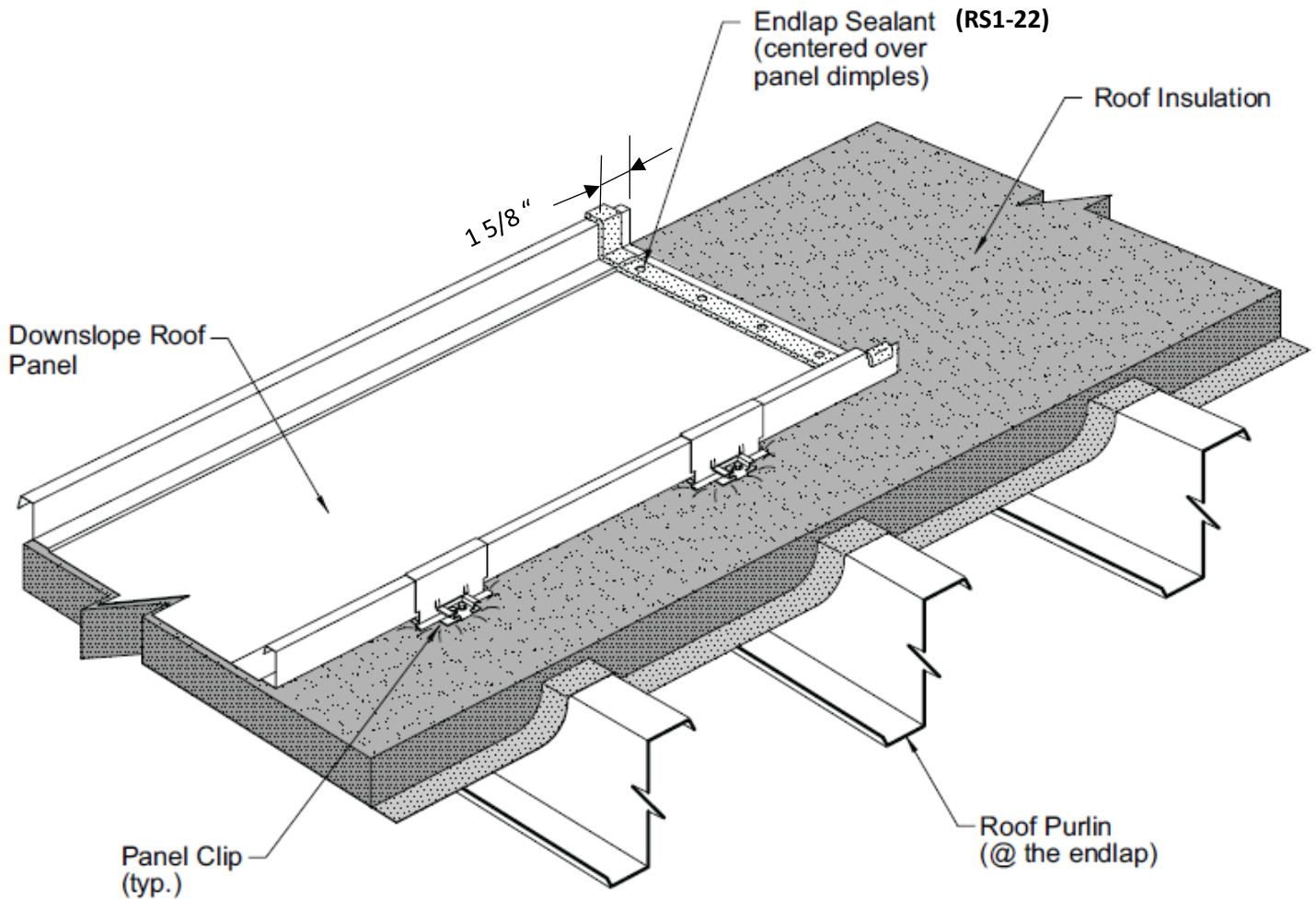
Slide the back-up plate under the roof panel, as shown.

The back-up plate must be set over the top of the roof structural. If insulation spacer blocks are used, the back-up plate must be set over the thermal block. **BE CAREFUL NOT TO DISPLACE THE THERMAL BLOCK.**

The back-up plate's tabs must hook over the end of the roof panel.



## 12.2 Installing End Lap Sealant



The proper placing of the end lap sealant is critical to the weather tightness of the roof end laps.

Before installing the end lap sealant, the roof panel's surface must be wiped clean and dry.

Position the sealant so that its upslope edge is uniformly against backup plates tabs. The roof panels have factory punched dimples, the sealant must be centered over the dimples.

Install a continuous strip of the pre-cut 22" end lap sealant (RS1-22) along the end of the roof panel as shown.

Check that the sealant fully contacts the roof panel's surface and that it is completely fitted into the panel corners and around the seams.

The sealant's protective paper helps to retain the sealant's shape during installation and protects the sealant's surface from damage and contamination. Do not remove the protective paper until immediately before the installation of the up-slope roof panel.

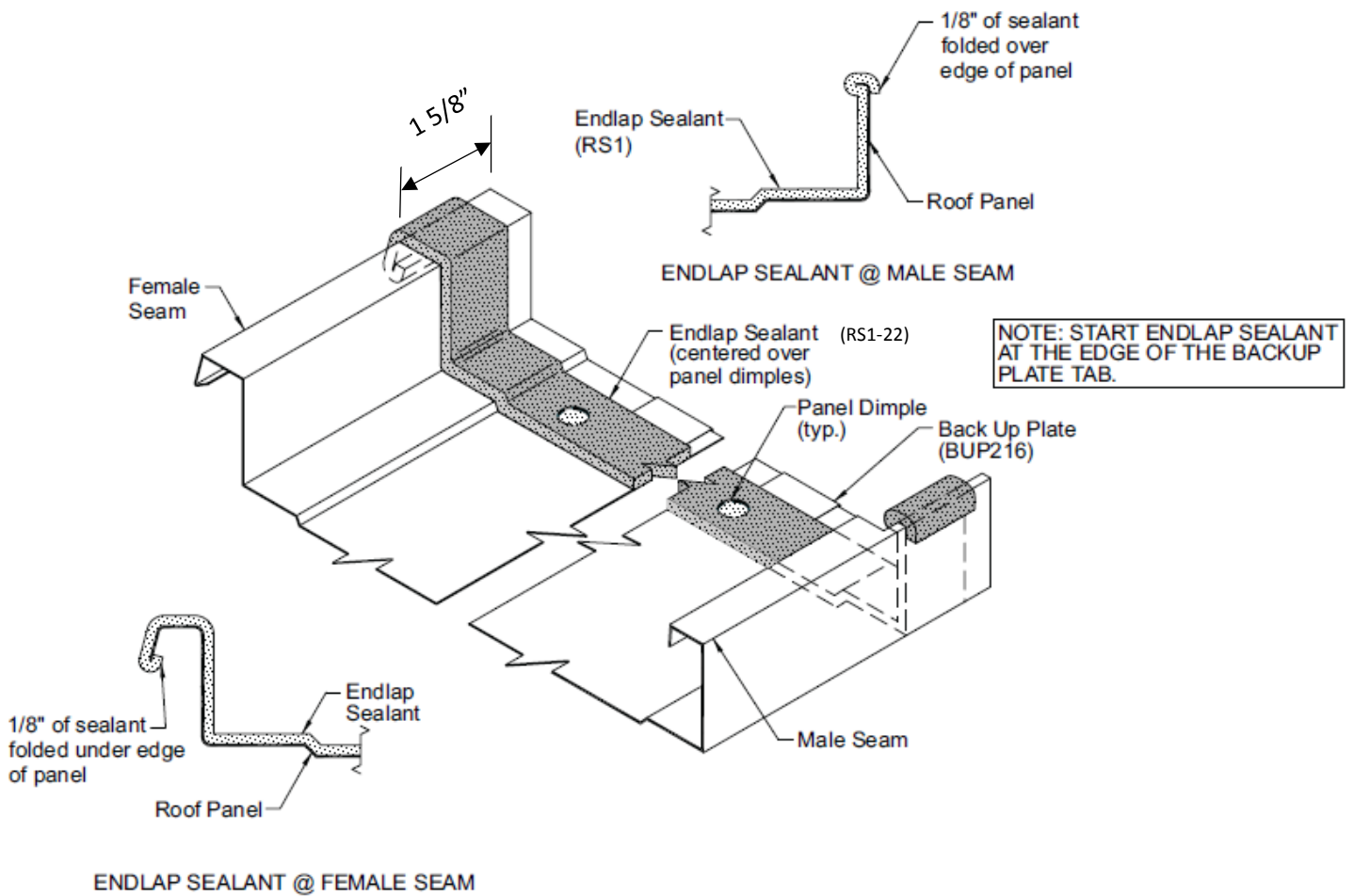
Specific end lap sealant details are shown on the following page.

## 12.2 Installing End Lap Sealant

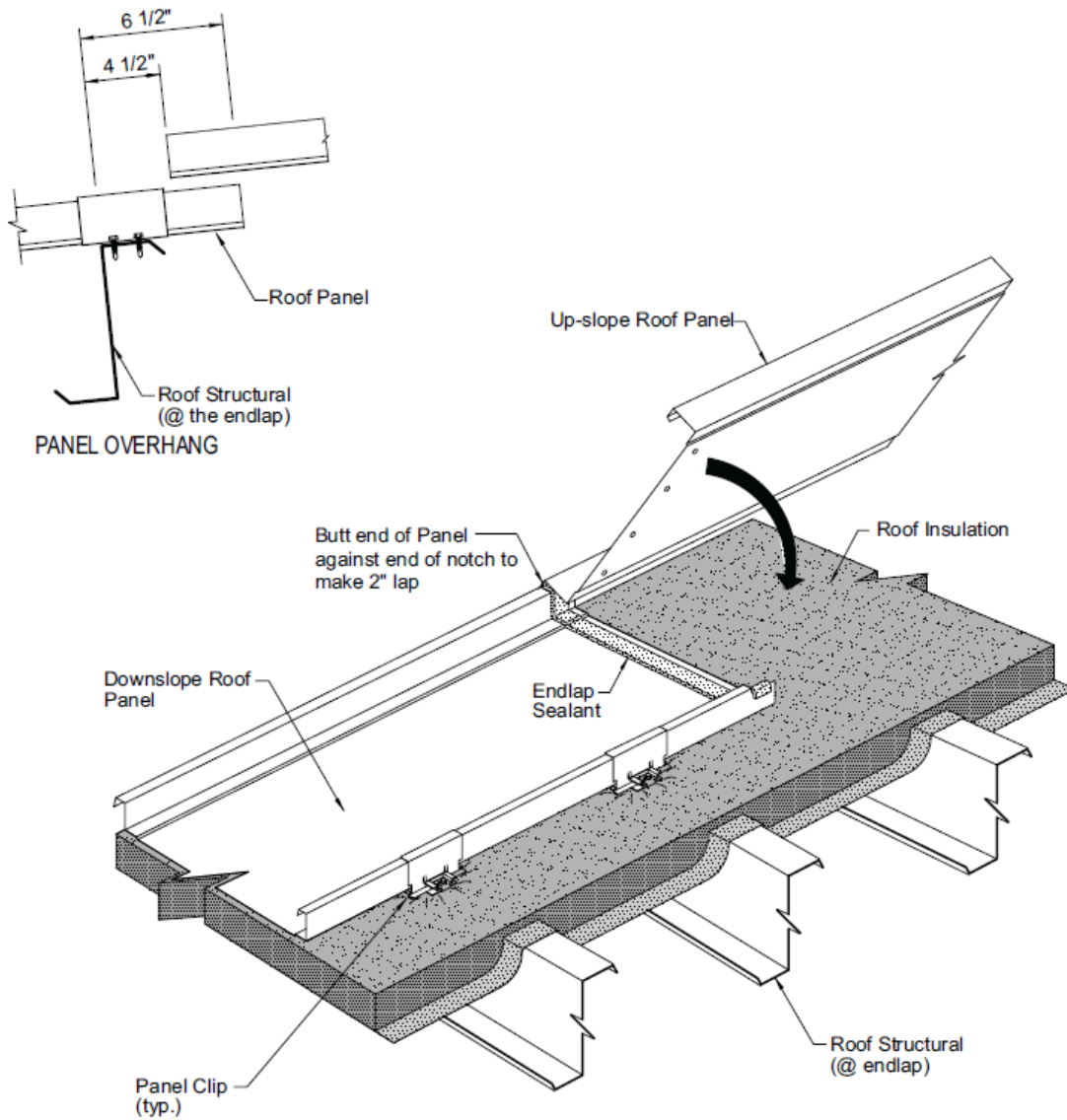
The end lap sealant is pre-cut to be fitted around the roof panel's seams as shown.

Check that the 1/8" ends of the sealant are correctly folded around the roof panel's edges. Excess sealant in the roof panel seams will cause difficult panel assembly. Remove any excess sealant.

After the sealant is correctly positioned, uniformly press the sealant against the roof panel's surface to assure adhesion. Do not use excess pressure which can thin the sealant.



### 12.3 Installation of End Lap



Wipe dry and clean the underside surface of the up-slope roof panel.

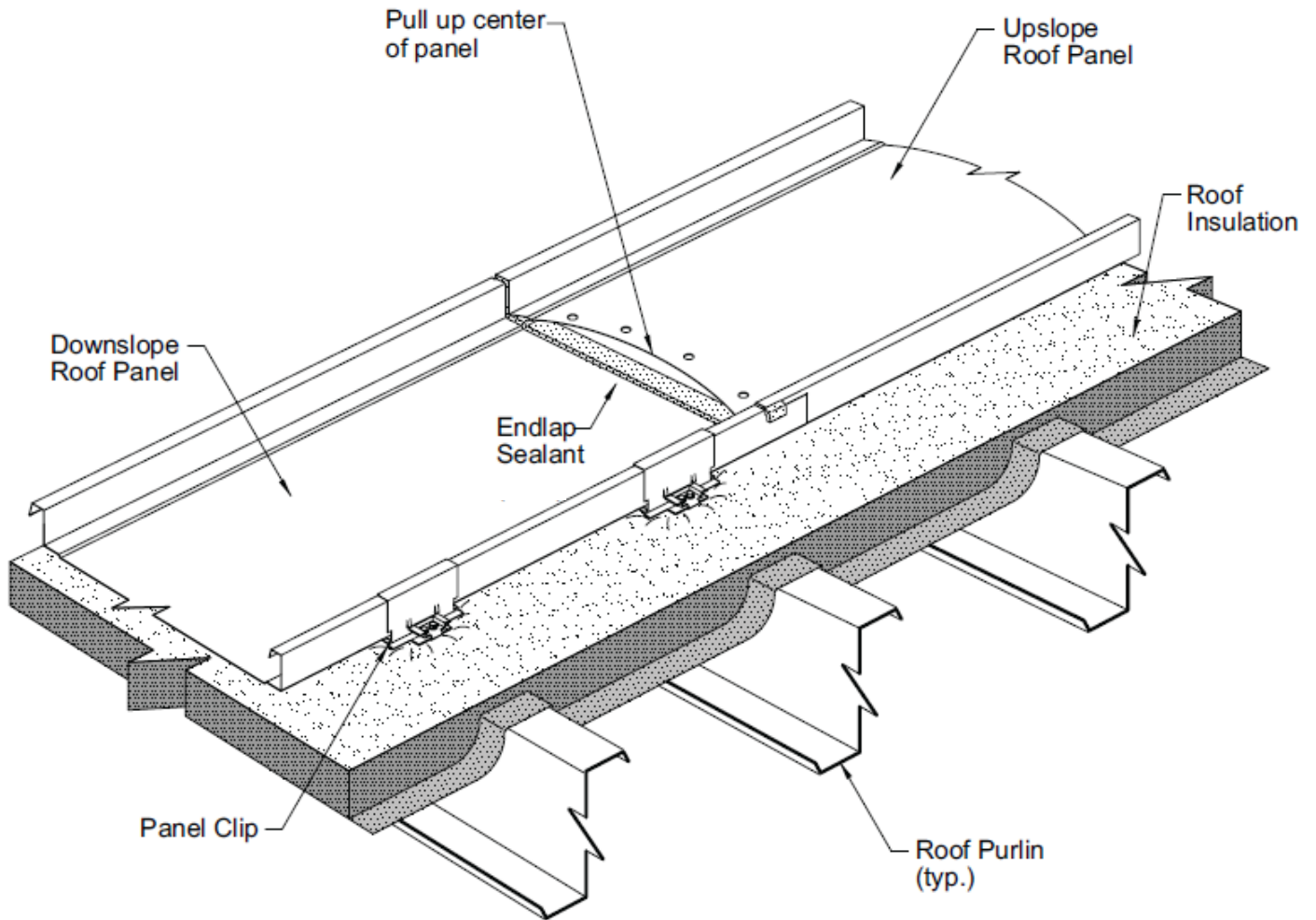
Remove the protective paper from the installed end lap sealant.

Position the end of the up-slope roof panel to make a 2" lap over the downslope roof panel.

At the seams, the end of the up-slope roof panel should butt against the notch on the downslope roof panel.

Check that the up-slope roof panel will correctly lap over the end lap sealant. If the panel has factory punched holes, check that the holes are centered over the sealant.

## 12.4 Engaging of End Lap



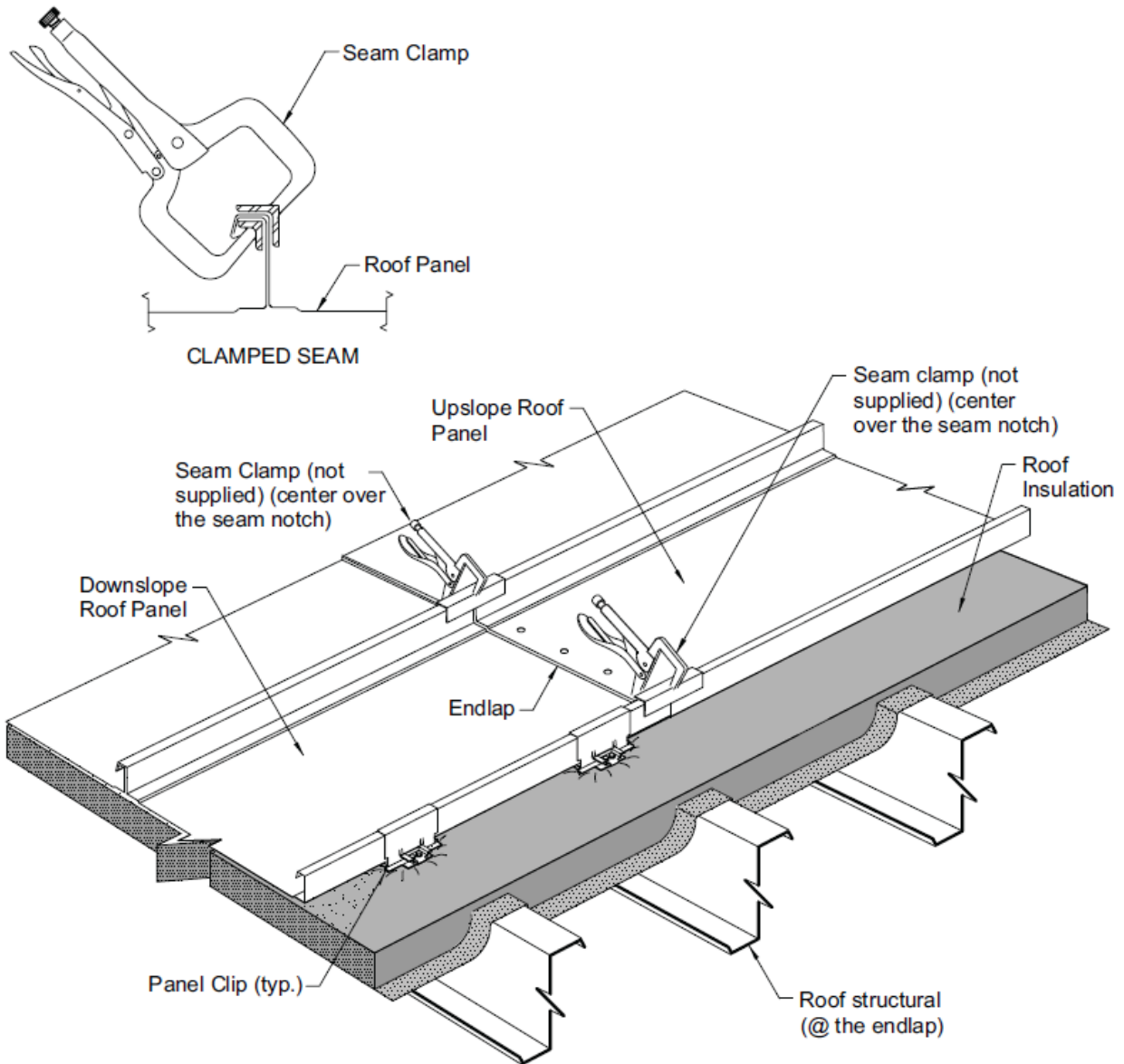
**Caution**  
While setting the roof panel,  
Do not wipe the endlap sealant  
off the sides of the panel.

Lower the up-slope roof panel to lap onto the downslope roof panel.

Do not displace or damage the sealant while nesting the up-slope panel.

While lowering the upslope roof panel, bow the end of the panel by pulling up on its center. This will allow the panel to more easily nest into the down-slope panel.

## 12.4 Engaging of the End Lap



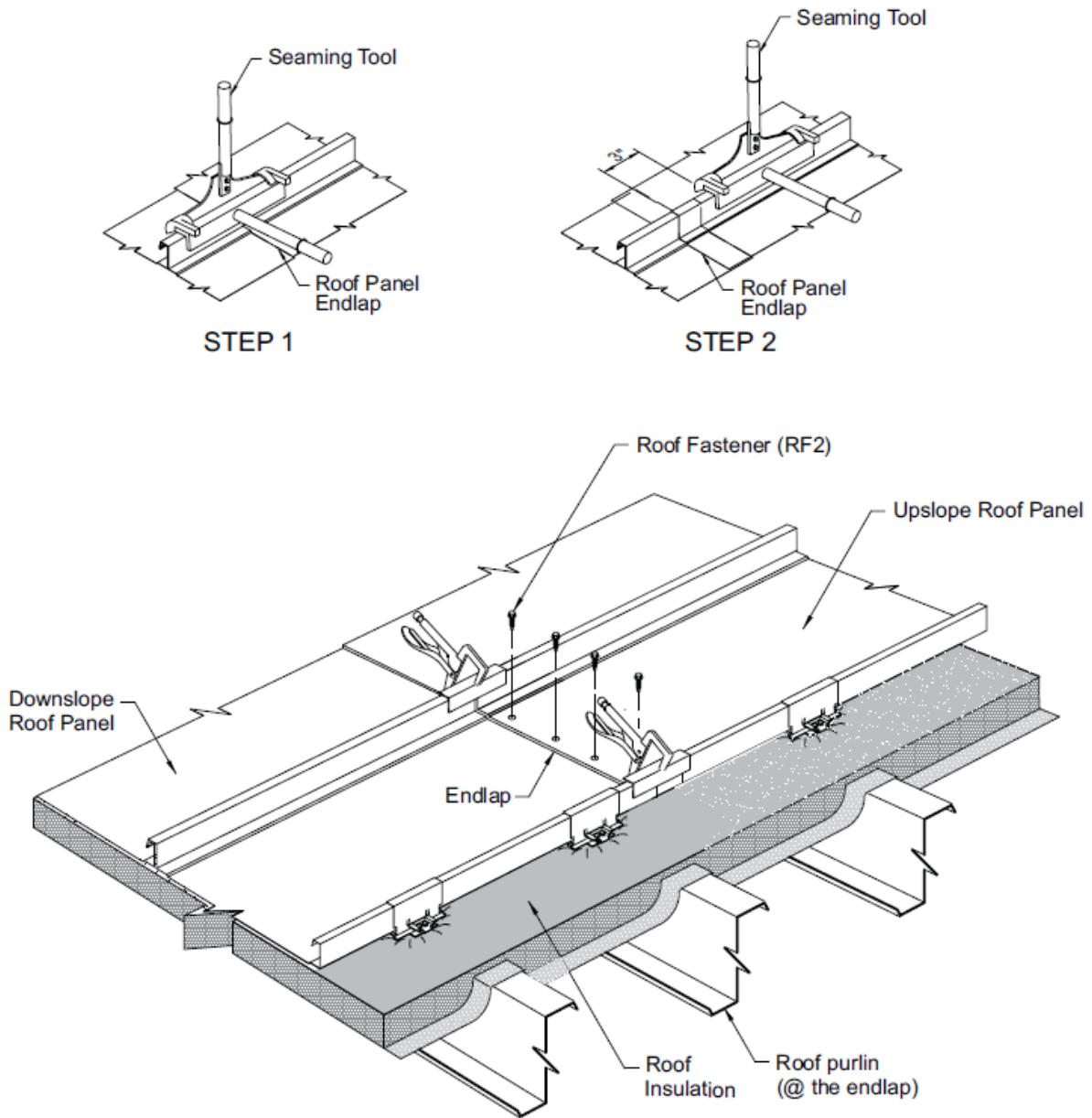
Use the seam clamps to draw the lapping panel seams together as shown.

Check that the clamp jaws are correctly aligned to the seam before closing the clamp. Misaligned clamps can distort and damage the roof panel seams.

Slowly close the clamp to allow the sealant to flow between the lapped seams.

With the seam clamps installed, uniformly press down on the up-slope panel to close the panel lap and to assure adhesion to the end lap sealant.

### 12.5 Fastening of the Intermediate Panel End Lap



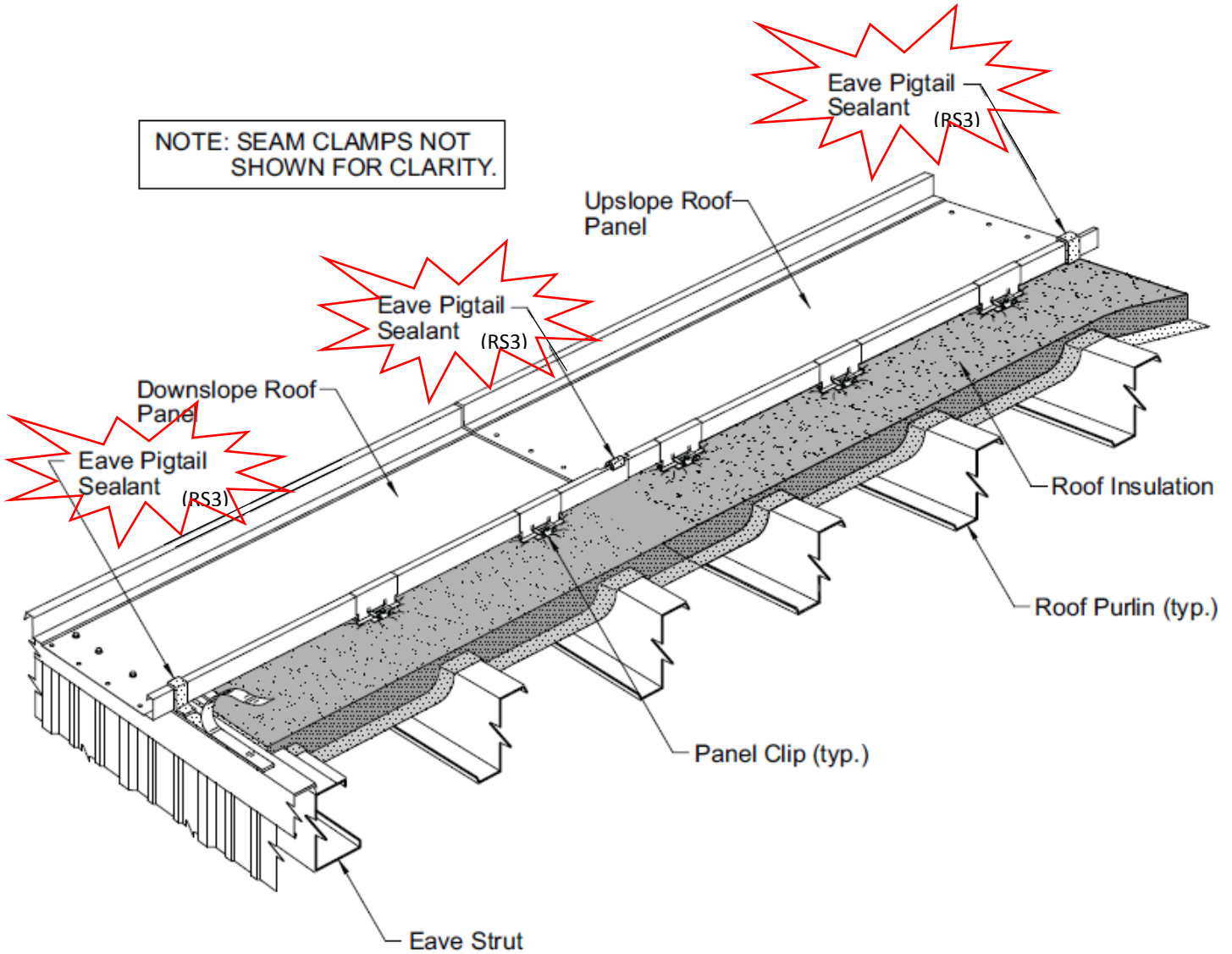
Install roof fasteners in the dimples at each end, then install fasteners in the remaining dimples.

Hand seam end lap, refer to seaming guide for specific steps.

Check that the roof fasteners penetrate thru the center of the end lap sealant and are securely engaged into the back-up plate.

