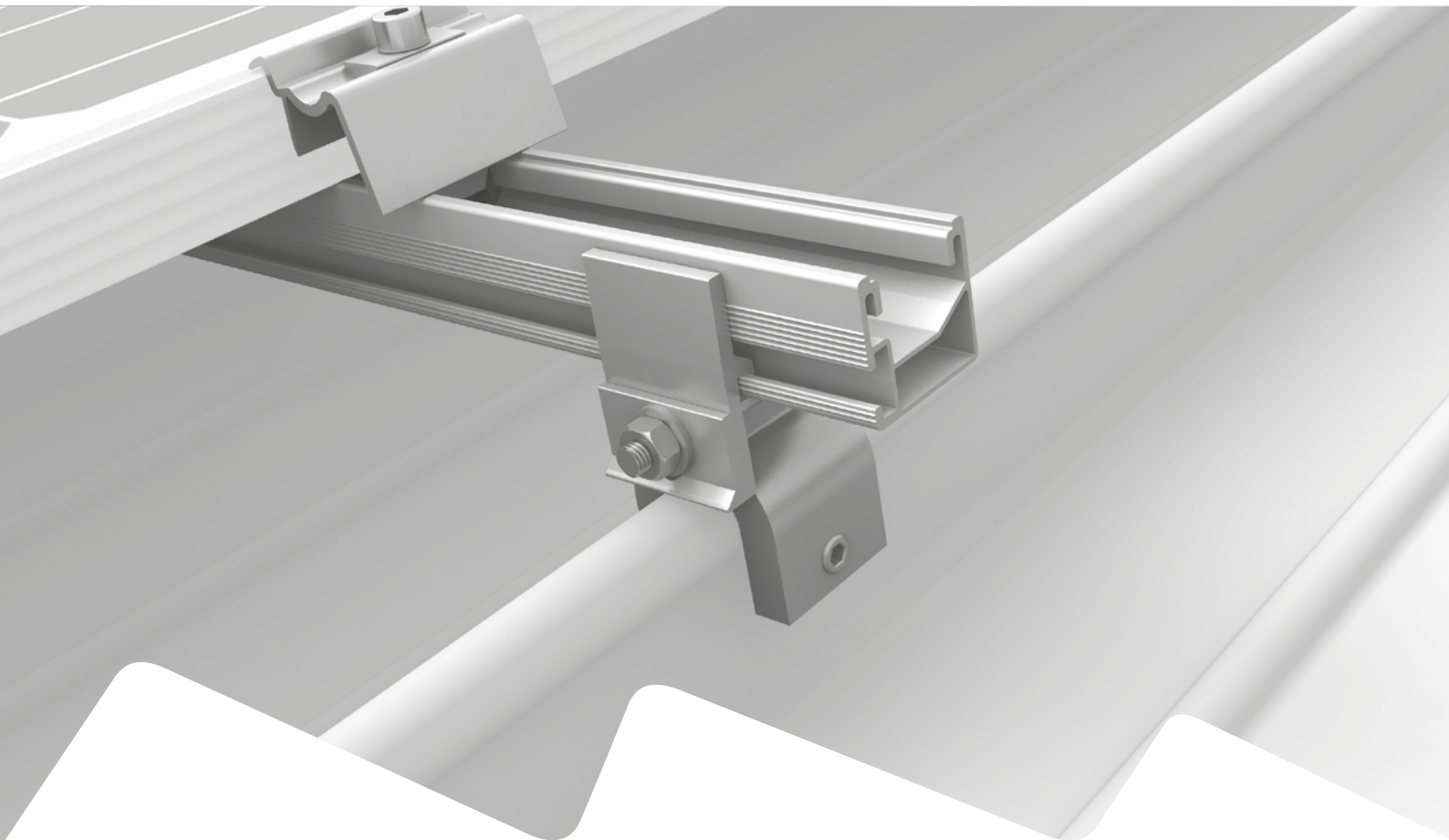




**Connecting Strength**



Assembly Manual

# **Standing seam clamps and clamps for metal roof systems with SingleRail or SolidRail**

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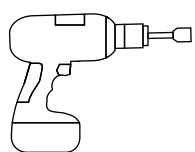
## Quality tested - several certifications

K2 Systems stands for secure connections, highest quality and precision. Our customers and business partners have known that for a long time. Independent institutes have tested, confirmed and certified our capabilities and components.

Please find our quality and product certificates under:

[k2-systems.com](https://k2-systems.com)

# Tools overview



5 mm



6 mm



13 mm



15 mm



6 - 32 Nm  
(4.5 - 22.2 lb-ft)



5 mm



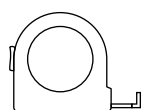
6 mm



13 mm



15 mm



≥ 3.0 m



≥ 6.0 m

## Digital Toolbox



**Do you already know our digital services?** Use our K2 DocuApp now and record the first important data directly at the customer or project site.

Simply transfer the data to our online planning software K2 Base. Here you can plan your project easily, safely and quickly. You receive a detailed project report with assembly plan and static report.

The K2+ interface enables seamless project data transfer to the planning tools of well-known inverter manufacturers or yield planning tools.

**Get started and register now:**

[docuapp.k2-systems.com](https://docuapp.k2-systems.com) →

[base.k2-systems.com](https://base.k2-systems.com) →

# General safety information

Please note that our general mounting instructions must be followed at all times and can be viewed online at [k2-systems.com](https://www.k2-systems.com)

- The equipment may only be installed and operated by qualified and adequately trained installers.
- Prior to installation, ensure that the product complies with on-site static loading requirements. For roof-mounted systems, the roof load-bearing capacity must always be checked.
- National and local building regulations and environmental requirements must be adhered to.
- Compliance with health and safety regulations, accident prevention guidelines and applicable standards is required.
  - Protective equipment such as safety helmet, boots and gloves must be worn.
  - Roofing works must be in accordance with roofing regulations utilising fall protection safeguards when eaves height exceeds 3 m.
  - At least two people must be present for the duration of the installation work in order to provide rapid assistance in the event of an emergency.
- K2 mounting systems are continuously developed and improved and the installation process may thereby change at any time. Prior to installation consult our website at [www.k2-systems.com/en/technical-information](https://www.k2-systems.com/en/technical-information) for up-to-date instructions. We can send you the latest version on request.
- The assembly instructions of the module manufacturer must be adhered to.
- Equipotential bonding/grounding/earthing between individual parts is to be performed according to country specific standards, as well as national laws and regulations.
- At least one copy of the assembly instructions should be available on site throughout the duration of the installation.
- Failure to adhere to our general safety and assembly instructions and not using all system components, K2 is not liable for any resulting defects or damages. We do not accept liability for any damage resulting in the use of competitor's parts. Warranty is excluded in such cases.
- K2 Systems GmbH reserves the right to exclude liability in case of disregard of our General Safety Instructions as well as in case of installation or mounting of components of a competitor.
- If all safety instructions are adhered to and the system is correctly installed, there is a product warranty entitlement of 12 years! We strongly recommend reviewing our terms of guarantee, which can be viewed at [k2-systems.com/en/warranty-terms-and-conditions](https://www.k2-systems.com/en/warranty-terms-and-conditions) We will also send this information on request.
- Dismantling of the system is performed in reverse order to the assembly.
- K2 stainless steel components are available in different corrosion resistance classes. Each structure or component must be carefully checked for possible corrosion exposure.

# The following guidelines apply



This System can be used without further testing by K2 systems in the following standard conditions. It is also suitable for higher requirements. However, if a value exceeds the standard conditions, please contact K2 Systems.



## Planning with K2 Base

We recommend our free online software K2 Base for the planning. In five steps, you can plan the right assembly system and get an installation recommendation, a bill of materials and the structural analysis report. Simply register and start planning: [base.k2-systems.com](https://base.k2-systems.com)



## Roof requirements

- Adequate roof cover holding force on the support structure or substructure.
- Roof incline: 5 - 75°



## Static requirements

It is important to ensure that the roof cover and support structure can absorb the forces transmitted from the clamp to the seam.



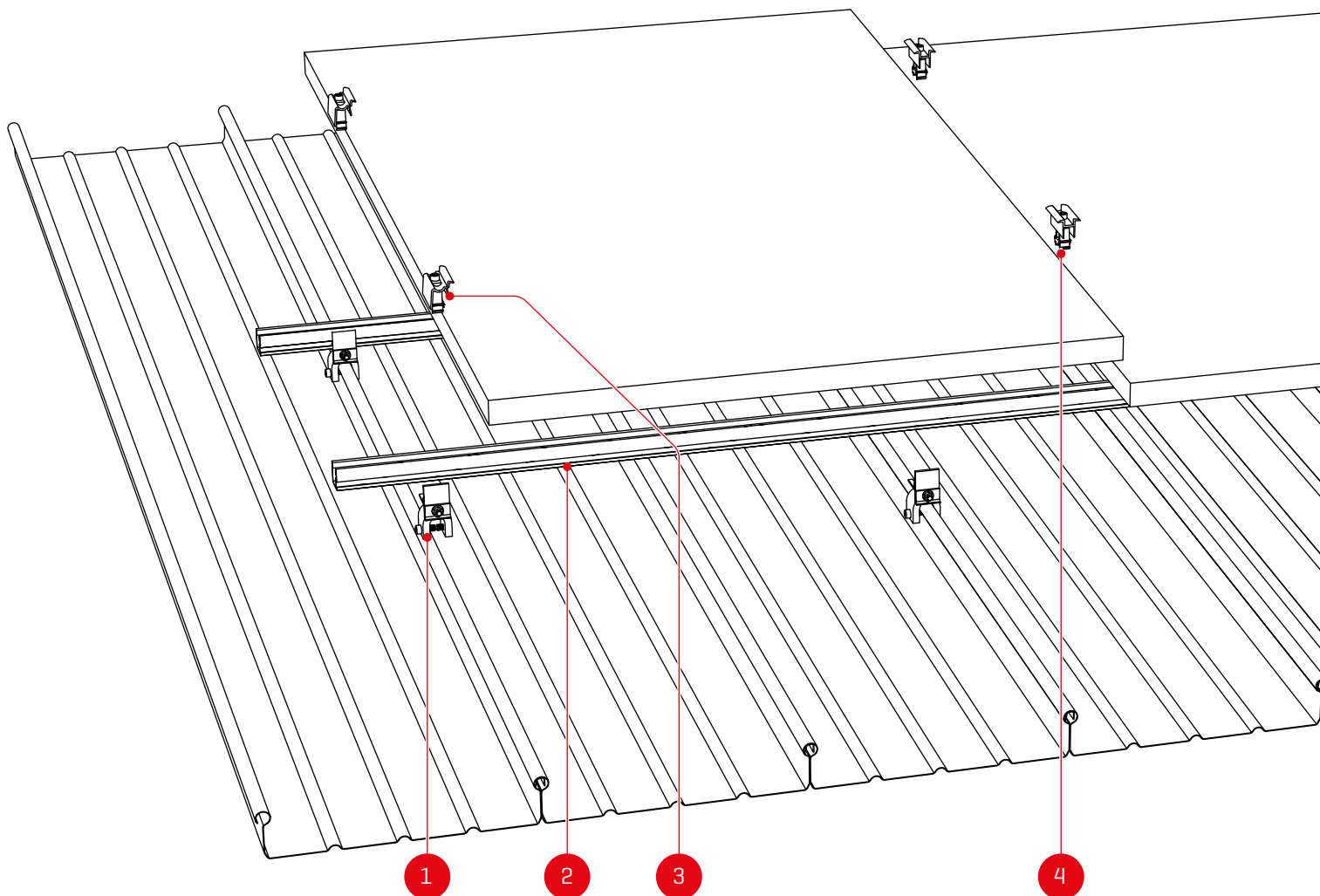
## Important mounting instructions

- The seam clamps/system roof clamps may impede thermally induced changes in sheet metal length under certain circumstances. A distance between the clamps and the cleats/holding clips of the roof covering must be taken into account, in order to ensure the thermal expansion of the roof cover is unimpeded:
  - **Folded standing seam**  
≥ 50 mm
  - **Round seam and metal roof systems**  
≥ 175 mm (or a value specified by the roofing manufacturer)
- The installation company must initially check that the standing seam clamps are suitable for the intended purpose.
- If the roofing material is made of copper,

