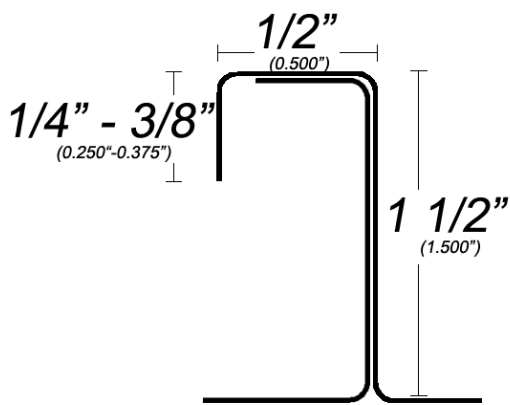


This machine is setup to seam
1.5" panel - 180° seam



Instructions to change this setup
are included in this Guide.

(You may discard this page.)



D.I. ROOF SEAMERS

Roof Seaming. Easier.™

CONTRACTOR SERIES ROOF SEAMER UNIVERSAL CONVERSION KIT

PLEASE DISTRIBUTE TO THE ERECTION CREW

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5676 PROGRESS STREET
NIAGARA FALLS, ONTARIO L2G 0C3

Contact us at 1-888-343-0456 or online at www.diroofseamers.com

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

GUIDE REVISION INFORMATION				
ACTIVITY	ADDENDUM RELEASE #	PAGES REVISED	RELEASE DATE	AUTHOR
MOST RECENT	#2	Format Change	4/7/2014	JLR
PREVIOUS REVISIONS	#1	Original Release	2/17/2014	JLR

PURCHASER INFORMATION

- If any inconsistencies appear in the seam or if you have any questions, problems, etc. **STOP SEAMING** and contact Technical Support at **1-888-343-0456** immediately.
- Follow all safety suggestions, warnings, etc. in this guide and posted on the machine itself.
- This tool has a six (6) month limited warranty. Please contact us for detailed information at 1-888-343-0456 or visit us at www.diroofseamers.com.

Your Contractor Series Roof Seamer motor requires a 20 amp, 100-125 volt AC power supply. Poor performance and motor damage can result from use of an improper power supply.

Recommended extension cord size:

Distance (FT)	0-50	50-100	100-200	200+
Wire Gauge (AWG)	12	10	8	6

MAINTENANCE RECOMMENDATIONS

- Clean tooling DAILY with Mineral Spirits, or as needed, due to contaminants.
- If you must remove or replace tooling, place ONE DROP of Loctite® 222 (purple) on the threads of the bolt before putting it back into the machine to prevent the bolts from backing out.
- When not in use, always store your Roof Seamer in a dry place to prevent damage to the machine. NEVER operate it in inclement weather such as rain or snow.

**READ THIS FIELD GUIDE COMPLETELY
BEFORE ATTEMPTING ANY CRIMPING
OPERATIONS!**

SERIOUS INJURY OR DEATH MAY OCCUR!