## 13.0 Full Panel Run Installation

### 13.1 Installing Pigtail Sealants



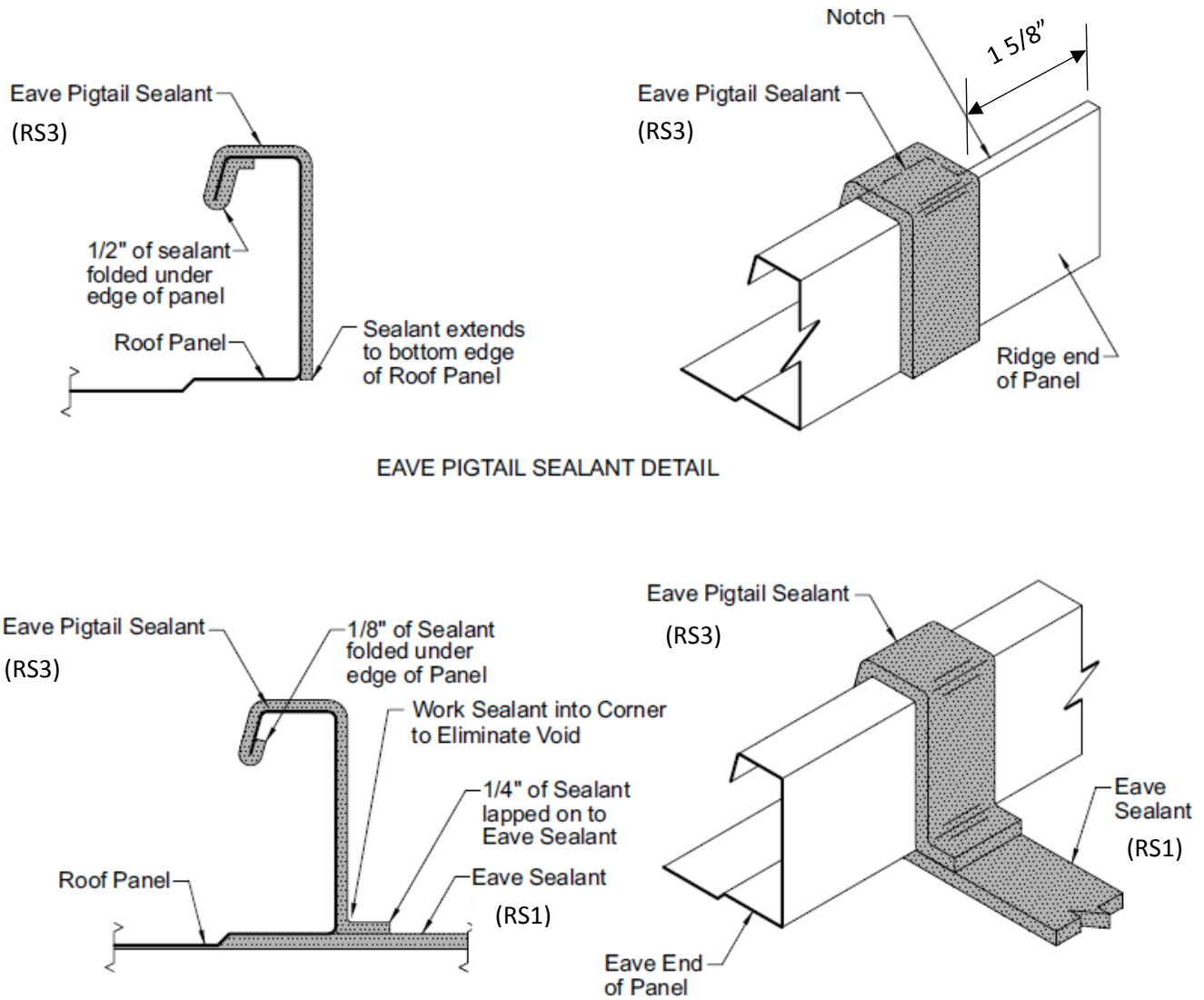
The 3" pre-cut pigtail mastic (RS3) must be correctly installed **BEFORE** the next roof panel run can be installed.

Refer to the next pages for specific pigtail sealant details.

Install these 3" pre-cut pigtail mastics on the leading edge of the roof panel as shown.



### 13.1 Installing Pigtail Sealants



EAVE PIGTAIL SEALANT DETAIL

At the ridge, position the 3" pre-cut pigtail mastic (RS3) so its edge is 1- 5/8" from the end of the roof panel. The sealant **must** lap over the edge of the roof panel's notch.

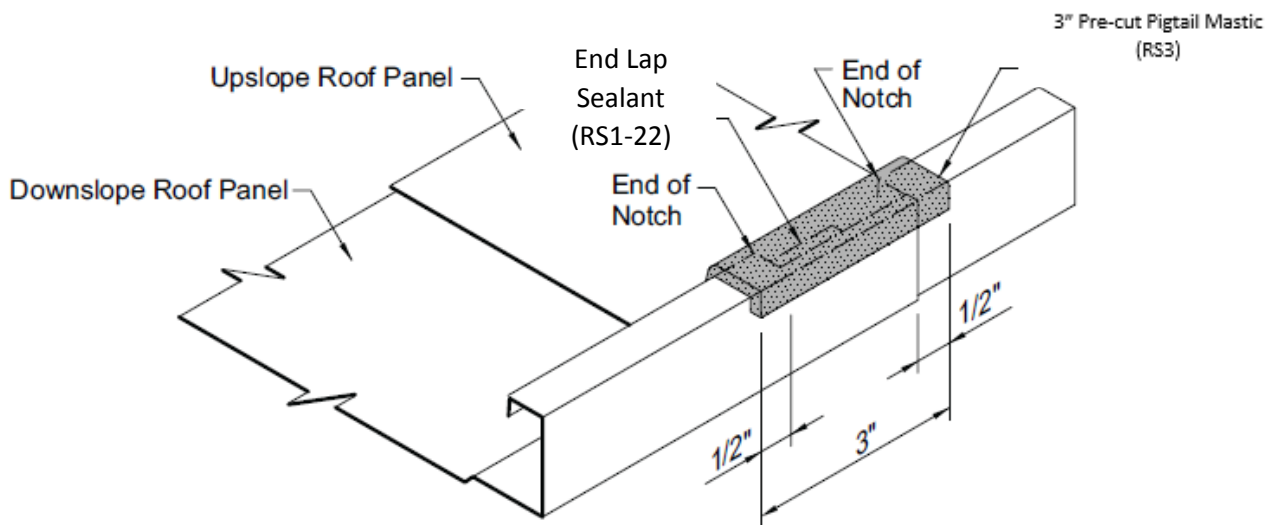
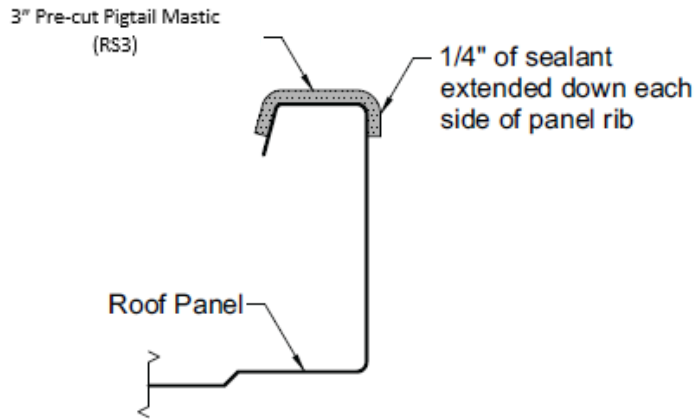
Fold the ridge pre-cut pigtail mastic (RS3) under the edge of the roof panel. The other end of the mastic should extend to the bottom edge of the roof panel's vertical seam.

At the low eave, lap 1/4" of the pre-cut pigtail mastic (RS3) onto the void closure's 8" pre-cut mastic (RS8). Fold the other end under the edge of the roof panel's female hook.

**Excess sealant in the seams will cause difficult roof panel assembly.** Remove any excess sealant.

After the sealant is correctly placed, uniformly press the sealant against the panel's surface to assure adhesion.

### 13.1 Installing Pigtail Sealants



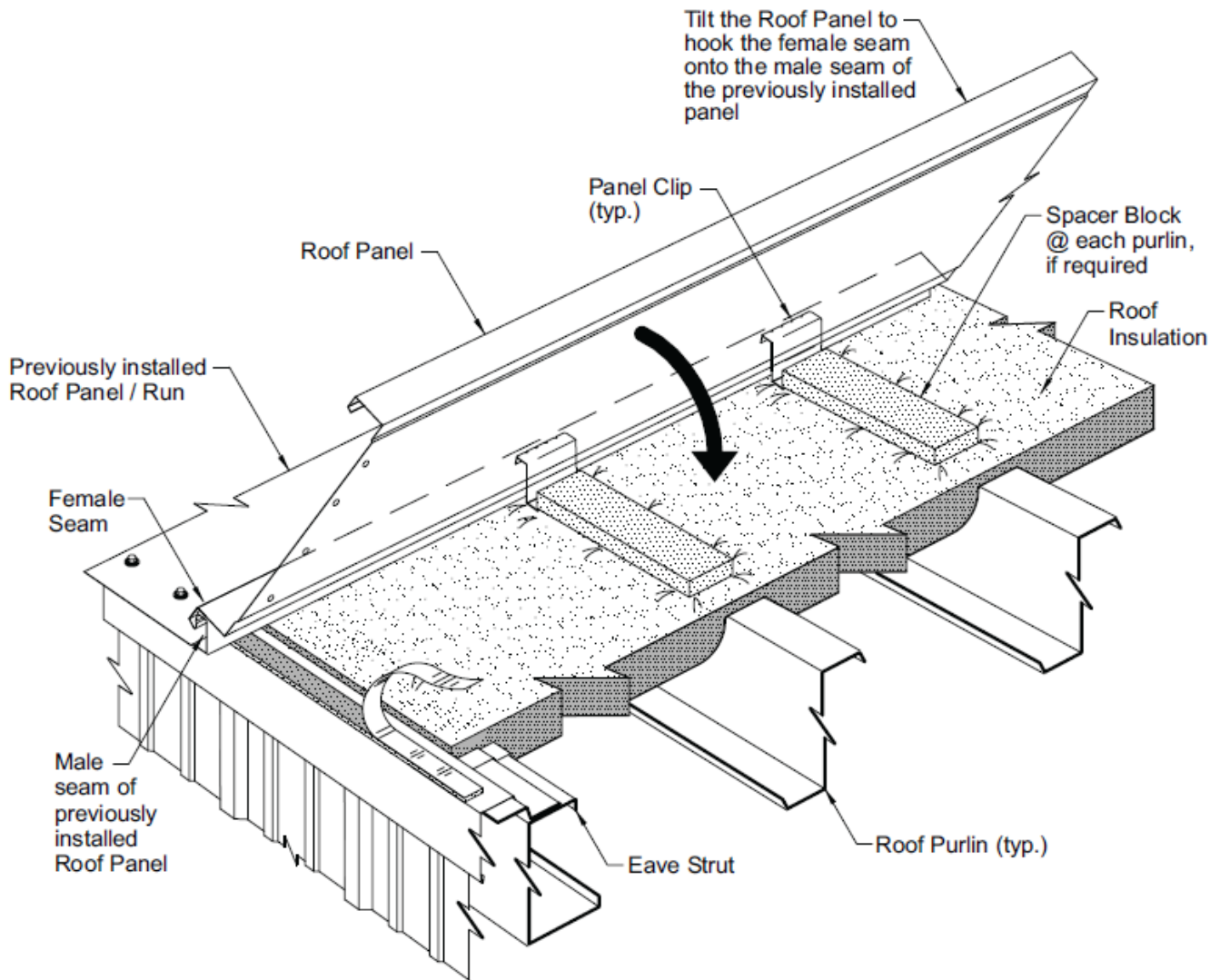
Position the 3" pigtail sealant to tape lap 1/2" beyond each end of the roof panel's notch.

Center the sealant tape over the roof panel's seam. Fold the edges of the sealant down over the sides of the seam.

**Excess sealant in the seams will cause difficult roof panel assembly.** Remove any excess sealant. **Cut, do not tear the mastic.**

After the sealant is correctly placed, uniformly press the sealant against the panel's surface to assure adhesion.

### 13.2 Installing the first full panel run



Remove the protective paper from the eave sealant. Remove only enough of the protective paper to allow installation of the next roof panel.

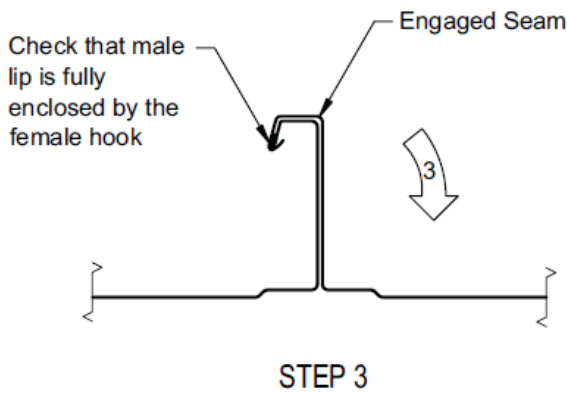
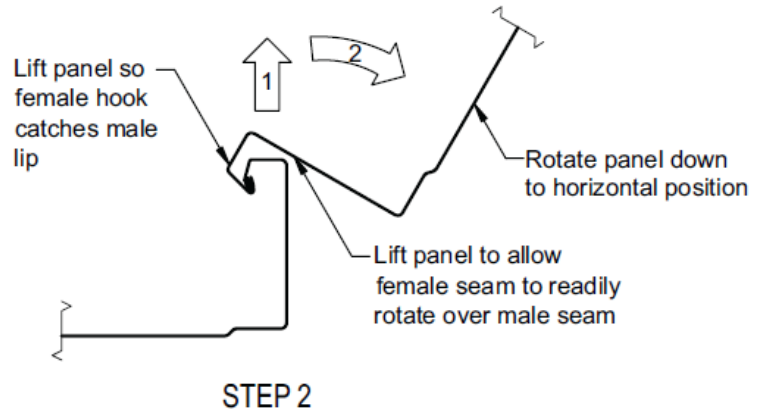
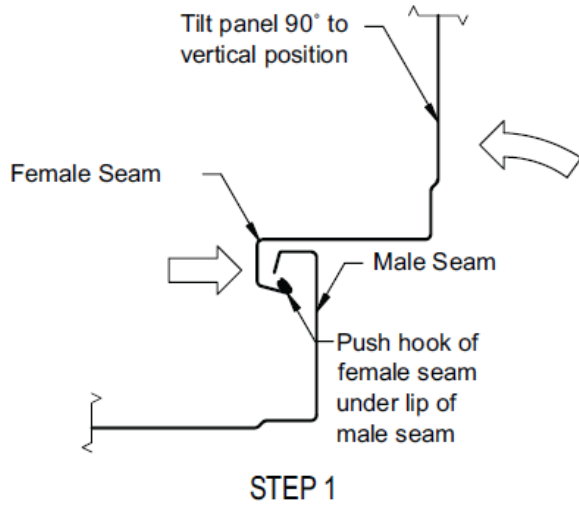
If required, place the insulation spacer blocks on top of the insulation directly over the roof structural.

Position the trailing edge of the roof panel over the leading edge of the previously installed roof panel and position the end of the roof panel 3-1/2" beyond the web of the eave strut.

Tilt the panel as shown so the female seam can be hooked over the male seam of the previous roof panel.

**Specific roof panel side lap assembly details are shown on the following page.**

### 13.3 Engaging the Intermediate Panel



**CAUTION**  
Do not scrape off seam sealant during the side lap assembly.

It is easier to hook the roof panel seams together if the roof panel is first tilted up to the vertical position.

With the roof panel in the vertical position, align its female seam to slide under the male seam of the previous roof panel.

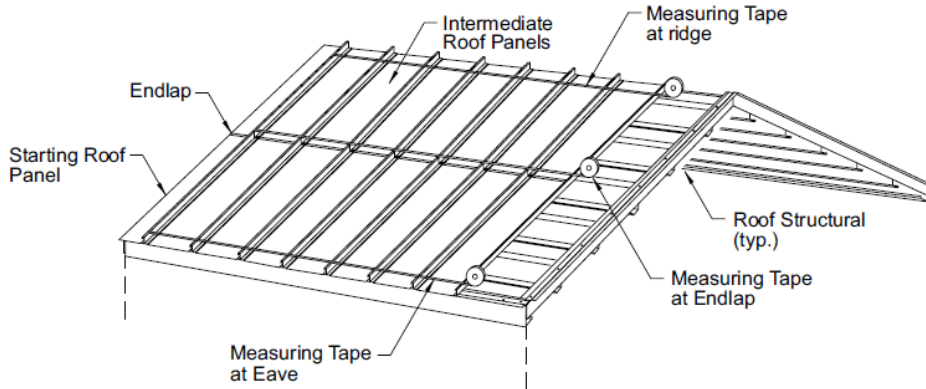
With the female seam under the male seam, lift up the roof panel so the female seam's hook catches the lip of the male seam.

While continuing to lift up on the roof panel, rotate the panel down to rest on the insulation or spacer blocks.

**IMPORTANT: Check that the female hook has enclosed the male lip along the entire length of the roof panel. If not, the roof panel side lap must be correctly reassembled before installing the next roof panel.**

### 13.4 Controlling Panel Width Modularity

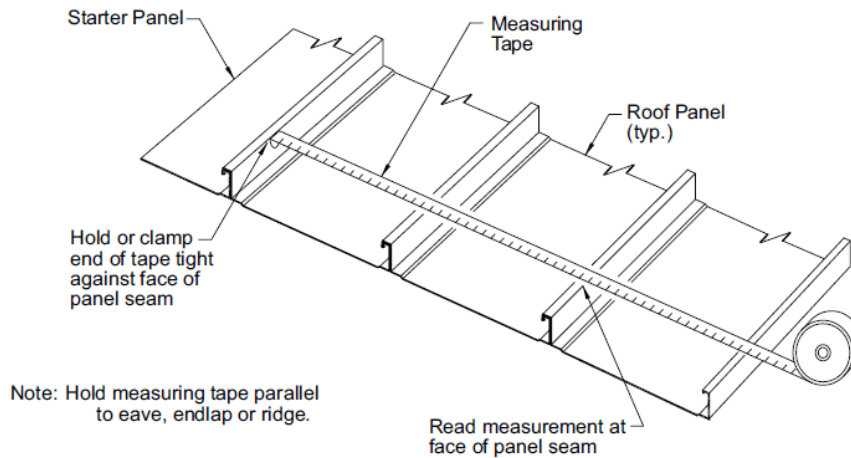
#### Controlling Panel Coverage



The coverage MUST be 16 inches O.C. for proper modularity and for the seamer to properly operate.

#### CHECKING PANEL COVERAGE

NOTE: CHECK OVER ALL PANEL MODULARITY EVERY SIXTH PANEL RUN.



#### PANEL COVERAGE MEASUREMENT

**Caution:** To assure proper fit-up of the side lap assembly, proper seaming and proper fit-up of closures, flashing, curbs, etc., it is important that each panel be held within the 1/16" panel coverage tolerance and that overall coverage be checked frequently and any coverage error be corrected before it accumulates.

**Coverage must be checked at the eave, ridge and at every end lap.**

To avoid accumulation error, the coverage measurement should always be from the rake line or the starting roof panel's seam.

To avoid measurement error, the measuring tape must be free and taut and must be parallel to the eave line or ridge line.

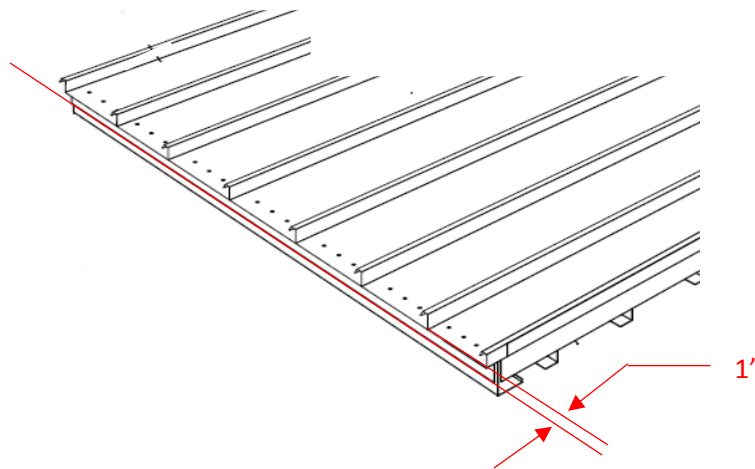
**Improper coverage will cause difficulty in seaming.**

### 13.4 Controlling Panel Width Modularity

#### IMPORTANT NOTE: HAND CRIMPING & MOTORIZED PANEL SEAMING

As the roof installation progresses, it is necessary to hand crimp and/or mechanically seam the previous panel run. Seaming options differ per project. Refer to the erection drawings for specific seaming requirements. Then review the details of the Seaming Manual.

As a **MINIMUM**, the roof **MUST** be hand crimped into a RollLok (TripleLok) seam profile at the low eave, end lap, high eave, and every clip location at the **END** of **EACH** workday. Failure to do so may result in panels coming off of the roof structural due to high winds.



Before the up-slope panel can be installed, the clips at the leading edge of the down-slope panel **MUST** be installed. This **MUST** be done in order so be able to hold panel modularity and so that the end lap detail will assemble correctly.

**NOTE:** At a purlin lap, pre-drill clip fastener locations with 3/16" diameter drill bit – as needed.

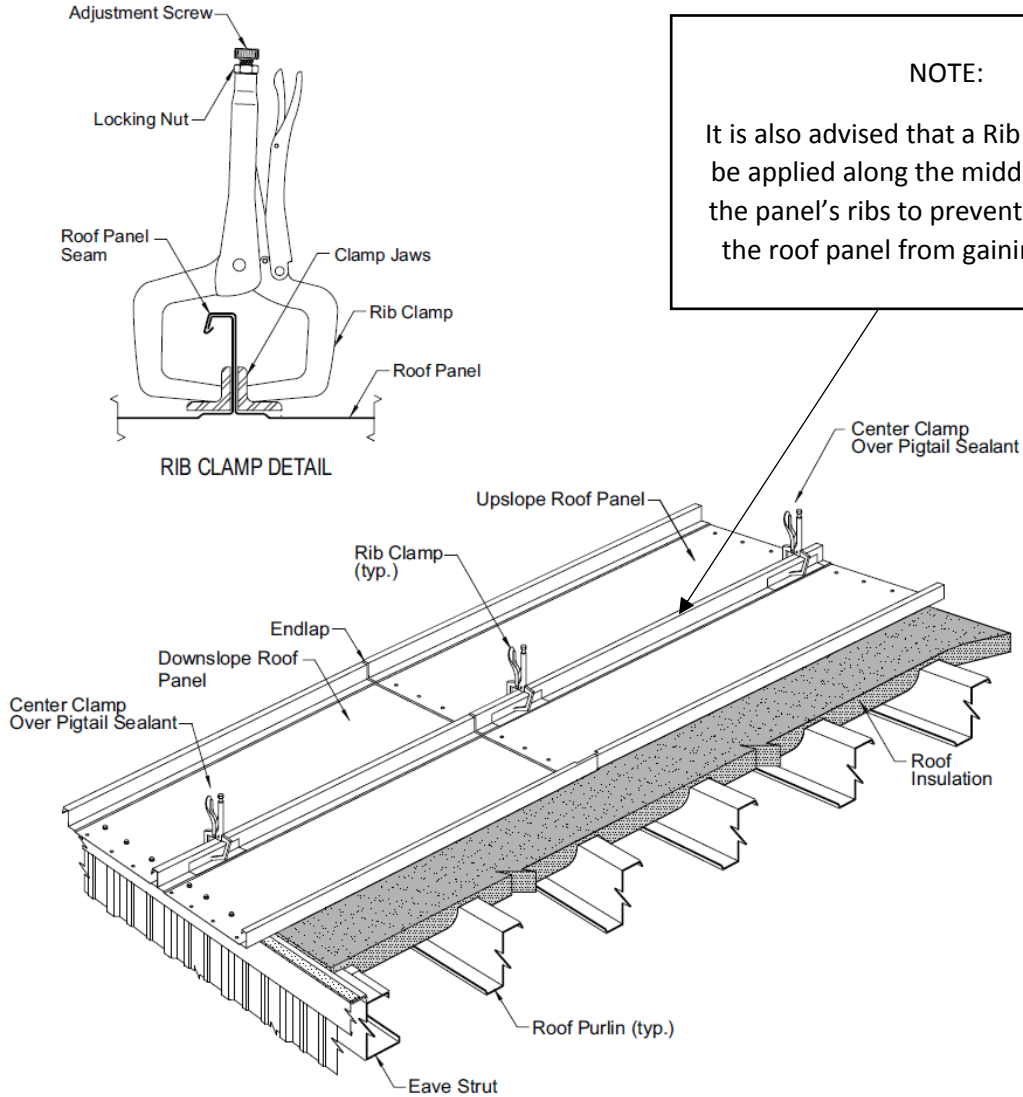
To help hold the correct panel overhang dimension at the eave, install a string line 1-inch past the end of the panels. To do this, clamp a short piece of rake angle to the already installed rake support angle using a pair of vise grips (as shown above). When installing panel runs, measure back the 1" to properly locate the end of the panels.

**Do Not** Use a tape measure to measure against a possible out of align eave strut. This will cause the panel edge to follow.

It is **important** to carefully measure panel coverage and clip locations at this time. Careful measuring and planning at this stage can save a lot of adjusting and re-work later. Once the clips are properly located, make sure that they are installed in a vertical manner and fully engaged into the secondary framing.

### 13.5 Installing Intermediate Panels

#### Controlling Panel Coverage



**NOTE:**  
It is also advised that a Rib Clamp or two be applied along the middle portions of the panel's ribs to prevent the center of the roof panel from gaining coverage.

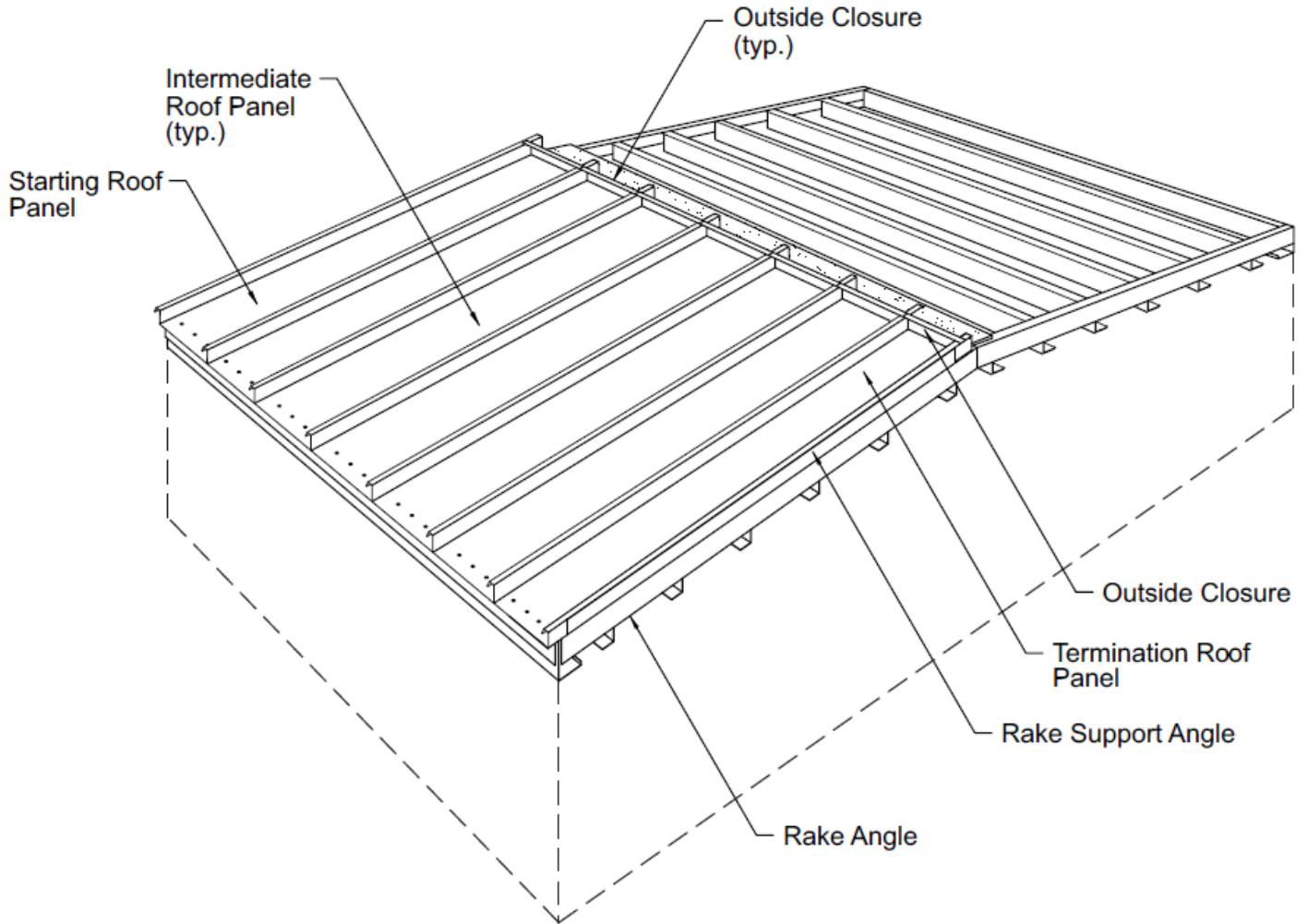
The most common coverage error is the spreading of the roof panel side laps, especially at the panel ends. This can cause excess panel coverage along the eave, end laps and ridge.

Before installing the next run of panel clips, use rib clamps to squeeze together the previous side lap as shown.

The rib clamps can be adjusted and locked so that they will squeeze the panel ribs to provide a consistent coverage width.

If excessive coverage has accumulated over several panel runs, do not try to correct all of the error at one time. Corrected roof panel coverage must not be greater than 1/16" per panel. Correct accumulated coverage error by making the correction over several panel runs. **Continue this sheeting process until the opposite end of the building is reached.** Outside closure should be installed as the sheeting process continues.

