



D.I. ROOF SEAMERS

Forming the Future Together™

CAP CURVER

PLEASE DISTRIBUTE TO THE ROOFING CREW

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

D.I. Roof Seamers
915 Highway 45
Corinth, MS 38834

Please Note: The Cap Curver produces CONVEX curves ONLY!

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	#7	1	9/14/23	RAN
PREVIOUS REVISION	#6	4	8/3/2022	RAN
PREVIOUS REVISION	#5	All	4/29/2021	RAN
PREVIOUS REVISION	#4	3rd	2/7/2017	RAN
PREVIOUS REVISION	#3	1st	11/19/2015	ECC
PREVIOUS REVISION	#2	All	11/04/2015	ECC
PREVIOUS REVISION	#1	Original Release	10/29/2015	MLW/ECC

READ THIS FIELD GUIDE COMPLETELY BEFORE OPERATION!

CAP CURVER SAFETY GUIDELINES

- Operators must always use PPE (Personal Protection Equipment).
- Never operate the machine while under the influence of drugs or alcohol.
- Operators **MUST** ensure that the cap feed and exit are clear of all obstructions.
- **KEEP** hands and feet clear of all tooling.
- Always unplug the machine when not in use.
- Always unplug the machine from the power source before adjusting, cleaning, or providing any routine maintenance.
- NEVER operate the machine in damp or wet conditions.
- Do NOT operate the machine when wearing long sleeves or loose-fitting clothing.

CAP CURVER OPERATING GUIDELINES

- Follow all safety suggestions, warnings, etc. in this guide and posted on the machine itself.
- If any inconsistencies appear in your cap or if you have any questions, problems, concerns, etc., **STOP** immediately and contact Technical Support at **1-888-343-0456**.
- Cleaning the machine may be required based on job site conditions. It is imperative that tooling be kept clean and free of debris. Failure to do so will result in damage to the material finish and material slippage.
- Tooling requires daily inspection.
- The machine must be level during operation.