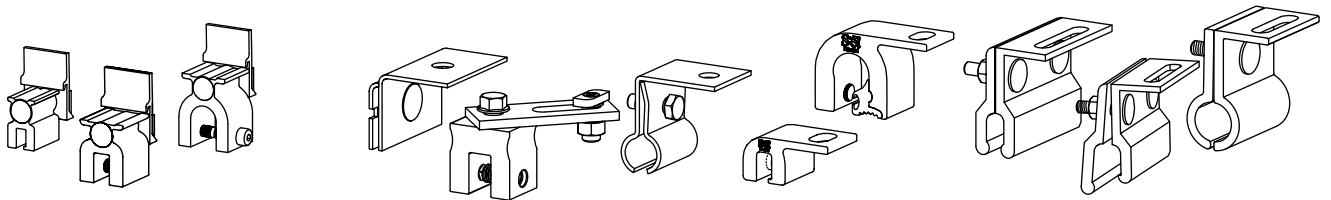
standing seam clamps made of aluminium must only be used in combination with a stainless steel inlay in order to prevent electrochemical corrosion.

- Pre-position the standing seam clamps and slightly tighten the grub screw. Only tighten the standing seam clamps with the specified tightening torque after mounting the rails.
- For all clamp fixtures it is important to ensure that the first rail position is installed so that it runs transversely to the seam and, where applicable, with cross bracing.
- After a maximum of 6.6 m, the components must be thermally separated. For titanium zinc already after a maximum of 3.3 m!
- The general standards and regulations for lightning protection must be observed on site and, where appropriate, a specialist must be consulted in order to draw up a lightning protection concept (use a lightning protection clamp if necessary). Country-specific regulations must be observed.
- The tightening torque of all module clamps is 16 Nm.
- A minimum mounting distance of 50 mm from the end of the rail / rail joint to the module frame.
- Observe the manufacturer's specifications for the clamping range of the module clamps and for mounting the modules (see the manufacturer's module data sheet)
- The mounting components are not climbing aids!
- The system must be checked by a specialist company after exceptional events, such as storms, heavy rain, earthquakes etc. If deformed or loose components or other damage is determined when checking the system, these must be replaced with new components.

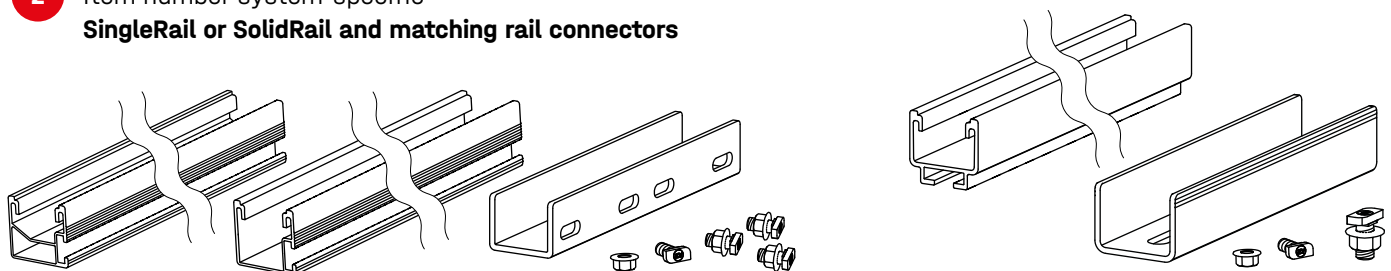
# Components

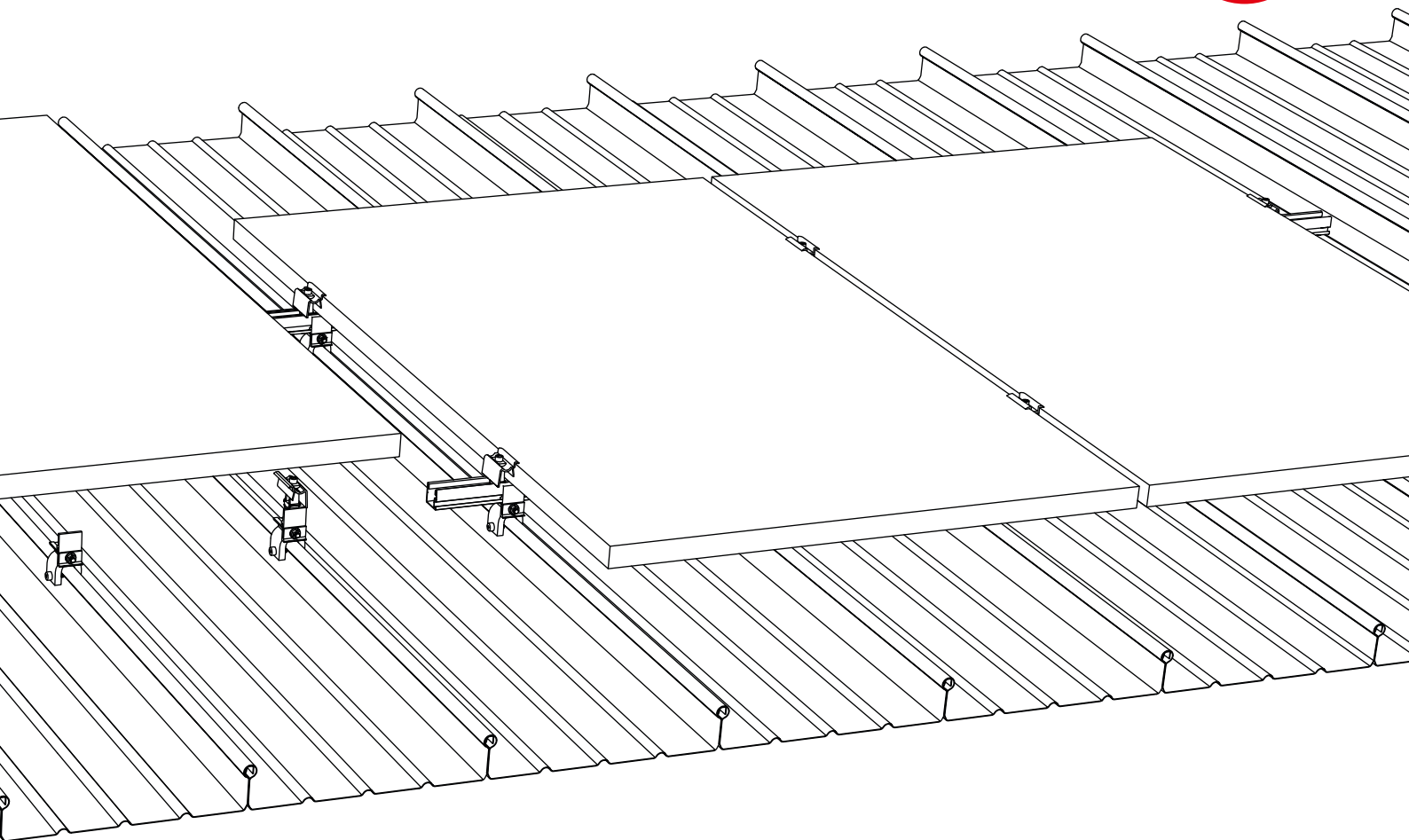


- 1** Item number system-specific  
**Standing seam clamps, see pag 8/9/10!**

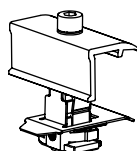


- 2** Item number system-specific  
**SingleRail or SolidRail and matching rail connectors**





**3** Item number system-specific  
**Module end clamps**



K2 Clamp EC  
25 - 40

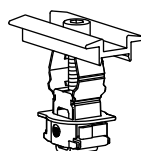


XS Clamp EC  
30 / 33 / 35



OneEnd  
30-42

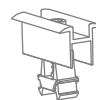
**4** Item number system-specific  
**Module middle clamps**



K2 Clamp MC  
25 - 40



XS Clamp MC  
30 / 33-35



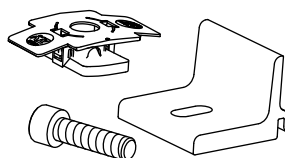
OneMid  
30-42

**Optional**

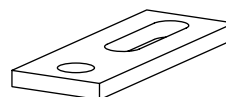
Item number system-specific  
**SolidRail connection:**  
T-bolt and locking nut



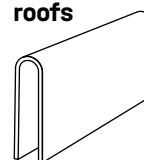
2003145  
**Climber**  
36/50 set



2002544  
**Adapter plate**  
SolidRail



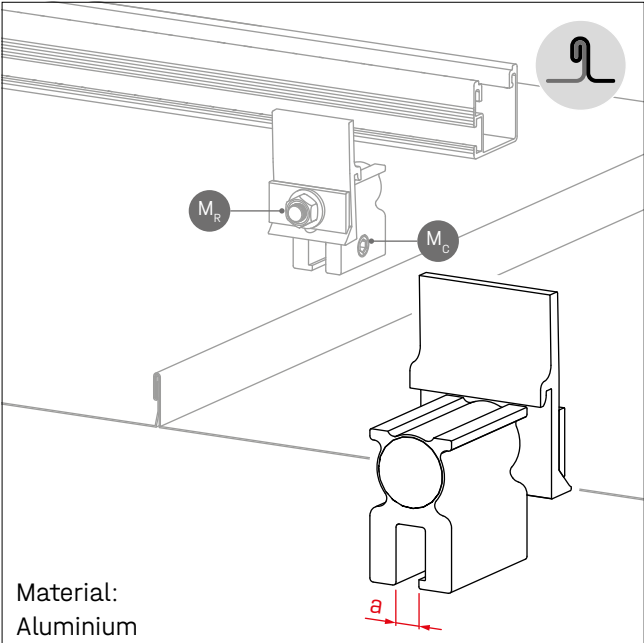
2001640  
**Stainless steel**  
inlay for copper  
roofs