## 14.0 Outside Closure Installation



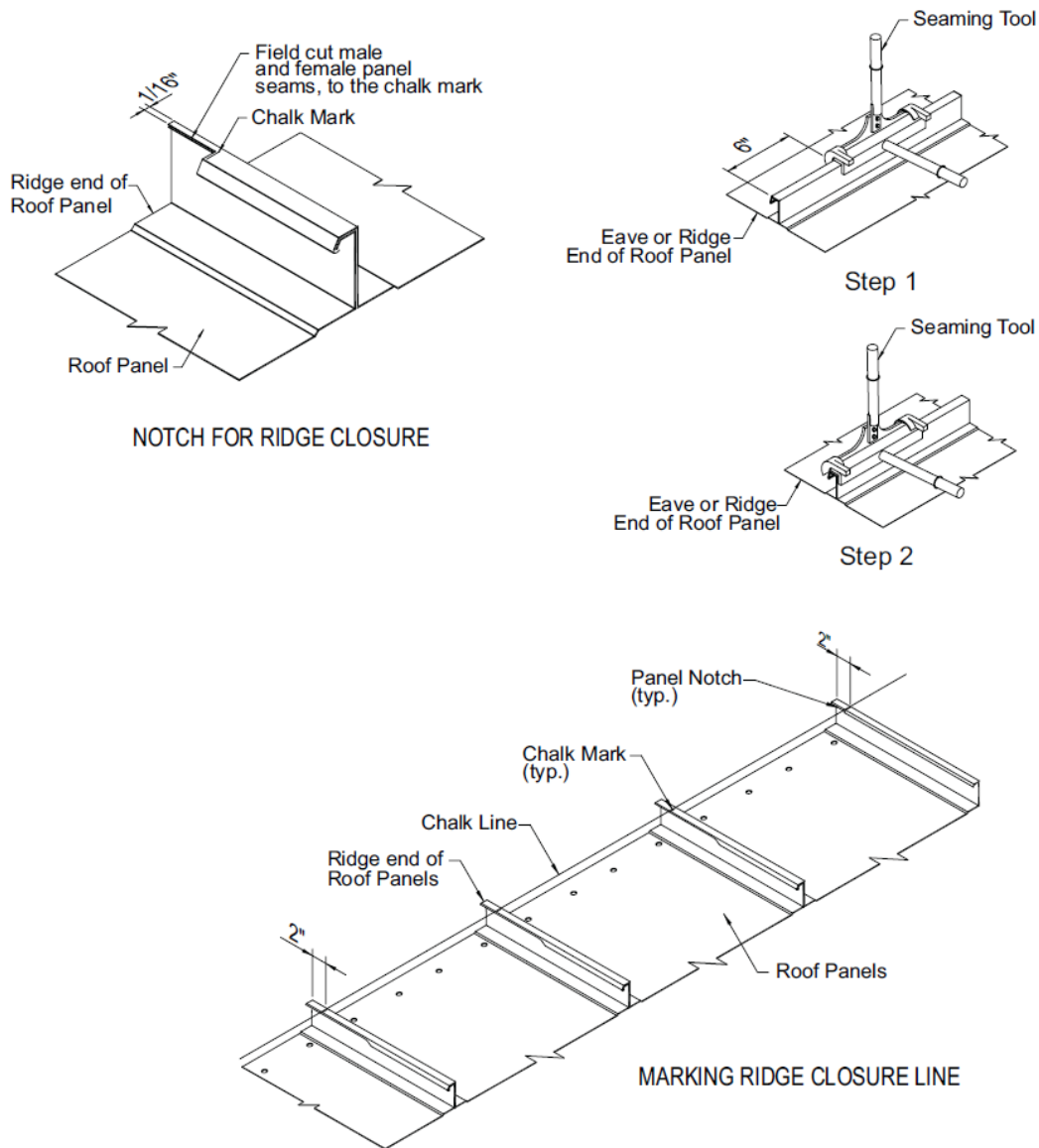
Metal outside closures are used to close the ends of the roof panels at the ridge, high eave and high eave transition conditions.

The details in this section will show roof panel preparation requirements and installation of the outside closures.

**NOTE: It is highly recommended that the outside closures be installed during the installation of the roof panels.**



## 14.1 Outside Closure Installation Preparation



Installation of the outside closures helps maintain the correct roof panel coverage at the ridge. If the outside closures are installed after the roof panels are in place, roof panel coverage error may prevent proper installation of the outside closures.

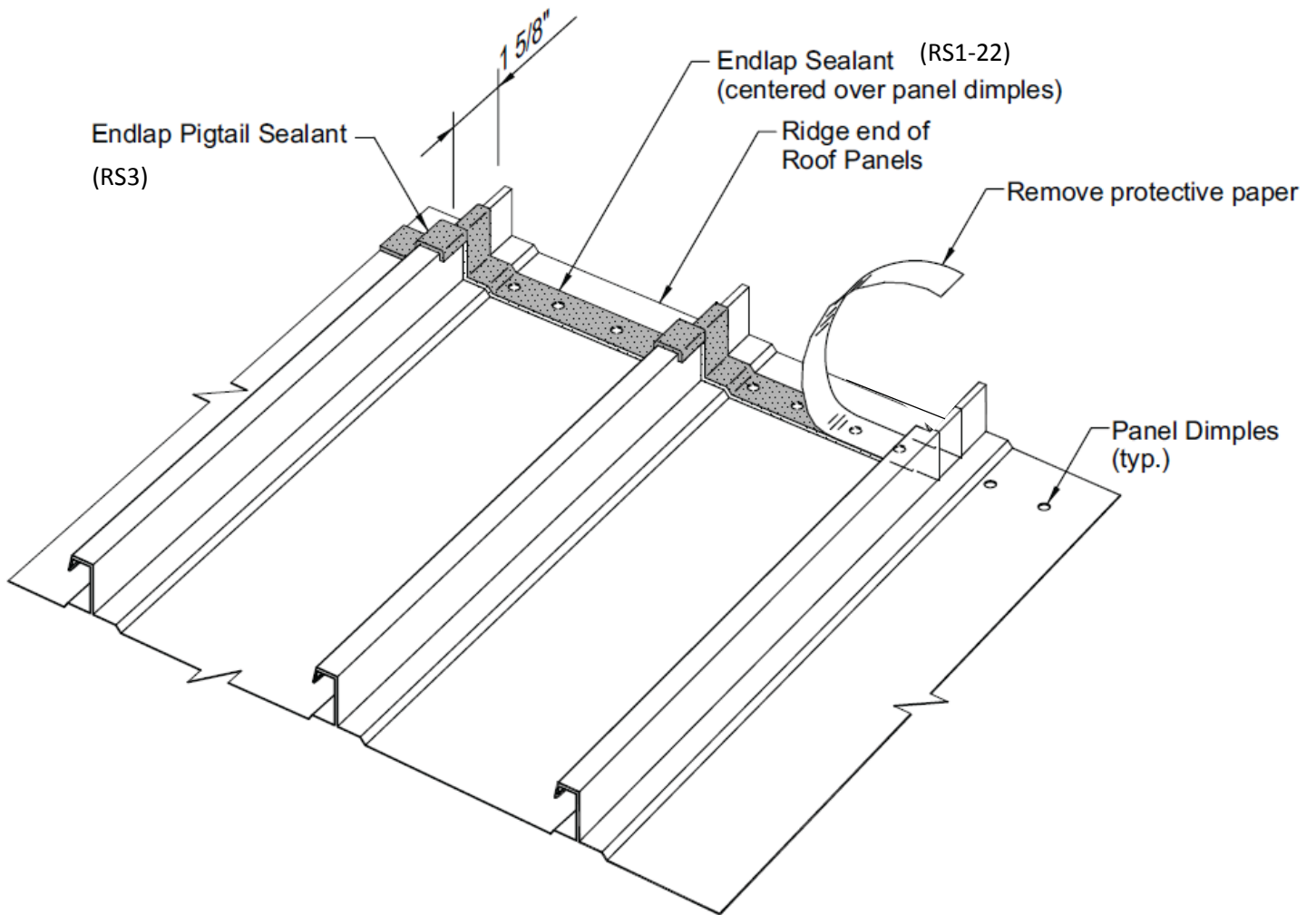
Check the alignment of the roof notches along the ridge. If the notches are staggered more than 1/4", use a chalk line to establish a straight notch line. Position the chalk line so no notch extends below the line.

Using the end of the factory notch (or chalk marks) as a guide, field cut the additional notching in both male and female portions of the seam as shown.

Hand seam 16" of uphill panel end before applying end lap sealant and outside closure to accommodate motor seamer.

**Refer to seaming guide for specific steps to accommodate motor seamer.**

## 14.2 Outside Closure Installation (Applying the sealant tape)



Before installing the end lap sealant, the roof panel's surface must be wiped clean and dry.

Install a pre-cut strip of end lap sealant (RS1-22) along the end of the roof panel as shown.

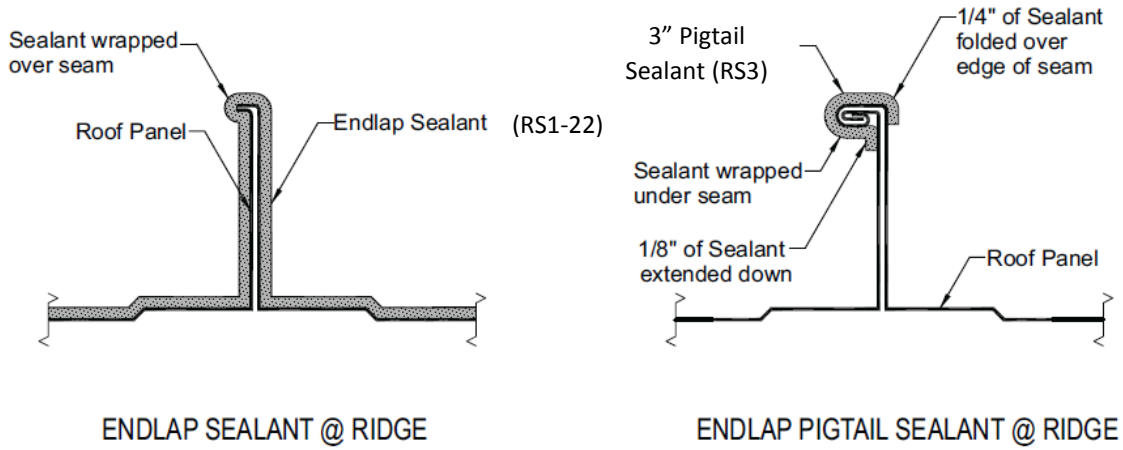
Position the sealant so that its downslope edge is uniformly 2" (edge of notch) from the end of the panel. The sealant must completely cover the roof panel's factory punched dimples (if punched).

Be sure to check that the sealant fully contacts the roof panel's surface and that it is completely fitted into the panel corners and around the seams.

Install the 3-inch long pre-cut pigtail sealant (RS3) as shown.

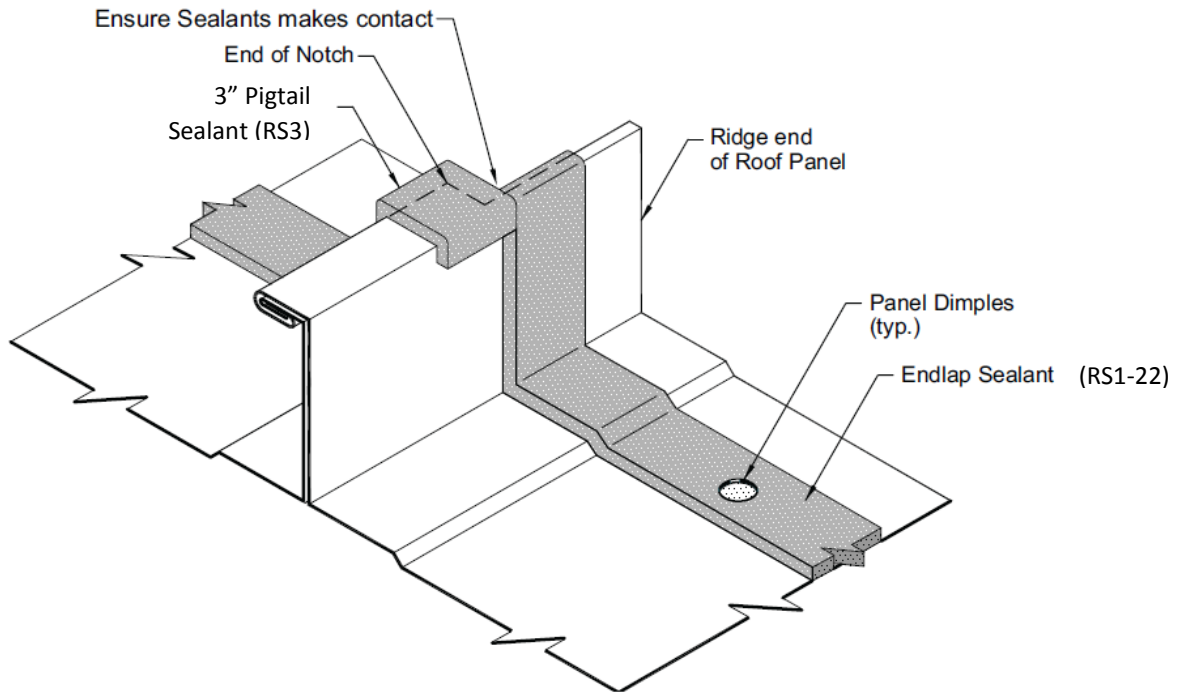
**Specific end lap sealant details are shown on the following page.**

**14.2 Outside Closure Installation**



ENDLAP SEALANT @ RIDGE

ENDLAP PIGTAIL SEALANT @ RIDGE



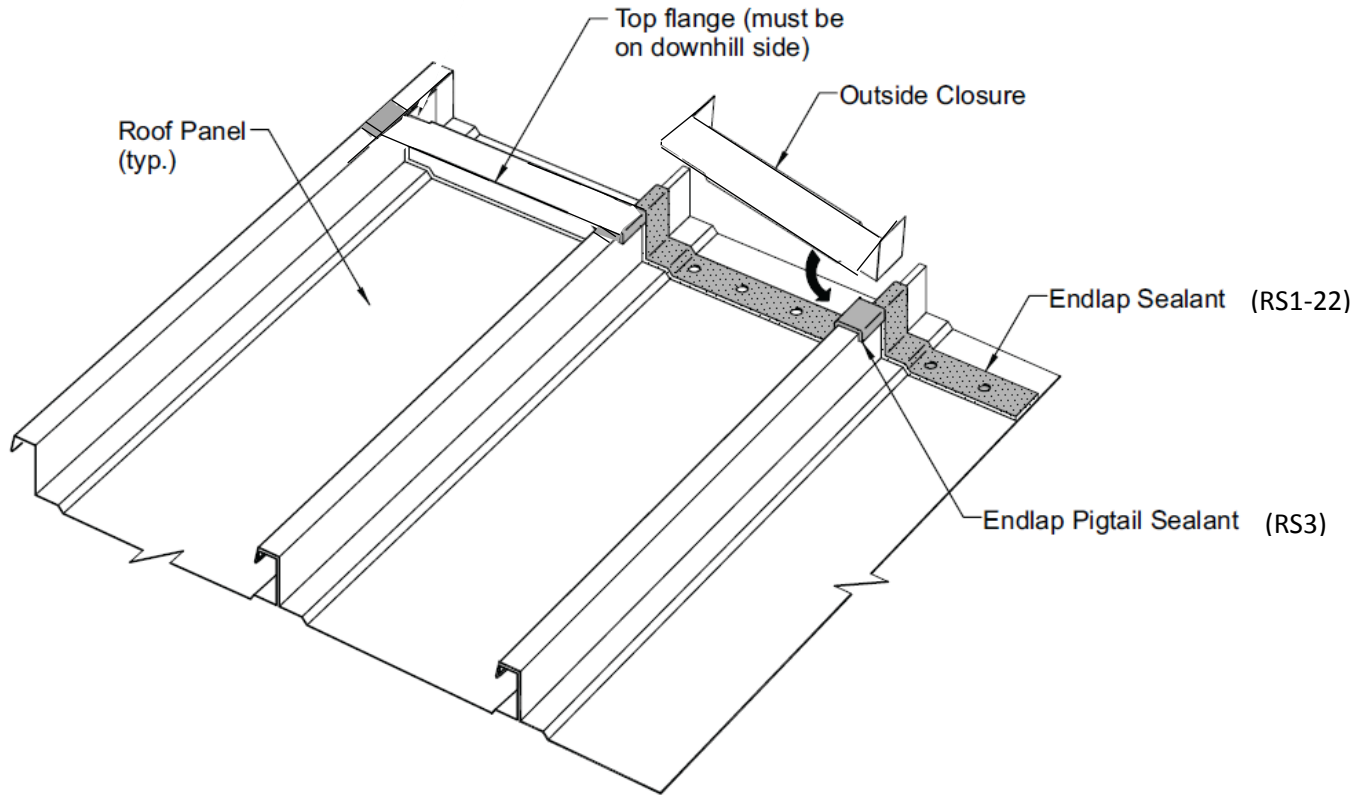
The correct installation of the end lap sealant is critical to the weather resistance of the roof system.

Be sure to verify that the sealant is installed as shown above before installing outside closures.

After the sealant is correctly positioned, uniformly press the sealant against the roof panel's surface to assure adhesion.

Do not use excess pressure which can thin the sealant.

### 14.3 Outside Closure Installation



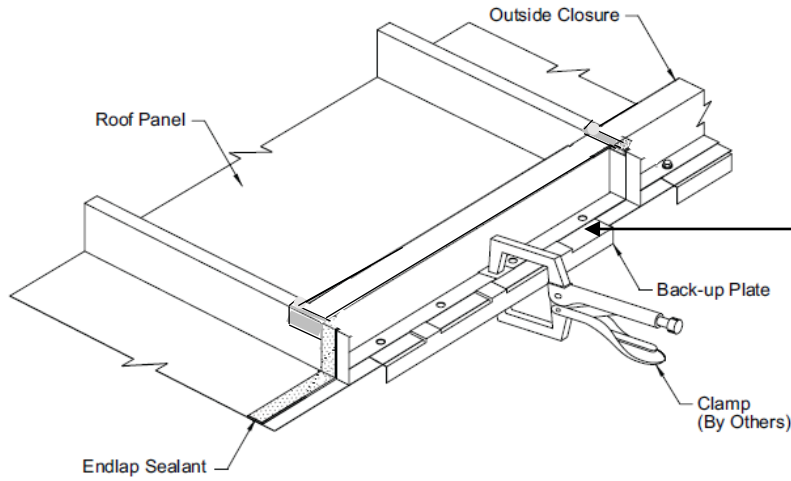
Wipe dry and clean the underside surface of the outside closure flanges.

Position the outside closure so its bottom flange is turned up-slope and its top flange is downslope.

Position the outside closure bottom flange directly over the end lap sealant and align the holes in the outside closure with the factory punched dimples in the roof panel.

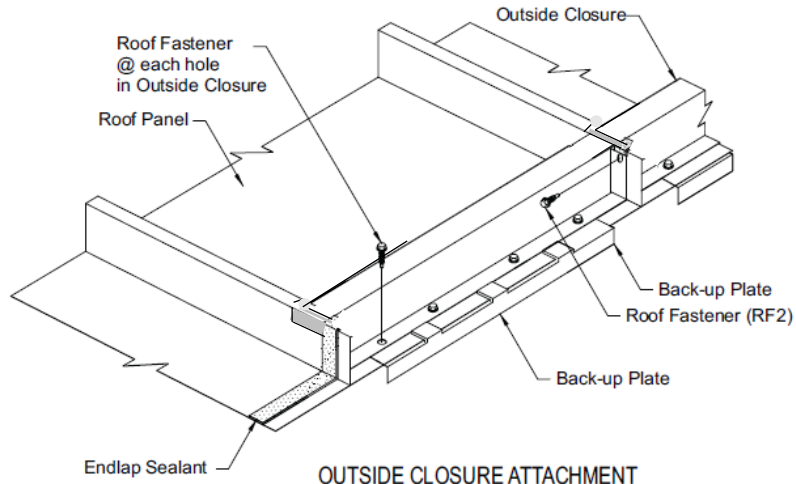
Be careful not to displace or damage the sealant while installing the outside closure and punches.

### 14.3 Outside Closure Installation



**NOTE:**  
 The back upslope edge of the outside closure bottom flange should be against the down slope edge of the back-up plate's tabs. Do not install the outside closure on top of the back-up plate tabs.

OUTSIDE CLOSURE ALIGNMENT



OUTSIDE CLOSURE ATTACHMENT

Uniformly press the outside closure into the ridge sealant to assure adhesion. Use a clamp to hold the assembly together while installing the fasteners.

Install roof fasteners through the holes in the outside closure bottom flange.

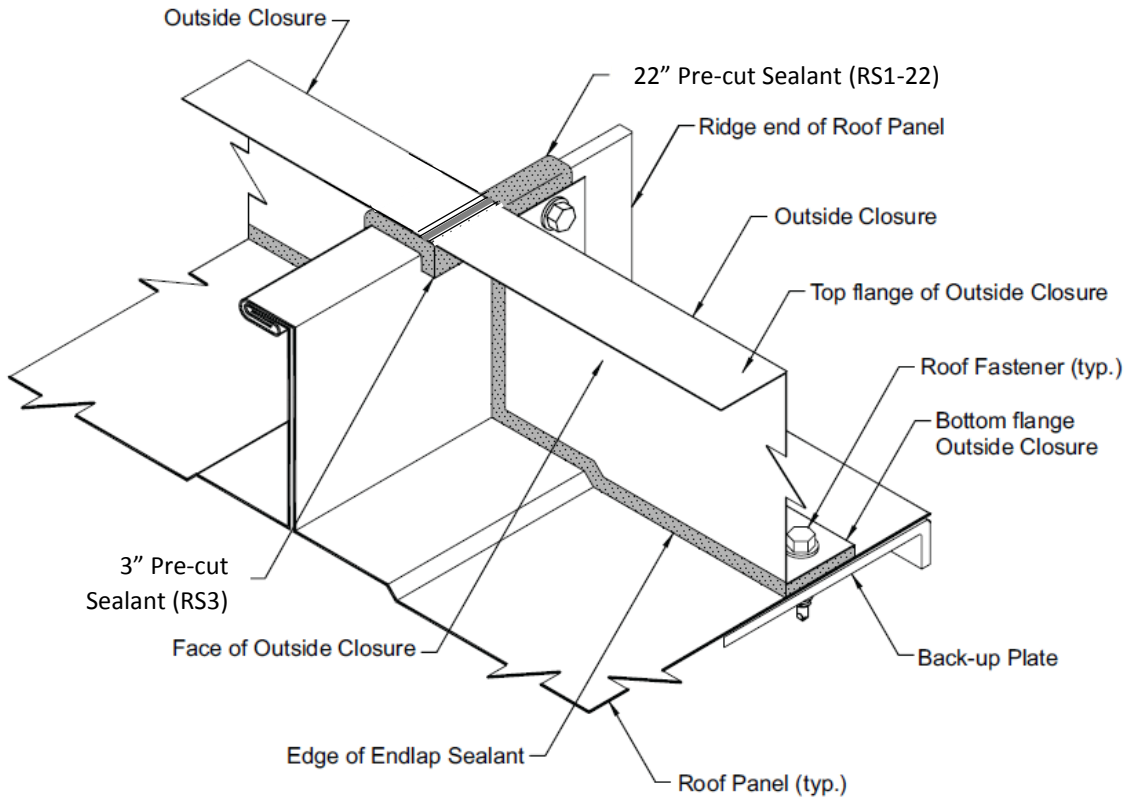
Check that the fasteners penetrate through the center of the end lap sealant and are securely engaged into the back-up plate.

Check that the face of the outside closure is perpendicular to the roof panel and aligned with the previously installed outside closures. If not, push the top of the closure to the correct position.

Install a roof fastener through the top of the end dam, through the roof panel seam and into the opposite outside closure.

**Important: Overtightening this fastener will squeeze the roof panel side lap assembly together and may affect the roof panel's coverage width. Carefully tighten the fastener only as necessary to maintain the correct panel width.**

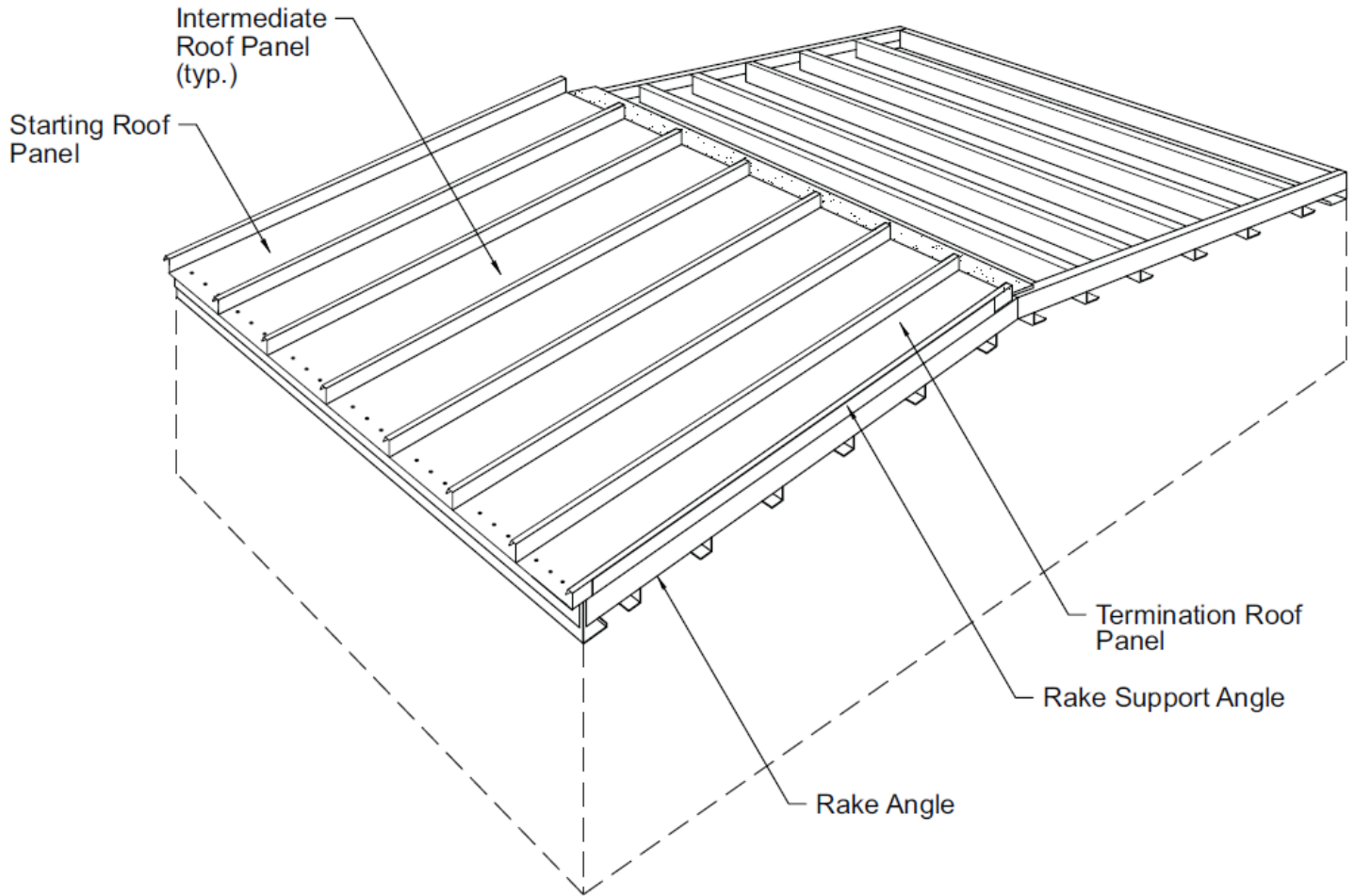
### 14.3 Outside Closure Installation



Verify that the outside closure is correctly assembled as shown.

**Check that there are no un-sealed voids between the roof panel and the outside closure, especially in the critical areas around the roof panel ribs and seams.**

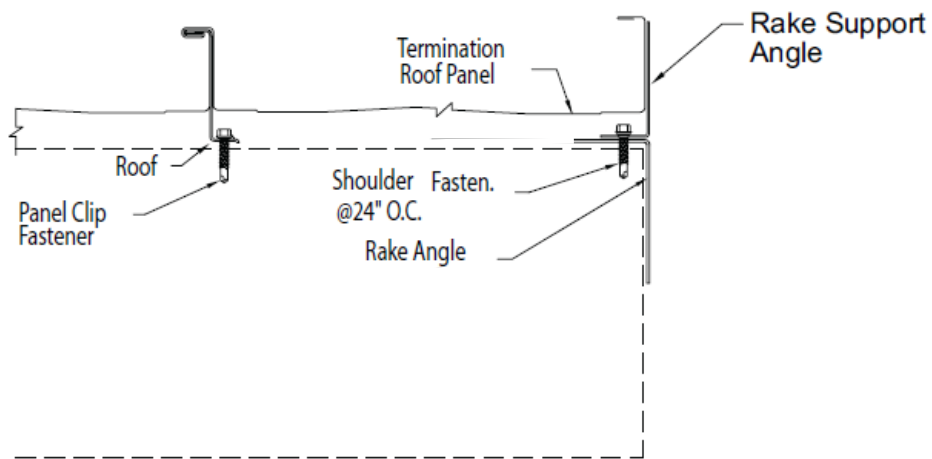
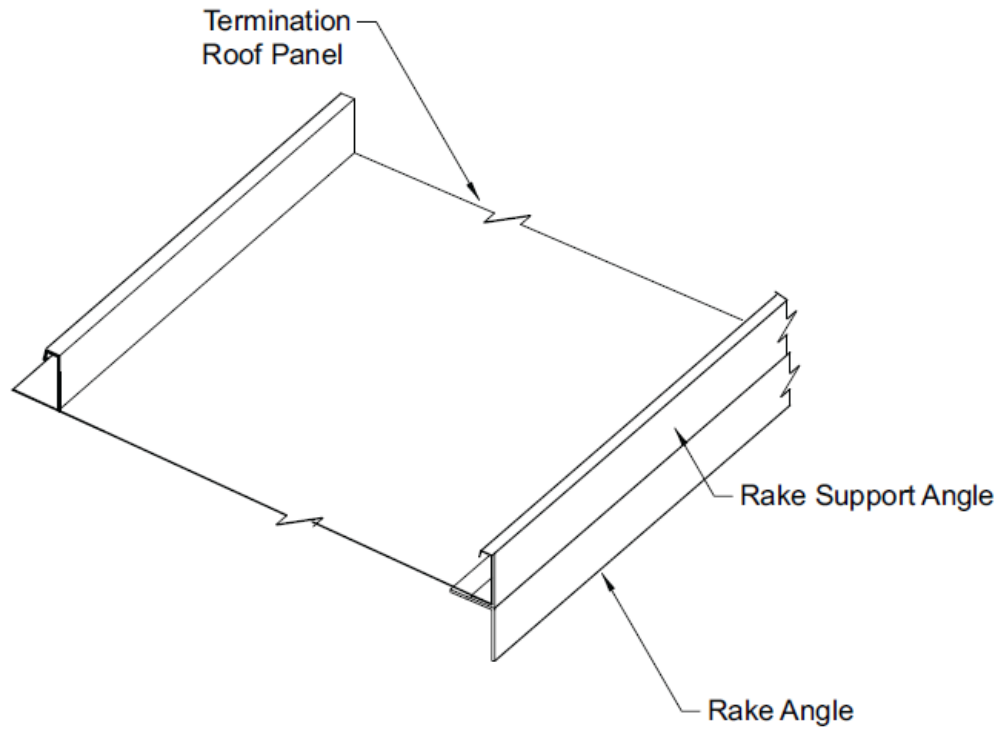
## 15.0 Panel Termination Installation



The details in this section show the installation of the termination roof panel.

The details show the termination roof panel installed at the finish rake. These details will show the termination panel finishing "on Module" and "Off Module".

