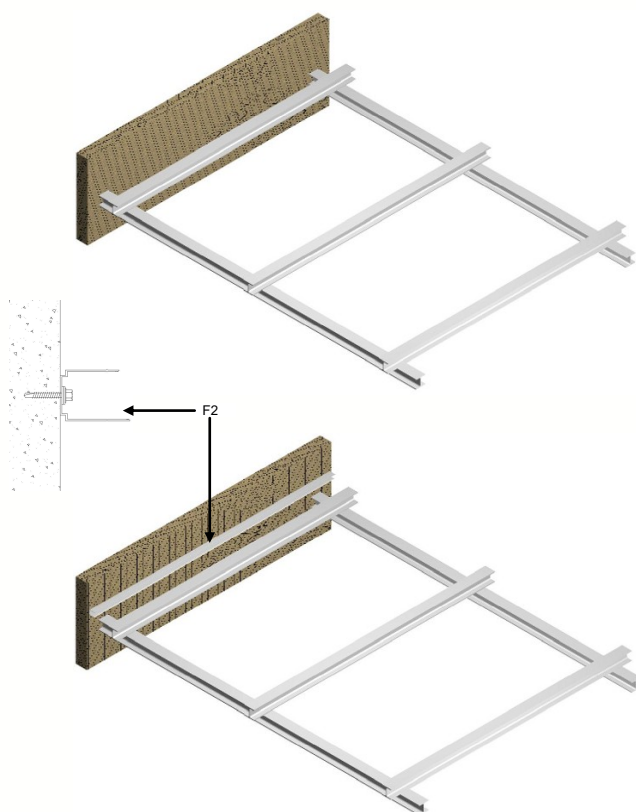


# INSTALLATION GUIDE FOR SYSTEM 655 PITCHED GLAZING

1) First ensure the linearity of the surface you wish to glaze and position purlins to meet the required snow load or non fragility classification.

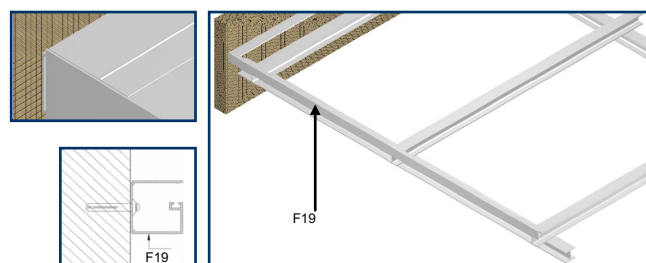
If the upper support is close to the top of the slope and no wall plate or securing angle is being used then the F2 upper profile can be fixed directly to the wall with suitable screws placed every 500mm. The F2 profile should be angled as necessary to suit the roof slope.

Note: on open canopies which do not abut a wall, or where it is not desirable to mechanically fix to the wall, the F2 upper profile can be fixed to the system glazing channels with suitable screws or bolts after the sheets have been installed.



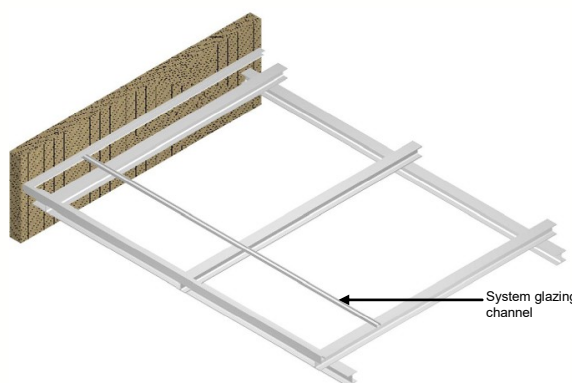
2) Locate the first F19 side profile - the side profile slots within the F2 upper profile. The F19 can be screwed down to all the cross supports or if the glazing system abuts a wall on this edge the F19 profile can be secured to this wall with suitable fixings.