# Clamps: sheet metal seam and metal roofing systems

## Compatible with SingleRail

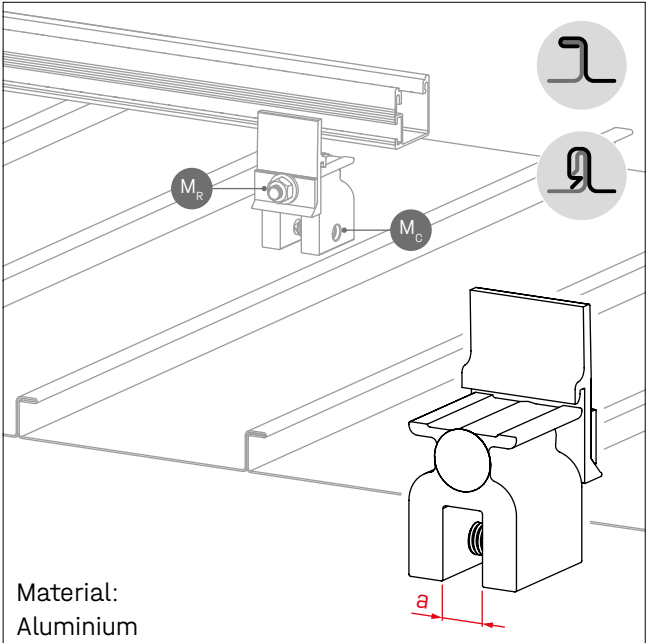
Standing Seam Clamp CF:x SingleRail 2003024



Seam type	Double standing seam
Sheet thickness	0.4 - 1.0 mm

$M_C = 18 \text{ Nm}$ ; excl. galvanised steel panel  $> 0.7 \text{ mm} = 18 - 20 \text{ Nm}$   
 $M_R = 15 \text{ Nm} \cdot a = 7.0 \text{ mm}$

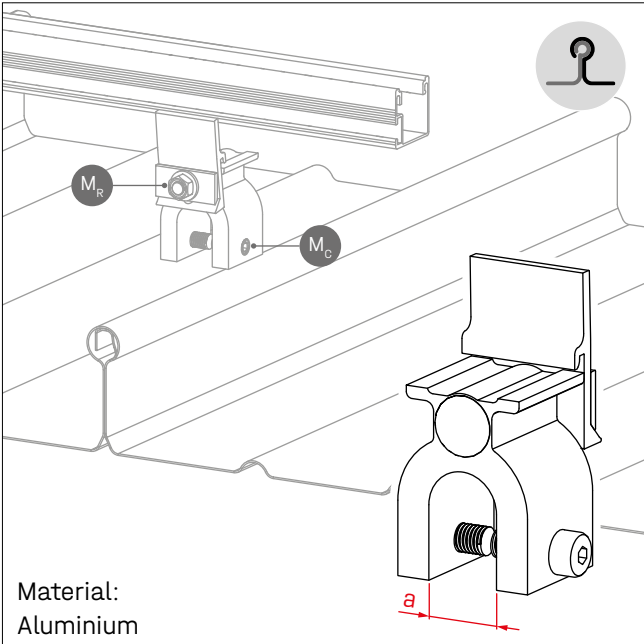
Snap Seam Clamp CF:x SingleRail 2003083



Seam type	Angeled and snaplock standing seam
Sheet thickness	0.4 - 1.0 mm (Steel panel $\leq 0.7 \text{ mm}$ )

$M_C = 18 \text{ Nm}$ ; excl. galvanised steel panel  $> 0.7 \text{ mm} = 18 - 20 \text{ Nm}$   
 $M_R = 15 \text{ Nm} \cdot a = 14.0 \text{ mm}$

Round Seam Clamp CF:x SingleRail 2002859



Seam type	Round standing seam (e.g. Bemo, Kalzip, Aluform, Rib-Roof Evolution)
Sheet thickness	0.6 - 1.2 mm

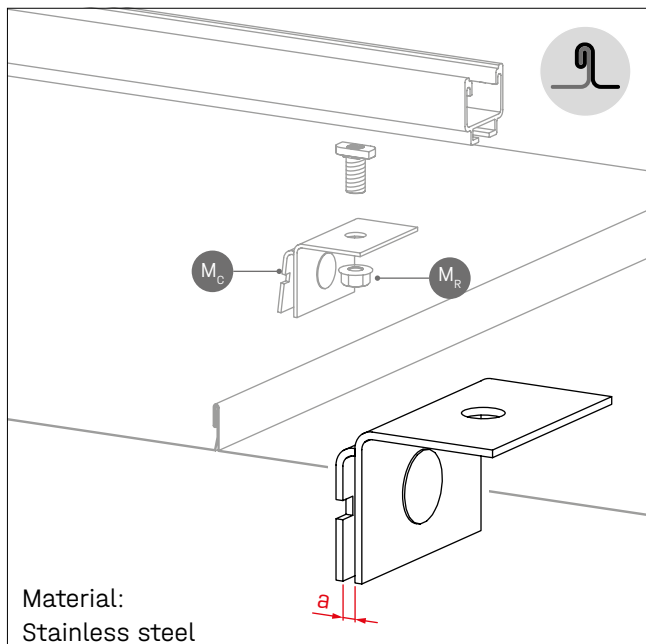
$M_C = 18 \text{ Nm} \cdot M_R = 15 \text{ Nm} \cdot a = 25.0 \text{ mm}$



## Compatible with SolidRail

Double standing seam clamp SolidRail

2001712



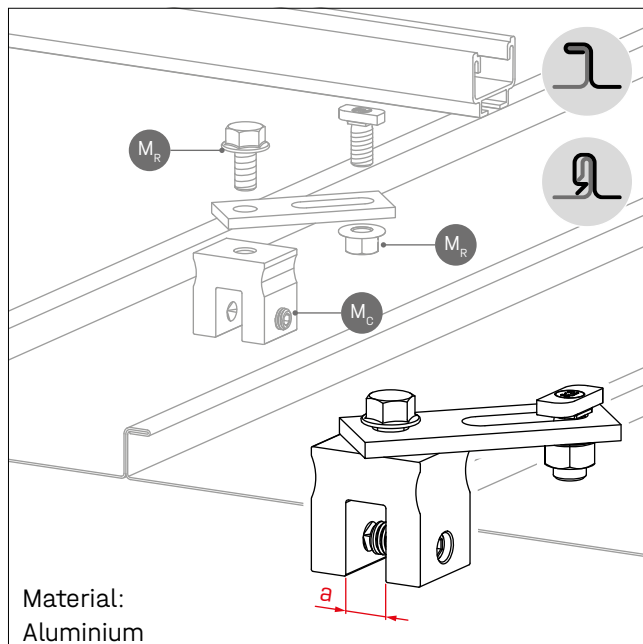
Material:  
Stainless steel

Seam type	Standing seam (min. 25 mm height)
Sheet thickness	0.7 mm
Clamping range	3.5 mm

$$M_C = 20 \text{ Nm} \cdot M_R = 32 \text{ Nm} \cdot a = 3.5 \text{ mm}$$

Snap Seam Clamp CF:x SolidRail

2003082



Material:  
Aluminium

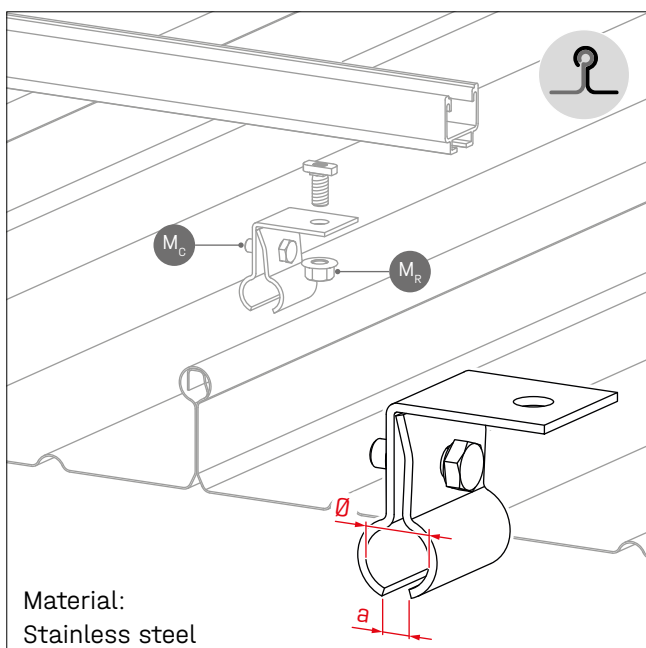
Seam type	Angeled and snaplock standing seam
Sheet thickness	0.4 - 1.0 mm (Steel panel ≤ 0.7 mm)

$$M_C = 18 \text{ Nm; excl. alvanised steel panel } > 0.7 \text{ mm} = 18 - 20 \text{ Nm}$$

$$M_R = 32 \text{ Nm} \cdot a = 14.0 \text{ mm}$$

Round SeamClamp; SolidRail

2001853



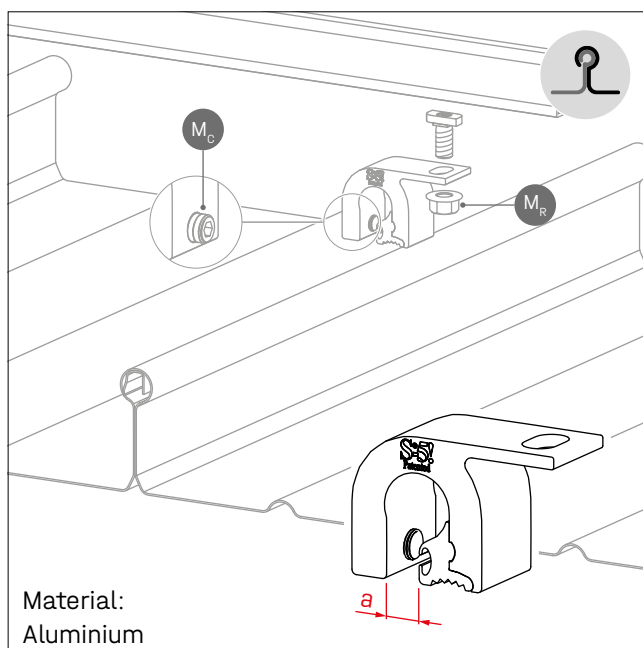
Material:  
Stainless steel

Seam type	Round standing seam
Sheet thickness	≥ 0.7 mm

$$M_C = 20 \text{ Nm} \cdot M_R = 32 \text{ Nm} \cdot a = 10.5 \text{ mm} \cdot \varnothing 19.0 \text{ mm}$$