15.1 Panel Termination Installation (On module)

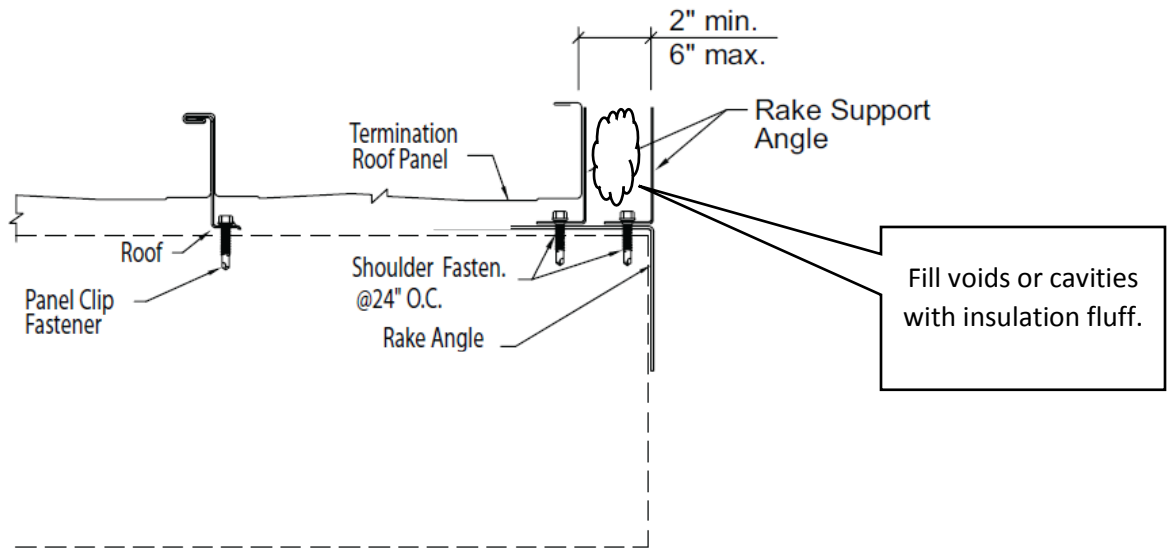
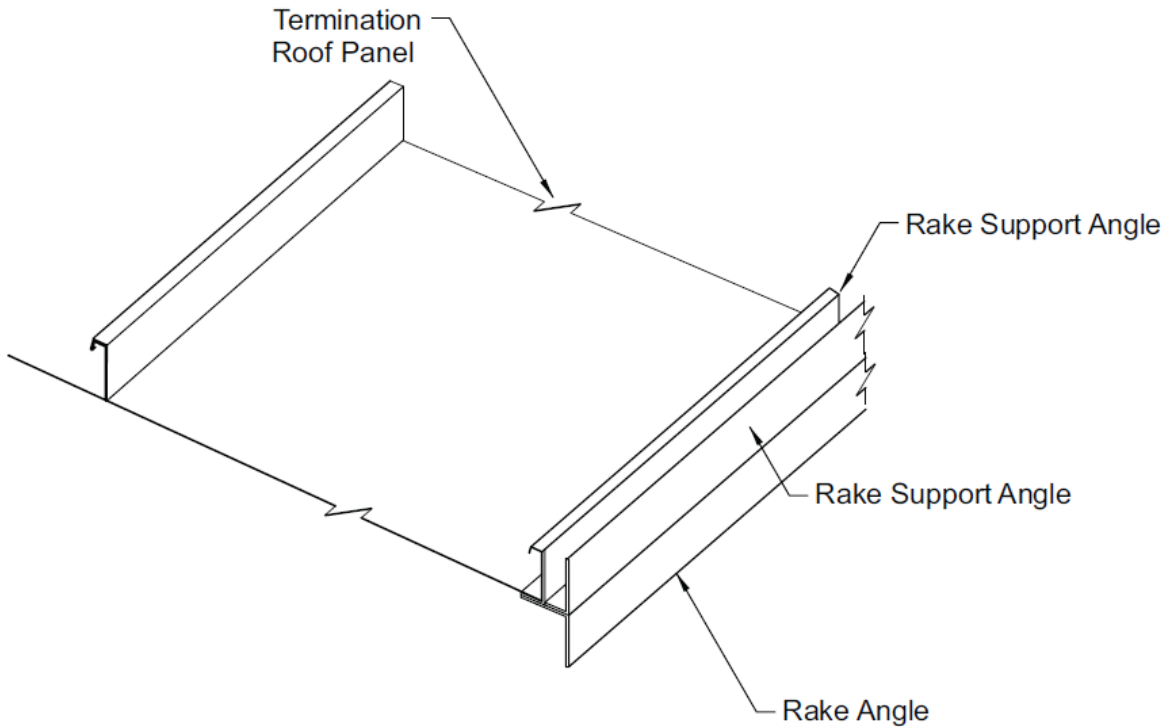


If termination roof panel ends on module at finishing rake, male seam of panel should be against rake support angle.

To prevent damage, secure seam to rake support angle with "C" clamp or temporary fasteners. Panel will not be fastened permanently until rake trim is installed.



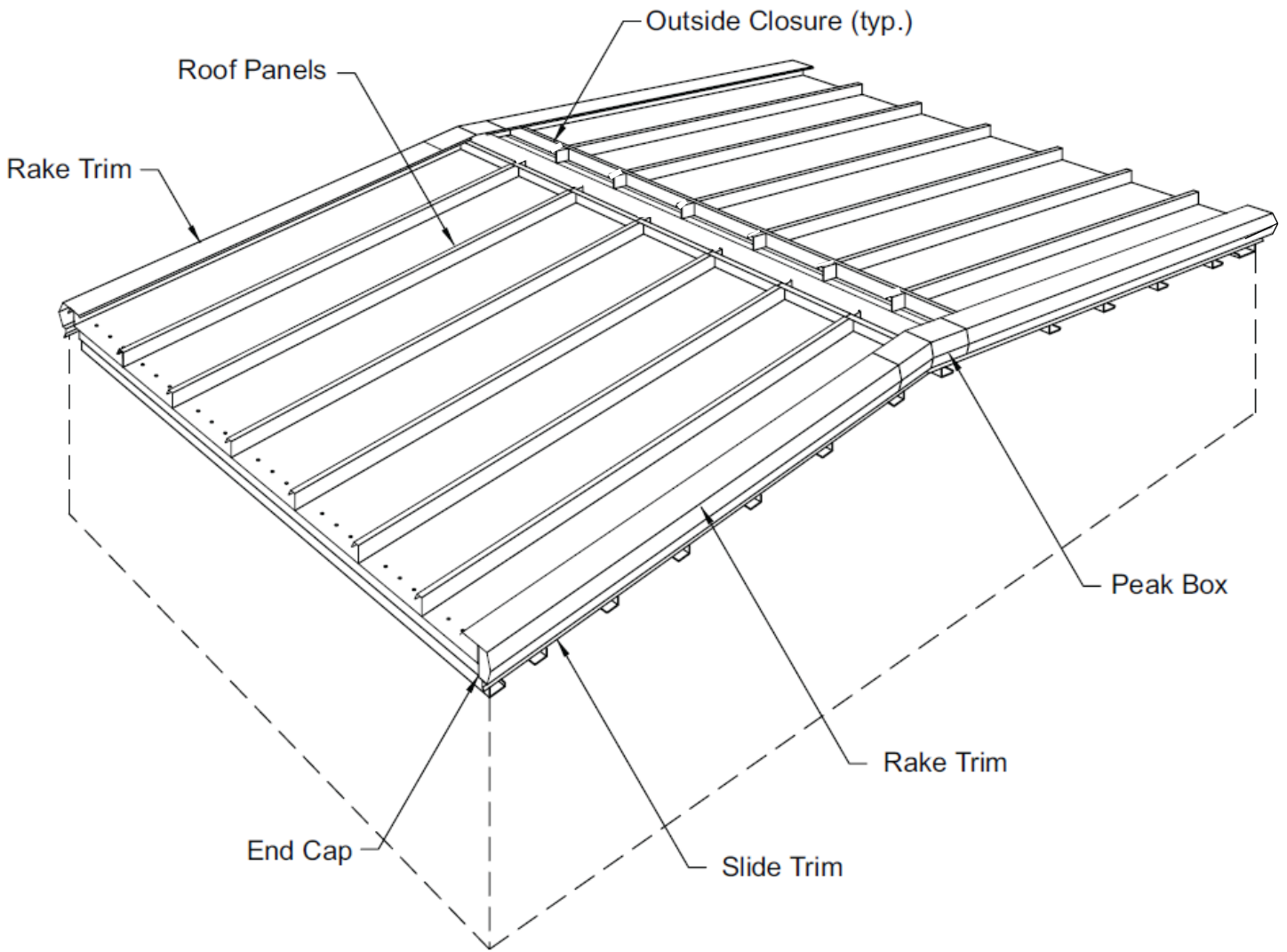
**15.2 Panel Termination Installation (Off module)**



If termination roof panel ends off module at finishing rake, attach additional rake support angle at panel end.

To prevent damage, secure seam to rake support angle with "C" clamp or temporary fasteners. Panel will not be fastened permanently until rake trim is installed.

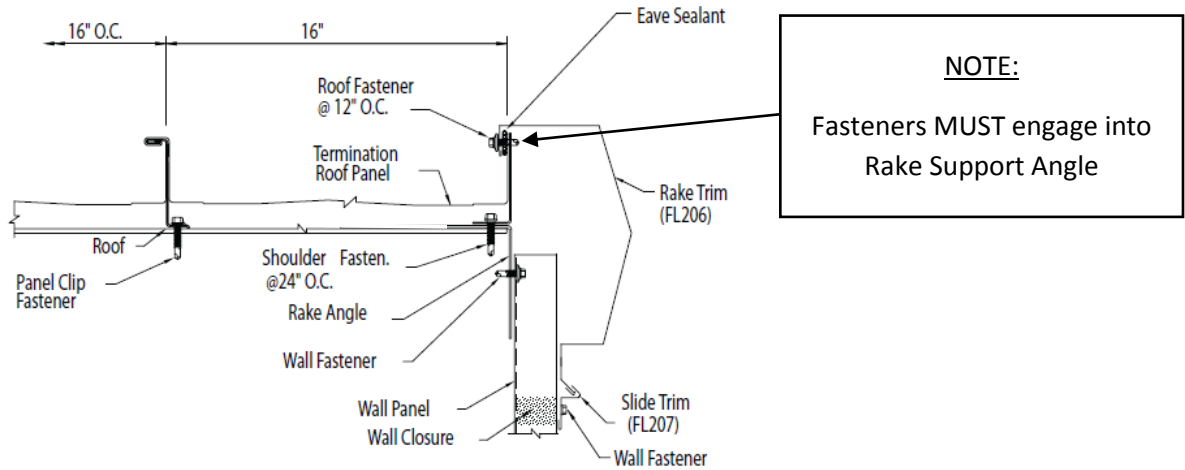
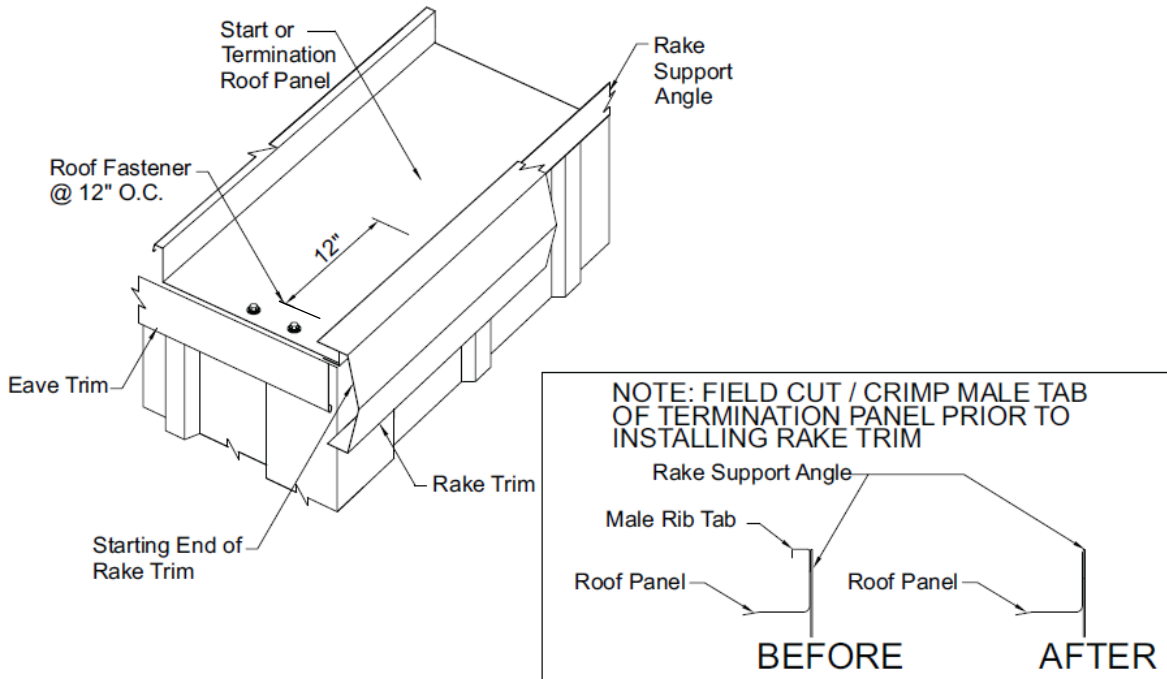
## 16.0 Rake Trim Installation



The details in this section show the installation of the rake trim, peak box and end caps.

These details show the rake trim at a termination roof panel condition. The details at a starting roof panel condition are similar.

**16.1 Rake Trim Installation (On module)**



Install the rake trim from eave to ridge to provide for water-shed at the splices.

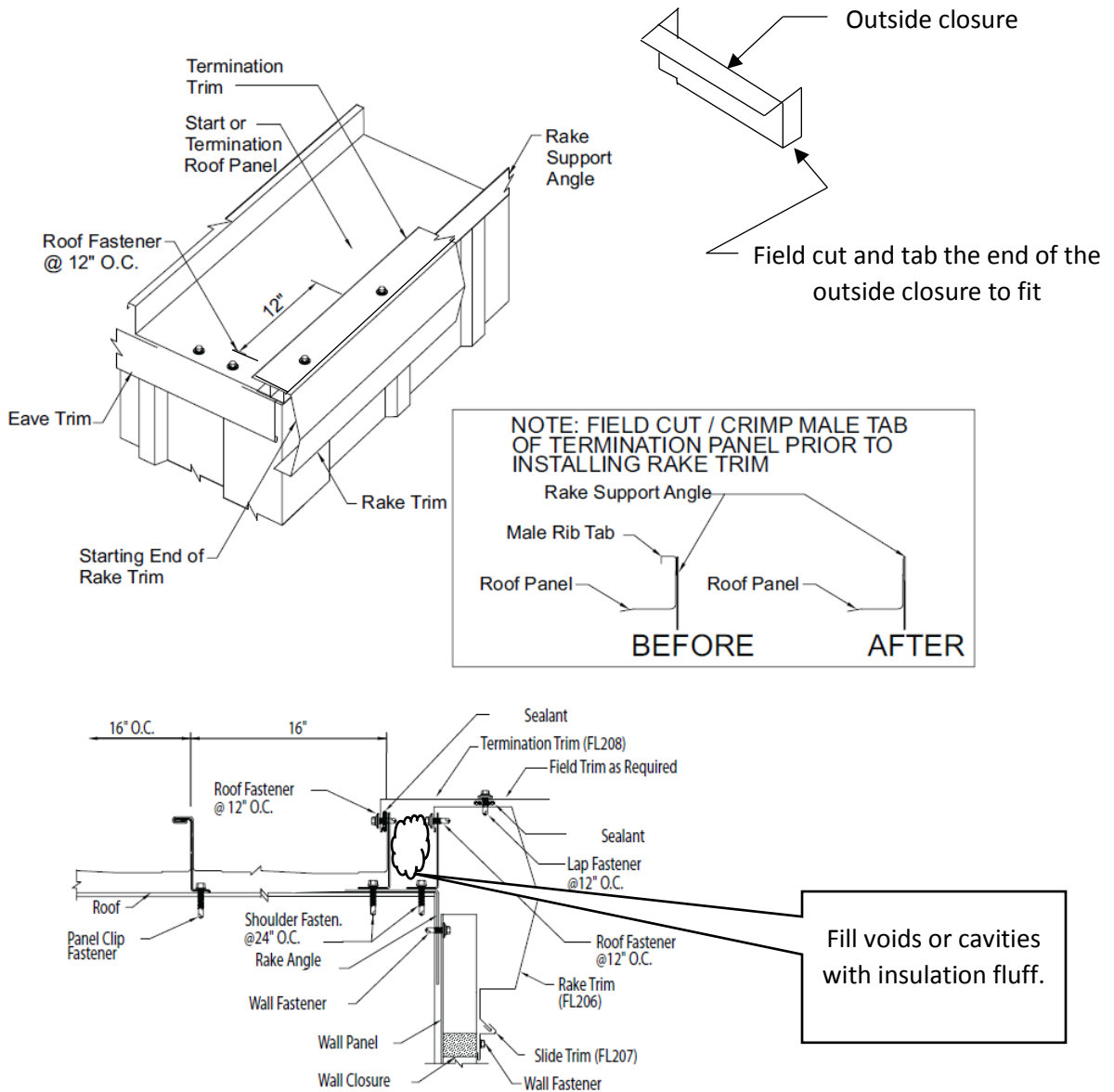
Fasten the rake trim to the roof panel and rake support angle with roof fasteners (RF2) at 12" spacing, as shown.

Install eave sealant continuous along the vertical leg of the roof panel.

Check that the fasteners penetrate the center of the sealant and securely engage the rake support angle.

Check that the rake trim is properly aligned with the face of the wall panel.

**16.2 Rake Trim Installation (Off module)**



Install the rake trim from eave to ridge to provide for water-shed at the splices.

Install eave sealant continuous along the vertical leg of the roof panel.

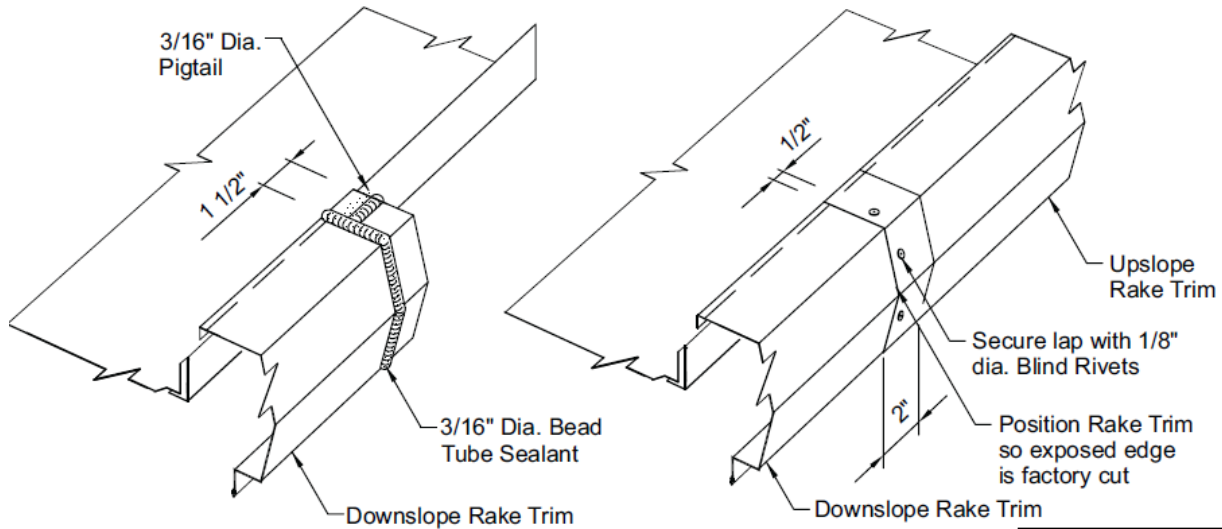
Check that the rake trim is properly aligned with the face of the wall panel.

Fasten the rake trim to the roof panel with roof fasteners (RF2) at 12" spacing, as shown. Attach termination trim as shown, using sealant and fastener (RF3).

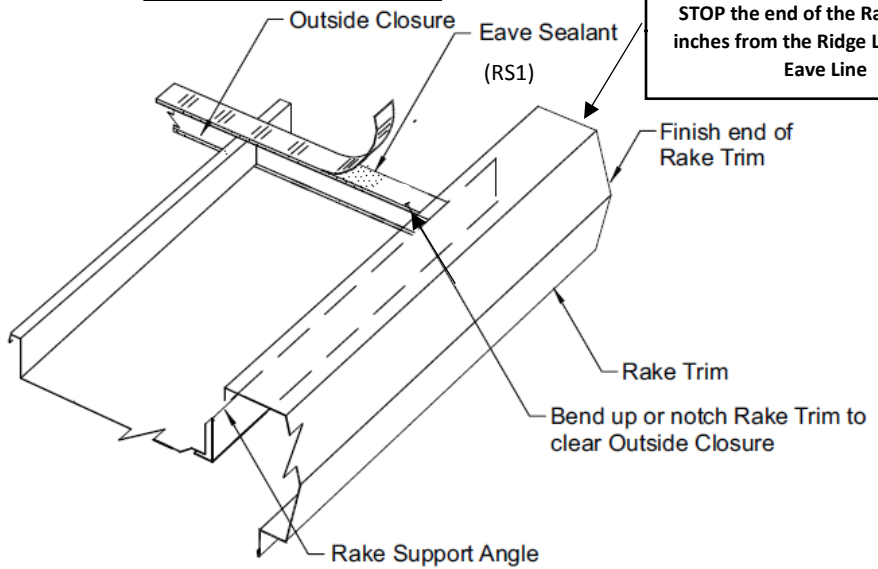
Check that the fasteners penetrate the center of the sealant and securely engage the rake support angle and rake trim.

Field cut termination trim as required as rake.

**16.3 Rake Trim Installation**



**RAKE TRIM SPLICE**



**NOTE:**  
STOP the end of the Rake Trim 2- inches from the Ridge Line or High Eave Line

**RAKE TRIM @ RIDGE**

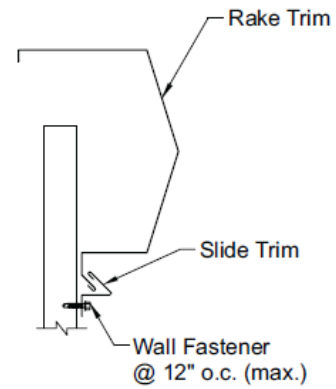
Assemble rake trim splices with tube sealant and rivets as shown.

At the ridge, field cut the uphill end of the rake trim 2" back from the center line of the ridge.

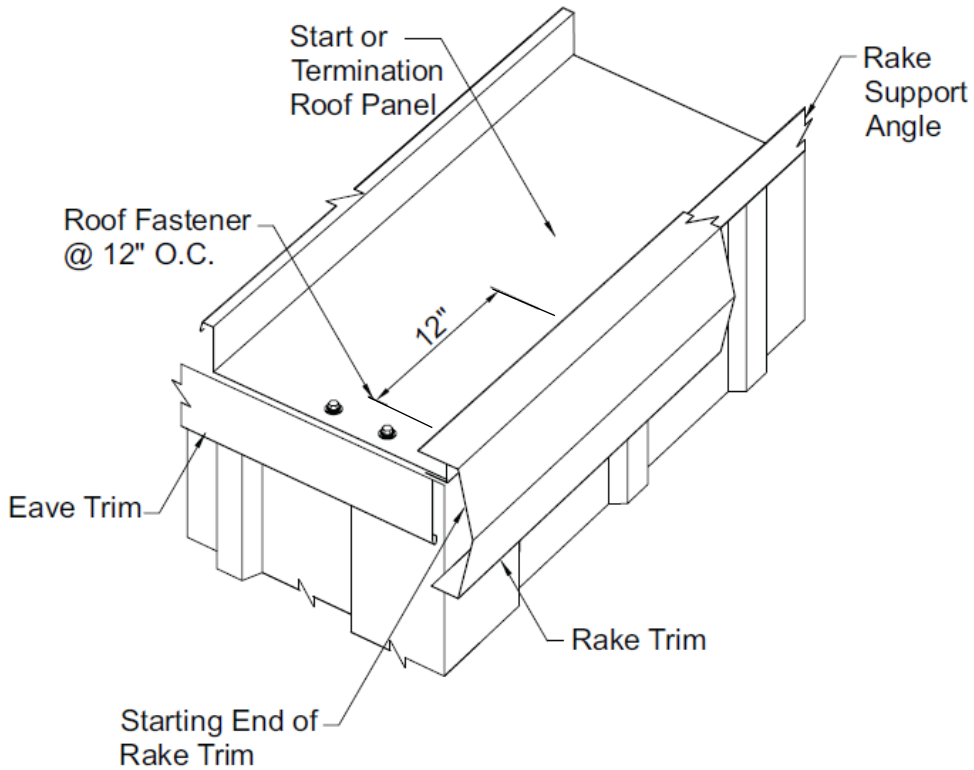
Bend or notch the rake trim's lip to clear the top flange of the outside closure.

At a high eave transition, field cut the end of the rake trim as required for a weathertight joint with the adjacent construction.

## 16.4 Rake Trim Installation (Slide trim)



SLIDING ATTACHMENT



The bottom edge of the rake trim must be secured with the slide trim to allow for expansion/contraction.

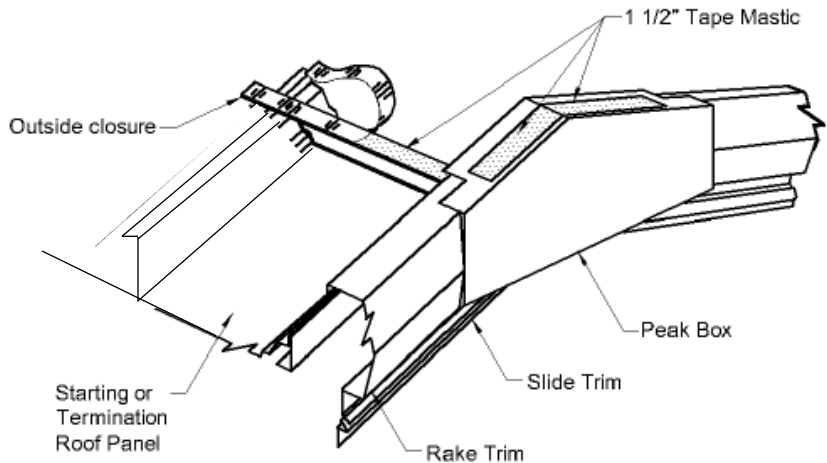
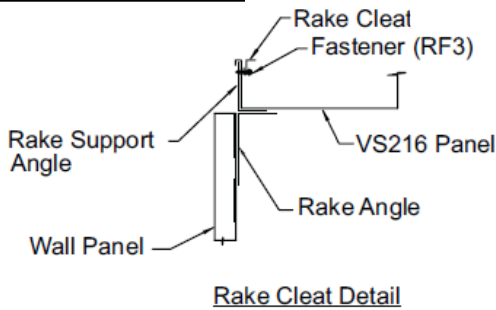
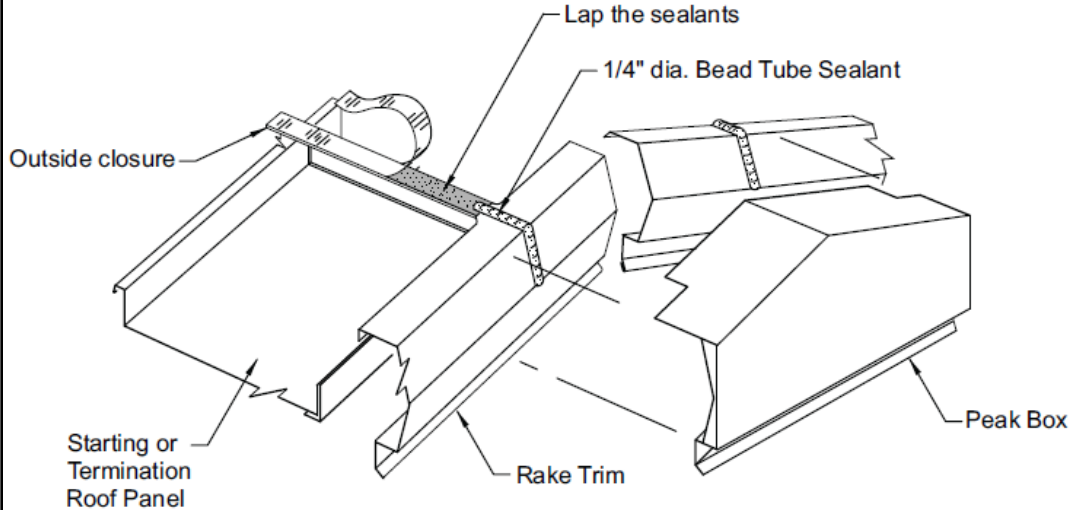
Install the slide trim continuous along the bottom edge of the rake trim as shown.

In all cases, the bottom edge of the rake trim must be installed straight and parallel to the roof line. Use a chalk line to guide the alignment of the rake trim's bottom edge.

16.5 Rake Trim Installation (Peak box)

NOTE: Insure that the rake support angle and the rake trim remain 2-inches down-slope of the ridge to allow for thermal movement.

Stop the Rake Support Angle and Rake Trim 2" either side of the ridge



Apply a continuous bead of tube caulk on the underside of the peak box where it comes in contact with the rake trims. Apply tube caulk to any gaps on the underside of the peak box in the mitered area.

After the peak box is in place, extend the 1 1/2" tape mastic from the outside closures to the sloped face to the rake trim. Next, install short pieces of 1 1/2" tape mastic to the flat portion of the ridge cap.

