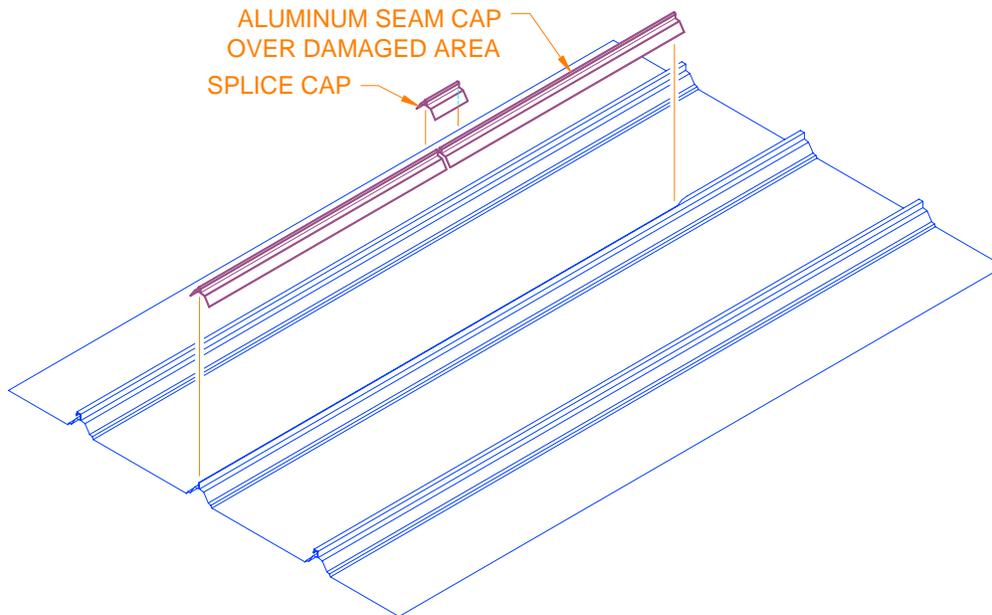




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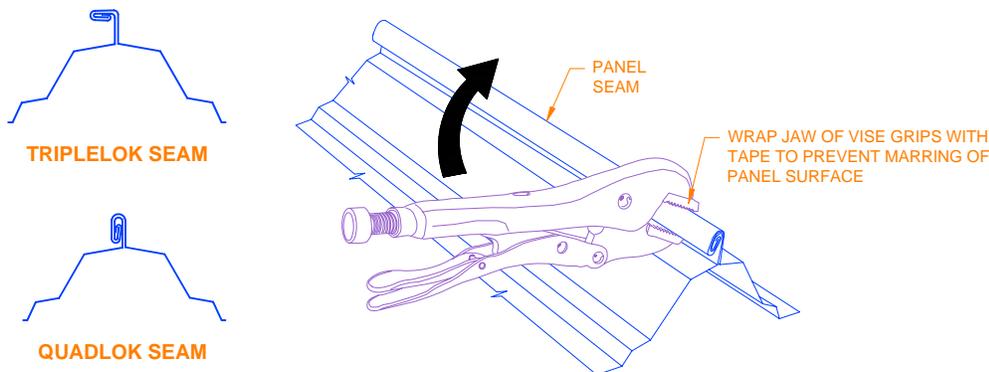
TS-324™ Side Seam Repair Procedure Utilizing LM Curb's Aluminum Seam Caps

The following procedure is designed to help in repairing a damaged standing seam incapable of being mechanically seamed (or false seamed) utilizing material supplied by LM Curbs, Inc.



Step 1 - Seam Prep.

If the roof has been Quadloked (180° seam), the ends of the damaged area will require the Quadlok seam to be opened slightly. This is to ensure the drilling procedure, described later, will not drill into the stem of the panel. Open approximately 6" of the seam slightly with a pair of vise grips and shown. This step is not necessary if the seam has only been Tripleloked.



