



INSTALLATION MANUAL

# CLASSIC STEEL ROOF TILES

**CLASSIC**  
SERIES

THE POWER OF ROOFS



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**THIS MANUAL IS ILLUSTRATIVE AND DOES NOT RELEASE CONTRACTORS FROM THE OBLIGATION TO FOLLOW THE RULES OF THE ROOFING PRACTICE.**

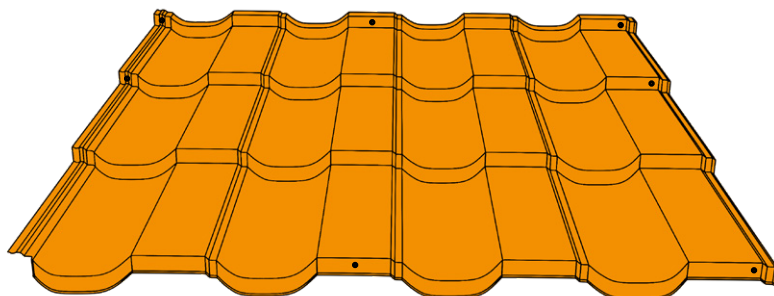
## 1. Technical specification of CLASSIC SERIES steel roof tiles

Technical parameters [mm]	
Effective width	1157
Total width	1202
Thickness of steel sheet	0,5
Total profile height	51/56/66
Rib height for the module 350	25/30/40
Rib height for the module 400	25
Module length	min. 1160 max. 6010
Weight	~ 4,5 kg/m <sup>2</sup>
Length of an overlap when separating steel sheets	60

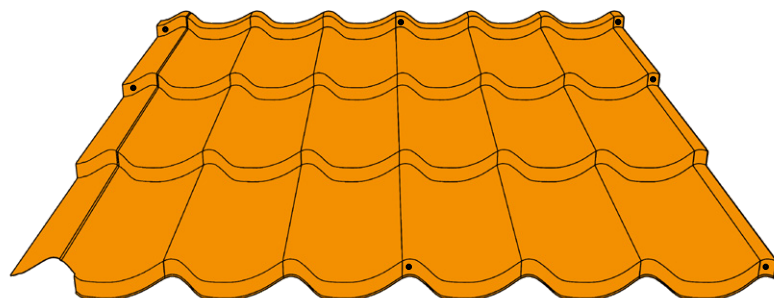
Technical parameters [mm]	
Effective width	1100
Total width	1183
Thickness of steel sheet	0,5
Total profile height	38/43/53/58
Rib height for the module 350	15/20/30/35
Rib height for the module 400	15/20
Module length	min. 1160 max. 6010
Weight	~ 4,5 kg/m <sup>2</sup>
Length of an overlap when separating steel sheets	60

Technical parameters [mm]	
Effective width	1105
Total width	1194
Thickness of steel sheet	0,5
Total profile height	52/57/67
Rib height for the module 350	25/30/40
Rib height for the module 400	25
Module length	min. 1160 max. 6110
Weight	~ 4,5 kg/m <sup>2</sup>
Length of an overlap when separating steel sheets	20