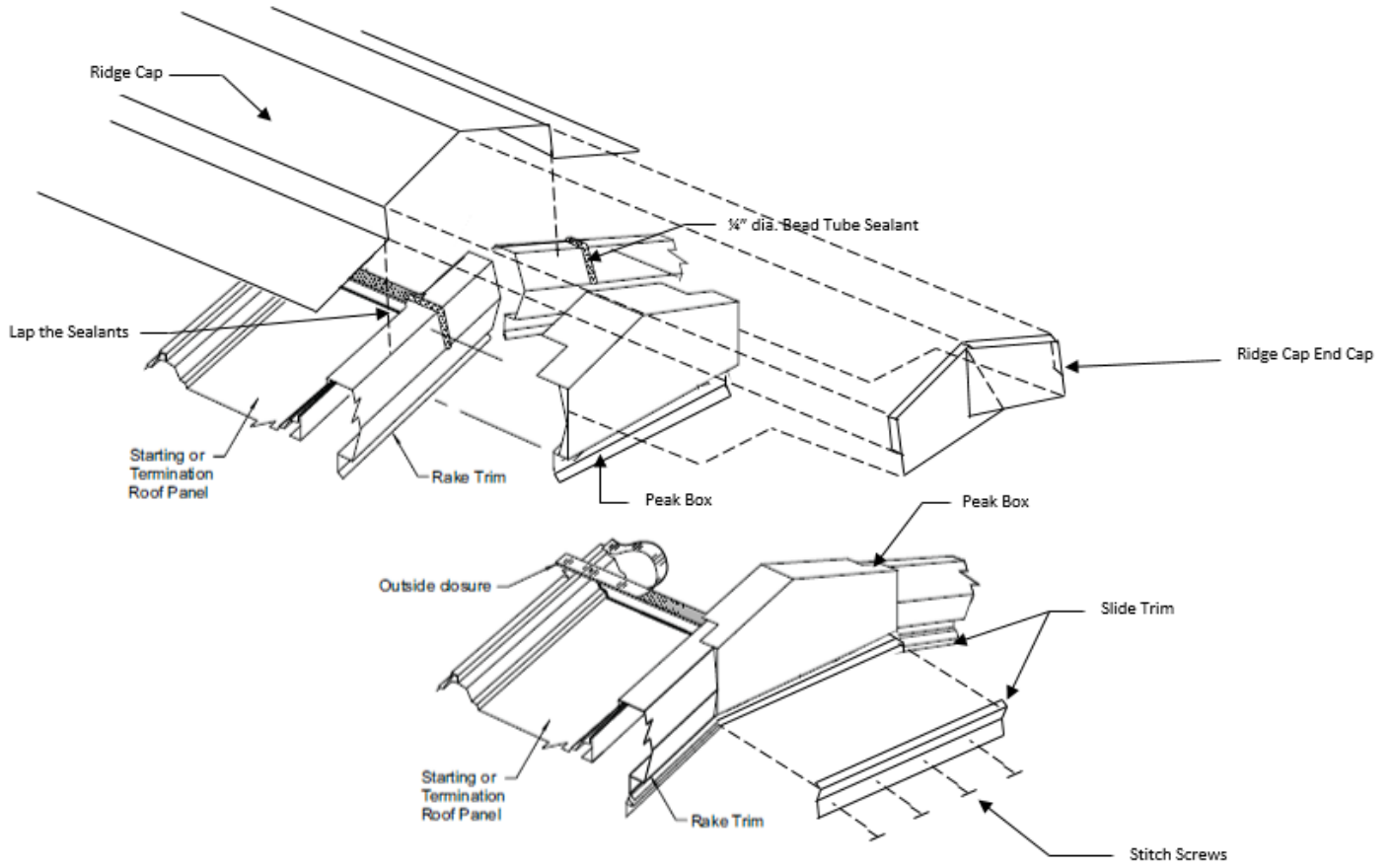
Center the prepared peak box over the ridge. Once centered, push the peak box down and over the rake trims. Make sure the back lip of the peak box is between the outside closures and the rake trim. Insure that there is a 2-inch space between the lip of the peak box and the closures to allow for thermal movement.

**DO NOT PLACE ANY FASTENERS IN THE PEAK BOX.** Doing so will not allow the rake trim to "float" with the expansion and contraction of the roof system. The peak box is held in place along the bottom by the slide trim and held in place along the top by the endcap.

Finish installing the slide trim over the bottom of the peak box. Install a continuous 1 1/2" tape mastic along the top of the outside closures on both sides of the ridge. Remove the paper backing ONLY as work progresses.

**FIELD CUT THE RAKE TRIM TWO INCHES (2") FROM THE RIDGE LINE OR HIGH EAVE LINE TO ALLOW FOR THERMAL MOVEMENT.**

### 16.5 Rake Trim Installation (Peak box)



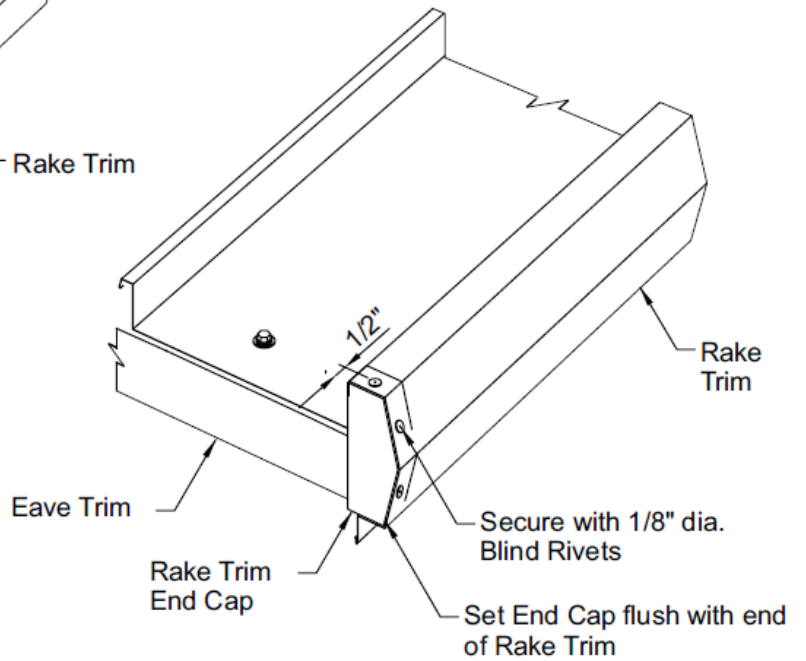
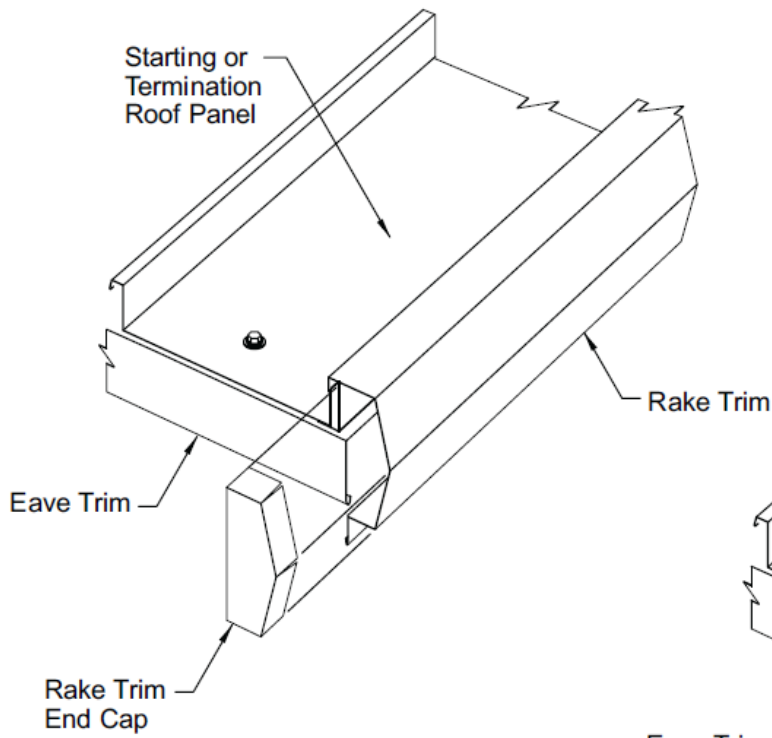


16.6 Rake Trim Installation (End cap)

**NOTE**  
Rake Trim End Cap is not required when eave has Eave Gutter or Eave Box Trim



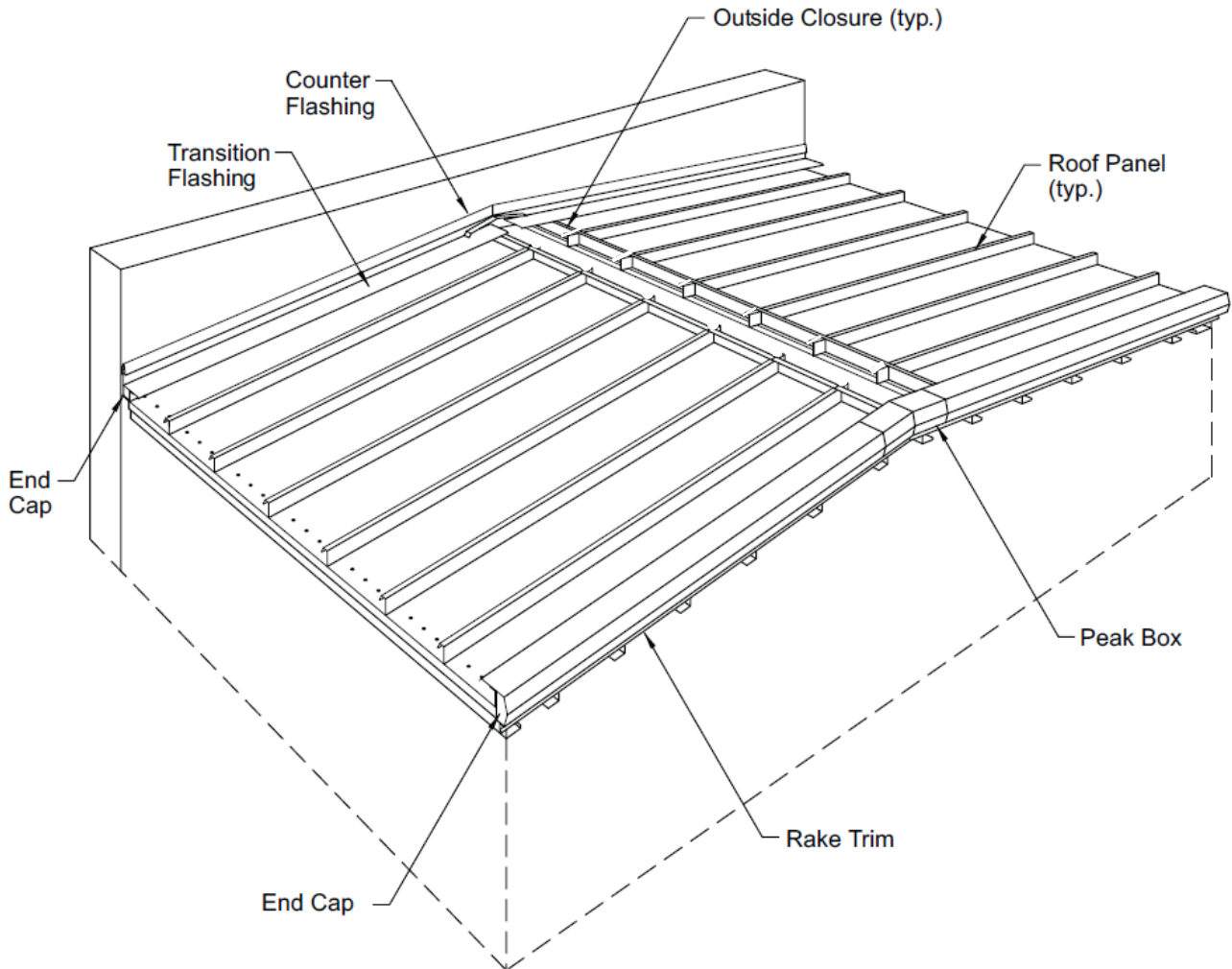
END CAP DETAIL



The rake trim end cap is only required for roof applications without eave gutter.

Install the end cap with tube sealant and rivets in the same manner as a splice.

## 16.7 Rake Transition Trim Installation



Note: Parapets or existing buildings should extend 1'-0" minimum above roof panels.

The details in this section show the installation of the rake transition flashing.

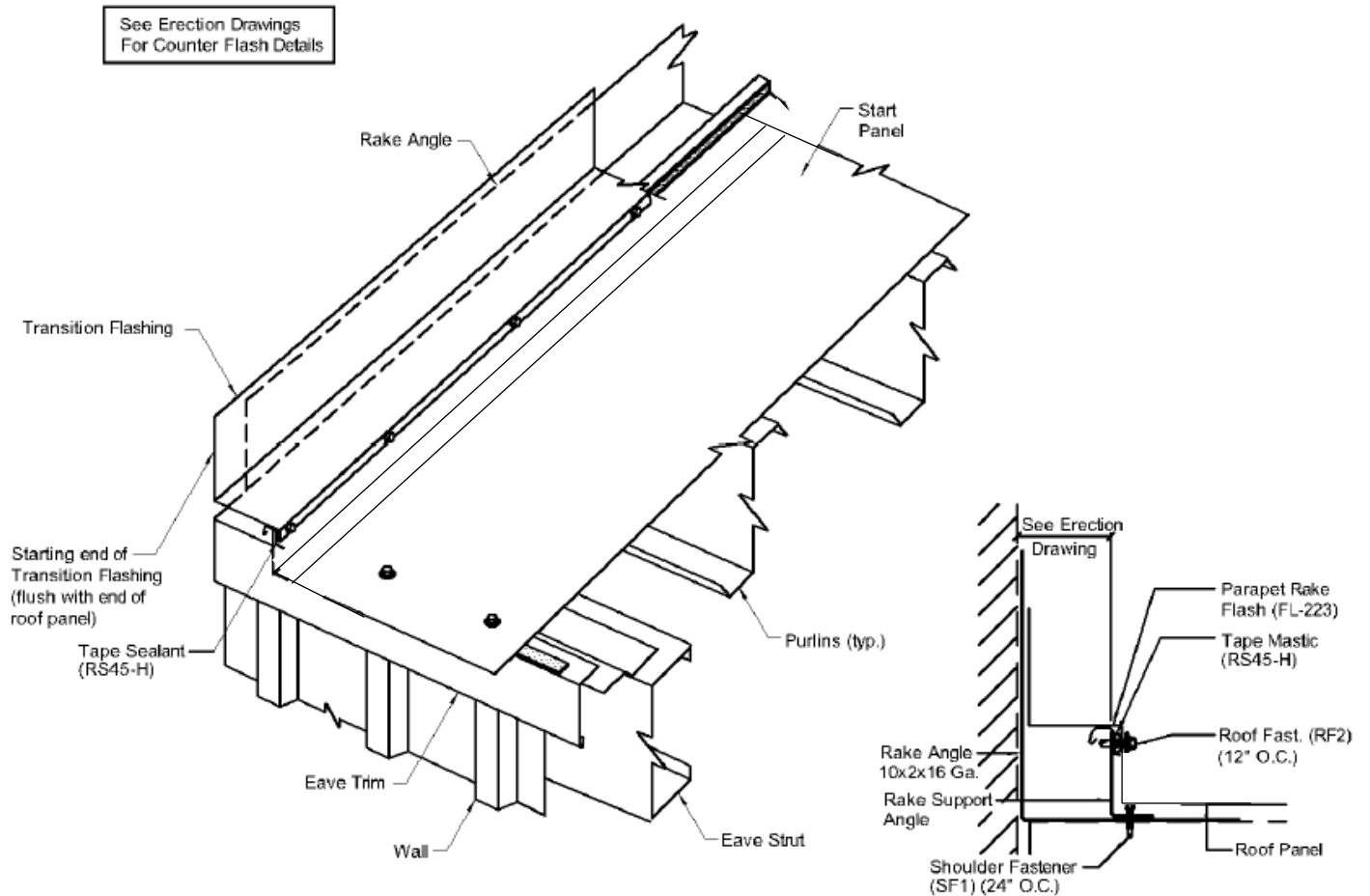
Counter flashing details are not shown. Refer to the erection drawings for the required counter flashing.

In all cases, verify that counter flashing will:

1. Allow expansion/contraction of the transition flashing.
2. Restrain the transition flashing during roof live loads and wind loads.

3. Provide a weather resistant seal between the transition flashing and the wall.

### 16.7 Rake Transition Trim Installation (w/o Rake Angle Cleat)



Install the rake parapet transition flashing from eave to ridge to provide for watershed at the splices.

Apply tape mastic (3/32" X 1/2") (RS45-H) between the panel and back of the rake parapet transition flashing.

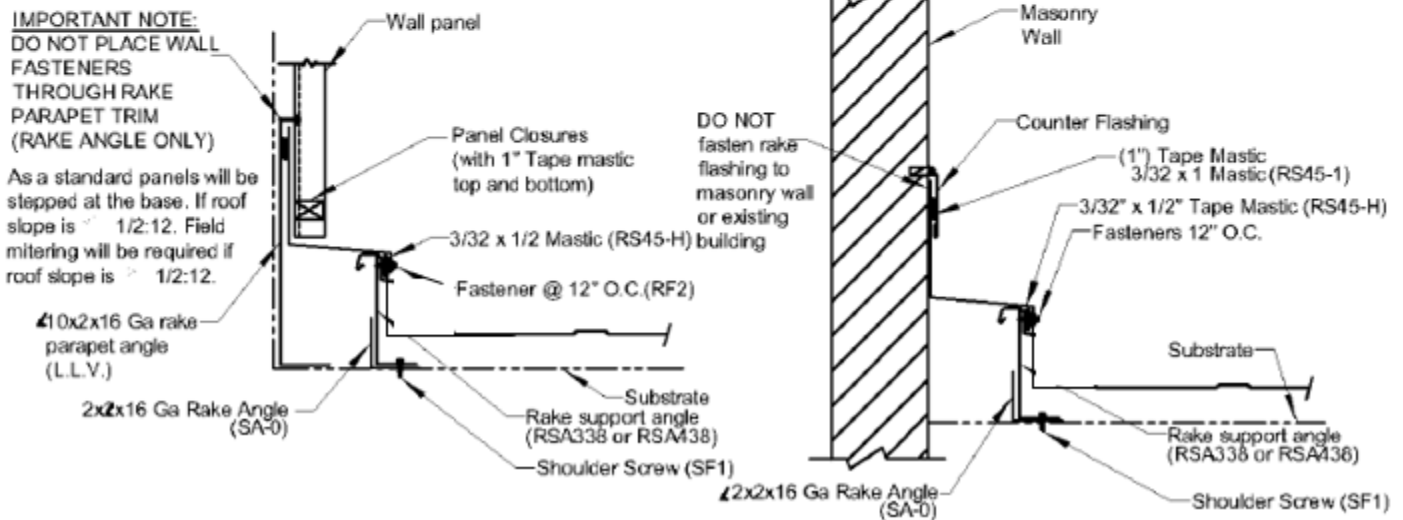
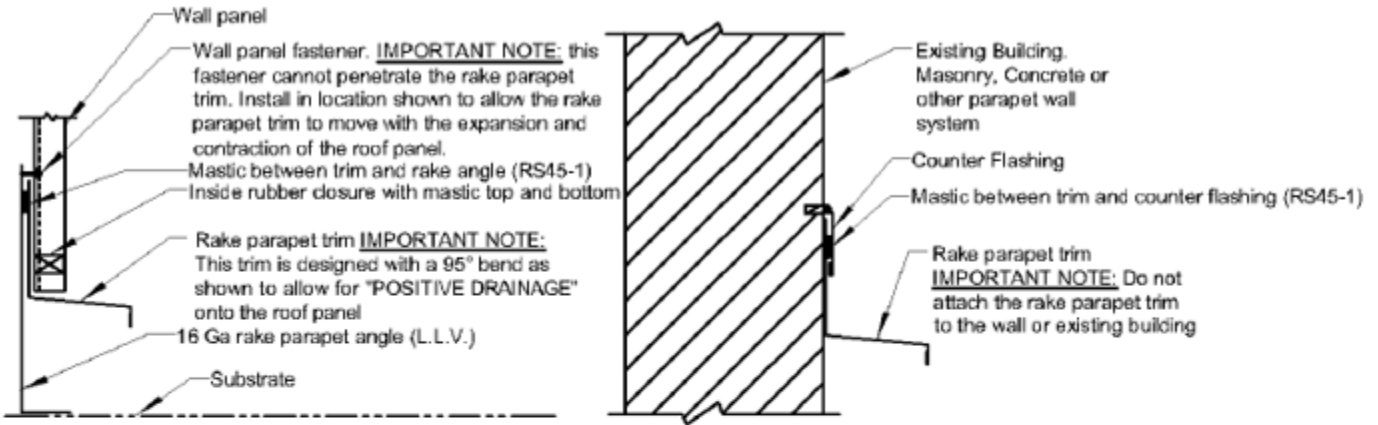
Start the down-slope end of the flashing flush with the end of the roof panel and position the back leg flush with the rake angle or wall construction.

Check that the flashing is set at a positive pitch to assure a watershed affect.

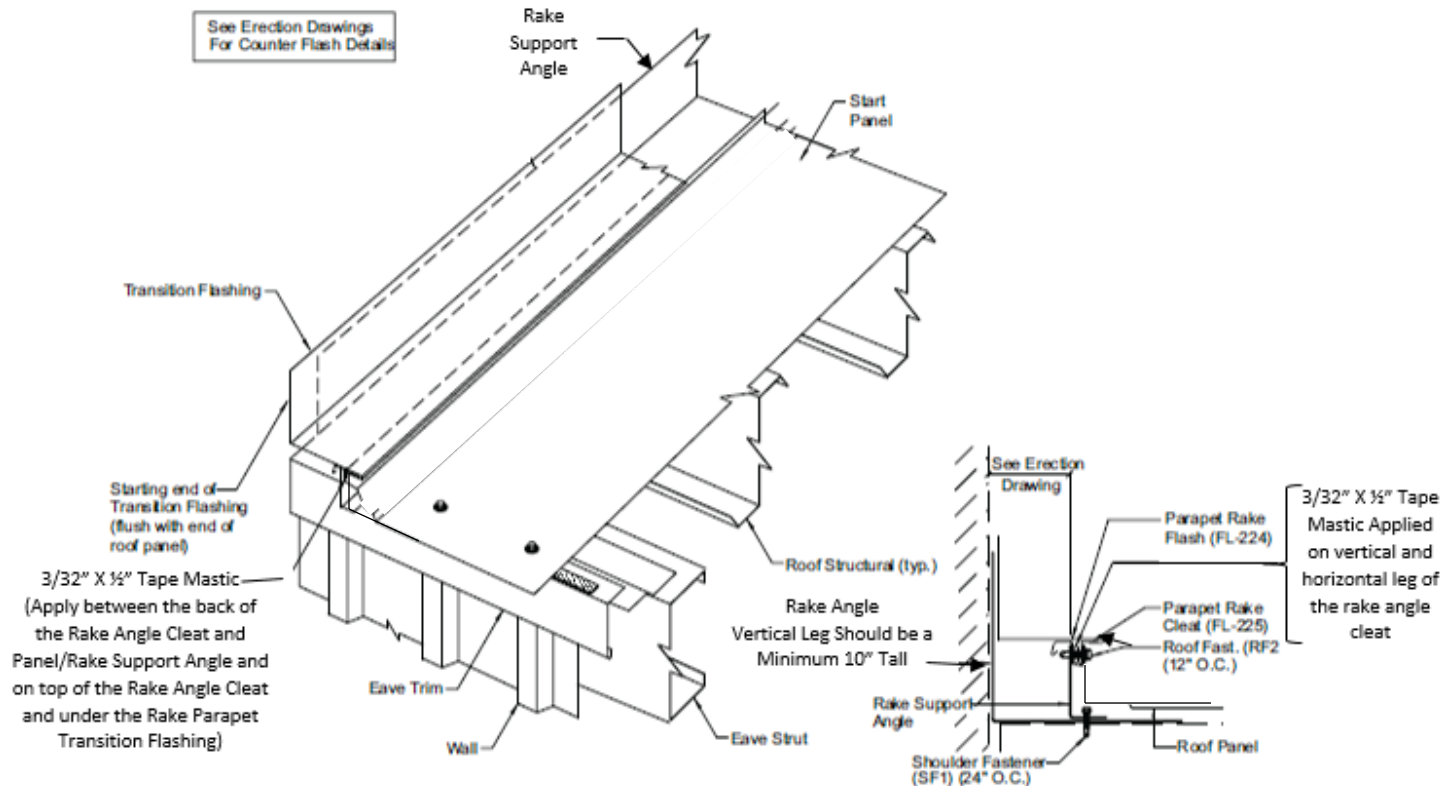
Check that the fasteners penetrate the center of the tape mastic and legs of the rake parapet transition flashing and are fully engaged.

See the following details for a closer look.

16.7 Rake Transition Trim Installation (w/o Rake Angle Cleat)



## 16.7 Rake Transition Trim Installation (with Rake Angle Cleat)



Install the rake parapet transition flashing from eave to ridge to provide for watershed at the splices.

Apply tape mastic (3/32" X 1/2") between the panel and back of the rake angle cleat.

Apply tape mastic (3/32" X 1/2") on top of the rake angle cleat between the rake parapet transition flashing and top of the rake angle cleat.

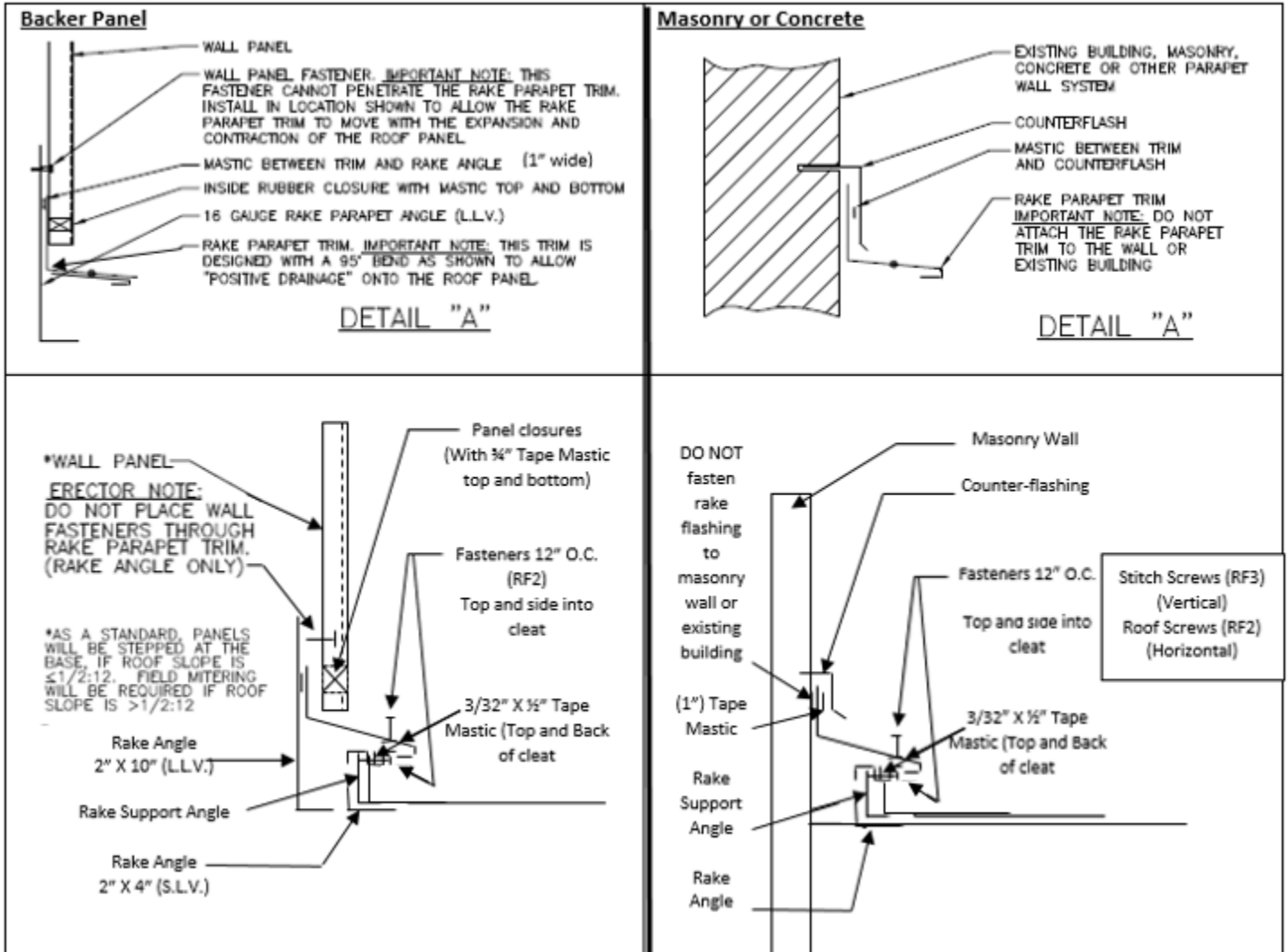
Start the down-slope end of the flashing flush with the end of the roof panel and position the back leg flush with the rake angle or wall construction.

Check that the flashing is set at a positive pitch to assure a watershed affect.

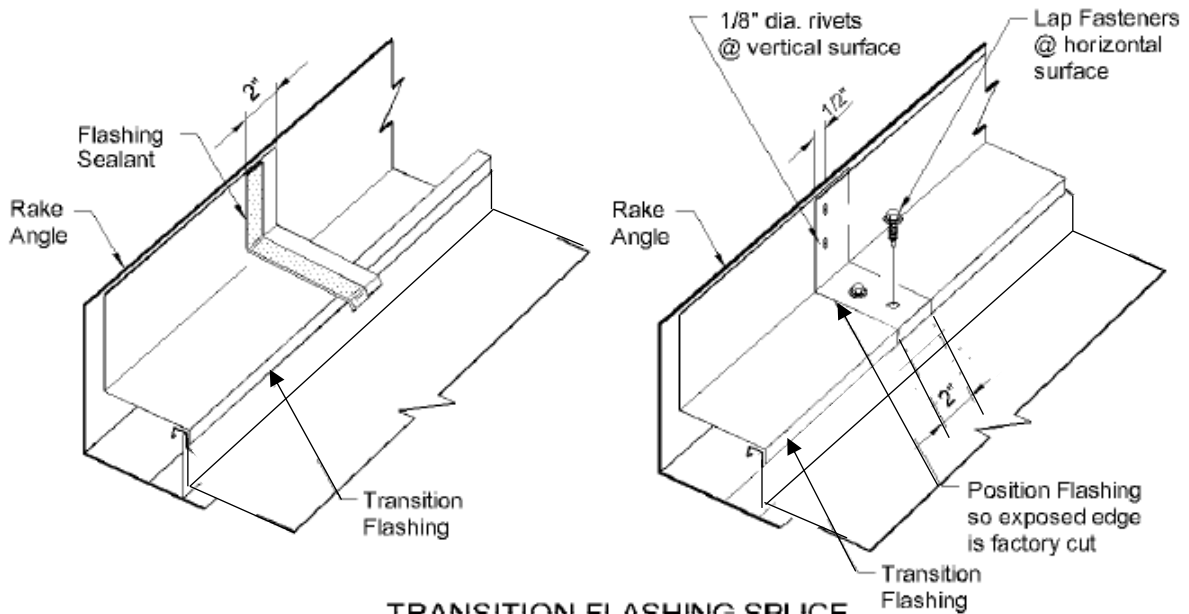
Slide the flashing's folded edge over the rake cleat.