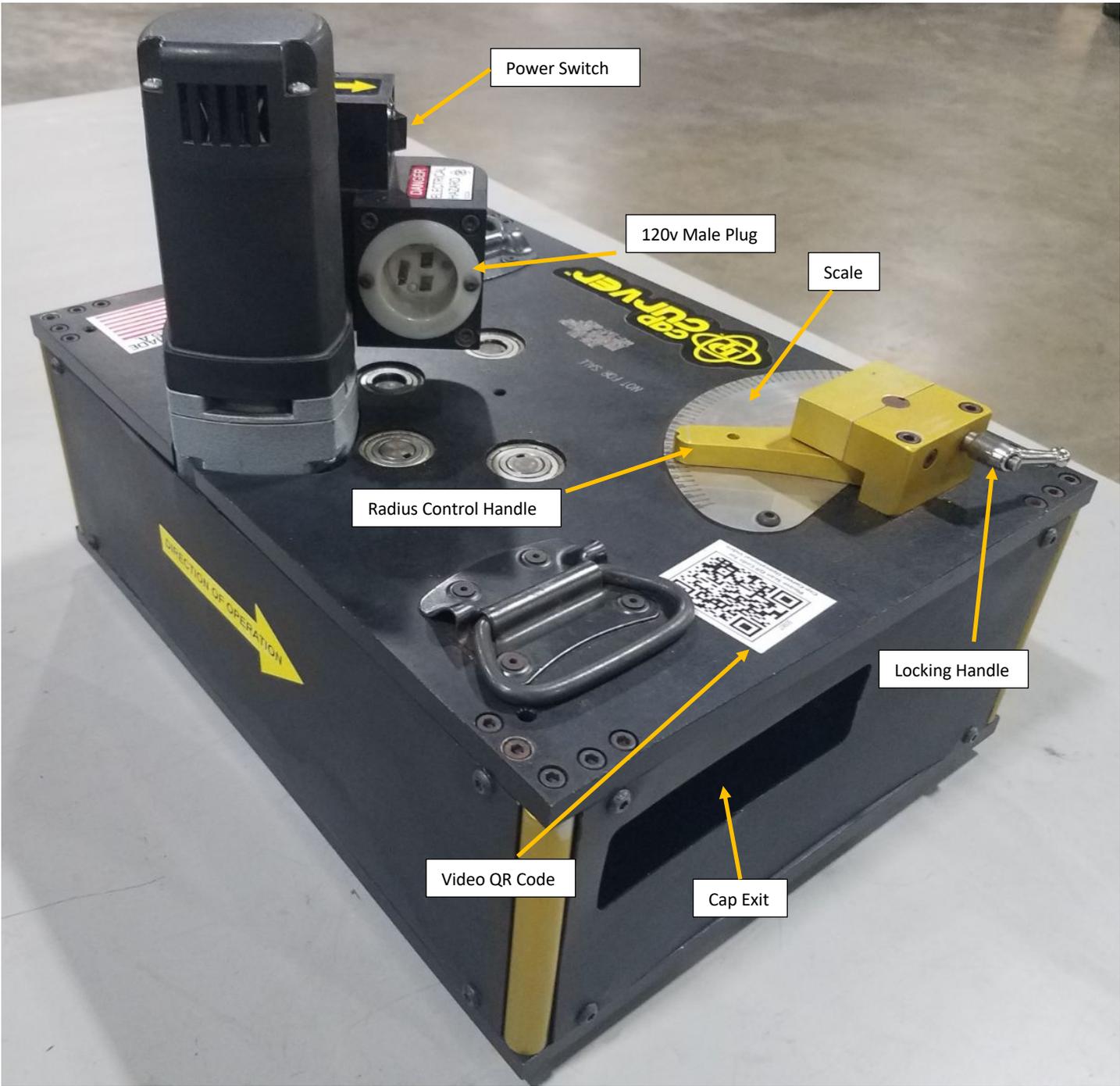
CAP CURVER 1 OPERATING GUIDELINES—CONTINUED

- The Cap curver is designed to curve narrow batten caps.
- Caps must always be supported on the feed side and exit side of the machine. Caps **MUST** be kept level entering and exiting the machine.
- When not in use, always store the machine in a dry place to prevent damage. NEVER operate it in inclement weather, such as rain or snow.
- Before operating the machine, you must ensure that the caps are free of all debris and contaminants such as sand, snow, excessive fluids, sealant/mastic, tools, extension cords, etc.
- Remove any protective plastic film that might have been applied to the metal caps by the manufacturer.
- Test and check your initial formed roof caps before forming additional caps. Field adjustments may be necessary for your application. Extra caps may be required for set up.
- Material handlers must follow the newly formed roof caps as the material exits the machine. Mark the ground with flagging or cones to alert others in the area where the material exits the machine.
- Formed roof caps need to be well supported when they are moved to the roof. A spreader bar and straps may be needed.
- This machine requires a 20-amp, 100–125-volt AC power supply. Poor performance and motor damage can result from the use of an improper power supply.

IMPORTANT

Required extension cord size:

Distance (FT)	0-100	100-200	200-300
Wire Gauge (AWG)	10	8	6



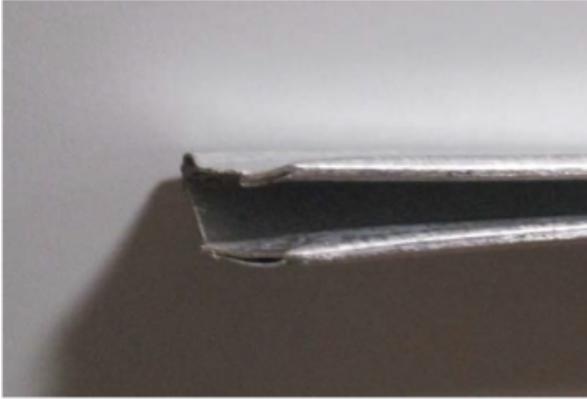
Operation Procedure

1. Remove the machine from the shipping container and place the unit on a stable and level platform with the controls facing up.
2. In most cases, the machine will ship to you preset to the radius submitted on your order. It is not uncommon for adjustments to be needed in the field. This is often due to differences between field materials and test materials. To adjust:
 - a. Turn the Locking Handle counterclockwise to unlock the Radius Control Handle.
 - b. Adjust the Radius Control Handle to a position that produces the radius needed for your application. Note: The indicators on the scale are for reference only and do not correspond with the actual radius of the cap.
 - c. Turn the locking handle clockwise to lock in the preferred setting.
3. Before running a cap be sure to note the direction the cap will enter and exit the machine.
4. Insert the narrow batten cap into the cap curver.



5. As the cap enters and exits the machine it must be supported every 10 feet.

6. If your caps are “flared” at the ends, as shown below, it might be necessary to snip the caps at a 45° angle on the end of the cap entering the curver.



7. To do this:

- a. Snip the bottom corner of the batten cap to a 45° angle. This action both clears the corners and closes the flare on the end of the cap.



8. Verify you completed panels radius on the roof before proceeding with other caps.