TO OPEN A CLOSED (QUADLOK) SEAM FOR DRILLING.....

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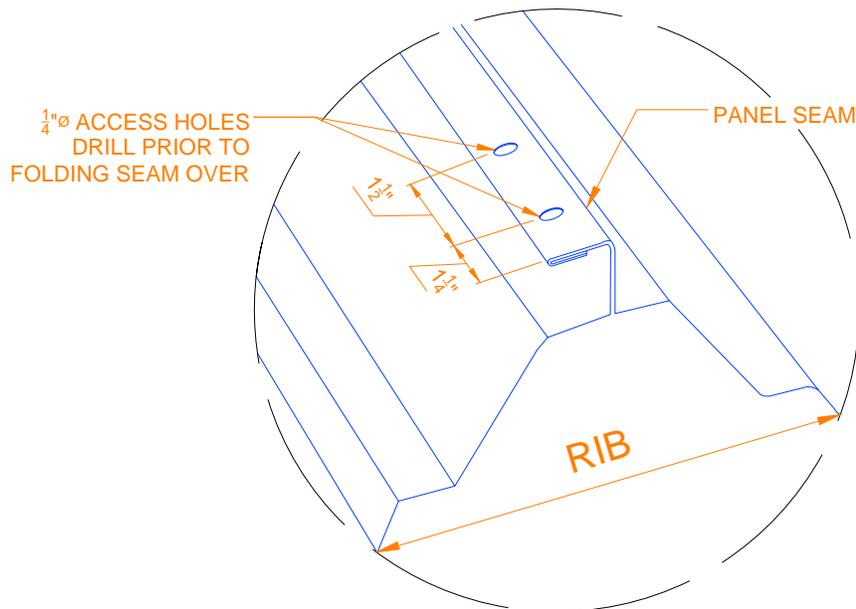
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Step 2 - Seam Drilling

Mark the hole locations at each end of the seam repair area, where you opened the seam. Drill $\frac{1}{4}$ " \varnothing holes as dimensioned. It is recommended to pre-drill $\frac{1}{8}$ " \varnothing holes first. Maintain a minimum of $1\frac{1}{4}$ " from the end of the panel if the damaged area extends to the end of the panel. **Be sure to remove all the drill shavings from the roof.**