Check that the fasteners penetrate the center of the tape mastic and legs of the rake angle cleat and are fully engaged.

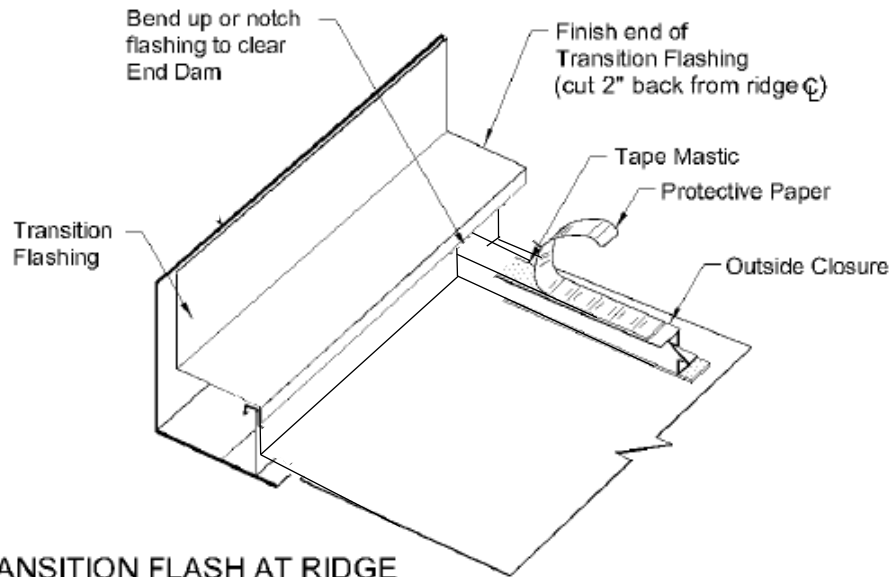
16.7 Rake Transition Trim Installation (with Rake Angle Cleat)



16.8 Rake Transition Trim Installation (w/o Rake Angle Cleat)



TRANSITION FLASHING SPLICE



TRANSITION FLASH AT RIDGE

Assemble transition flashing splices with eave sealant and lap fasteners as shown. Wipe dry and clean the lapping surfaces of the flashing.

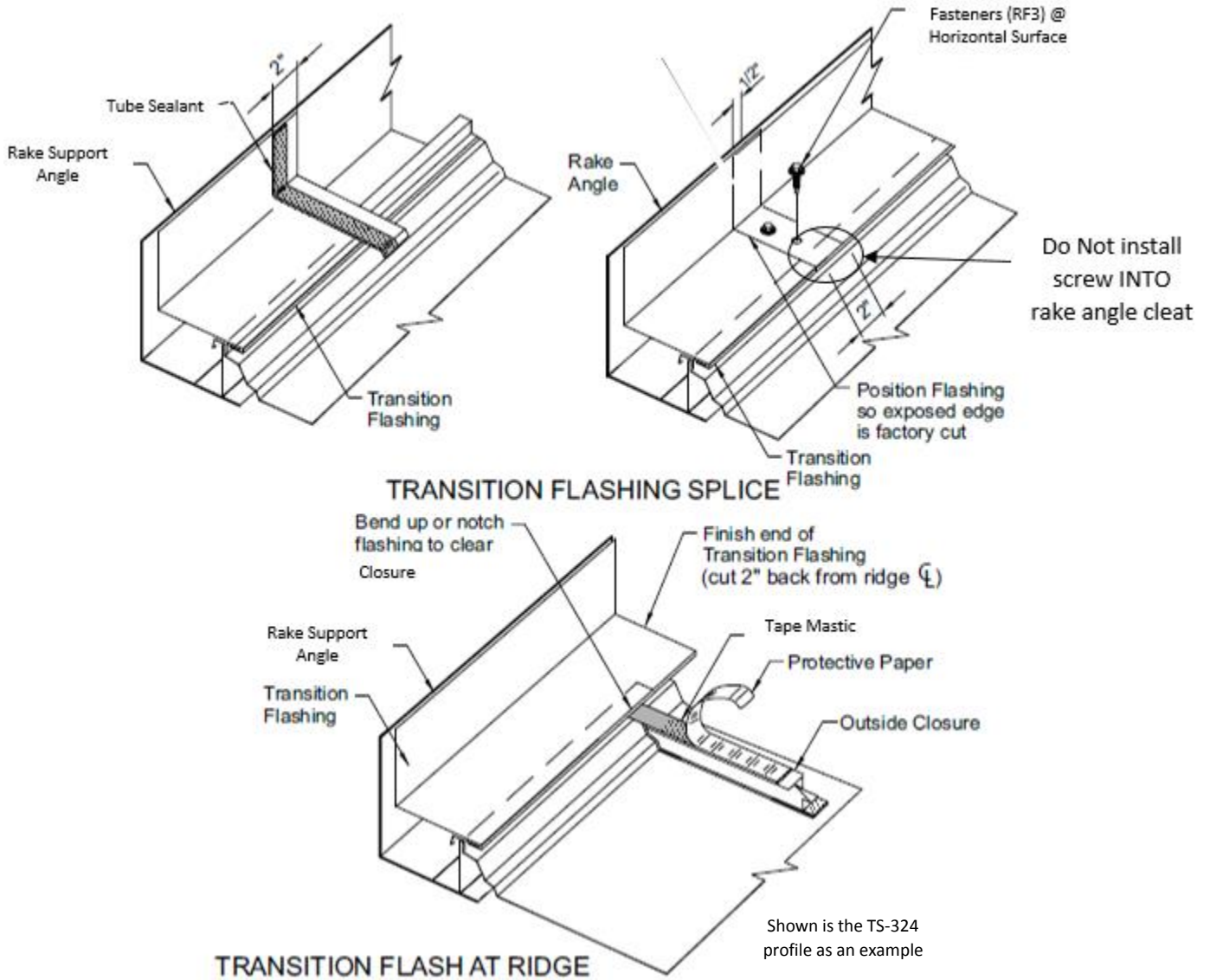
Bend or notch the flashing's lip to clear the top flange of the outside closure.

At the ridge, field cut the end of the flashing 2" away from the center line of the ridge.

At a **high eave transition**, field cut the end of the flashing as required for a weathertight joint with the adjacent construction.

DO NOT attach vertical leg of trim to rake angle.

**16.8 Rake Transition Trim Lap Installation (with Rake Angle Cleat)**



Assemble the transition flashing laps with Polyurethane tube sealant and stitch screws (RF3) as shown. Wipe dry and clean the lapping surfaces of the flashing.

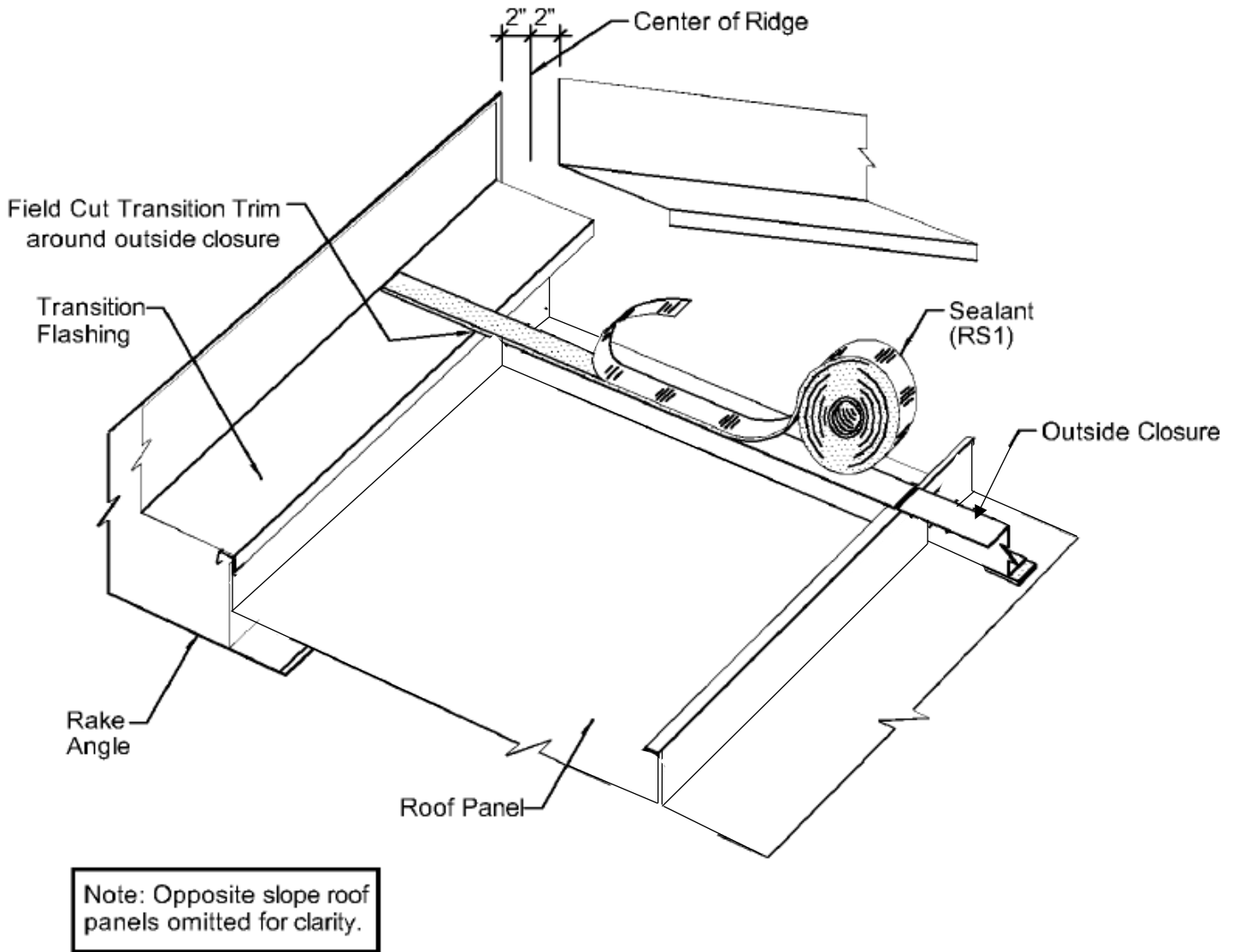
Bend or notch the flashing’s lip to clear the top flange of the outside closure.

At the ridge, field cut the end of the flashing 2-inches away from the center line of the ridge to allow for thermal movement

At a high eave transition, field cut the end of the flashing as required for a weather tight joint with the adjacent construction.



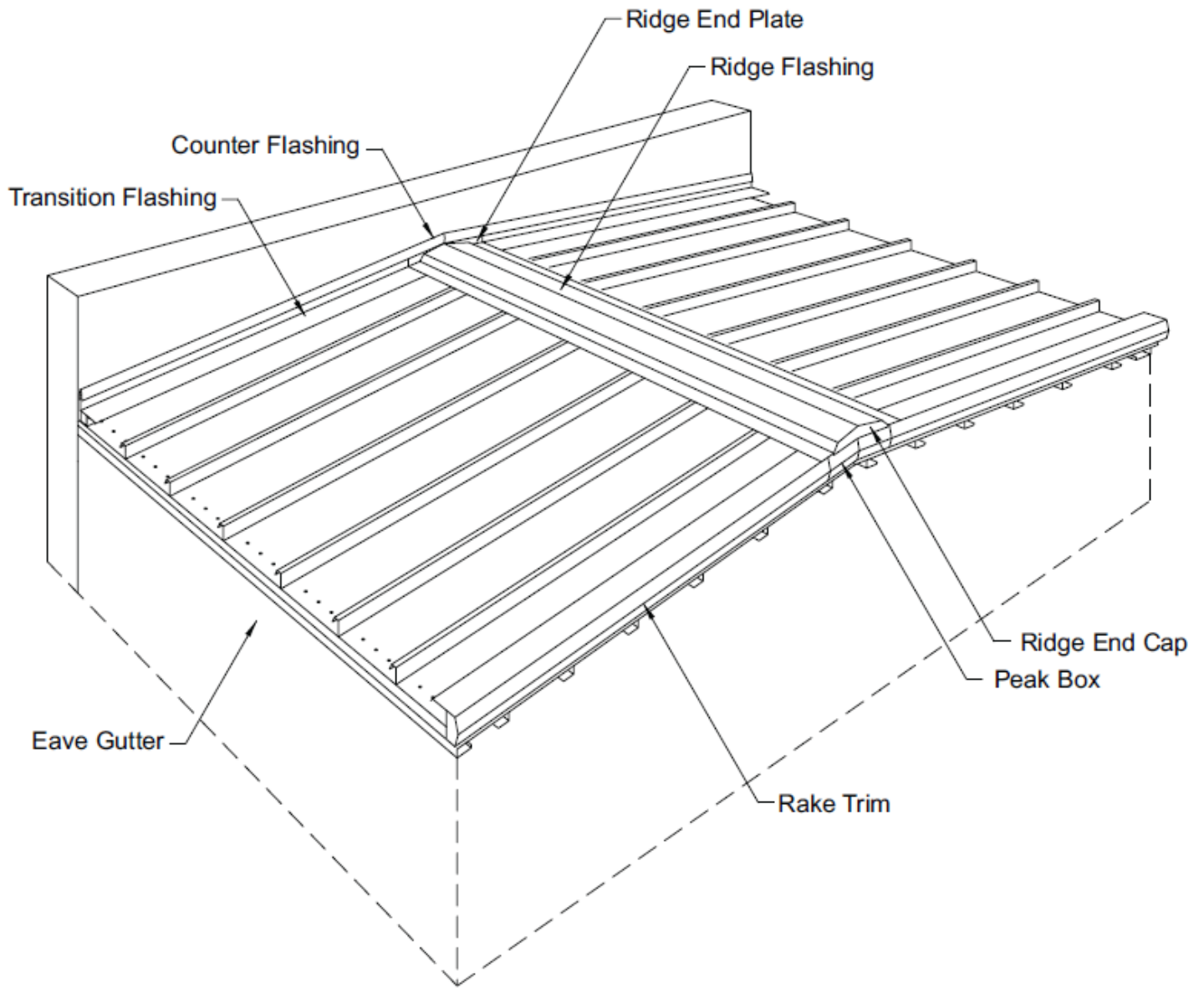
### 16.9 Rake Transition Trim and Ridge Cap Installation



Position the edge of the tape mastic (RS1) flush against the face of the transition flashing and extend the ends of the tape mastic to align with the outside closures.

Install the tape mastic (RS1) continuous along the top flange of the outside closures.

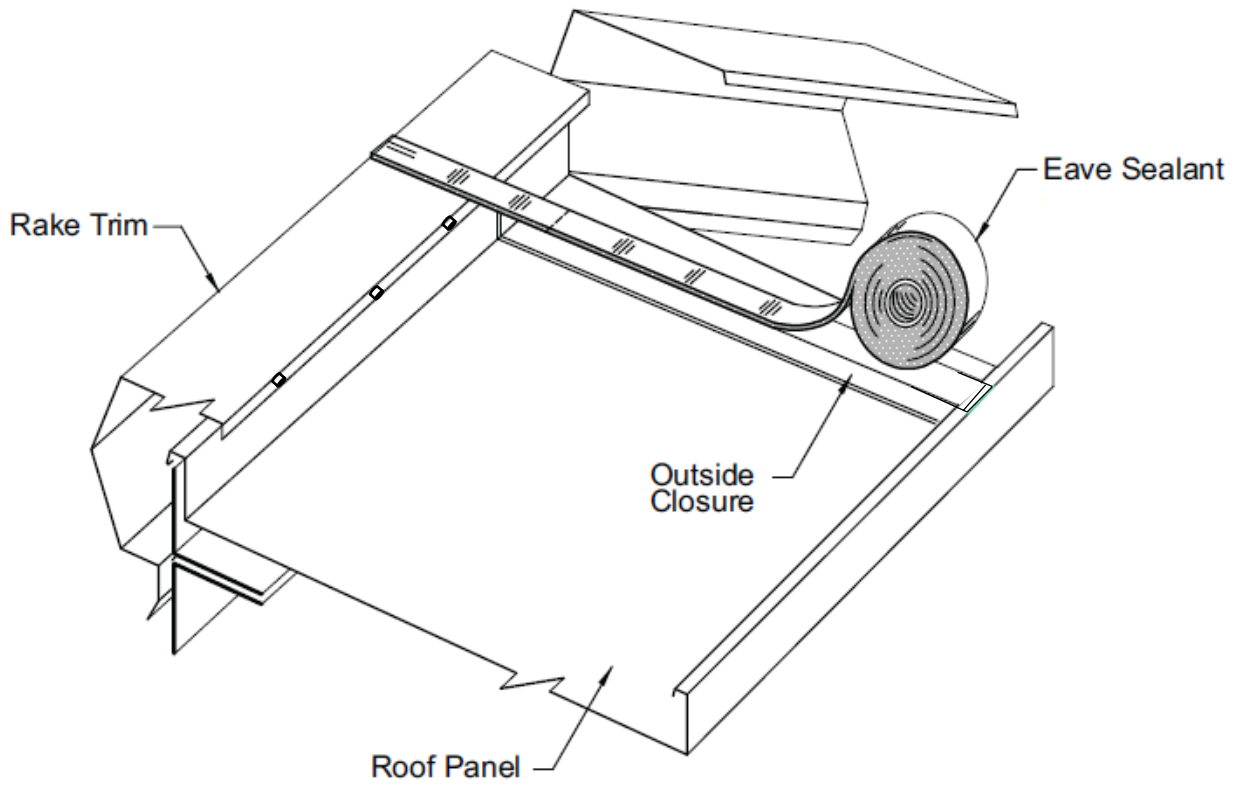
## 16.10 Ridge Cover Installation



The details in this section show the installation of the ridge cover.

The ridge cover can start or finish at either a rake trim condition or a rake transition condition.

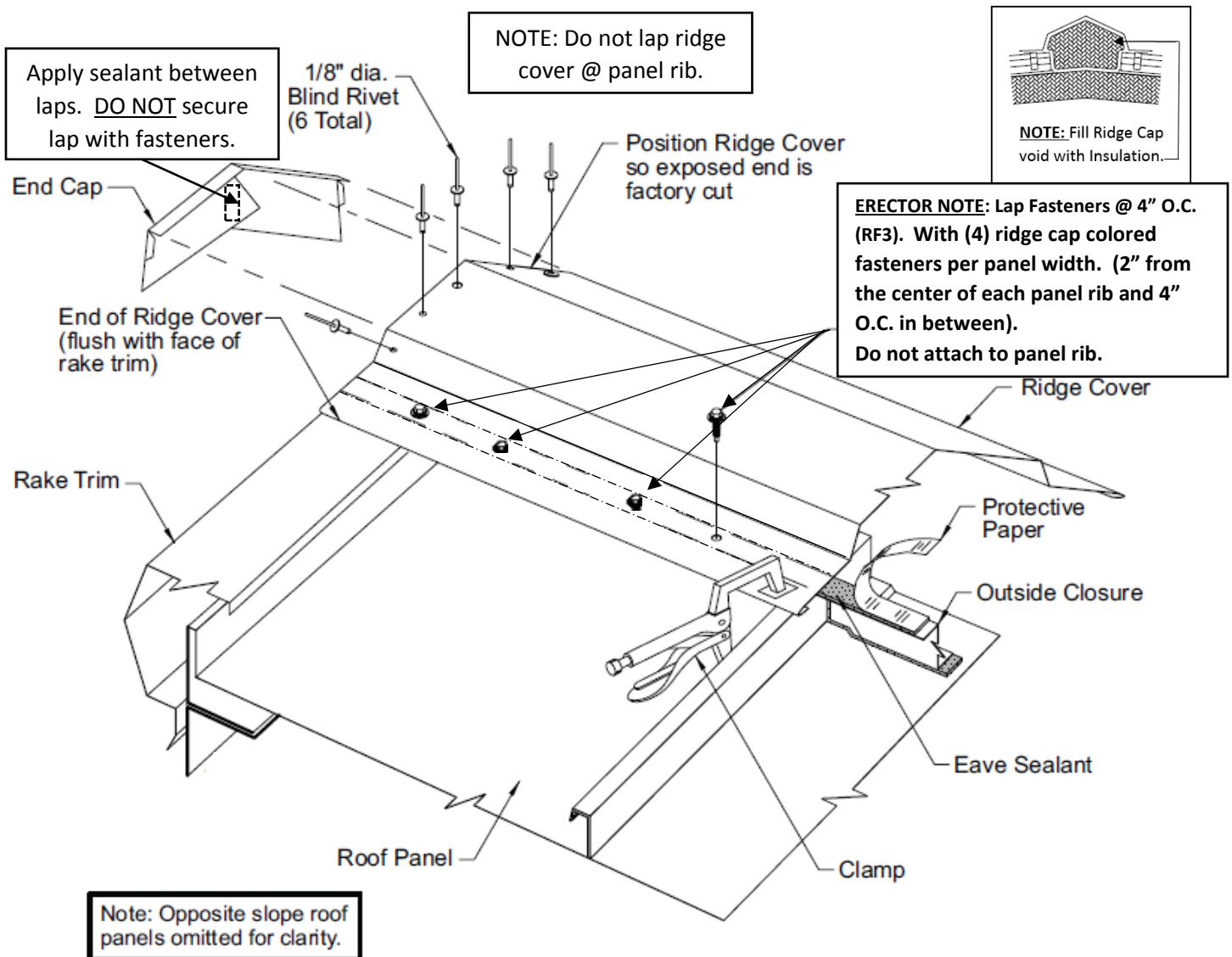
### 16.11 Ridge Cover Sealant Tape Installation



Note: Opposite slope roof panels omitted for clarity.

Install eave sealant continuous along the top flange of the outside closures.

## 16.12 Ridge Cover and End Cap Installation



Fill the ridge cap void with insulation.

Install the ridge cover to span across the opposing outside closure runs as shown.

Position the end of the ridge cover flush with the end of the rake trim.

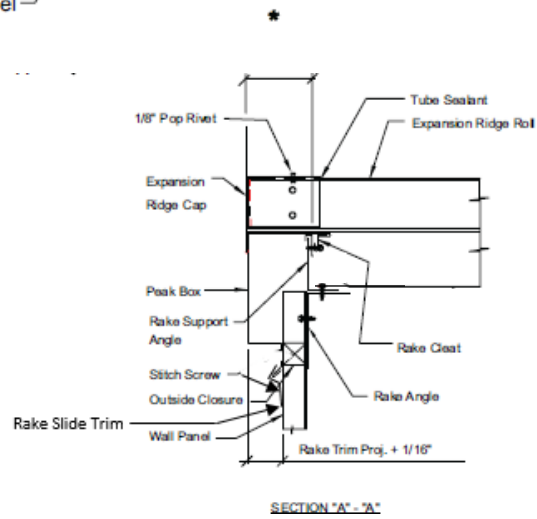
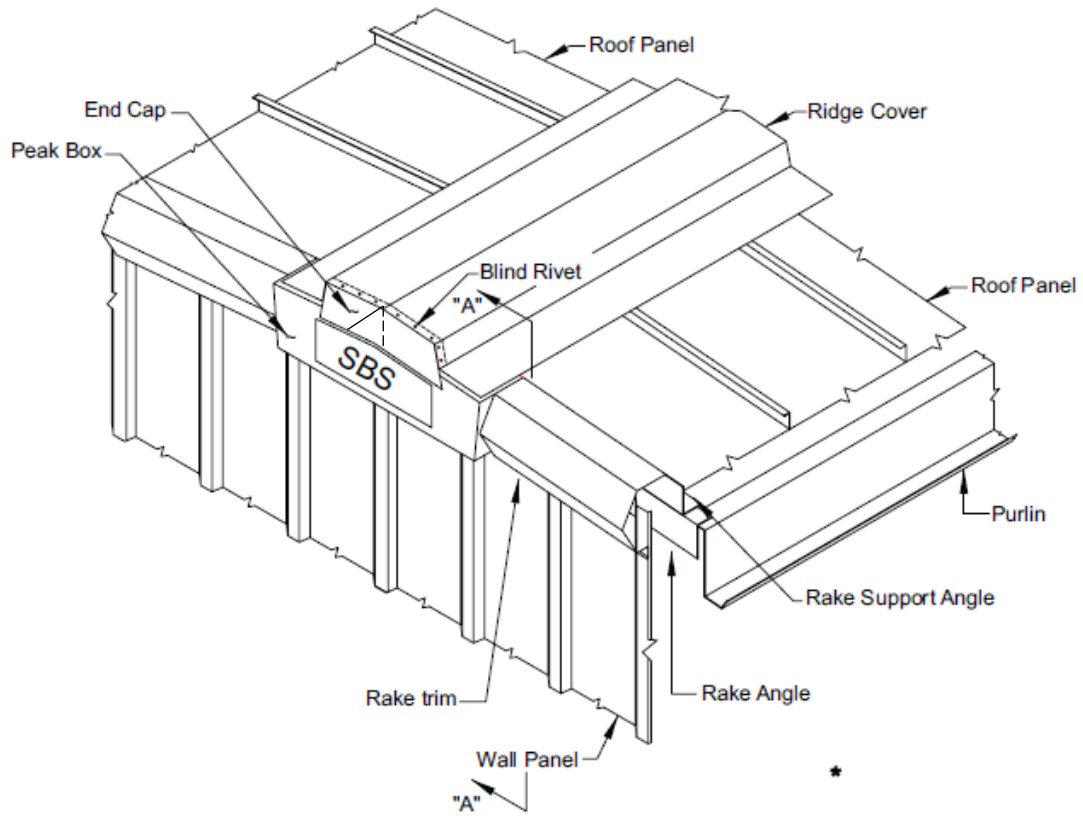
Align the center of the ridge cover over the ridge centerline. Use a string line to assure a straight ridge cover installation.

Fasten the ridge cover to the outside closures with lap fasteners spaced as shown. Check that the fasteners penetrate the center of the outside closure.

Install first lap fastener greater than 1-1/2" from end of ridge cover (inside the notched out area of peak box).

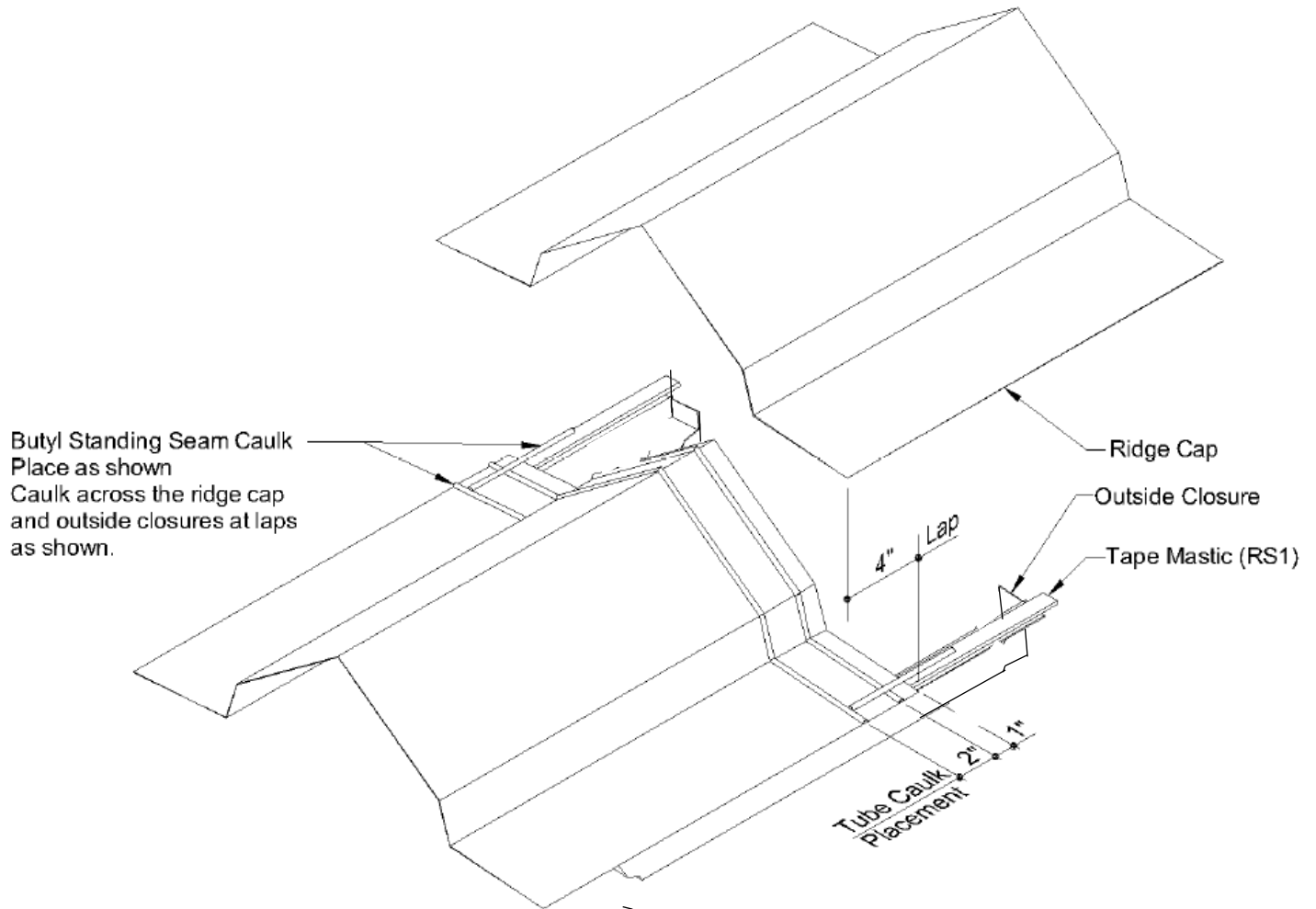
Install end cap into end of ridge cover as shown.

### 16.12 Ridge Cover Installation



\* Wall Panel Thickness, Plus Rake Trim Projection, Plus 1/16"

### 16.13 Ridge Cover Installation



**IMPORTANT NOTE: DO NOT LAP THE RIDGE CAP AT A PANEL RIB.**

The ridge cap is to be lapped 4-inches, utilizing (2) beads of Butyl standing seam tube caulk.

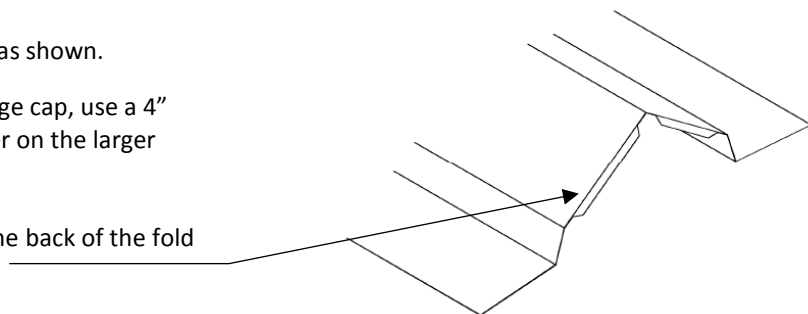
Also apply the tube caulk to the tape mastic as shown.