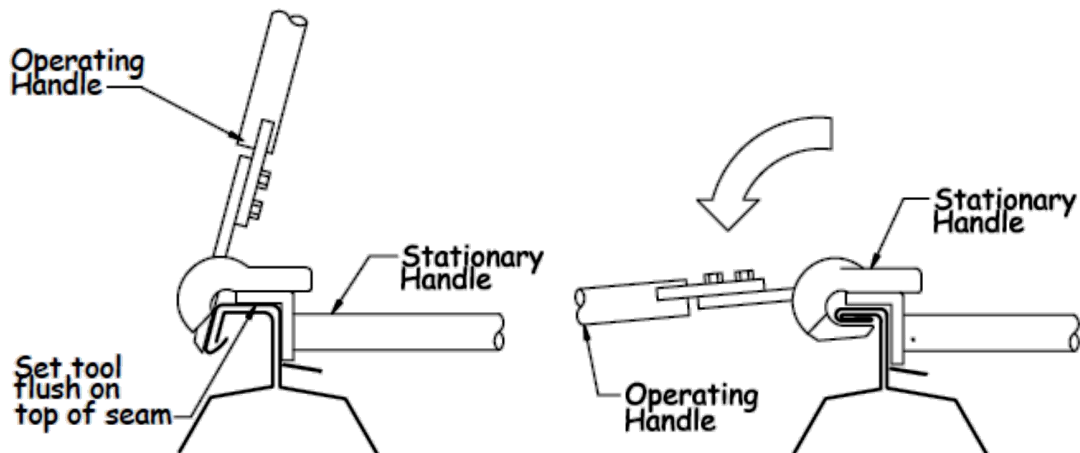
OPERATING YOUR ROOF SEAMER

Before beginning, ensure that the panels are installed correctly and are free of all debris and contaminants such as sand, snow, excessive fluids, sealant/mastic, tools, extensions cords, etc. Also, always attach a safety hook to a tether during any time the seamer is on the roof to prevent it from falling off.

It is recommended to “seam as you go.” In other words, seam the roof panels as they are being installed. This ensures that each panel is kept within module and installed correctly.

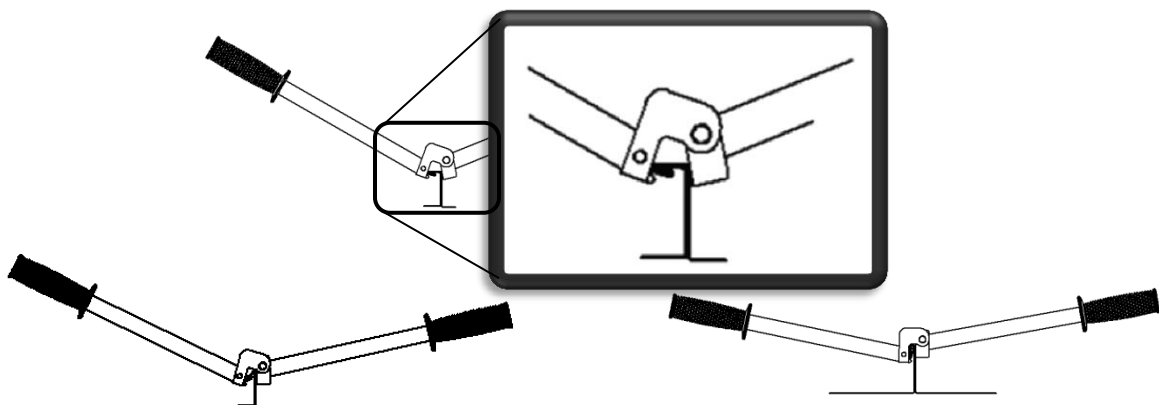
STEP 1

To begin, hand crimp 8”-10” of each panel at the beginning of the seam with the 90° (Single Lock) Hand Crimpers. If you are seaming a 90° profile, skip to **STEP 3**.