Seal all the joints between the framing profiles and the wall or supporting structure.



3) Insert one system glazing channel inside the upper profile and locate it in the required position. Next secure the channel with suitable stainless steel low profile fixings to the purlins and to the wall plate/securing angle where used.

Note: for 3mm thick steel glazing channels pre-drilling pilot holes for screws is advised.



# **INSTALLATION GUIDE FOR** **SYSTEM 655 PITCHED GLAZING**

4) Cut off one hooked side of the first sheet to the required width as determined by the overall glazing run. Hand or power saws for metal or wood are suitable for cutting polycarbonate sheet.

Note: take care to remove any swarf generated from within the sheet chambers and when handling cut edges.

5) Slot the cut edge of the sheet within the aperture of the F19 side profile and clip the remaining hook into the first glazing channel. The sheet pushes up within the F2 upper profile.

Note: it may be necessary to notch the edge of the sheet slightly to fit round any fixings used to secure the F19 side profile down to cross supports.

Then insert another channel inside the F2 upper profile one sheet width away (655mm) and secure as before.

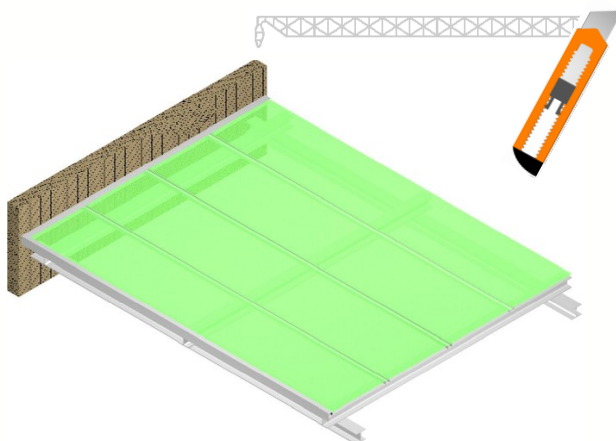
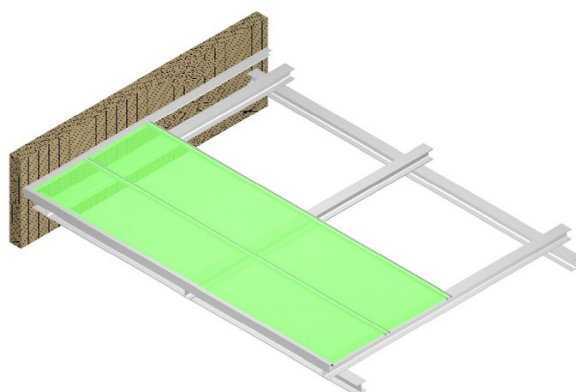
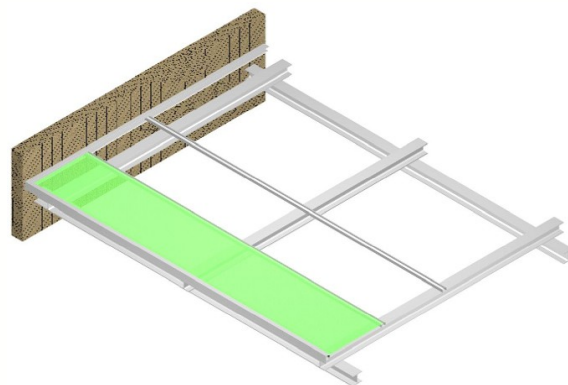
6) Next push fit another sheet into the F2 upper profile and the second glazing channel. Then fit it in the channel where the first sheet has already been clipped in - use of some force will be required to engage the sheets within the glazing channels.

Proceed like this until the last but one sheet is reached.

7) Cut the very last sheet to the correct width in order to suit the overall size of the glazing.

Then secure the last glazing channel to the cross supports and insert the hook of the last sheet into this channel.