Tips to strengthen the large planes of the ridge cap, use a 4" wide vise clamp and form a short leg stiffener on the larger elevation ridge cap only.

Fold the material downwards to a 90°. Tap the back of the fold with a hammer to form a sharp 90° bend.

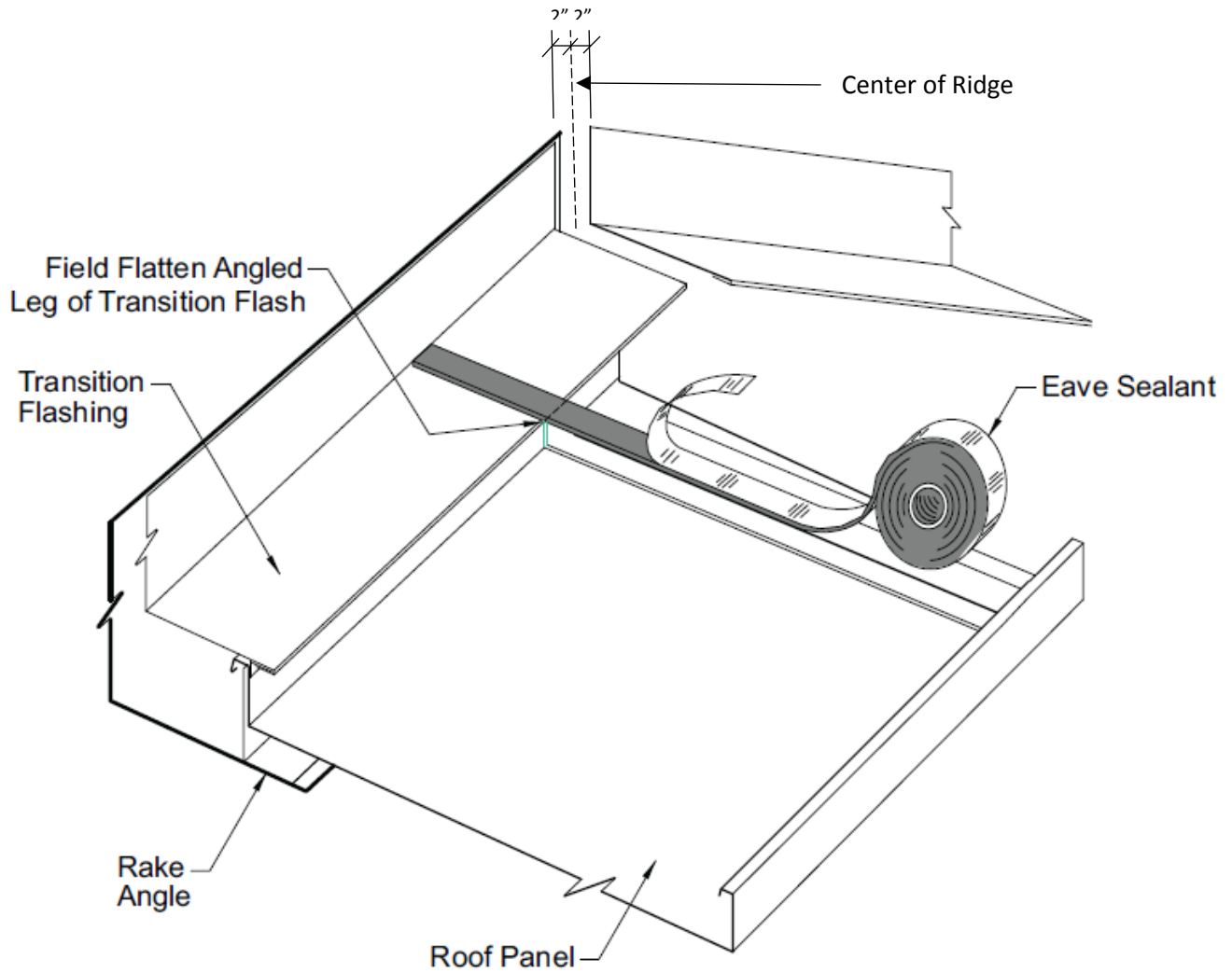
**DO NOT USE FASTENERS AT THE RIDGE CAP LAPS.**

**DOING SO WILL NOT ALLOW FOR LONGITUDINAL MOVEMENT ALONG THE RIDGE CAP AS IT IS DESIGNED.**



## 16.14 Ridge Cover to Rake Parapet Installation

### Standard Rake Parapet Transition Flashing and Ridge Cap Installation



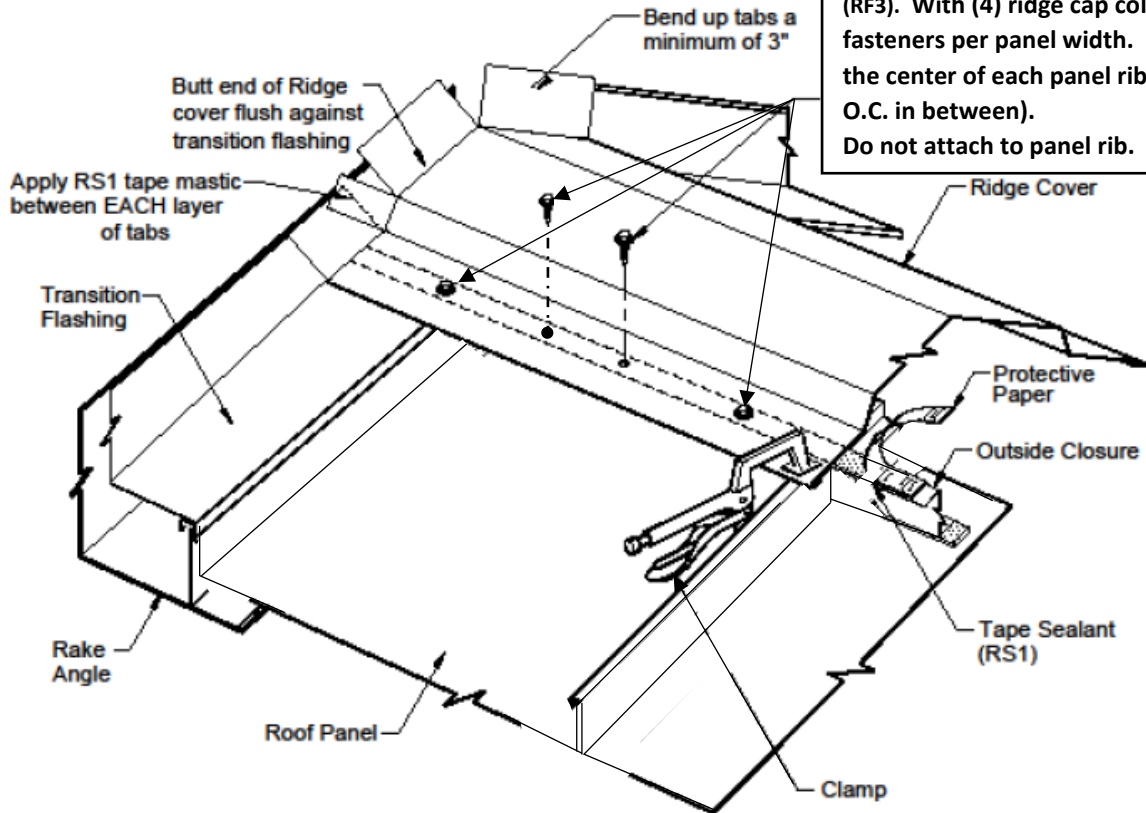
Note: Opposite slope roof panels omitted for clarity.

Position the edge of the sealant flush against the face of the transition flashing and extend the ends of the sealant to align with the outside closure's edge.

Install eave sealant continuous along the top flange of the outside closure. Lap the end of the sealant over the outside closure.

## 16.14 Ridge Cover Installation

### Standard Rake Parapet Transition Flashing and Ridge Cap Installation



**ERECTOR NOTE:** Lap Fasteners @ 4" O.C. (RF3). With (4) ridge cap colored fasteners per panel width. (2" from the center of each panel rib and 4" O.C. in between). Do not attach to panel rib.

Note: Opposite slope roof panels omitted for clarity.

Cut each plane of the ridge cap and fold it upwards a **minimum** of 3-inches. This is required to extend behind counter flashing or backer panels for thermal movement and weather tightness. (The ridge top point can raise 3-inches during expansion on a large roof plane.)

Apply tape mastic (RS1) between EACH layer of the tabs.

Install the ridge cap to span equally across the opposing outside closures.

Position the end of the ridge cap flush with the sloped edge of the rake trim.

**FILL THE RIDGE CAP CAVITY WITH INSULATION ITCH.**

Align the center of the ridge cap over the ridge centerline. Use a string line to assure a straight ridge cap *installation*.

*The ridge cap MUST be properly positioned before touching the tape mastic. Mastic cannot be reused.*

**Fasten the ridge cover to the outside closures with (4) ridge cap colored fasteners (RF3) per panel width. (2" from the center of each panel rib and 4" O.C. in between).**

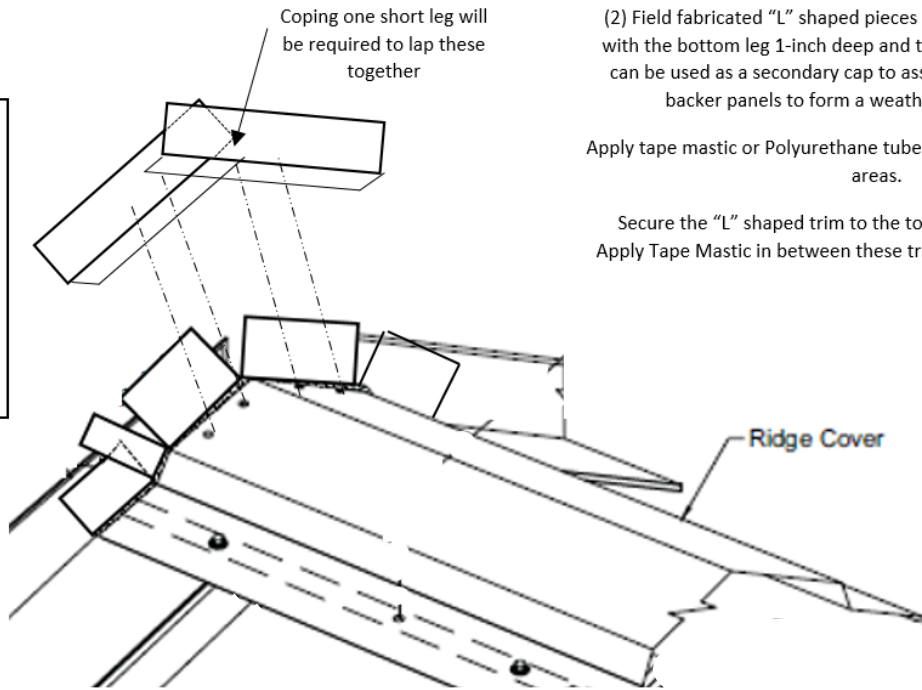
Check that the fasteners penetrate the center of the outside closure's top flange and its tape mastic.



## 16.14 Ridge Cover Installation

### Standard Rake Parapet Transition Flashing and Ridge Cap Installation

The top of the ridge cap, the ridge cap tabs and the "L" shaped trim **MUST** be allowed to move upwards 3-inches.



(2) Field fabricated "L" shaped pieces of trim, 12-inches in length with the bottom leg 1-inch deep and the vertical leg 3-inches tall, can be used as a secondary cap to assist the counter flashing or backer panels to form a weather tight connection.

Apply tape mastic or Polyurethane tube caulk between **ALL** adjoining areas.

Secure the "L" shaped trim to the top planes of the ridge cap. Apply Tape Mastic in between these trim pieces and the ridge cap.

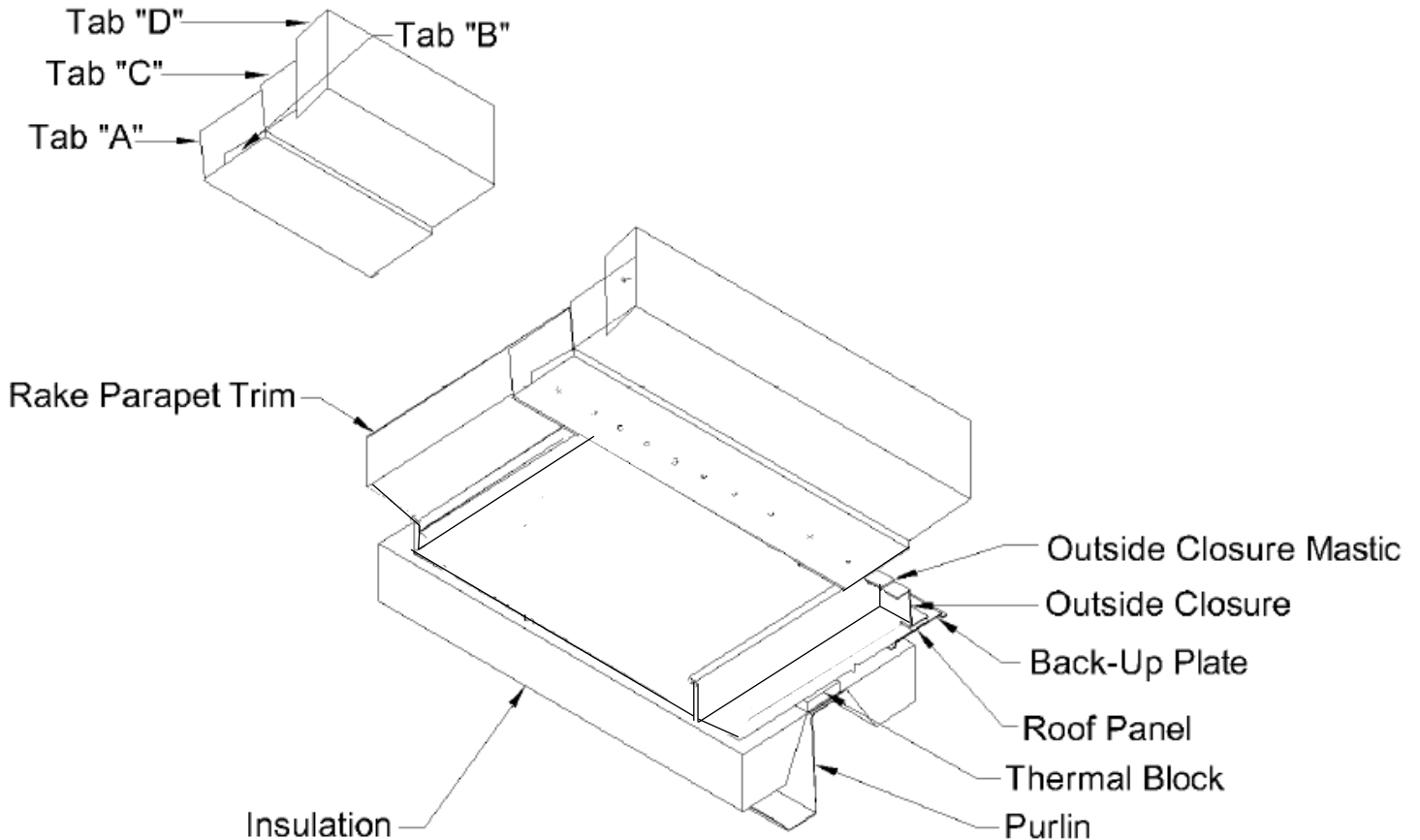
Jamb trim can trim out the backer panel cut-out

(MUST be installed at an elevation which will allow for thermal upwards movement of the ridge cap.)

## 16.15 High Eave Trim to Rake Parapet Installation

### Standard Rake Parapet Transition Flashing and High eave Installation

#### FIELD BEND 4" TABS



Apply the 1 ½" wide tape mastic (RS1) continuously across the top of the outside closures. Remove the paper backing ONLY as the work progresses.

**NOTE: FIELD MITERING IS REQUIRED BEFORE INSTALLING THE HIGH EAVE PARAPET TRIM.**

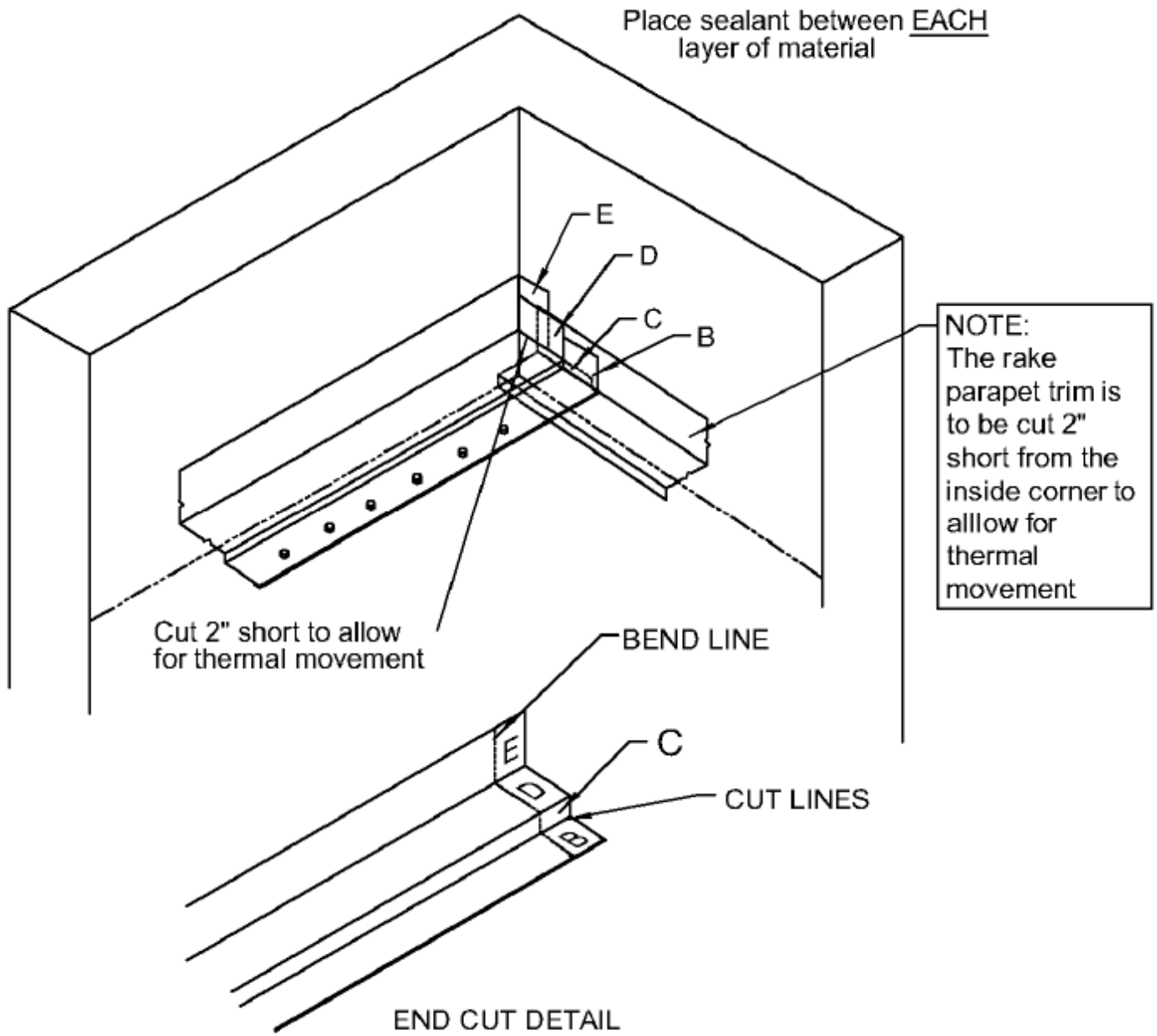
Scribe A LINE 4-INCHES IN FROM THE END OF THE HIGH EAVE PARAPET TRIM. Make a "through" cut at all bends to form tabs "A", "B", "C", and "D" as shown below. Bend tabs as shown above.

Apply MS Polymer or Permathane tube caulk around the perimeter of all tabs and place the high eave parapet trim over the outside closures and fasten with four screws per each outside closure.

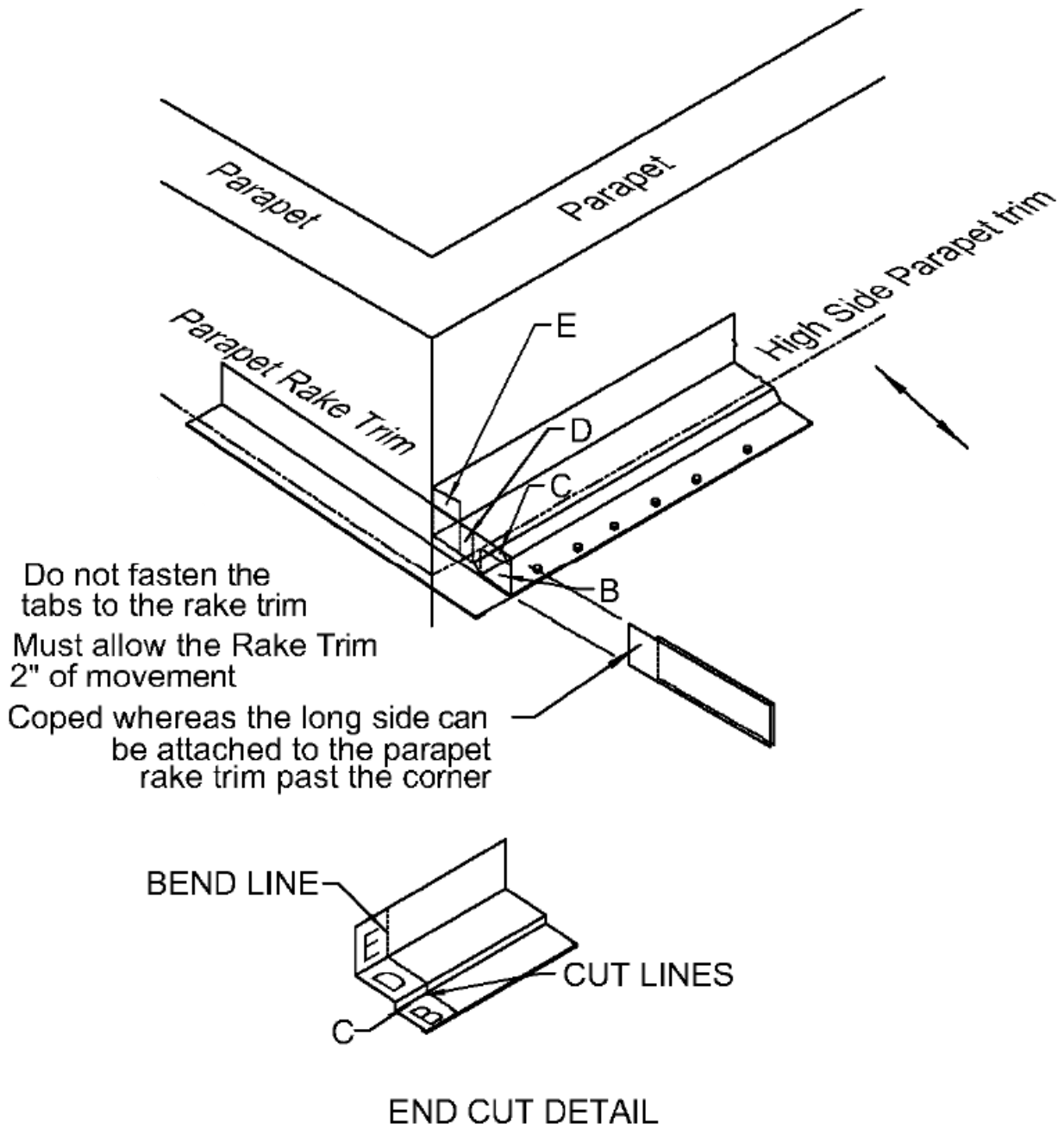
**The trim MUST be properly positioned BEFORE touching the mastic. Mastic cannot be reused.**

Refer to the erection drawing details for the high eave parapet trim attachment to the wall.