Round Seam Clamp S-5! SolidRail

1000888



Material:  
Aluminium

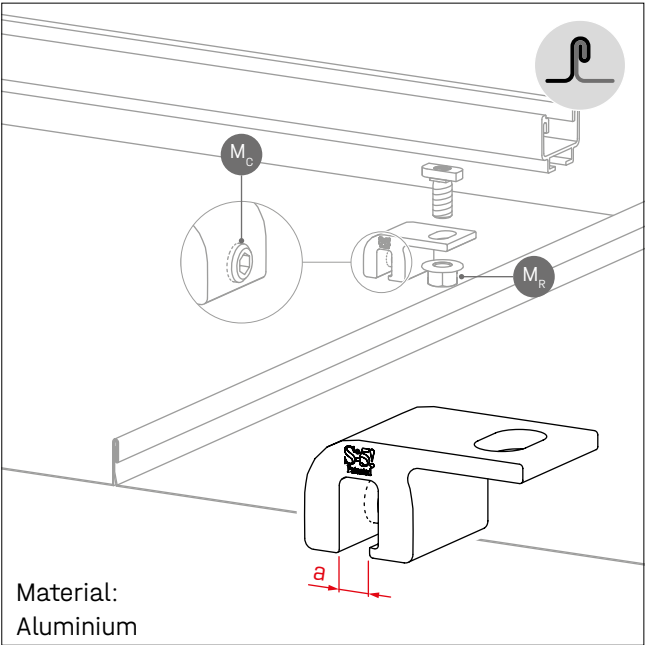
Seam type	Round standing seam
Sheet thickness	0.6 - 1.2 mm; $\varnothing$ seam profile ≤ 23 mm

$$M_C = 15 - 17 \text{ Nm; excl. galvanised steel panel } > 0.7 \text{ mm} = 18 - 20 \text{ Nm}$$

$$M_R = 32 \text{ Nm} \cdot a = 11.5 \text{ mm}$$

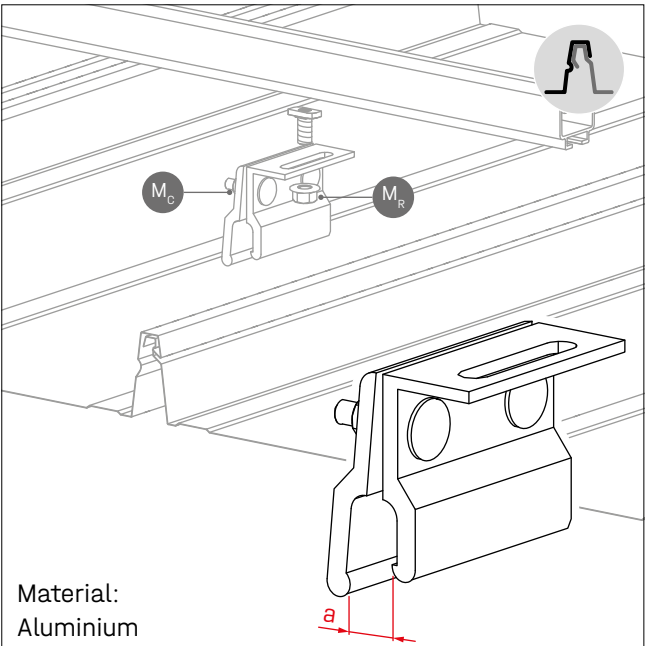
# Compatible with SolidRail

Standing SeamClamp S-5! SolidRail 1001052



Seam type	Double standing seam
Sheet thickness	0.4 - 1.0 mm
$M_C = 15 - 17 \text{ Nm}$ ; excl. galvanised steel panel $> 0.7 \text{ mm} = 18 - 20 \text{ Nm}$ $M_R = 32 \text{ Nm} \cdot a = 7.0 \text{ mm}$	

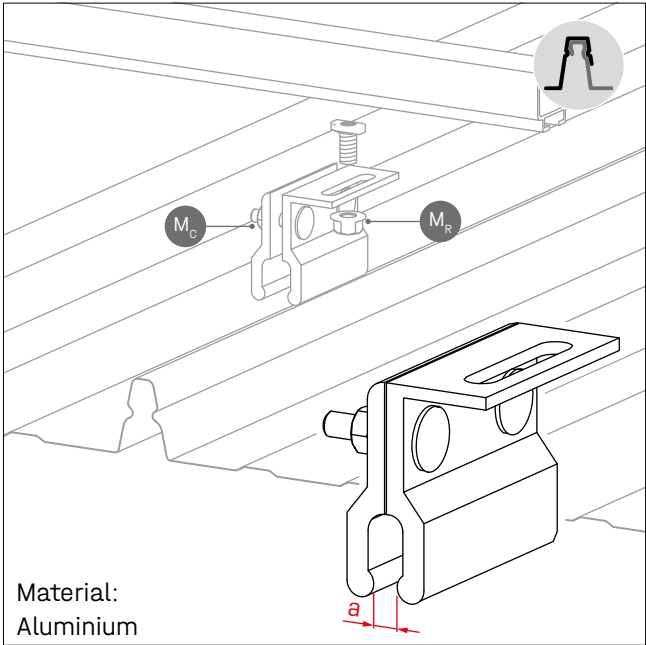
Metal roof system clamp RibRoofSpeed500 2002225



Seam type	Rib-Roof Speed 500 *
$M_C = 20 \text{ Nm} \cdot M_R = 32 \text{ Nm} \cdot a = 17.0 \text{ mm}$	

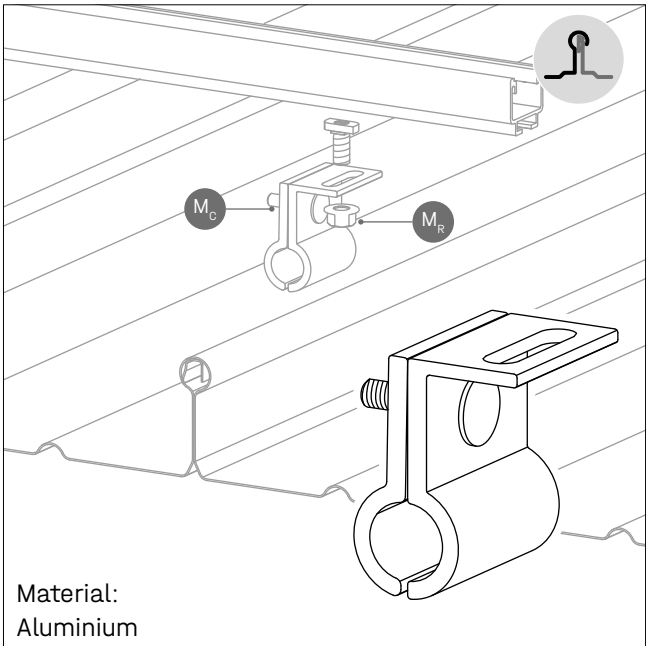
\* From delivery year 2005; older roofs on request

Metal roof system clamp Zambelli RibRoof465 2002118



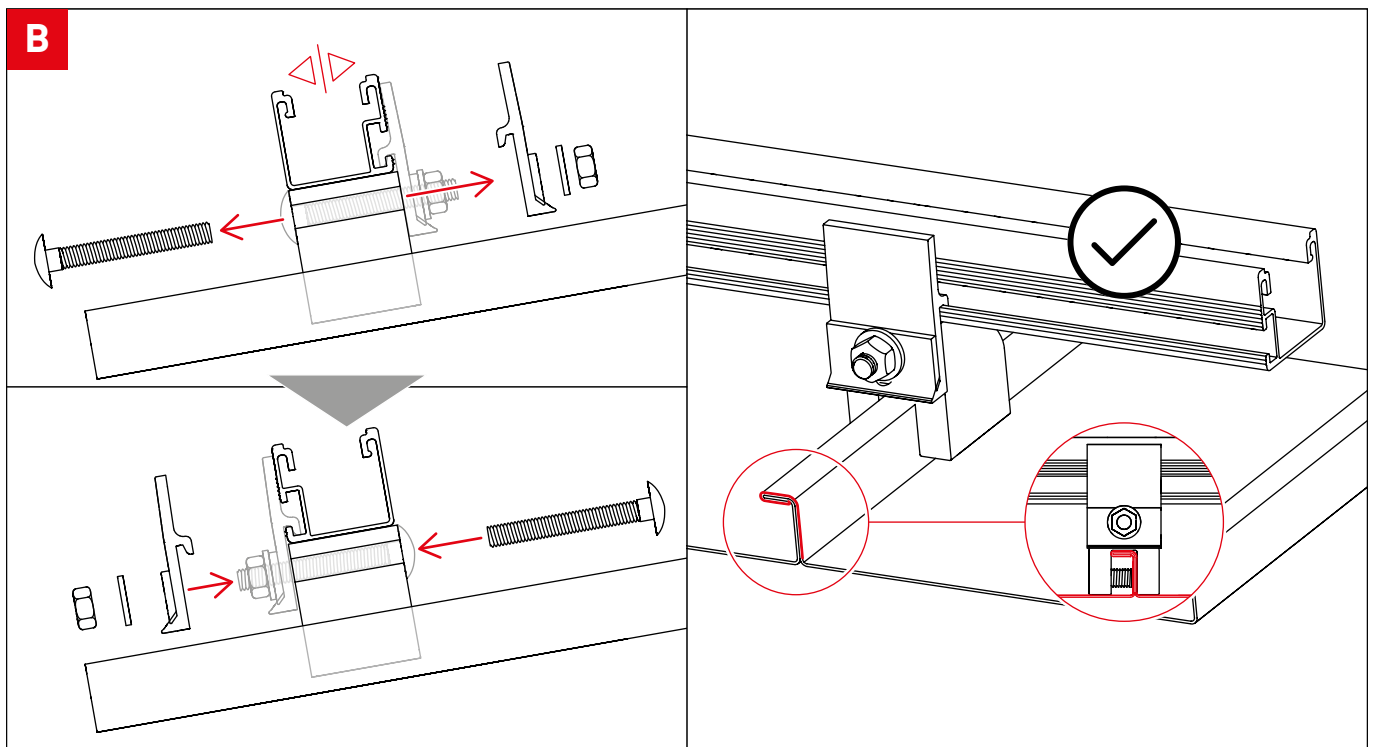
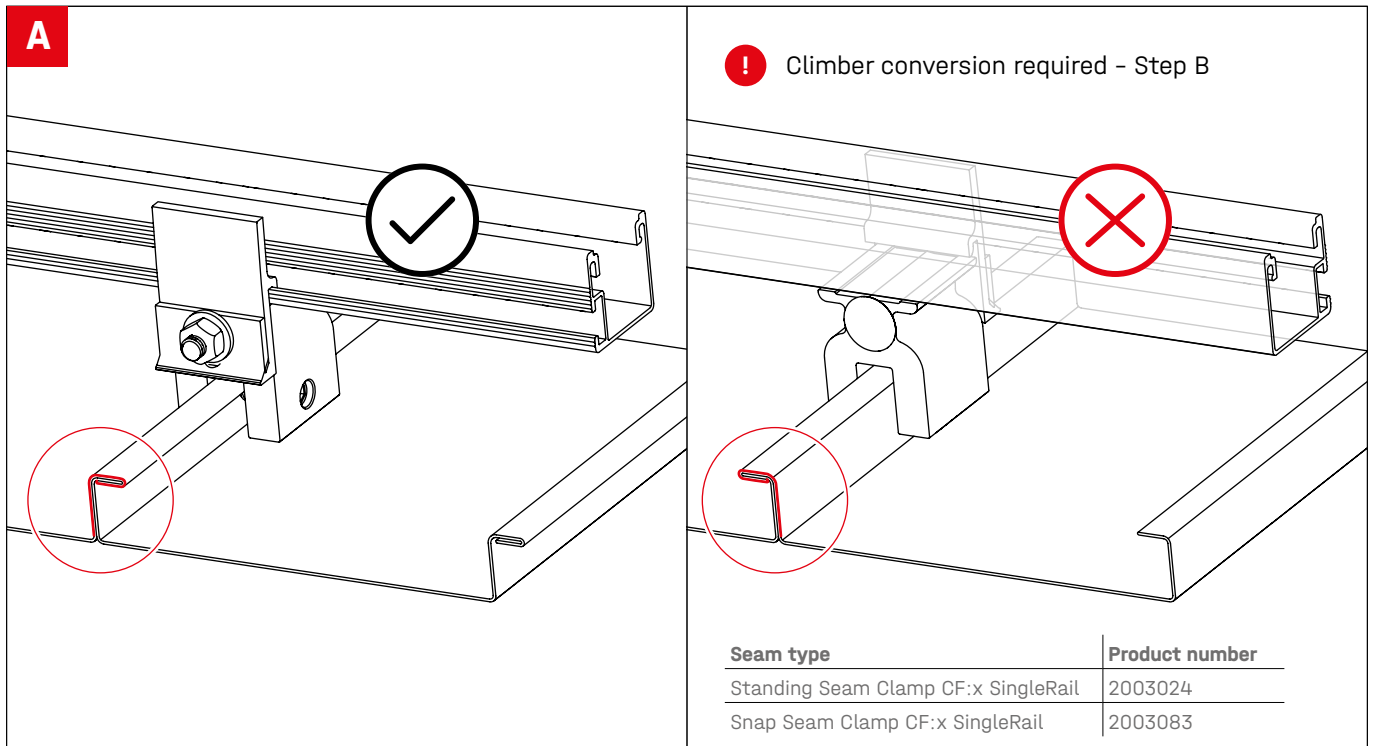
Seam type	Rib-Roof 465
$M_C = 20 \text{ Nm} \cdot M_R = 32 \text{ Nm} \cdot a = 12.0 \text{ mm}$ <b>Always mount on the overlap rib!</b> A minimum distance of 50 mm plus length expansion (approx. 100 - 200 mm) to the retaining brackets must be maintained to ensure the length expansion of the profiled sheets.	