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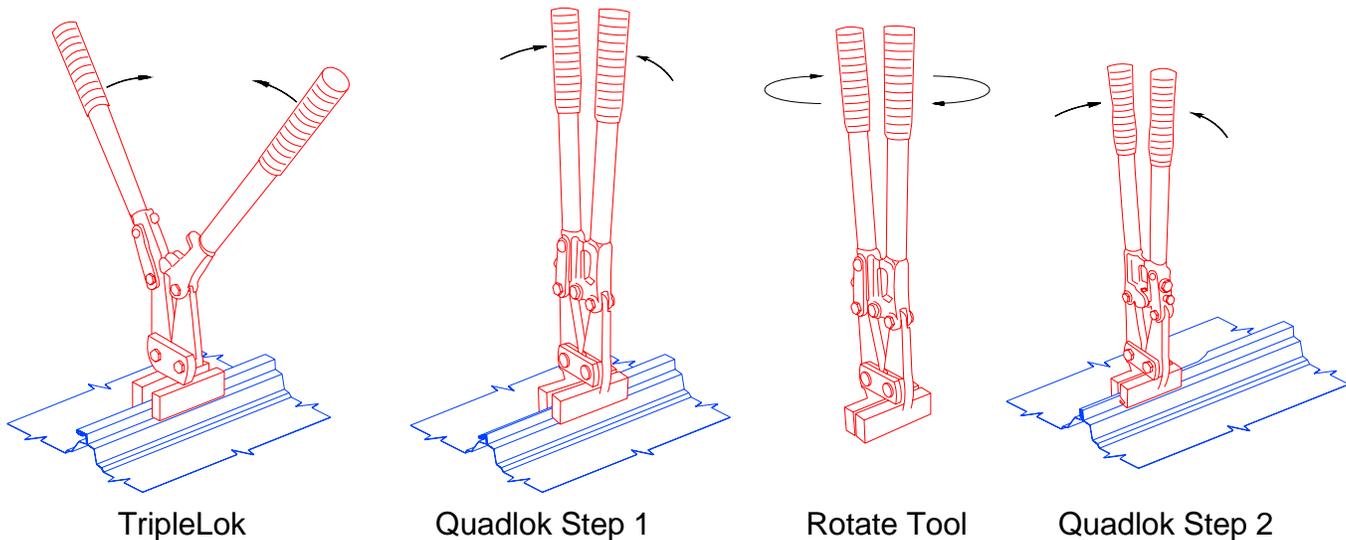
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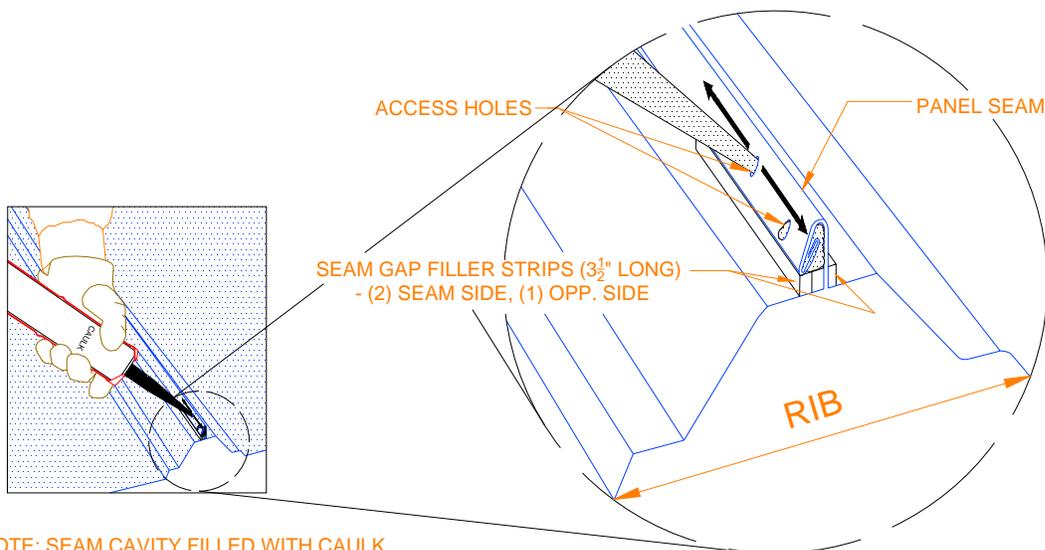
Step 3 - Quadlok Seam

Quadlok the entire damaged area of seam. The entire seam between each set of drilled holes should now be Quadloked. If the roof system has already been Quadloked, then only Quadlok the area you opened for the drilling step (see Step 2).



Step 4 - Panel Seam Sealant & Caulking

Cut three 3½" long strips of ¼" tape sealant for each drilled section. Two of the pieces are to be inserted just below the seam and forcefully pushed into the area between the seam and the horizontal leg of the panel seam. The last piece of ¼" tape sealant is applied to the back side of the seam. Once the ¼" tape sealant has been applied then tube caulking is to be injected through the ¼"Ø drilled holes. The tube caulk should be **slowly** injected into each hole until it is seen forcing its way out beyond the ¼" tape sealant.



