

## Installation Instructions

**S-5!<sup>®</sup> Warning!** Please use these products responsibly! Visit our website or contact your S-5! distributor for available load test results. The user and/or installer of these parts is responsible for all necessary engineering and design to ensure the S-5-S, S-5-E, or S-5-B has been properly spaced and configured.

**Notice to S-5! users:** Due to the many variables involved with specific panel products, climates, snow melt phenomena, and job particulars, the manufacturer cannot and does not express any opinions as to the suitability of any S-5! assembly for any specific application and assumes no liability with respect thereto. S-5! products are tested for ultimate holding strength on various profile types and materials. This information is available from the S-5! website: [www.S-5.com](http://www.S-5.com). This document is an installation guide only and the photographs and drawings herein are for the purpose of illustrating installation tools and techniques, not system designs.

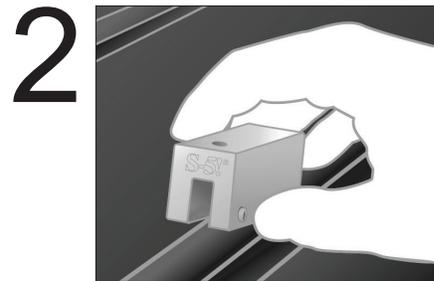
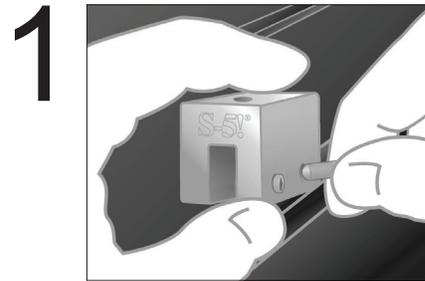
**The S-5-S, S-5-E, and S-5-B clamps are designed to fit typical standing seam profiles.** When attaching to machine folded seams (regardless of panel profile and geometry), S-5! clamps are designed to engage the seam as shown\*. For horizontal seam applications, the setscrews must be accessible from the top for tightening.

## Tools Needed

- Screw Gun
  - 3/16" Allen Bit Tip (Provided)
  - Dial-Calibrated Torque Wrench\*
- (\*For accurate tension values, do NOT use a clicking torque wrench)

## To Install S-5-S, S-5-E, or S-5-B (and Minis)

1. Partially thread the setscrew(s) into the clamp by hand.
2. Determine how to position the clamp. On many snap-together type seams, the setscrew(s) are opposite the open (or overlap) side of the seam. On some seams, this aspect of clamp orientation is not critical.
3. Tighten the setscrew(s) at the base of the clamp using a screw gun and the included screw gun bit tip. For optimal holding strength, setscrew(s) should be tensioned to 160 to 180 inch pounds on 22ga steel, and 130 to 150 inch pounds on all other metals and thinner gauges of steel.



**\*S-5! clamps are designed to engage the seam.**

### S-5!<sup>®</sup> Warning! Please use this product responsibly!

Products are protected by multiple U.S. and foreign patents. Visit the website at [www.S-5.com](http://www.S-5.com) for complete information on patents and trademarks. For maximum holding strength, setscrews should be tensioned and re-tensioned as the seam material compresses. Clamp setscrew tension should be verified using a calibrated torque wrench between 160 and 180 inch pounds when used on 22ga steel, and between 130 and 150 inch pounds for all other metals and thinner gauges of steel. Consult the S-5! website at [www.S-5.com](http://www.S-5.com) for published data regarding holding strength.

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These instructions are for use by those experienced in the trade. Always follow appropriate safety precautions and use appropriate tools.