Metal roof system clamp RibRoofEvolution 2002226



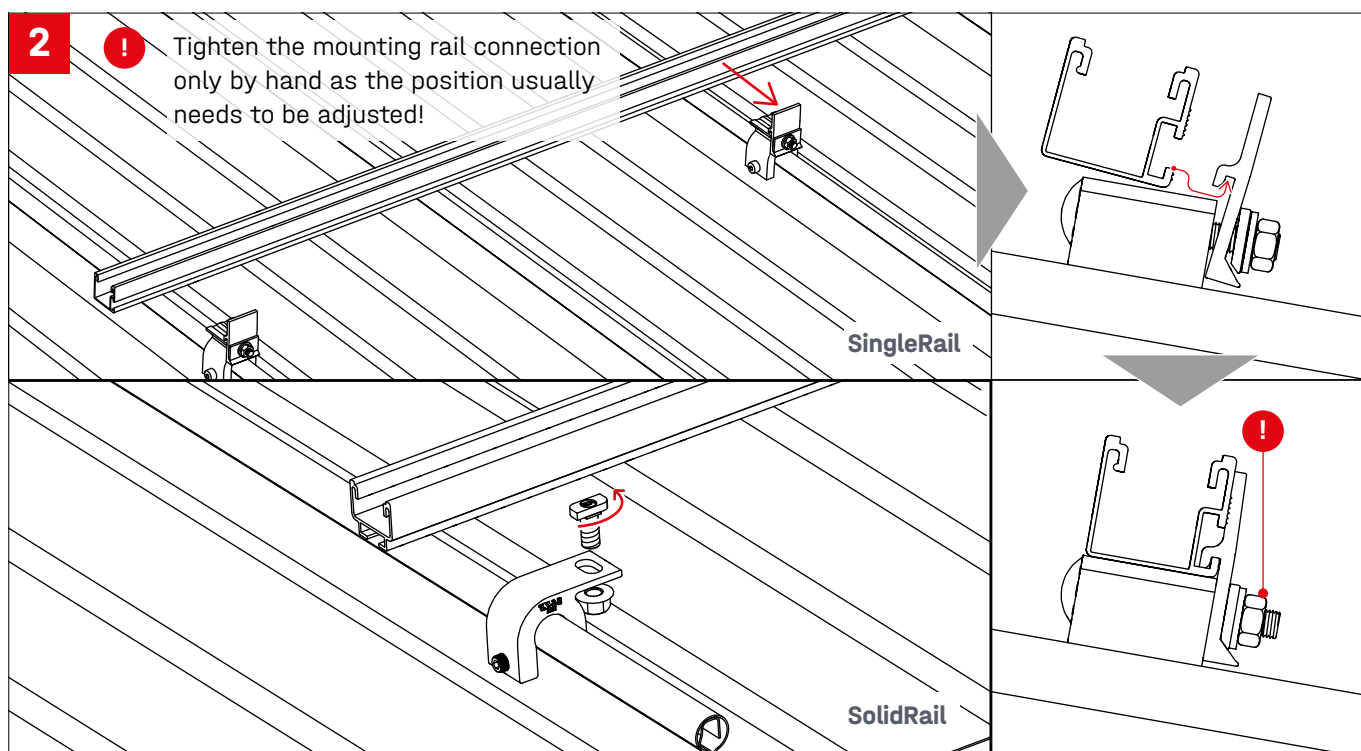
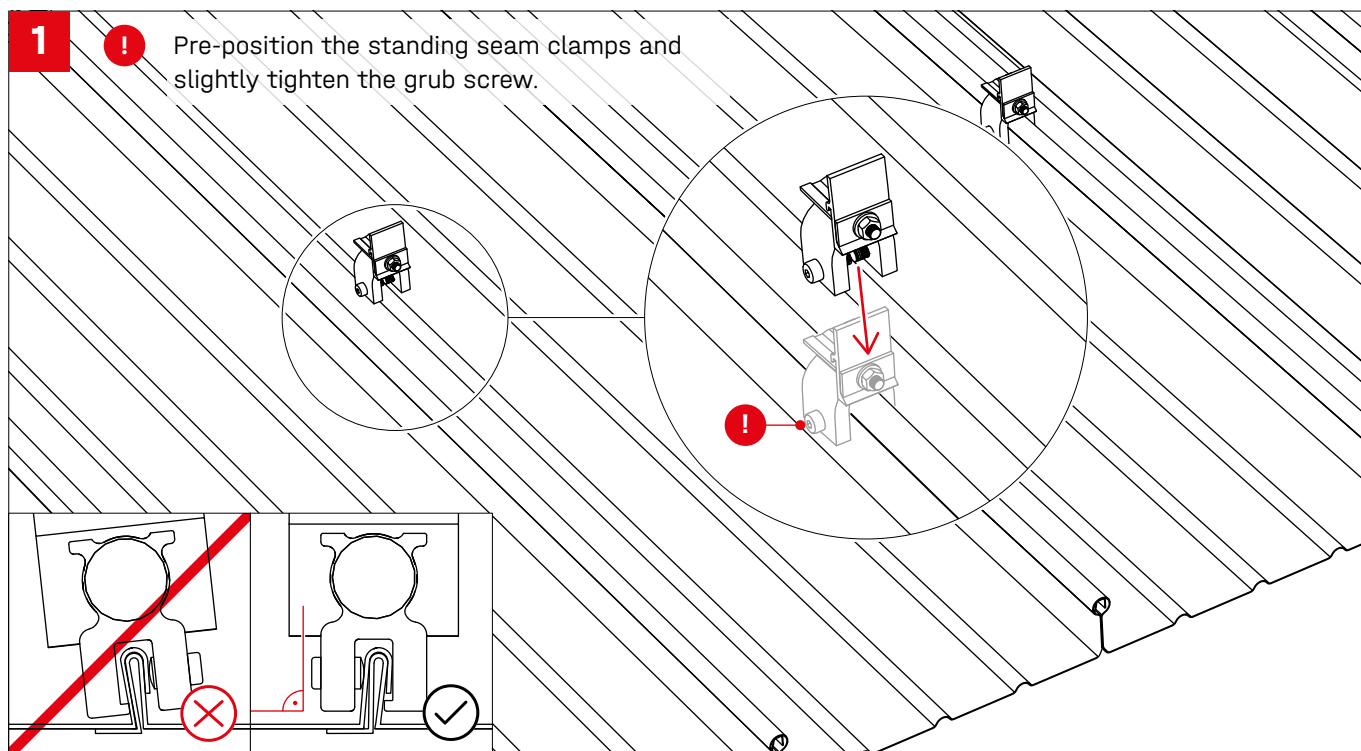
Seam type	Rib-Roof Evolution
$M_C = 20 \text{ Nm} \cdot M_R = 32 \text{ Nm} \cdot \varnothing 23.0 \text{ mm}$	