NOTE: SEAM CAVITY FILLED WITH CAULK THROUGH FIELD DRILLED ACCESS HOLES

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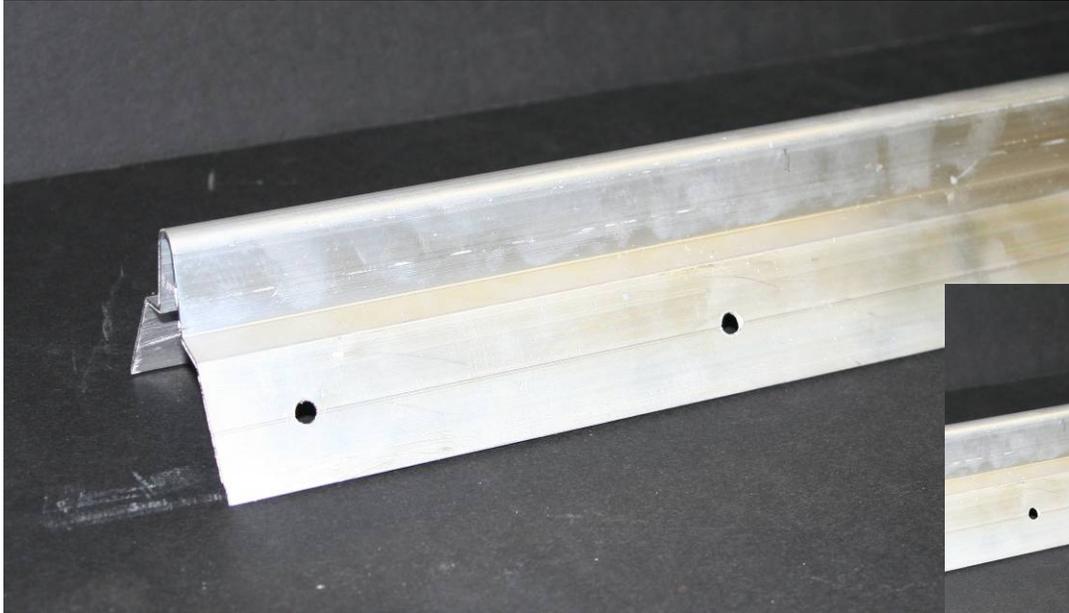
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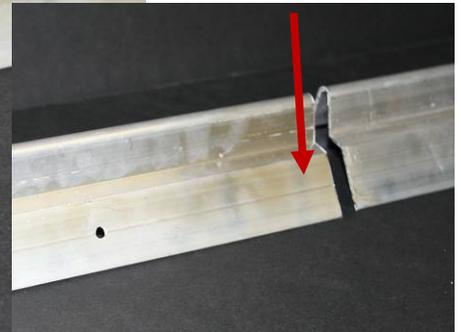
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Step 5 - Seam Cap Pre-drilling

Pre-drill $\frac{1}{4}$ " \varnothing holes in the 12'-6" side seam repair cap supplied by LM Curbs, Inc. Use the groove in the long leg of the repair cap to locate the holes vertically. These holes should start 1" from the end of the seam repair cap and continue at maximum of 1'-0" o/c down the length of the repair cap. **DO NOT** drill a hole at an end where there will be a splice cap (for applications requiring more than one cap). Where there is a splice cap, the hole should be held back 6" from the end of the repair cap.