System 655 - 16mm thick x 655mm wide multiwall polycarbonate sheet



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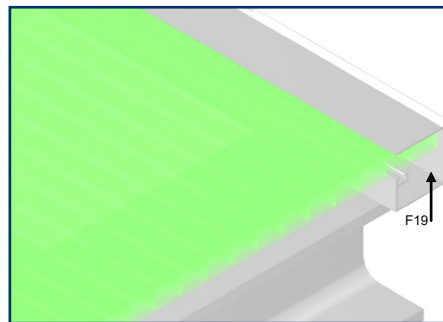
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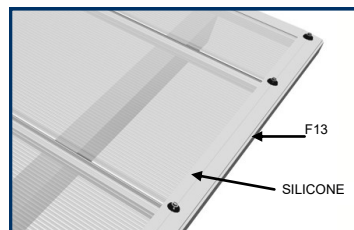
**01676 523386**  
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# **INSTALLATION GUIDE FOR** **SYSTEM 655 PITCHED GLAZING**

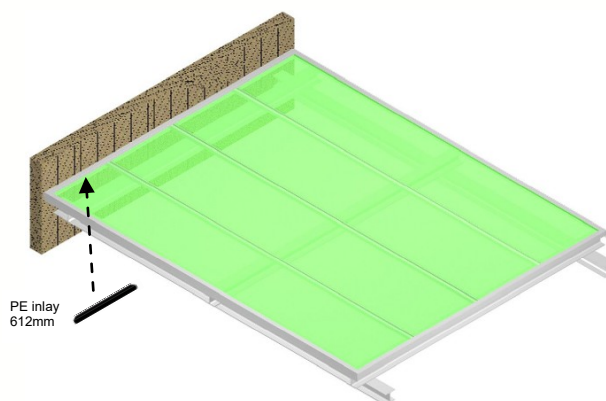
8) Position and fix the remaining F19 side profile and seal the joint against the framework if necessary.



9) At the bottom end of the slope fit the F13 lower profile over the sheets, glazing channels and side profiles. The F13 can be secured to the glazing channels and side profiles from above or below using suitable fixings or bolts. Ensure the vents/weep holes in the F13 profile are on the underside of the glazing. Once secure, seal the junction of the F13 and sheet with a suitable polycarbonate grade silicone sealant.



10) To finish the installation - at the top insert the 612mm PE foam inlays, which push fit, inside the F2 upper profile between the glazing channels. If access to the underside cannot be achieved after the installation, fit PE inlays when inserting each sheet as you progress along the roof.



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### General Notes:

- Minimum roof pitch recommended is 5 degrees.
- For low pitched roofs a bead of clear silicone is also advised between the F2 upper profile and top of the sheets in addition to any upper flashing.
- If using long sheets it may be necessary to join side profiles on top of a purlin to match the sheet length. Here seal around the butt joints with silicone.
- Do not fix all the glazing channels first and insert all the sheets after, instead proceed with securing channels and sheets alternately.
- For enclosed roofs 1300mm PE foam inlays can also be fitted on the eaves support/bottom purlin and uppermost support where necessary for draft proofing. Insert these before fixing glazing channels.
- Sheets fit tightly into the specially designed glazing channels - use of force with rubber mallets/timber blocks or similar may be necessary. The channels may require some additional bracing during this part of the installation especially in the case of large spans between supports.
- For open canopies which use sheets and channels less than 5mtr in length, the F2 upper profile and F13 lower profile can be substituted for smaller F3 universal profiles to provide an even look. In this case weep holes should be drilled in the lower F3 profile at the location of each glazing channel. Also for best fitting the F3 profiles should be notched out at the ends to accept the F19 side profiles.
- Ensure the 612mm PE inlays are installed the correct way around so a tight fit is achieved.
- If cutting sheets to length remove swarf and re-seal sheets with suitable adhesive breather tape.

The above instructions are intended for standard applications, please contact Rockwell's Technical Department for any queries relating to the installation of System 655.