GENERAL DESCRIPTION: The Industrial Series Gutter System is an exceptionally strong gutter product for industrial & commercial type buildings. The gutter is attached to the building with an assembly of brackets and your order may also contain other accessories such as mitered corners. As part of this set of instructions there are several drawings which show the component parts and accessories and how they are applied. Please take a moment to review these drawing so you may become familiar with the terms used in this instruction guide.

SKILLS & TOOLS REQUIRED: While the Industrial Series gutter system is designed for easy installation it is not designed for installation by those not knowledgeable in the trade such as a home owner. This product requires the experience of a skilled sheet metal mechanic for a proper installation. Basic sheet metal tools required for normal gutter installations are all that is necessary for a proper installation.
INDUSTRIAL GUTTER INSTALLATION INSTRUCTIONS

GENERAL NOTES: Our gutters are installed in the left to right direction (left to right is read as you stand on the roof and face ground level). This installation instruction assumes that you are starting from an end cap position, see the mitered corner drawing when starting from those conditions. Industrial gutters require expansion joints at 40’ intervals (every 4th piece).

Unless so stated on your order, sealants (caulk) and fasteners are not included with your order. We recommend a high grade clear silicone (such as GE) or gutter seal as manufactured by 3M. Use aluminum rivets (with aluminum mandrels) 1/8” x 1/4” for connecting the gutter lap joints (maximum spacing of rivets shall be 2”) and 1/8” x 3/8” rivets for connecting the inside straps. Use #10 x 1” stainless screws to fasten the gutter’s rear edge to wood plates. Review the architectural specifications for the required support bracket fastener(s); since the product is designed to withstand snow & ice loads it is important to use the correct fastener(s) for this bracket. If architectural specifications do not state fastener type use #10 x 2” flat head stainless screws.

Our Industrial Gutters are available in custom sizes & shapes. These instructions apply to such custom applications as well.
INDUSTRIAL GUTTER INSTALLATION INSTRUCTIONS

GUTTER INSTALLATION:

STEP 1: INSTALLING THE SUPPORT BRACKETS, beginning at the left side of the building’s roof edge install enough support brackets to “run or hang” 4 sections of gutter (17 brackets). The 1st bracket shall be located 1” from its center to the buildings’ end, and the remaining brackets shall be installed at 30” centers.

Sloping of gutters is achieved with the proper installation of the support brackets. The best way to allow for slope is by chalking a line on the buildings exterior and fastening the support brackets according to that line. The gutter system will not accommodate a slope greater than 1/8” in 10’ (one section), nor more than 1/2” in 40’. Slopes greater than this are not necessary.

One final note on support bracket installation, the high point bracket should be installed flush with the top of the wood plate (at the roof surface) with the remaining brackets not exceeding 1/4” below this level. This will allow for proper flashing of roof to gutter when using SAF-Perimeter Systems gravel stop or trims. If you elect to install your support brackets at a lower point, be sure to check and see that your corresponding flashing will accommodate this condition.
INDUSTRIAL GUTTER INSTALLATION INSTRUCTIONS

STEP 2:

Fasten the rear upper edge of the gutter with stainless screws through the pre-punched slotted holes. The screw should center the hole and screwed to the point that it is snug to the gutter surface but does not warp or bind the gutter. **DO NOT OVER TIGHTEN THESE SCREWS,** the idea is to let the gutter float to allow for thermal movement. Prior to installing the next gutter, apply sealant to the inside right edge of this gutter ¾” from edge – sealants must be between the lap joints and shall be applied in sufficient quantity to ooze out into view on the interior gutter surface. Remove this excess sealant.

Industrial gutters are tapered with their left hand end having a notched lip and being slightly smaller in size than its’ right end. This allows for a 1” telescoping lap joint. Once in position, rivet the joint with 1/8” x 1/4” at 2” centers. Touch up the rivet heads with sealant and be sure to check the joint for any sealant voids. As an alternate, you can “pre-assemble” four (4) gutter sections together and place the assembly into position at one time. Of course you will need additional man power to handle such large sections. Fasten the rear edge of the gutter with stainless screws through pre-punched holes in a snug manner as mentioned earlier. At this time, install your downspout outlets.
INDUSTRIAL GUTTER INSTALLATION INSTRUCTIONS

STEP 3: INSTALL EXPANSION JOINTS at the ends of every forth (4th) gutter section which will divide the gutter system into 40’ segments. The expansion joint consists of a self-adhesive rubber strip to cover a 1” gap joint between adjoining sections and a exterior cover plate. At the end of the forth (4th) gutter and prior to its installation, install a gutter expansion cover plate to center the joint. Do not caulk the cover plate. Install the next gutter section and allow a 1” gap for expansion. Cover this joint with the peel & stick membrane supplied with your order being careful to achieve a good bond of rubber to metal. This completes the application of the liner’s expansion joint.

It is critical to the performance of the system that expansion joints be installed at 40’ intervals. The only exception is; you may omit expansion joints for independent runs of gutter which do not exceed 50’. The run must receive end caps on both ends to be considered independent. Gutters installed without proper allowance for thermal expansion WILL LEAK at their joints.

DO NOT LEAVE GUTTERS EXPOSED TO WINTER CONDITIONS, (SNOW & ICE) WITHOUT INSTALLING THE INTERIOR STRAPS. GUTTERS ARE SUBJECT TO DAMAGE UNDER SUCH CONDITIONS.
INDUSTRIAL GUTTER INSTALLATION INSTRUCTIONS

STEP 4: INSTALL THE INSIDE STRAPS by hooking into the gutter’s hemmed edge and rivet its back leg to the gutter (DO NOT NAIL) with 1/8" x 3/8" aluminum rivets. Inside straps should be installed at 30" centers and alternate with the support bracket. In other words, an inside strap shall be located between each support bracket.

**********END**********
1. Drain should be mounted to the receiver prior to installation.

2. Install gutter with associated brackets and straps as per our standard installation instructions. Cut gutter section if necessary.

3. INSTALL DRAIN WITH ASSOCIATED BRACKETS AND STRAPS AS PER OUR STANDARD INSTALLATION INSTRUCTIONS. CUT GUTTER SECTION IF NECESSARY.

4. Securely seal the bottom hole and bolt.

5. Fully secure the bottom hole and bolt.

6. Ensure the drain is placed in position after installation.

7. Mount drain(s) away from metal or stainless steel. Apply mouth bead or flange to the drain flange.

8. The drain receiver has a threaded female (M) flare nut. Use the flashing clamp bolt to the interior side of the drain receiver to clamping position of the receiver and mount the drain to the underside of the drain receiver.

9. Identify grade sealant.

10. Slat seins are not pre-finished. Use a high grade of silicone or equivalent.