STEP 2

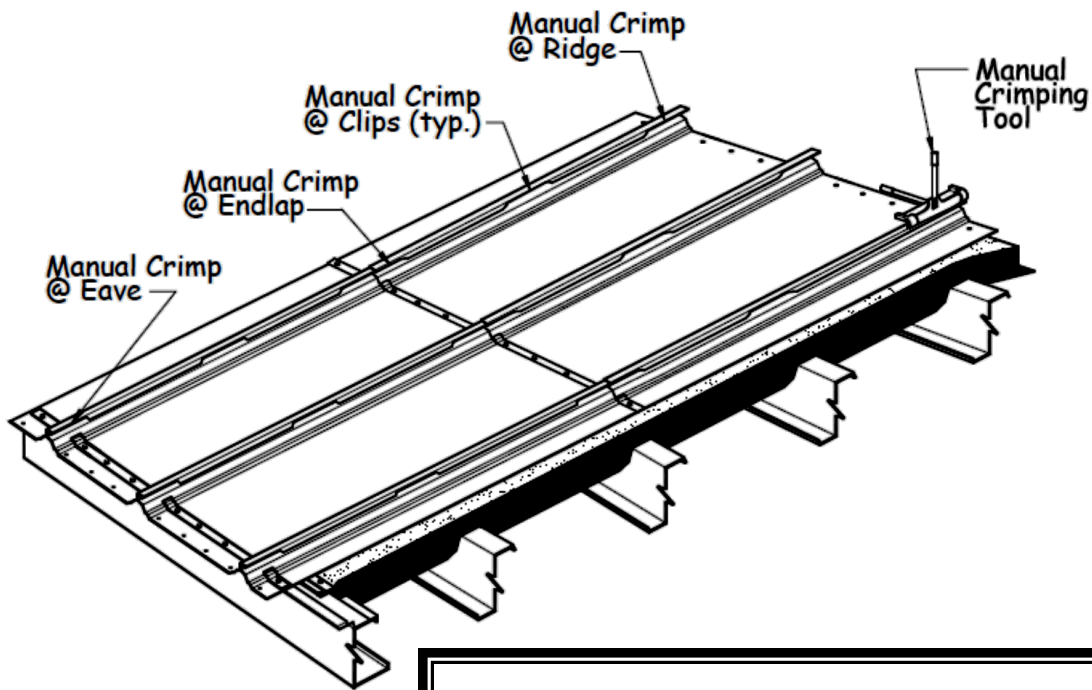
Next, hand crimp 5” at the beginning of the seam with the 180° (Double Lock) Hand Crimpers.



STEP 3

If the roof has already been installed, each clip must be hand crimped with a 90° (Single Lock) Hand Crimper to keep each panel safely in place.

Follow this diagram as a suggestion to crimping locations.



Always follow your roof panel manufacturer's suggestions and warnings for the installation of your particular roof system.

STEP 4

Next, place the machine on the hand crimped portion and engage the locking handle by pulling it out until it locks into place. Note: Ensure that the last set of tooling on the seamer is aligned over the Double Locked portion that was hand crimped. Connect the power supply into the quick-release plug near the handle of the machine and turn the machine on. Run the seamer for approximately 12" to ensure that you are receiving the desired seaming operation. If so, continue in this manner for the completion of the run.



It is important to remember to use extreme caution when reaching the edge of the roof. Stop and disengage the locking handle of the seamer while the wheels remain on the roof panel. Do not run the seamer within 6" of the end of a panel, beyond the end of a panel or over a previously seamed area. Use your hand crimpers to finish any area that the seamer may not be able to complete, such as against a ridge cap, end cap or at a pitch change in the roof.

Note: The Roof Seamer may leave dark forming marks on light colored panels. This is acceptable as long as the paint finish is not damaged. Marks can easily be rubbed off by hand – DO NOT use solvents that will soften or remove paint.

CHANGING THE SEAMER SETUP

The Universal Series Conversion Kit for the Contractor Series Roof Seamer can produce 6 different finished seam profiles. With the use of this kit you can complete a 90° or a 180° seam on 1", 1.5" and 2" roof panels. It is important to note that this seamer is for use on panels without a male down leg and a material composition of 24 gauge steel or lighter. This machine can be used on various metals such as steel, copper, zinc and aluminum.

This kit includes all of the tools needed to convert your seamer to achieve the finished seam of your choice. You may access instructions to change the setups by visiting http://www.diroofseamers.com/seamers_CSuniversal.html or clicking on the setup number in the following chart. Reference these setup instructions to set your machine to produce the finished seam of your choice.

It is essential that your seamer is set correctly to achieve the proper finished seam. Each setup indicates the proper tooling, shims, guide wheels and gap settings needed to properly set your seamer to produce the desired finished seam profile.