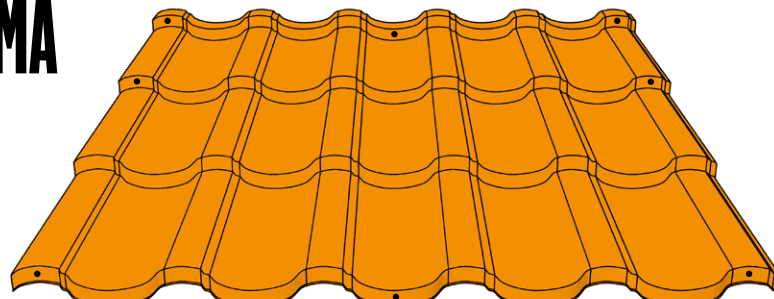
**HETA**



**ALFA**

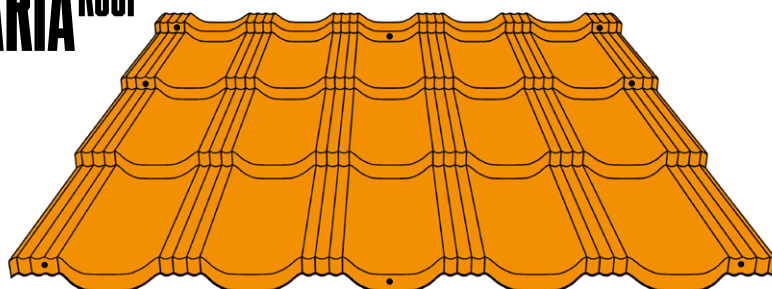


**STIGMA**



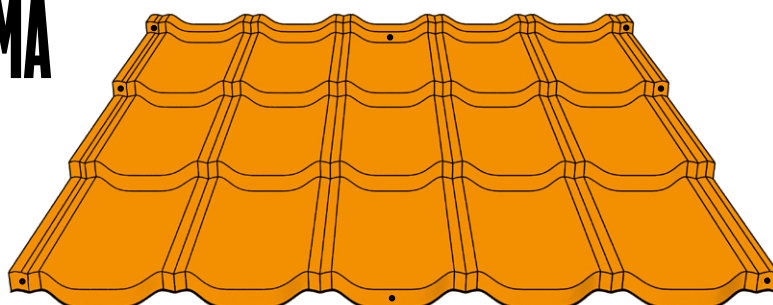
Technical parameters [mm]	
Effective width	1120
Total width	1206
Thickness of steel sheet	0,5
Total profile height	45/50/60
Rib height for the module 350	25/30/40
Rib height for the module 400	25
Module length	min. 1160 max. 6110
Weight	~ 4,5 kg/m <sup>2</sup>
Length of an overlap when separating steel sheets	20

## BAVARIA<sup>ROOF</sup>



Technical parameters [mm]	
Effective width	1150
Total width	1212
Thickness of steel sheet	0,5
Total profile height	45/50/60
Rib height for the module 350	25/30/40
Rib height for the module 400	25
Module length	min. 1160 max. 6110
Weight	~ 4,5 kg/m <sup>2</sup>
Length of an overlap when separating steel sheets	20

## GAMMA

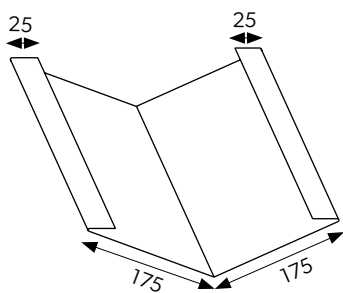


**The CLASSIC SERIES steel roof tiles with the rib heights of 30 mm, 35 mm and 40 mm have ready-made mounting holes on the rib.**

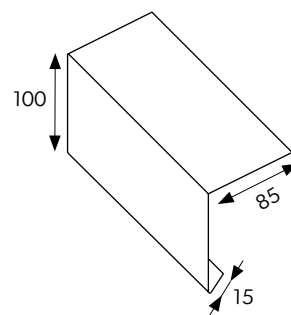


## 2. Flashing system

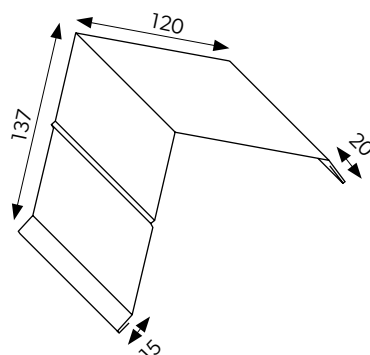
The flashings are made of sheets characterized by the same palette of coatings and colors as our steel roof tiles, trapezoidal sheets and roof panels.



