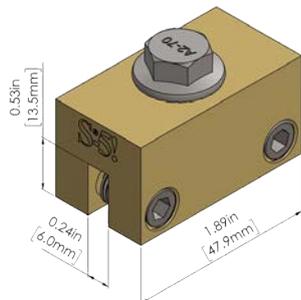
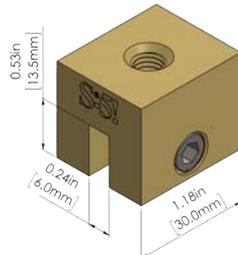


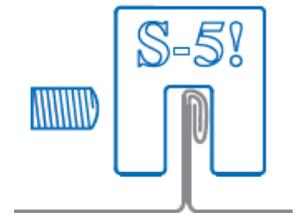
B-Clamps



S-5!® B-Clamp



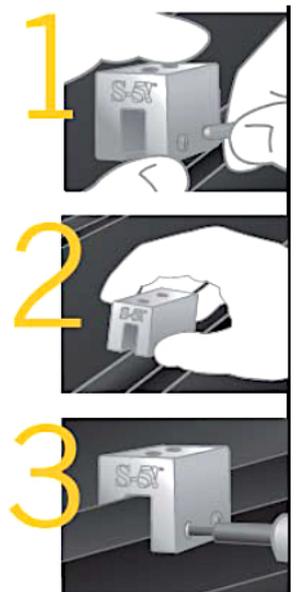
S-5!® B-Mini



To install the S-5!® B-Clamps:

The S-5!® B-Clamps, made of Brass, are designed for Copper double-folded standing seam paneling. The material properties of the respective metals, the brass B-Clamps and the combination with each other must be checked in advance due to possible contact corrosion.

- Partially thread the setscrews into the clamp by hand. Determine how to position the clamp. When attaching to machine-folded seams (regardless of panel profile and geometry), S-5!® B-Clamps are designed to engage the seam, as shown in illustration on the top right, with setscrew opposite seam fold.
- If the foot of a sliding clip extends into the clamping area of the clamp, the thermal elongation of the seam can be hindered. The clamps must then be placed at a distance of approx. 25 mm from the sliding clip.
- The set screws are fitted with the S-5!® mounting bit with a tightening force of 15 -17 Nm.
- Tighten the set screws on the B-clamps and tighten both again.
- Many screw-drivers do not always offer a constant tightening force. The tightening force must therefore be checked with a calibrated torque wrench and the set screws tightened if necessary.
- If an M8x16 stainless steel screw is used for the installation in the M8 thread on the top side, it must be tightened with a torque of 18 Nm.



Please note in general:

- Please make sure that the load coming into the clamp will be taken by the structure of the roof. Assumption is that the determination has been made that the roof to which the S-5! clamps will be attached is structurally adequate. Any loads imposed on the S-5! clamps will be transferred to the panels. Panel seams must have sufficient flexural strength to carry these loads. Panels must also be adequately attached to the building structure, and the structure must be sufficient to carry these loads. In particular, the snow and wind loads, the additional loads from the installations attached to the clamps, as well as the increased loads in the edge and corner areas of the roof construction must be considered.
- A sufficient number of clamps must be provided. For statically relevant clamps, a distance of at least 500mm from the end of the standing seam profile must be maintained. RoofTech and the makers of the S-5! clamps make no representations with respect to these variables. It is the responsibility of the user to verify this information, or seek assistance from a qualified design professional or stress analyst, if necessary.
- Responsible for the stability of a building structure is the building owner or the owner or operator. The installer is responsible not only for the installation but also for the roof on which the system is installed. Whoever installs a system on an existing roof without having checked the stability beforehand, violates existing law! For critical installations, inquire for specific test data of ultimate tensile load on specific panel materials and seam types. The sufficient holding force of the roofing to the supporting or substructure must always be ensured. The sufficient holding force of the roofing on the supporting or substructure must always be guaranteed. Proof must be provided by the customer or installer. In cases of doubt, a structural engineer must be consulted to determine the loads and its effects.
- In the case of handcrafted metal roofing on wooden formwork, the edge and corner areas should not be covered with installations, PV-modules etc. due to the limited load-bearing capacity of the roofing and the adhesives. In the central area, the skipping of seams is usually not possible. Therefore, we recommend to install clamps on each seam. The installation of e.g. PV systems represents a punctual load entry; therefore, we recommend reduced clip distances and screwed clips. The mounting and fastening of the clamp should be carried out between the clips to achieve an optimal load sharing.
- When mounting rigid objects such as rails, pipes, cable trays, etc. on the clamps, they must be separated at regular intervals (max. 3m) in order to limit deformations due to thermally induced length changes of the mounted materials.
- The material properties of the respective metals, the combination with each other as well as the installation instructions and regulations of all manufacturers involved (including those of the metal roof) must be observed.
- S-5! Clamps are not suitable as fall protection applications. The S-5! clamps may only be used for this purpose in a certified and approved fall protection system. The respective system provider is responsible for this and must provide proof of this.
- The user and/or installer must always clarify in advance the application possibilities and application of our products in connection with the other used materials and products at the single project. The user and/or installer of all our products is responsible for all necessary engineering and design to ensure that the S.5! clamps and other products has been properly spaced and configured.
- RoofTech GmbH and S-5!® - Metal Roof Innovations Ltd. recommend that the planned installation, PV system, snow guard system, etc. should be verified by a qualified professional who is responsible for the snow and wind loads, the additional loads from the installations attached to the clamps, the statics and assembly as well as the planning and construction of and on metal roofs.
- The photographs and drawings herein are for the purpose of illustrating installation, tools and techniques, not system designs. RoofTech GmbH and S-5!® - Metal Roof Innovations Ltd. do not assume any liability. S-5! products are protected by international patents of Metal Roof Innovations, Ltd..
- RoofTech GmbH and S-5!® - Metal Roof Innovations Ltd. assume no responsibility and liability for assembly, suitability and applications.