## Installation instructions for SingleRail



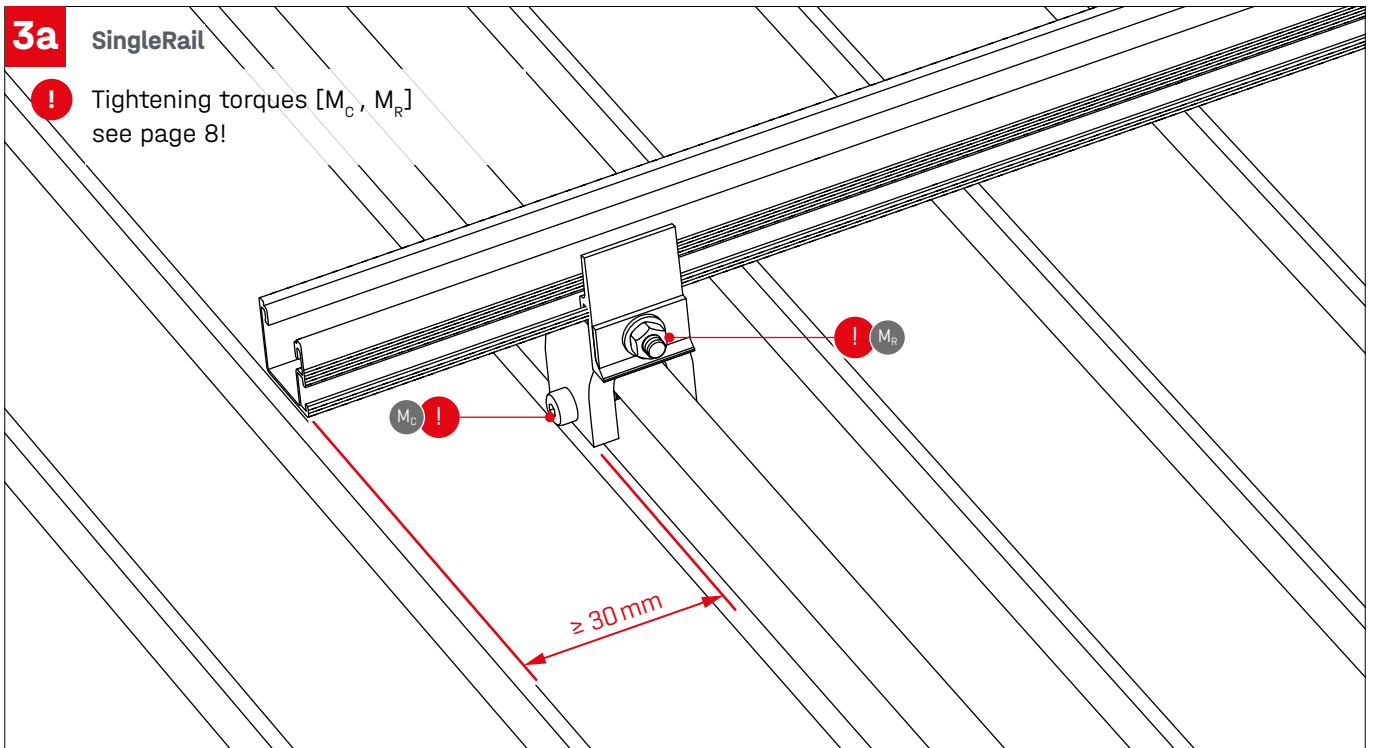
# Assembly

## Basic assembly

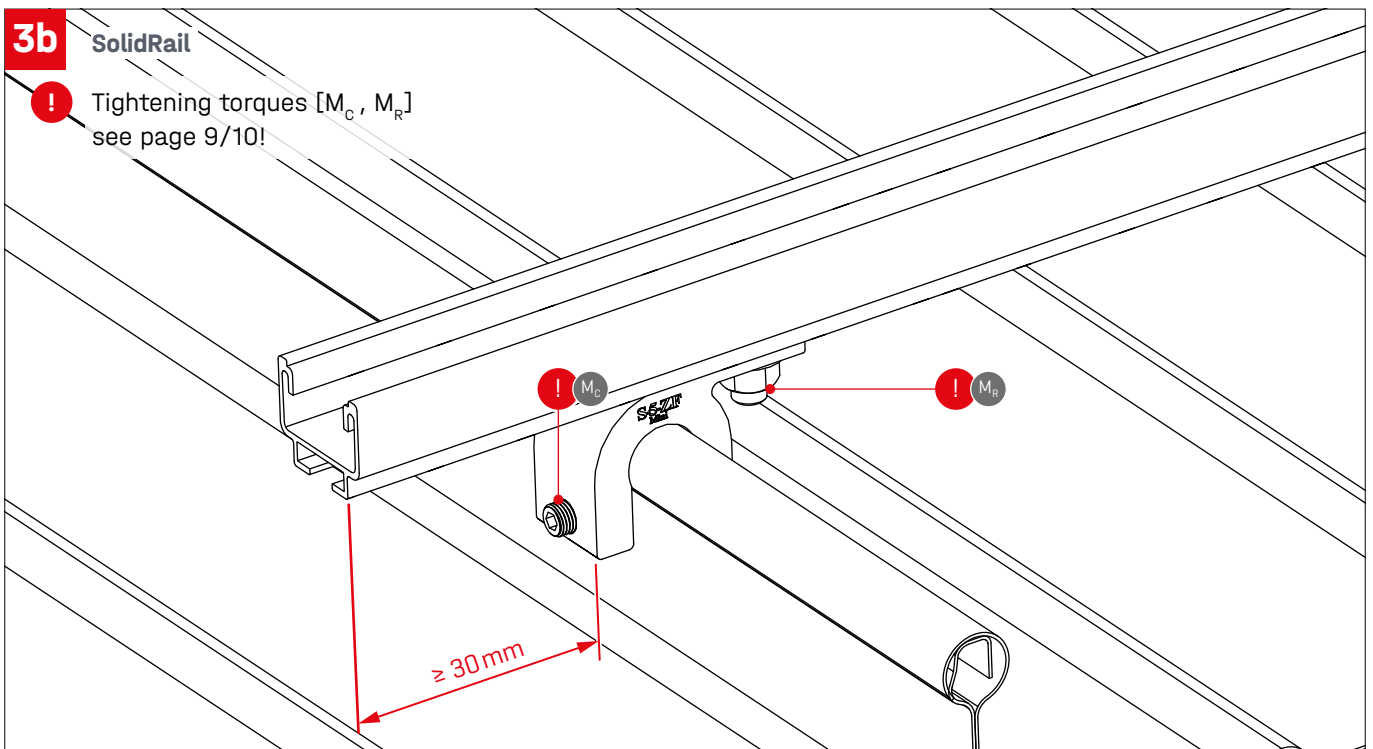


**3a**
**SingleRail**

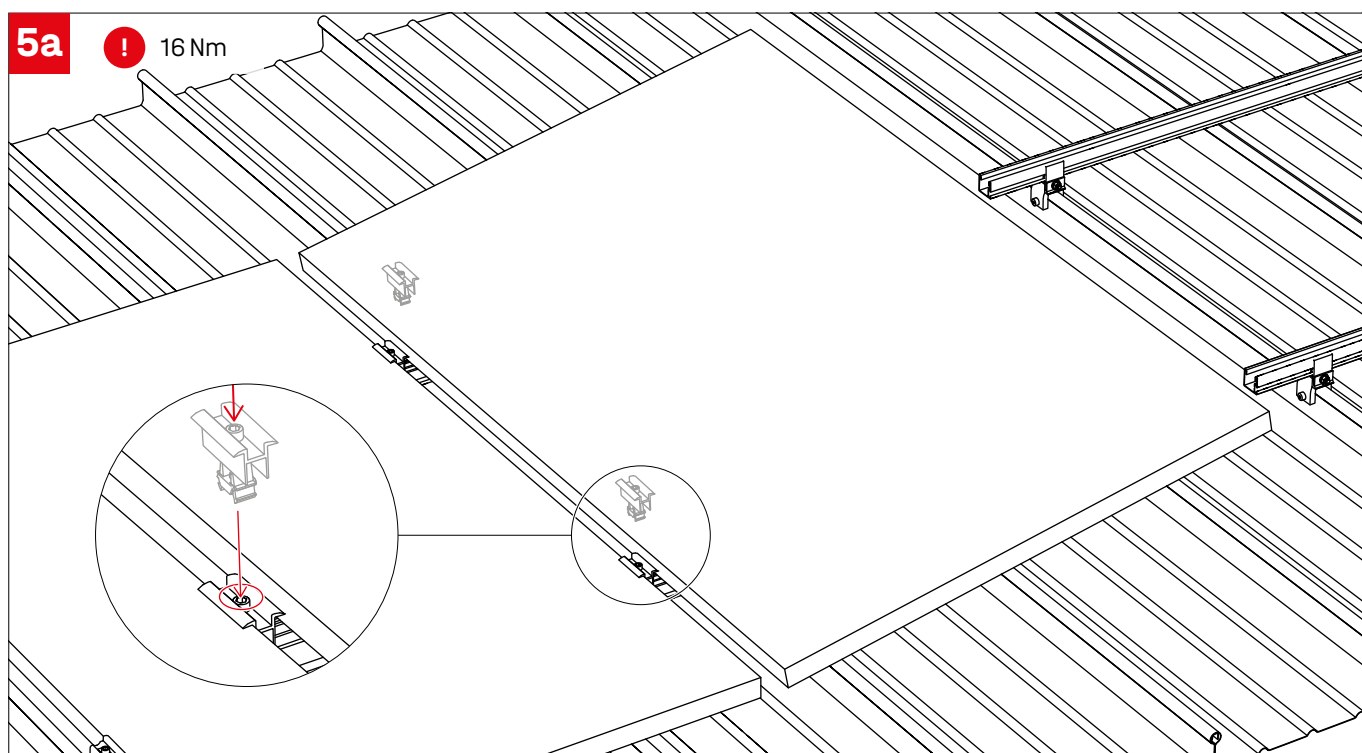
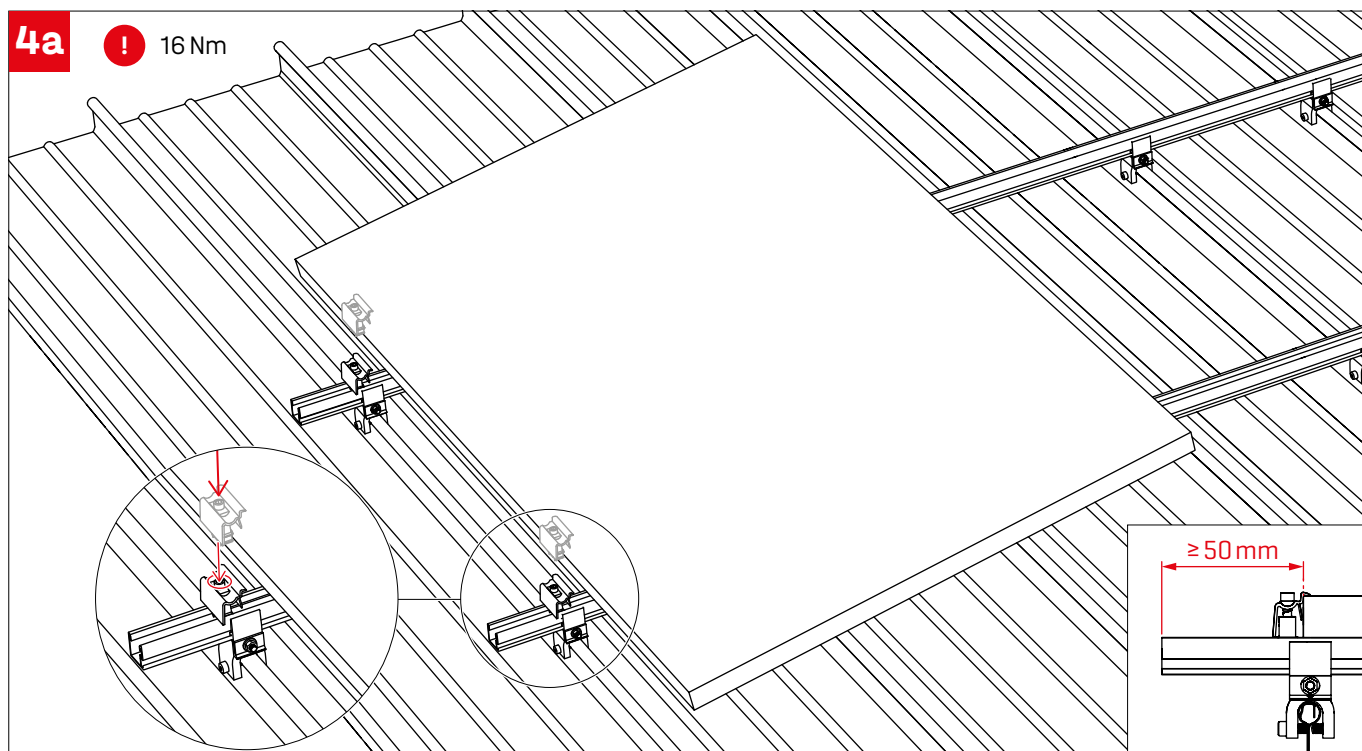
! Tightening torques [ $M_C$ ,  $M_R$ ]  
see page 8!