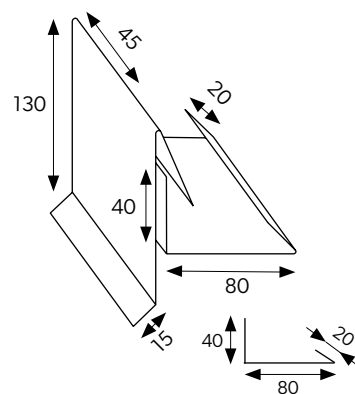
VALLEY GUTTER



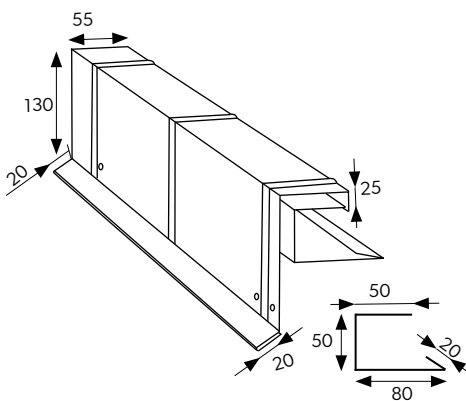
OVER-GUTTER STRIP



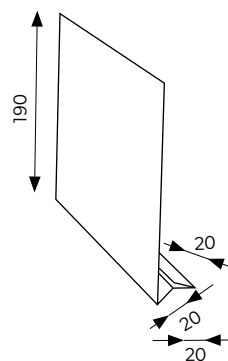
WIND BRACE I



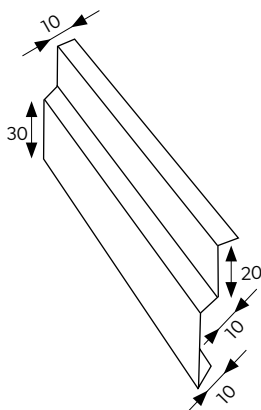
WIND BRACE II



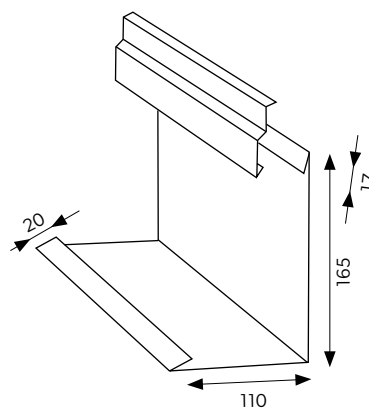
WIND BRACE III



UNIVERSAL VERGE TRIM/  
WIND BRACE EXTENSION



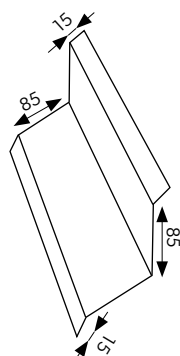
EAVES STRIP



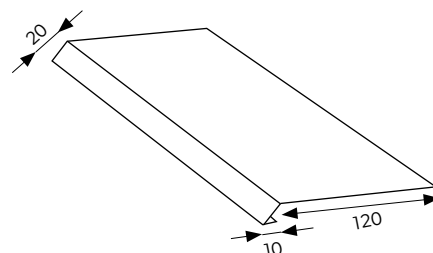
WALL FLASHING WITH  
EXPANSION STRIP



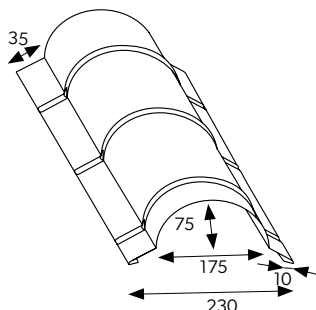
We offer standard flashings with a length of 2 m and a thickness of 0.5 mm as well as non-standard flashings up to a length of 8 m and a thickness of 2 mm suitable for all heights of ribs (30-40 mm).



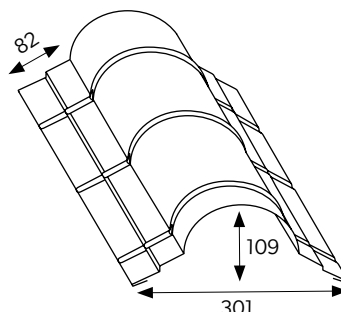
NEAR WALL FLASHING I



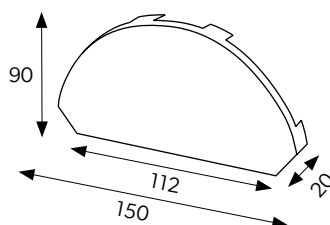
EAVES STRIP



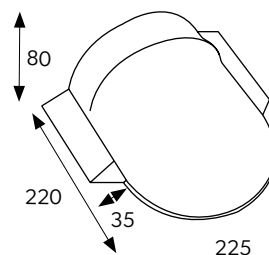
BARREL-SHAPED RIDGE TILE



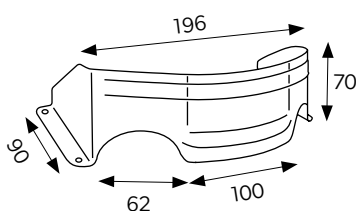
WIDE RIDGE TILE



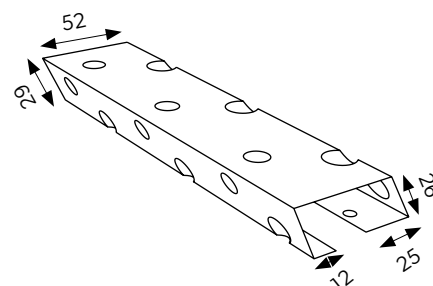
BOTTOM OF THE BARREL RIDGE TILE



HIP TILE ENDING



SNOW GUARDS



UNIVERSAL VENTILATION FLASHING /  
STARTING PROFILE

The flashings are made of sheets characterized by the same palette of coatings and colors as our steel roof tiles, trapezoidal sheets and roof panels.



We offer standard flashings with a length of 2 m and a thickness of 0.5 mm as well as non-standard flashings up to a length of 8 m and a thickness of 2 mm suitable for all heights of ribs (30-40 mm).

### 3. General instructions

#### Transport

Vehicles intended for the transport of steel roof tiles should be adapted to the transport of loads with the length of the transported sheets. The sheets should be tightly fastened into one package so that there is no friction that could damage the coating. Damage to the base varnish is not subject to complaint. When handling the sheets during manual unloading, the number of people should be selected in such a way as to prevent the sheets not only from shifting along one another but also from their bending by grabbing them in the points where they have the greatest stiffness.