SETUP INFORMATION

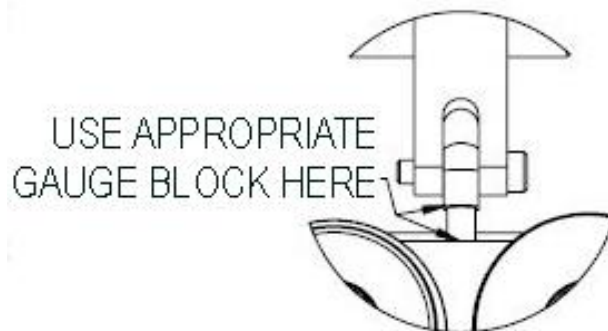
<u>Setup #</u>	<u>Finished Profile</u>
<u>1 (29001) Base Setup</u>	1.5" 180°
<u>2 (29002)</u>	1" 180°
<u>3 (29003)</u>	1.5" 90°
<u>4 (29004)</u>	1" 90°
<u>5 (29005)</u>	2" 90°
<u>6 (29006)</u>	2" 180°

TOOLING

Included in your kit is the proper forming rollers and drive rollers needed to set up your machine to produce the desired finished seam profile. All steel forming rollers are identified by part # on the roller itself and the setup. There are also two different diameters of fiber drive rollers. The 40004 drive roller has a diameter of 2" and the 40009 has a diameter of 2.5". All rollers must be installed according the setup sheet of the intended finished seam profile. Tooling can be removed by using the 1/2" open end wrench and removing the hex bolt from the axle of the tooling you wish to remove. It is important to remember that the axle is keyed and the key should not be lost when changing tooling. There is also a washer (30134) that holds the tooling on. It is important to note that some locations require shims between the washer and the bottom of the tooling to keep the tooling in proper position. Proper shim placement is called out on each setup.

GAP SETTINGS

Gap settings are located at the bottom of each setup page. These gaps are set by using the appropriate gauge block (Go/No-Go Gauge) and measuring between the eyebolt and the seamer chassis as indicated on the setup sheets. Failure to set these gaps correctly will result in a poor finished seam quality. A 5/32" Allen wrench and a 7/16" open end wrench are included in the kit to help make these adjustments. These tools are used to remove the shoulder bolt from the eyebolt so that it can be adjusted as needed. The appropriate gauge block for each setup is listed in the chart below.



<u>Setup #</u>	<u>Gap Setting</u>	<u>Gauge Block</u>
1	.300" +/-	30705
2	.300" +/-	30705
3	.355" +/-	30706
4	.355" +/-	30706
5	.385" +/-	30707
6	.385" +/-	30707

GUIDE WHEELS

There are three different size guide wheels included with your Universal Kit. These can be changed with the 3/16" Allen wrench. They are as follows:

30595 - 1" diameter for your 1" standing seam profile.

30050 - 2" diameter for your 1.5" standing seam profile.

30052 – 2.6" (< 2 5/8") diameter for your 2" standing seam profile.

SHIMS

Correct placement of shims is imperative when setting up your seamer. Please refer to the appropriate setup for details. Shims are as follows:

<u>Part #</u>	<u>Color</u>	<u>Thickness</u>
50047	Silver	.015 (1/64")
30310	Red	.0625 (1/16")
30147	Blue	.125 (1/8")

90° SETUPS

All 90° setups are bi-directional. This means that you can run up one seam and down the next. In order to use the seamer in this manner, the locking key (50272) must be removed so that the electrical switch can be moved to both the forward and reverse positions.

Only a 90° hand crimper is needed to start the seamer when using one of the 90° set ups.

All clip locations should be hand crimped to 90°.

180° SETUPS

All 180° setups must be run with the locking key (50272) installed in the electrical switch as indicated in the setup. Failure to install this key can result in damage to your seamer and/or your roof panels.

180° setups will run right to left and will complete the 180° finished seam in one pass.

The 180° setups will require the use of both the 90° and 180° crimpers to properly start the seamer. Please refer to the hand crimping portion of this guide for proper crimping instructions. Never do a 180° crimp ahead of the seamer.

All clip locations should be crimped to 90°.