16.16 High Eave Trim to Rake Parapet Installation

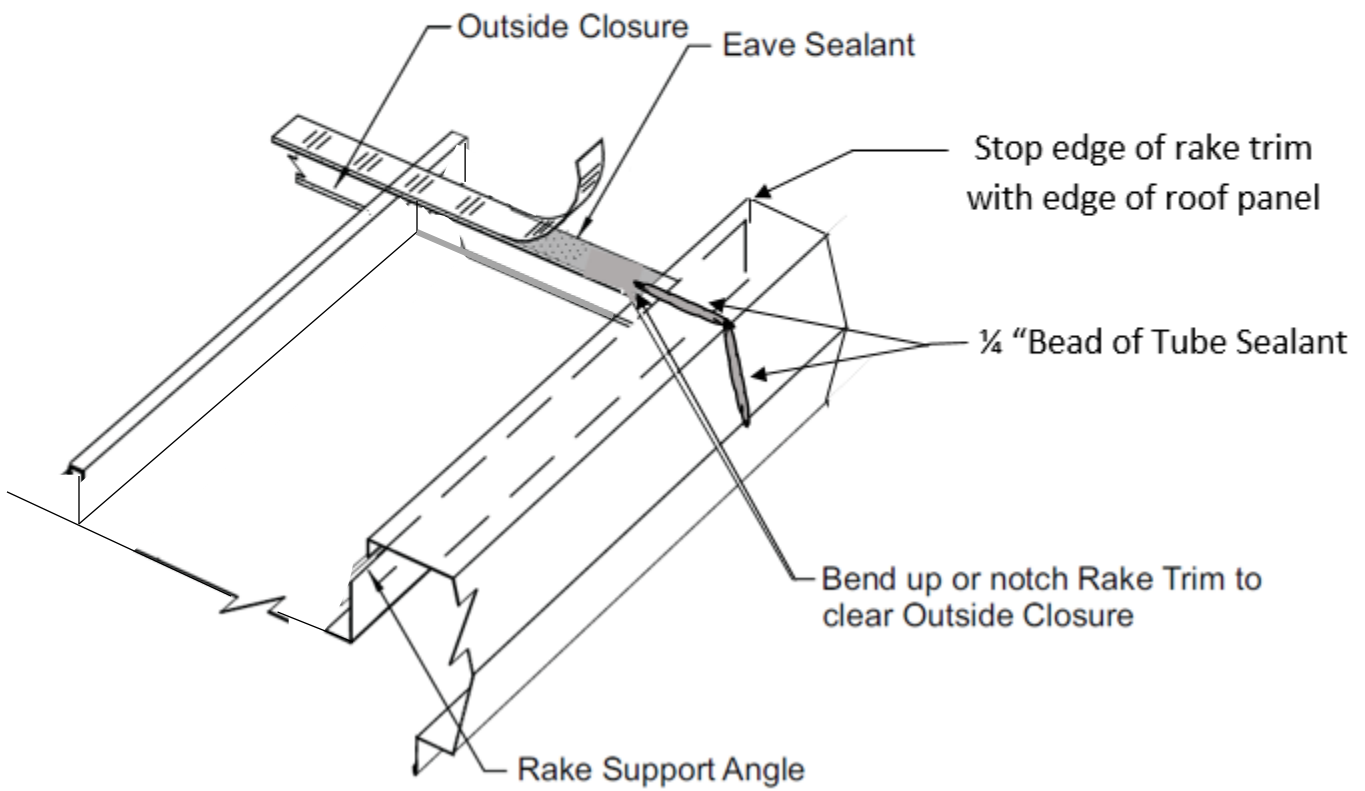


16.17 Standard Rake Parapet Transition Flashing and Ridge Cap Installation

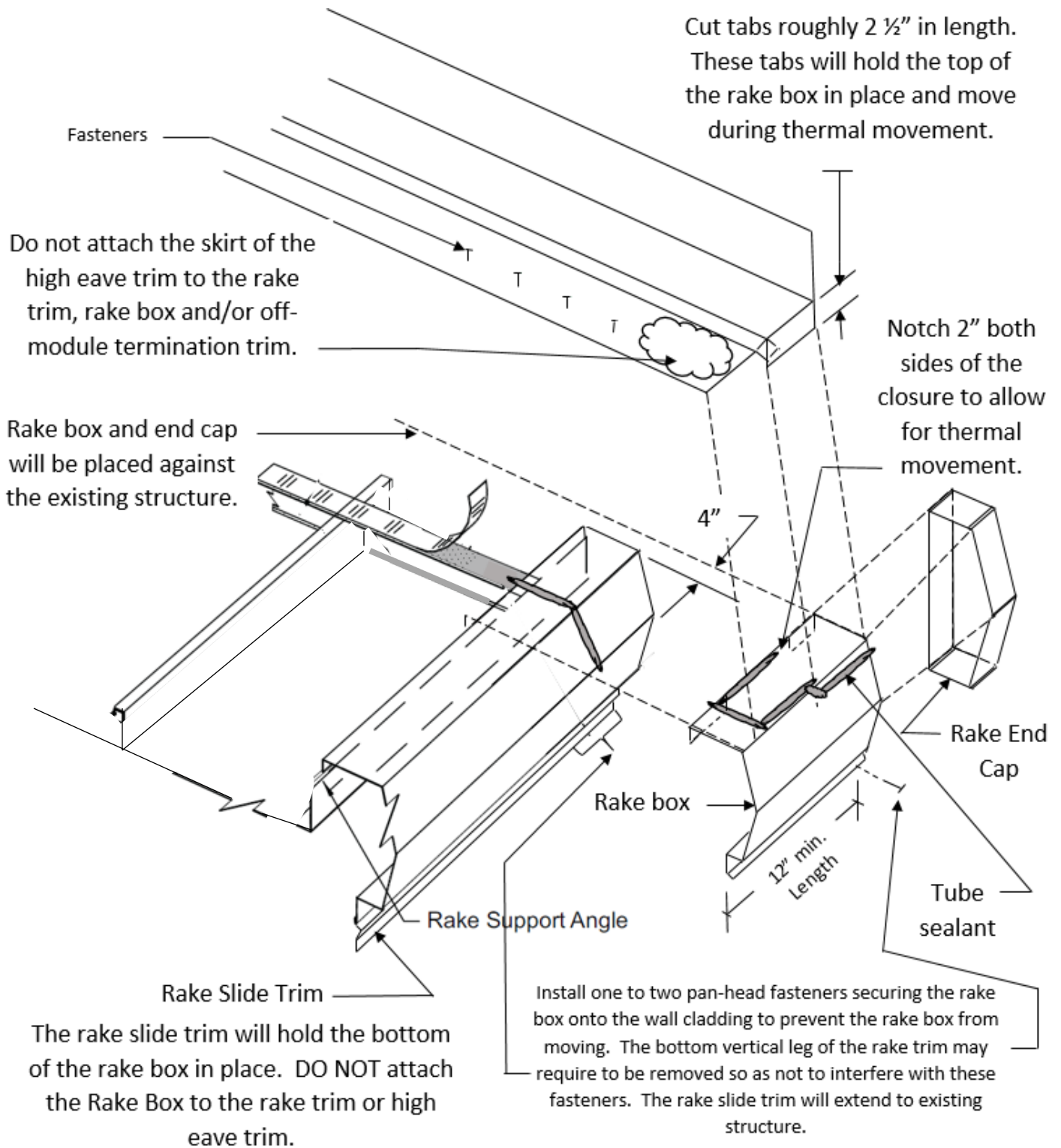


16.18 Lean-To to High Eave Rake Box Installation

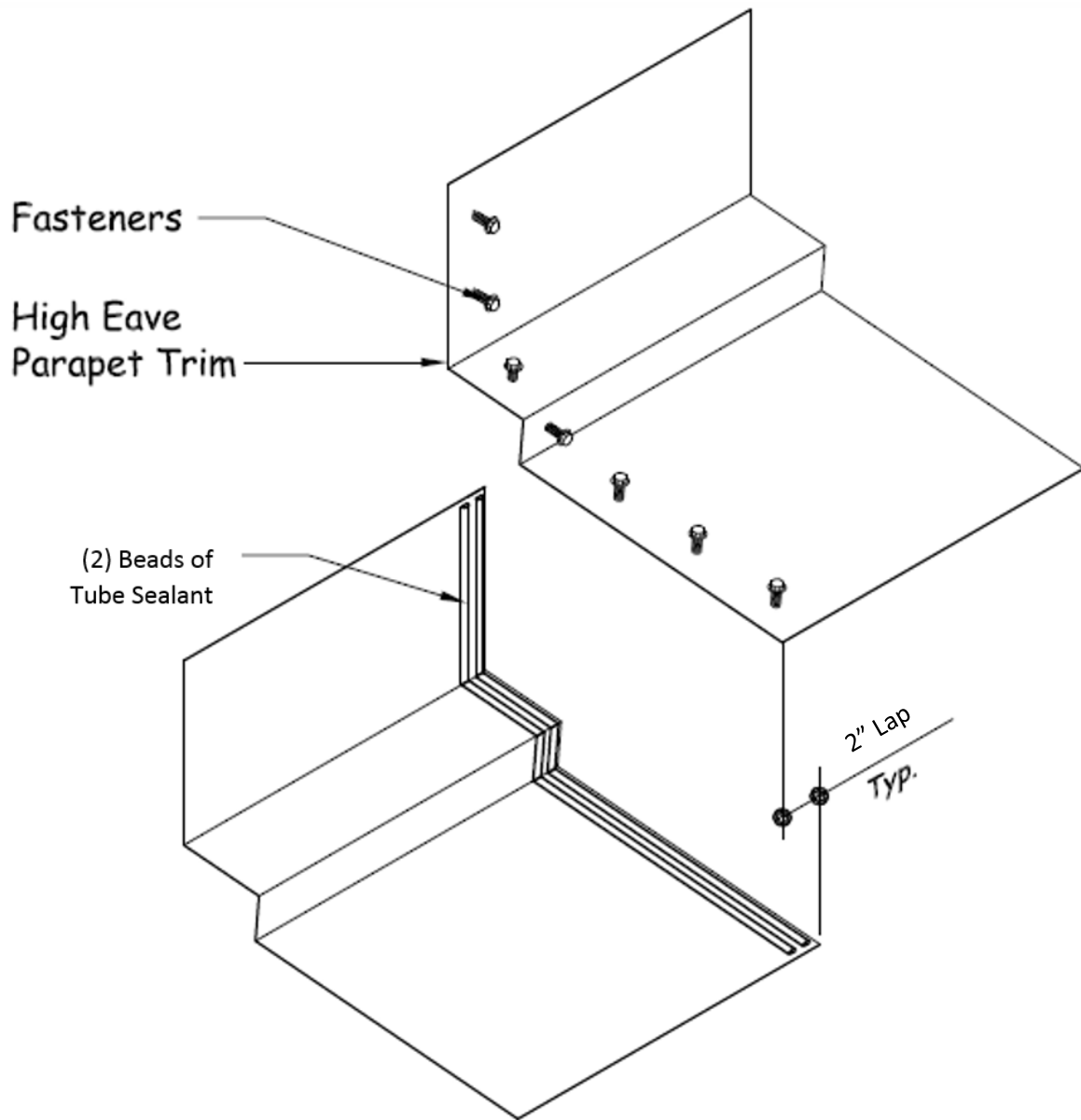
LEAN-TO to HIGH EAVE RAKE BOX INSTALLATION



16.18 Lean-To to High Eave Rake Box Installation



### 16.19 Standard Rake Parapet Transition Flashing and Ridge Cap Installation



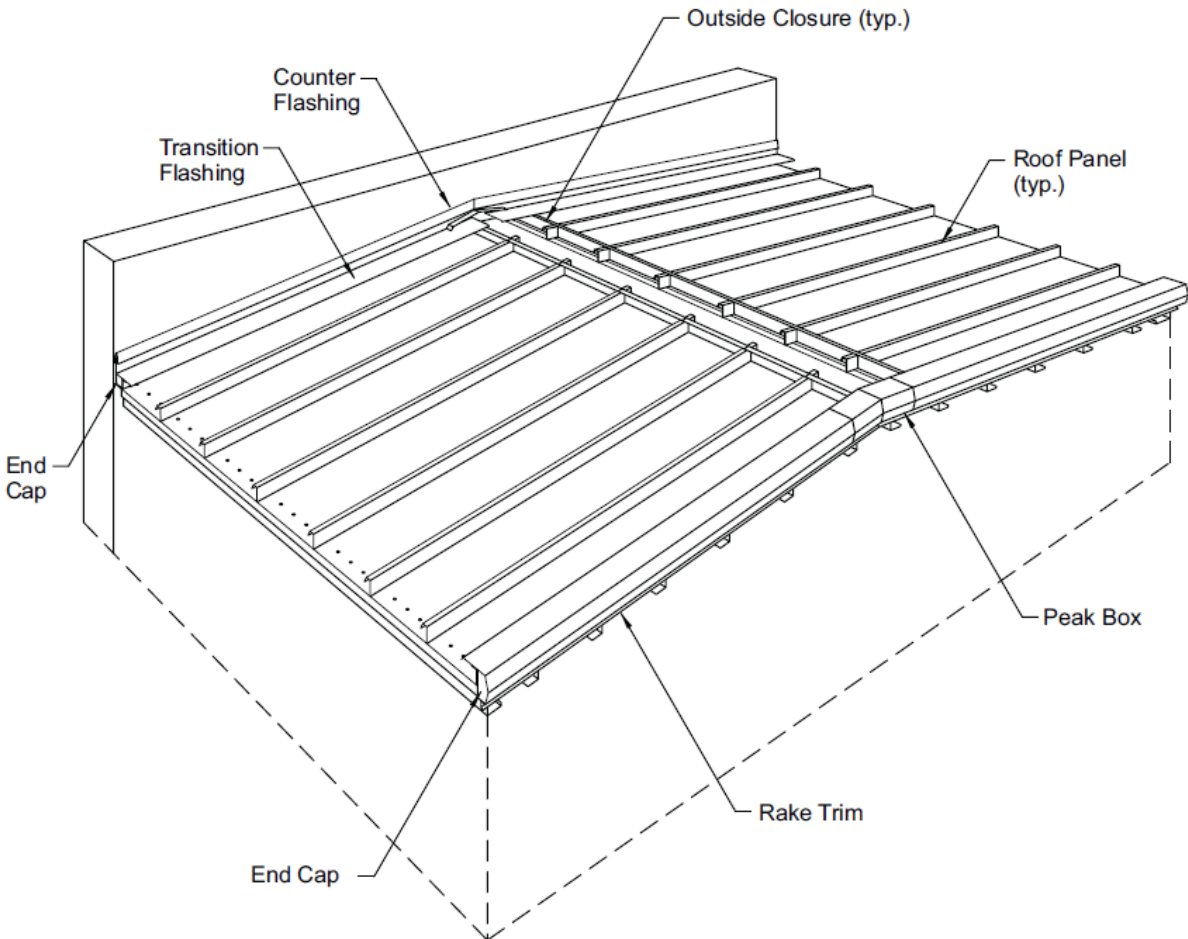
To lap the high eave parapet trim, apply (2) continuous beads of MS Polymer or Permthane tube caulk to the end of the installed piece of trim.

DO NOT attach the trim to the rake angle.

Position the adjoining piece on top of the caulk, lapping 1-inch in length. Fasten with (7) trim-colored self-drilling screws.

Insure that the fasteners penetrate through the caulking.

## 16.20 Standard eave gutter Installation



Note: Parapets or existing buildings should extend 1-0" minimum above roof panels.

The details in this section show assembly and installation of the eave gutter.

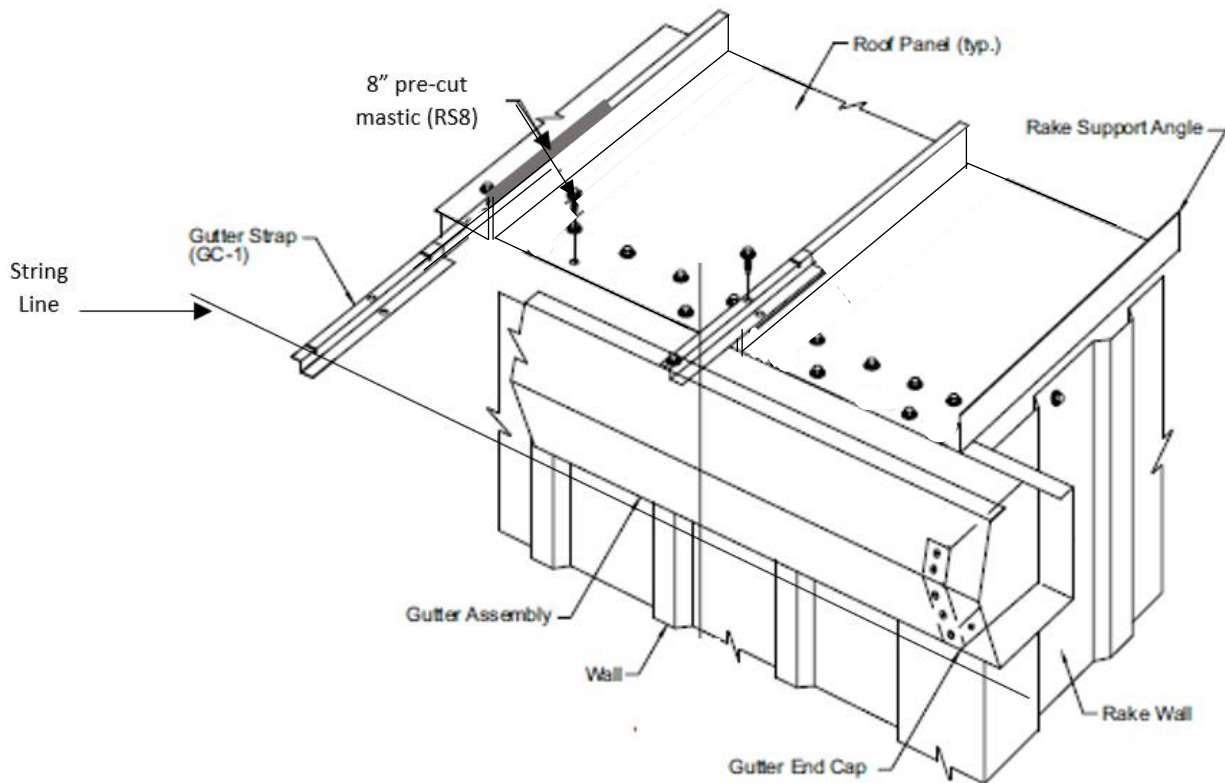
Assembly of the gutter should be accomplished with care given to the final appearance. The appearance of the gutter will have a critical effect on the appearance of the project.

Determine which direction the building is most often viewed from. Install the gutter laps facing away from the most often viewed direction.

Proper downspouts are necessary to prevent gutter overflow and roof flooding. Refer to the erection drawings to determine the required downspout size and spacing.



## 16.21 Eave Gutter Installation



Establish a string line beyond the eave edge of the roof panel to aid in proper gutter bracket alignment.

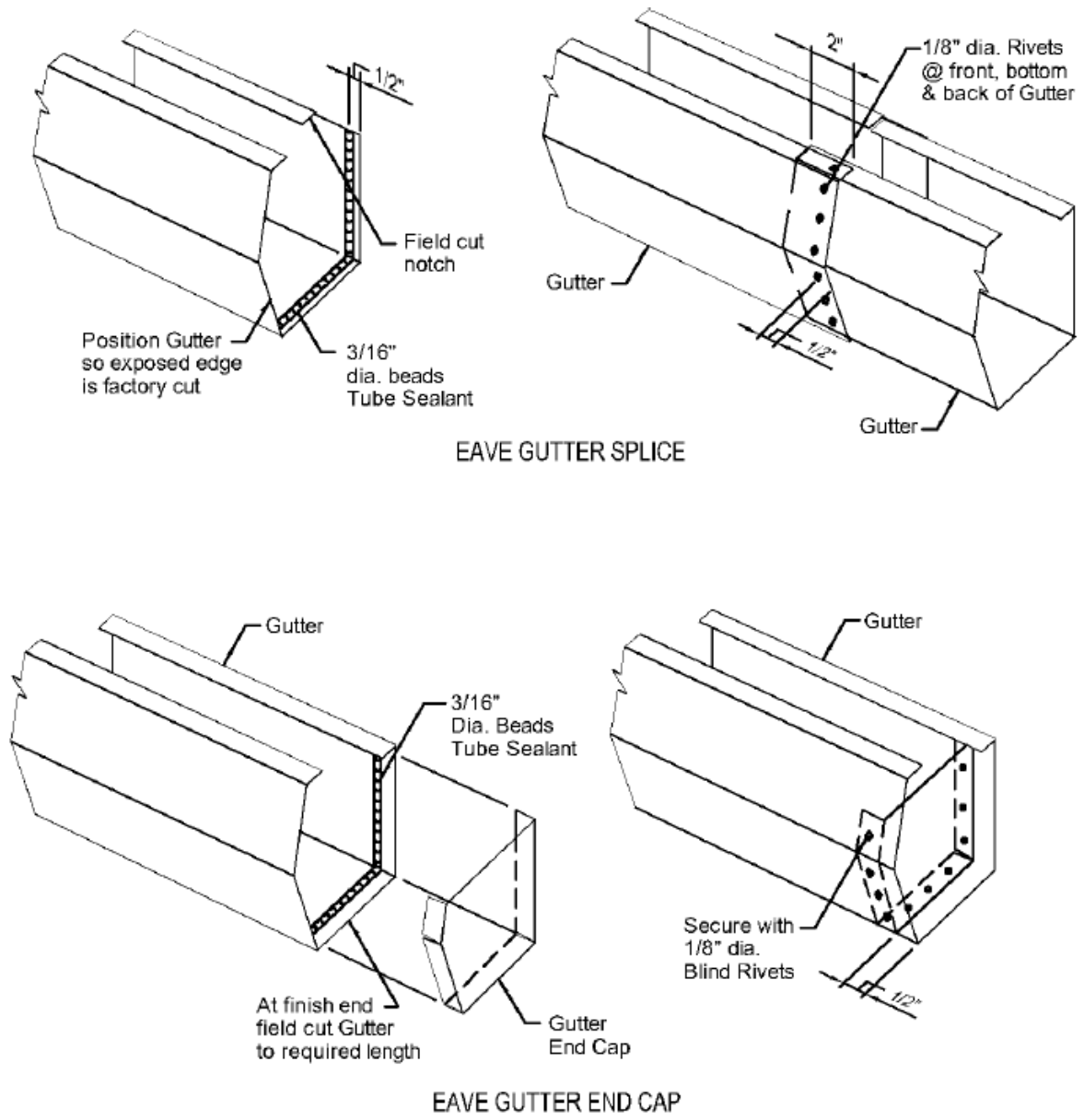
Apply 8-inch pre-cut mastic (RS8) between the gutter bracket and roof panel rib.

**NOTE:** Before the gutter bracket can be installed, the panel seam at the low eave **MUST** be hand crimped. Place the gutter bracket on the roof panel, holding the low eave end at the string line.

**Gutter brackets are required at every other panel rib**

Fasten the gutter bracket to the panel rib with (2) self-drilling screws ensuring that the tape mastic has been penetrated.

**16.21 Eave Gutter Installation**



Layout the gutter assemblies in manageable lengths (30' to 40') before raising to the roof.

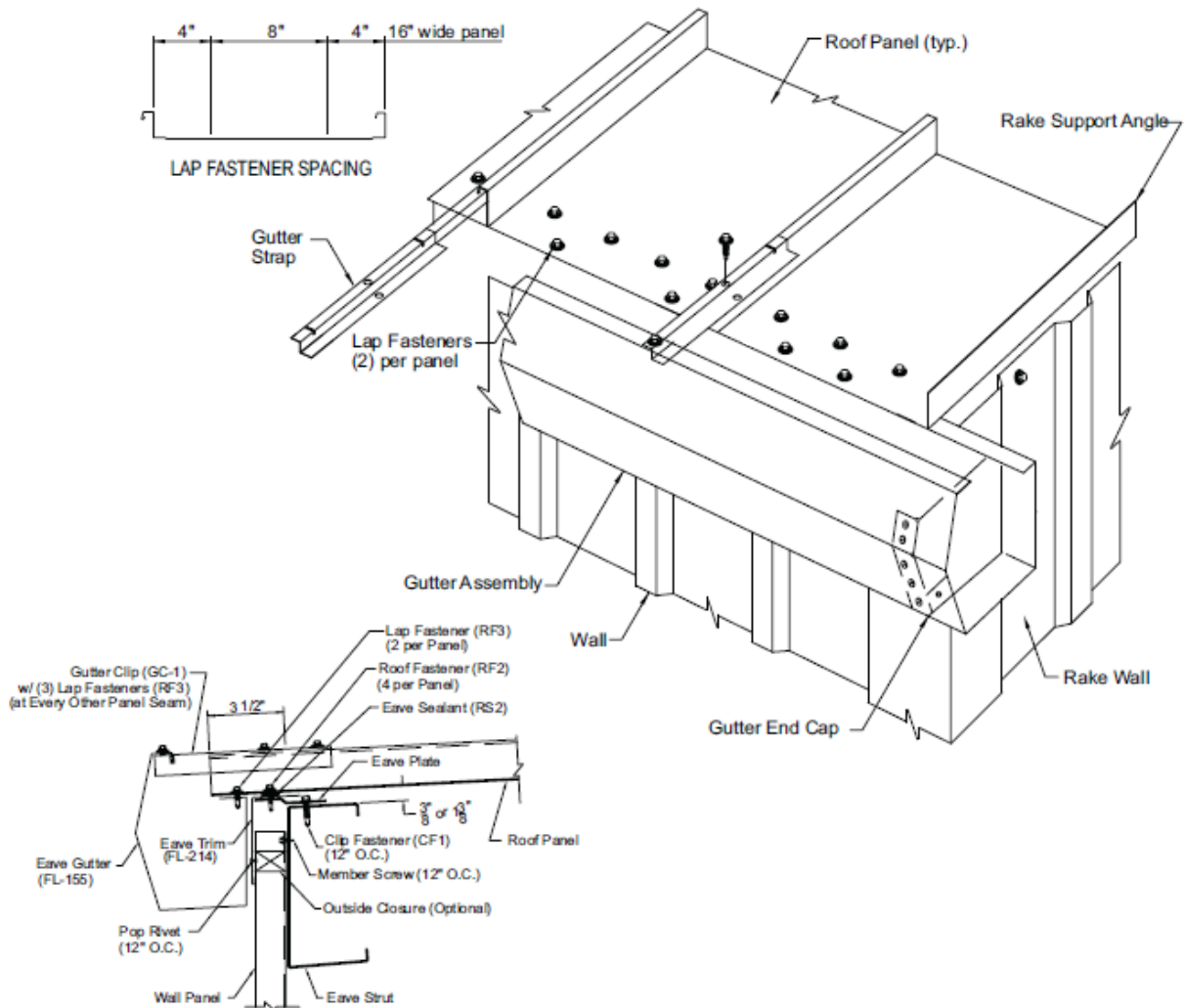
Start and finish the gutter ends flush with the exterior face of the rake walls.

Assemble the gutter end caps and splices with tube sealant and rivets as shown on the above details.

**ERECTION TIP:** Assemble lengths on the ground then with proper man power, slide the length under the eave and temporary clamp to eave overhand for fastening thru factory pre-punched holes.

Apply 1/2-inch wide tape mastic to the top side of the back lip of the gutter. (Optional)

## 16.21 Eave Gutter Installation



Lift the gutter assembly into position under the edge of the roof panels and temporarily clamp the back flange of the gutter to the roof panel.

Position the back face of the gutter assembly flush against the eave trim and position its ends flush with the exterior face of the rake wall.

Fasten the gutter's back flange to the underside of the roof panel with lap fasteners.

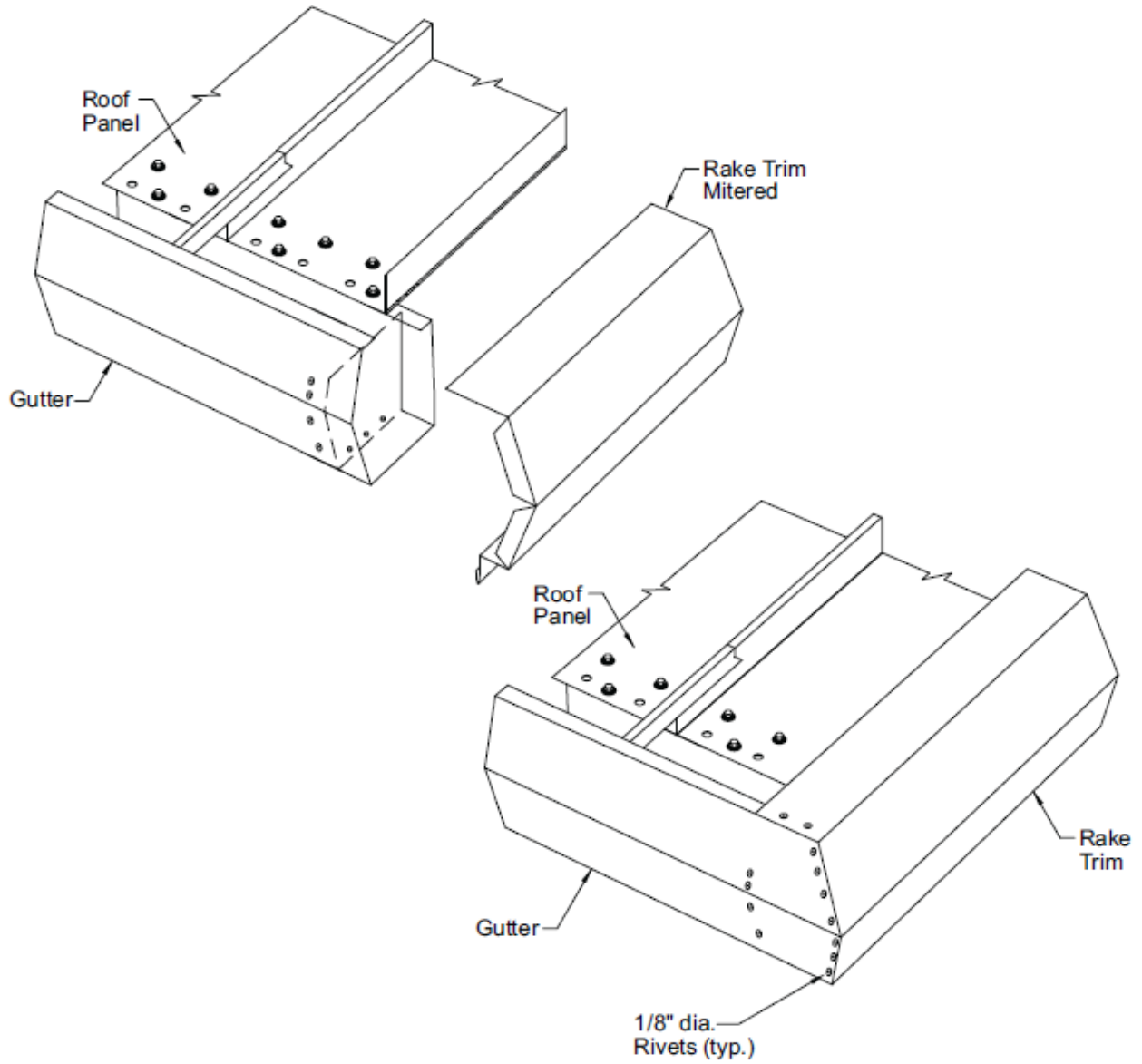
Check that the lap fasteners are securely engaged into the gutter's back flange.

Align the outer edge of the gutter straight and level. Use a string line to assure that the gutter is straight.

Install the gutter supports and fasten to the roof panel with lap fasteners. Refer to erection drawings for the required gutter support spacing.

Fasten the gutter's outer flange to the end of the gutter support with a lap fastener as shown.

## 16.22 Standard Rake Flashing and Gutter Installation



Check to make sure all edges are sealed with MS Polymer tube sealant.

Insert the rake trim into the gutter.

Align the mitered edges and attach with 1/8" diameter pop rivets.

## 17.0 Check List

The following check list is intended to assist the builder and/or erector in troubleshooting and punching out the Horizon TS-324 Roof System. This list is not intended to serve as a certification of the roof system, because many details such as mastic installation are impossible to inspect after the roof has been erected. However, in conjunction with continuous quality control measures during the erection process, this list should help insure a safe, weather tight roof system.

Horizon recommends that detailed notes be taken during the inspection and punching out the roof. The erector or the actual person doing the work should have access to these notes. Do not place pencil markings on the Galvalume panels, because the pencil lead will cause rusting and will void your Galvalume warranty. Instead, consider using clothes pins attached to the seam of the panel to point out problem/unfinished areas. These work well, do not create a mess, and can be seen from across the roof.

### 17.1 Panel Craft Roof Detail Compliance List

#### LOW EAVE CONDITION

- Y N Is the first bend in the eave plate aligned with the edge of the eave strut or other roof member?
- Y N Does the eave plate extend all the way to the end wall steel line?
- Y N Is the eave plate fastened to the eave strut at 12-inches O.C.?
- Y N Is mastic applied continuously along the top of the eave plate?
- Y N Has the 3-inches pre-cut mastic been installed on the low eave panel rib prior to the next panel being installed?
- Y N Is the insulation visible at the eave plate (from the outside)? (If so, this is not correct.)
- Y N Are there two fasteners installed through each of the void closure?
- Y N Is the space around and above the void closure properly sealed with mastic and/or tube caulk?
- Y N Are the gutter support brackets installed 48-inches O.C.?
- Y N Are there four fasteners installed into the flat of the panel at the low eave?

#### RAKE CONDITION

- Y N If the building has insulation, does the insulation extend to the rake support angle and/or steel line?
- Y N Are the rake trim fasteners installed 12-inches O.C.?
- Y N Is the base of the rake trim allowed to float inside the slide trim?

#### END LAP CONDITION

- Y N Is the end lap mastic properly placed between the laps?
- Y N Does the end laps have a back-up plate with ALL four tabs engaged?
- Y N Has the end lap tube caulk been properly placed up-slope and adjacent to the tape mastic?
- Y N Are the back-up plates properly engaged by the fasteners?
- Y N Are there any stripped or missing fasteners at the panel end laps?
- Y N Are all over-sized fasteners properly tightened?
- Y N Are there four fasteners installed at the end lap?
- Y N Has the cinch strap been installed?

#### Panel Side Lap Condition

- Y N Are all panel side laps properly hooked?
- Y N Can you see insulation or paper tabs protruding from the side laps? (If so, this is not correct.)
- Y N Are the two fasteners per panel clip spread out as far as possible? Avoid placing fasteners side by side.
- Y N Has all the roof seams been hand crimped into a TripleLok seam profile – as a minimum?
- Y N Are the FINAL roof seam type utilized and completed per design? (TripleLok or QuadLok)

## 17.0 Check List

### RIDGE OR HIGH EAVE CONDITION

- Y N Has the 3-inch pre-cut mastic been installed on the high side panel before the next panel has been installed?
- Y N Has the Butyl standing seam tube caulk been installed up-slope and adjacent to the tape mastic?
- Y N Is the outside closure mastic placed properly?
- Y N Is the 3-inch pre-cut mastic being placed over the notch area at the ridge/high eave before the outside closure is being installed?
- Y N Is the panel seam notched to receive the outside closure?
- Y N Were the outside closures installed as the roof was being erected for proper coverage and alignment?
- Y N Was mastic installed on top of the closures?
- Y N Was the 3-inch pre-cut mastic applied over the panel notch and butt joint of the closures?

Is the ridge cap installed properly, including:

- Y N Was caulk applied at the ridge cap end laps?
- Y N Is there five fasteners used to install the ridge cap to EACH closure?
- Y N Do not install fasteners at the ridge cap end laps?

### GENERAL CONDITION

- Y N Are the roof panel runs installed straight?
- Y N Are there any damaged panels installed?
- Y N Are perimeter clips installed? (If required)
- Y N Are the panel clips attached to the purlins or bar joists with two fasteners?
- Y N Are there clip fasteners seen at EVERY panel side lap and purlin/joist intersecting point?
- Y N Has all pencil lead and markings been cleaned from the panels?
- Y N Have all metal shavings, dirt, etc., been cleaned from the roof?
- Y N Are the HVAC units draining into the gutter with PVC piping?
- Y N Has the roof curb framing/flashing been installed properly?
- Y N Has treated lumber been avoided as a means of supporting piping and other roof accessories?
- Y N Are the downspouts been properly spaced according to the erection instructions?
- Y N Are the downspout openings in the gutter cut to the proper size to allow for adequate water drainage?
- Y N If the Panel Craft is being installed over a non-Horizon structure, has the Engineer of Record reviewed the purlins for adequate bracing?
- Y N Have lead, iron or copper pipes been coated or painted to protect against corrosion with the Galvalume?

**DUE TO THE PROCESS OF CONTINUOUS IMPROVEMENT, THE  
PRODUCTS AND PROCEDURES IN THIS MANUAL ARE SUBJECT TO  
CHANGE WITHOUT NOTICE**