**3b**
**SolidRail**

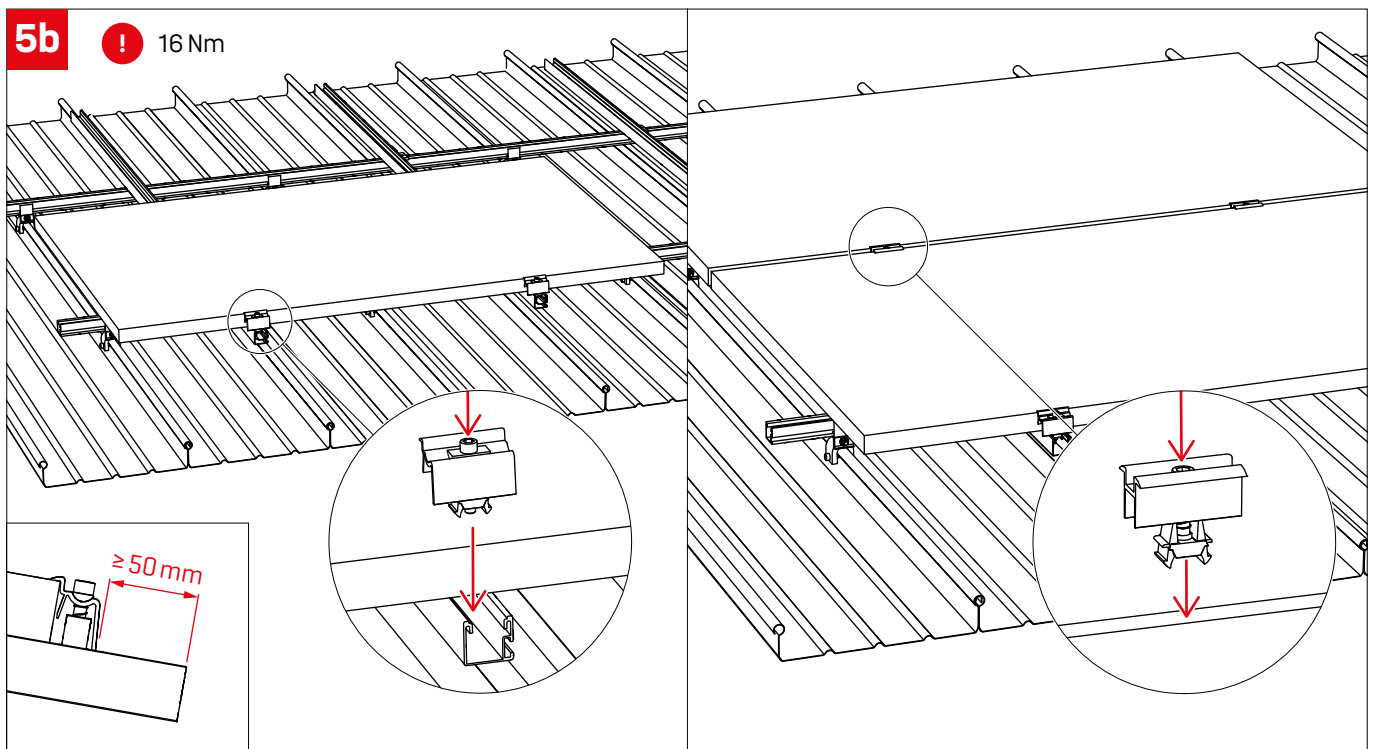
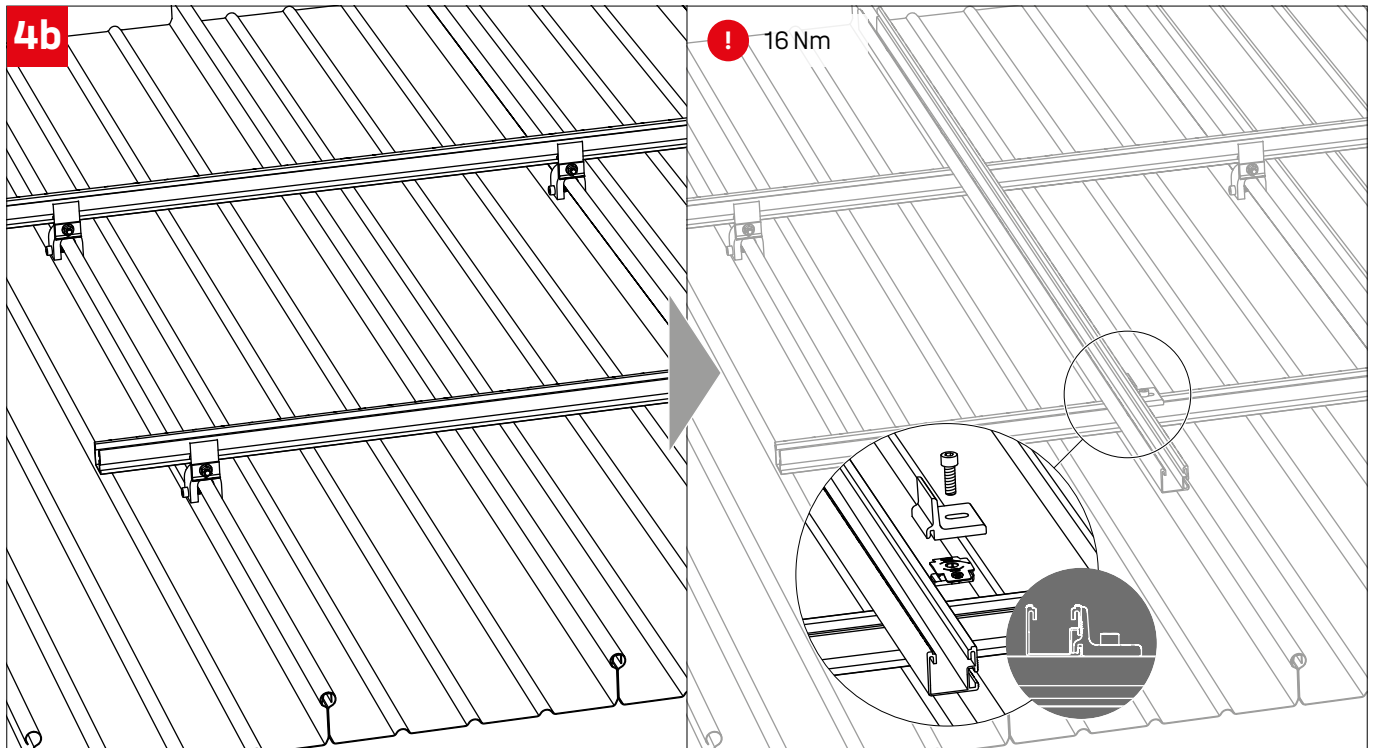
! Tightening torques [ $M_C$ ,  $M_R$ ]  
see page 9/10!



## Portrait: 1 layer

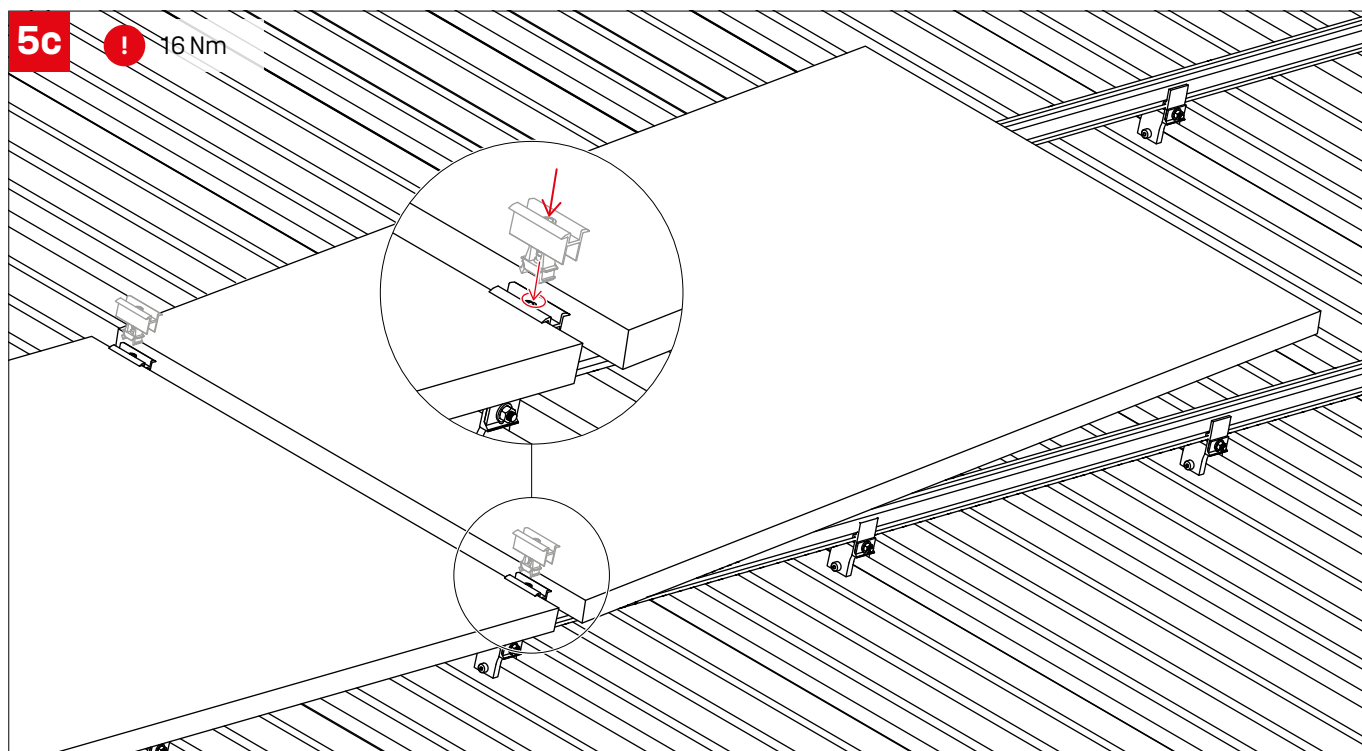
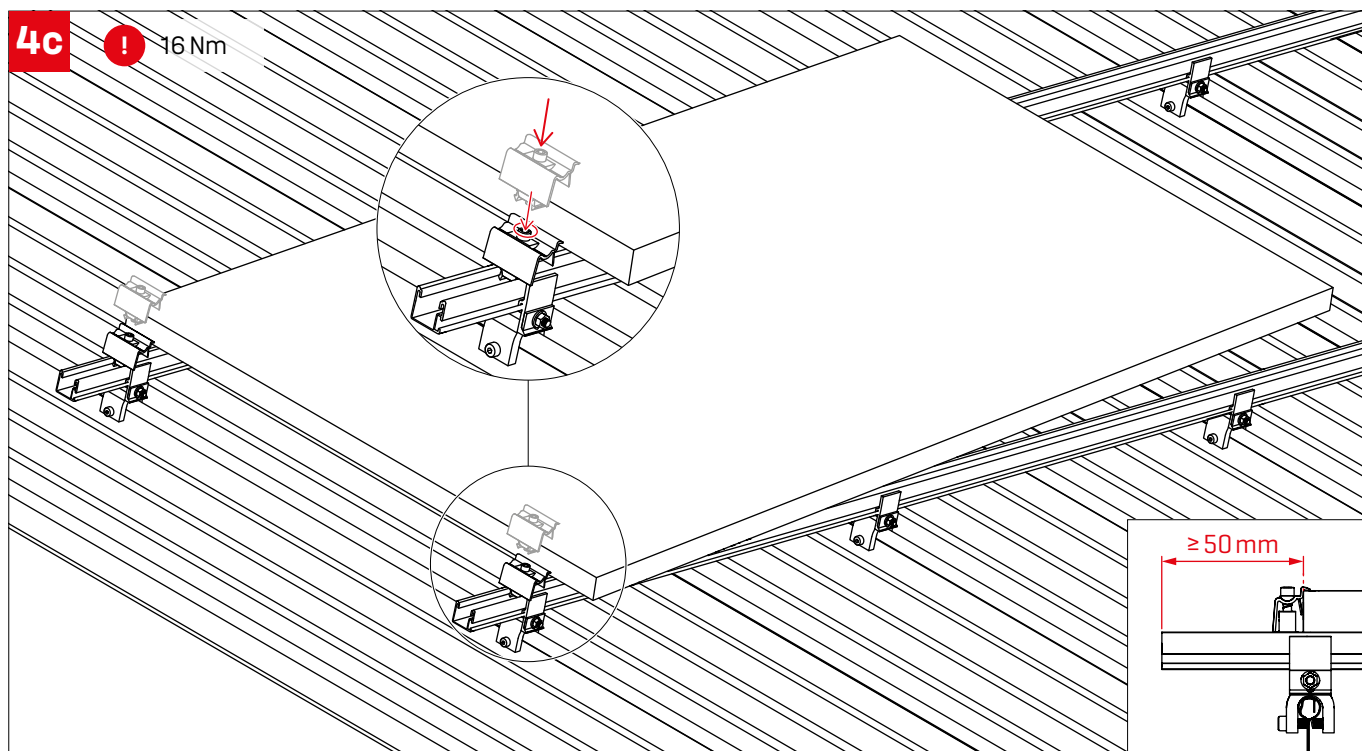