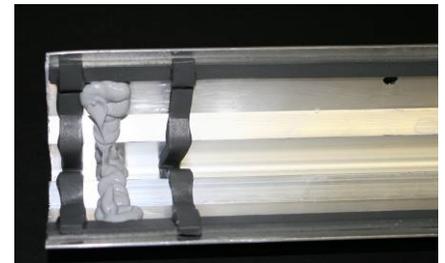
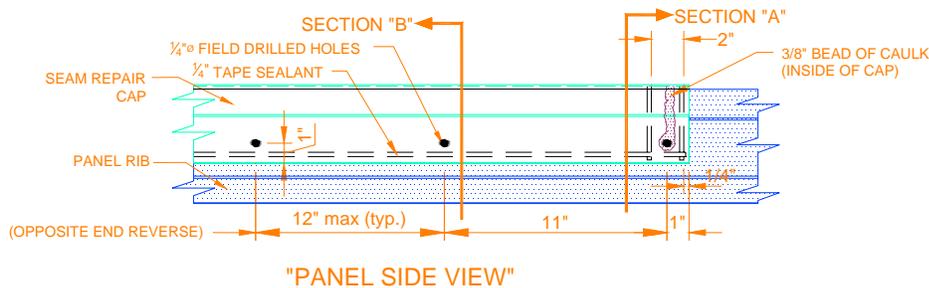
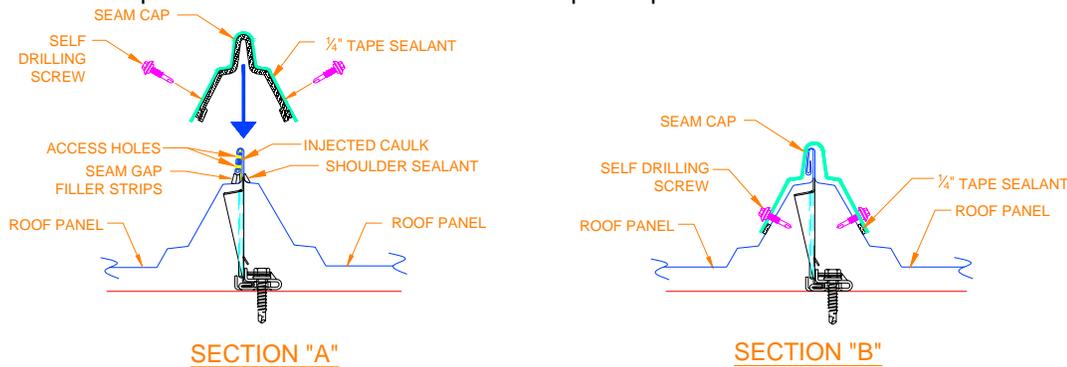


No holes 6" from end at splice.



Step 6 - Seam Cap Sealant Application

Install $\frac{1}{4}$ " tape sealant and tube sealant to the repair cap.



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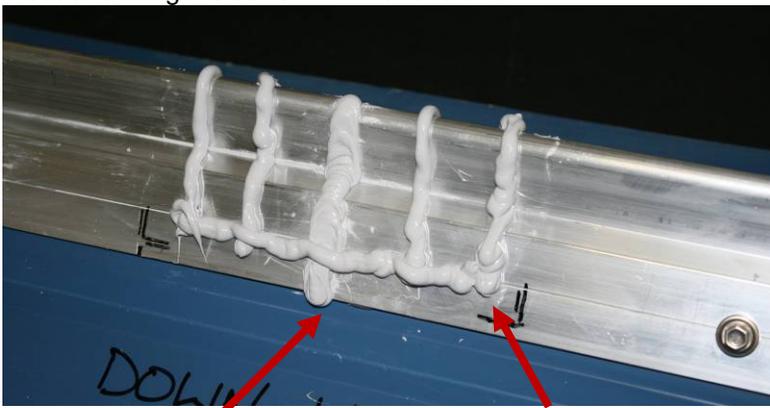
Step 7 - Seam Cap Installation

Install repair caps to damaged seam and install roof fasteners through pre-drilled holes in repair cap. Maintain a minimum of ¼" gap between the repair caps to allow for expansion/contraction of the repair caps. If needed, apply pressure to the top of the repair cap to allow the repair cap to follow the profile of the panel seam.



Step 8 - Splice Cap Prep.

Dry fit and mark the end location of the splice cap. Install a bead of sealant in the ¼" gap between repair caps. This sealant should completely bridge the ¼" gap. Install two vertical beads of tube sealant on each side of the splices with a bead running the bottom from end to end.



Bead of tube sealant bridging the ¼" splice gap

Two beads of sealant with a bridge at the bottom.

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Step 9 - Splice Cap Installation

Pre-drill $\frac{1}{4}$ " \varnothing holes in the uphill side of the splice cap **only**. Install the splice cap at each splice.