## Landscape: 2 layers, clamping position long side



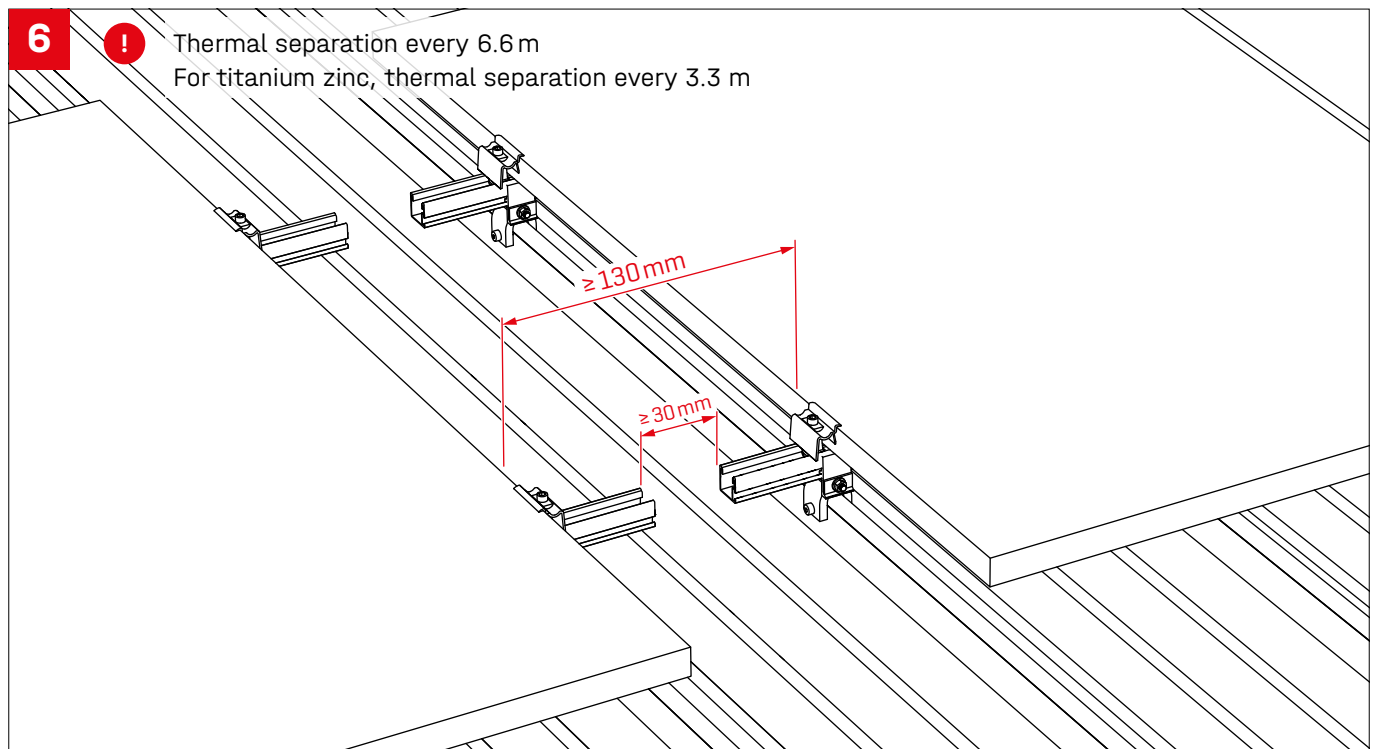


## Landscape: 1 layer, clamping position short side

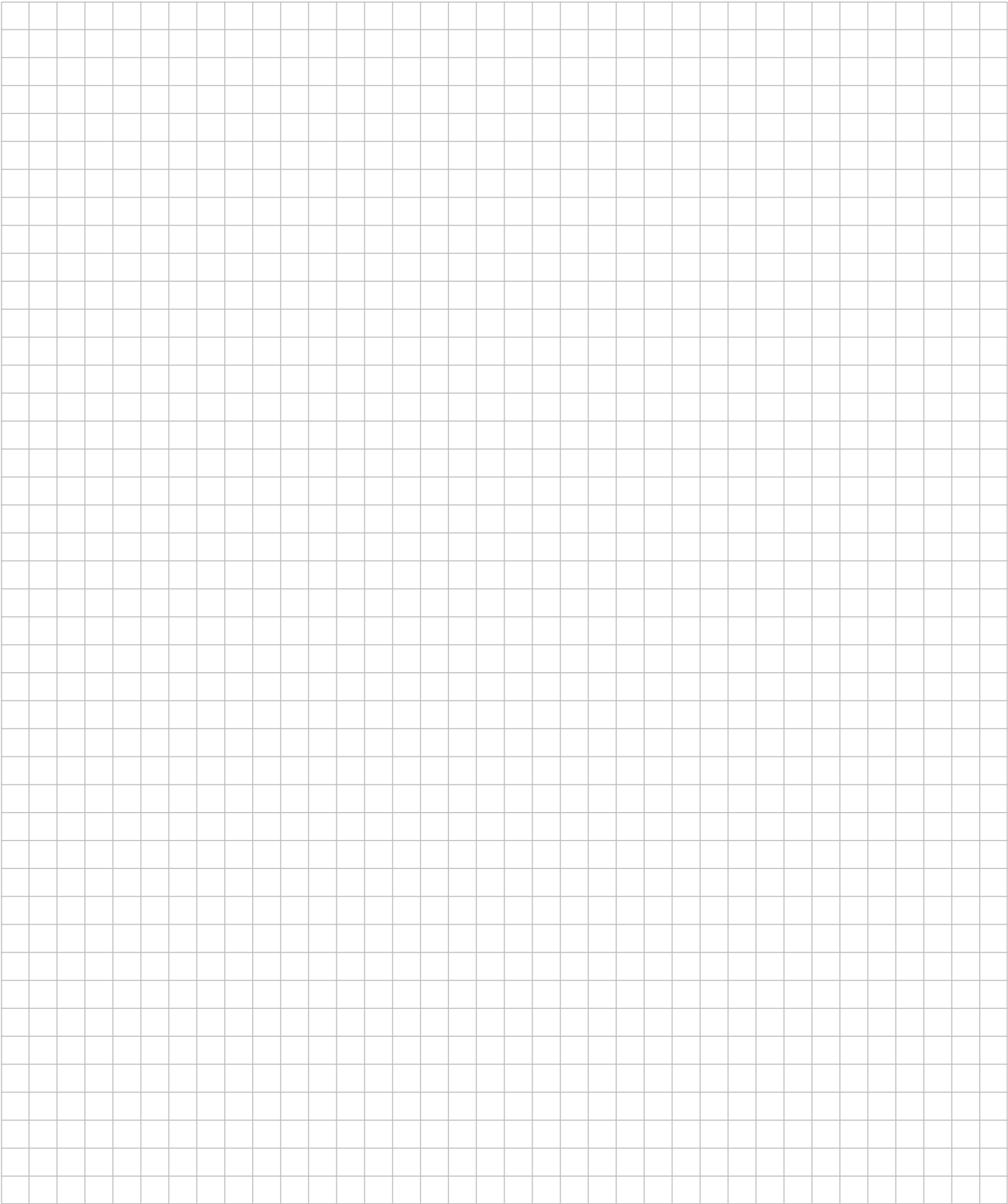




## Thermal separations



## Notes





# Connecting Strength

## Thank you for choosing a K2 mounting system.

Mounting systems from K2 Systems are quick and easy to install. We hope these instructions have helped. Please contact us with any questions or suggestions for improvement. Our contact data:

- [k2-systems.com/en/contact](https://k2-systems.com/en/contact)
- **Service Hotline: +49 7159 42059-0**

Our General Terms of Business apply. Please refer: [k2-systems.com](https://k2-systems.com)

### K2 Systems GmbH

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Standing Seam Clamps Assembly DE V4 | 0925 · Subject to change  
· Product illustrations are exemplary and may differ from the original.