#### Storage

CLASSIC SERIES sheet roof tiles should not be stored in original packaging for more than 3 weeks from the date of production. Upon expiry of this period, cut the package open, remove the protective foil and place thin spacers between the sheets. Total storage time cannot exceed 5 months since the production date.



**IMPORTANT - damage to the steel sheet panel surfaces as a result of moisture dismisses any claims. The manufacturer is not liable for any difference in the colour shades, appearance of the coating and dimensional deviations (within tolerances approved based on standards applicable to a given product) between different orders.**

#### Cutting the steel sheet

It is not allowed to cut the sheets with tools that cause thermal effect (sudden increase of temperature), e.g. angle grinder. This causes damage to the organic and zinc coating and thus leads to corrosion accelerated by hot filings melting into the sheet surface. To cut the sheets, use a nibbler or manual scissors if the sections are short.



**ATTENTION - one of the guarantee conditions is to protect open cut edges of a coated sheet with lacquer.**

#### Maintenance

In the case of damage to the coating caused during transport, assembly and processing, it should be carefully treated with varnish in the damaged area, first cleaning the surface of dirt and fat. Edges of the roof not protected with lacquer may delaminate. This is a natural phenomenon and does not represent the grounds for guarantee claims. It is recommended to control the roof every year in order to perform maintenance works.



**Before starting the works, remember to write down the serial number of one of the sheets. It is necessary to fill out the guarantee form.**

Cutting sheets to size does not include bevels. In case the slope length exceeds the allowable sheet length, the material is automatically divided in half.



**CLASSIC SERIES tiles can be used on roofs with an inclination angle of not less than 9°.**

## 4. Preparing the structure

Sheet roof tiles should be installed on a traditionally prepared substrate with the use of battens and counter battens. The installation and preparation of the base should be performed according to normal roofing procedures. It is necessary to remember about the eaves and ridge ventilation. When installing sheet roof tiles with a rib height of 25 mm and higher, a universal ventilation flashing is required (**Fig. 2**). In the case of lower ribs, the first batten should be raised by the embossment height (**Fig. 2.1**). Before starting the installation, check the roof diagonals. CLASSIC SERIES tiles can be used on roofs with an inclination angle of not less than 9 degrees.

FIG.1

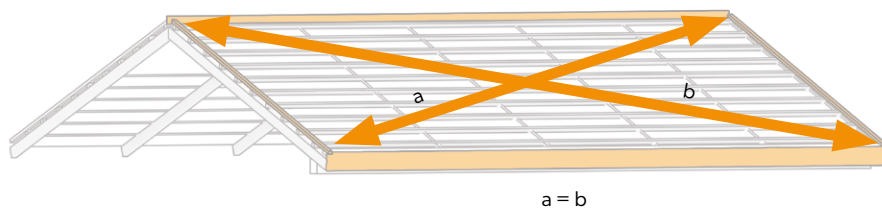


FIG.2

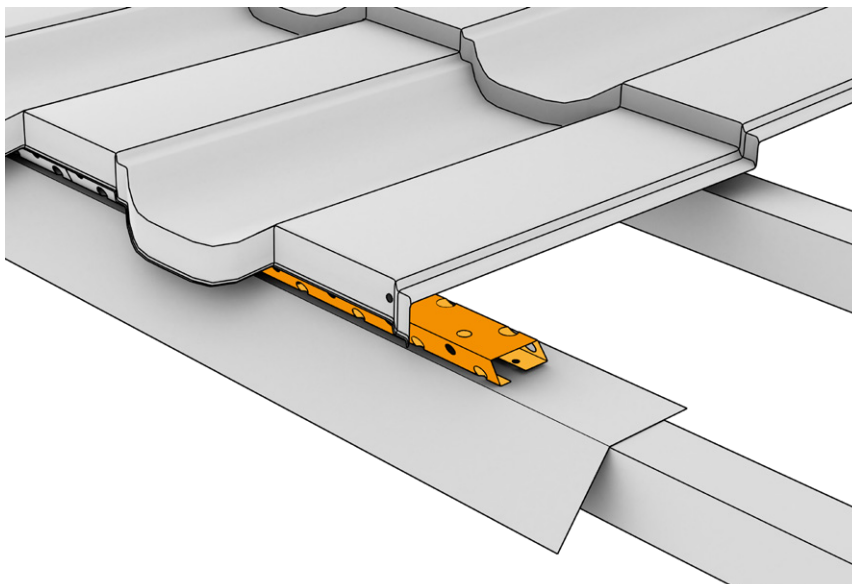
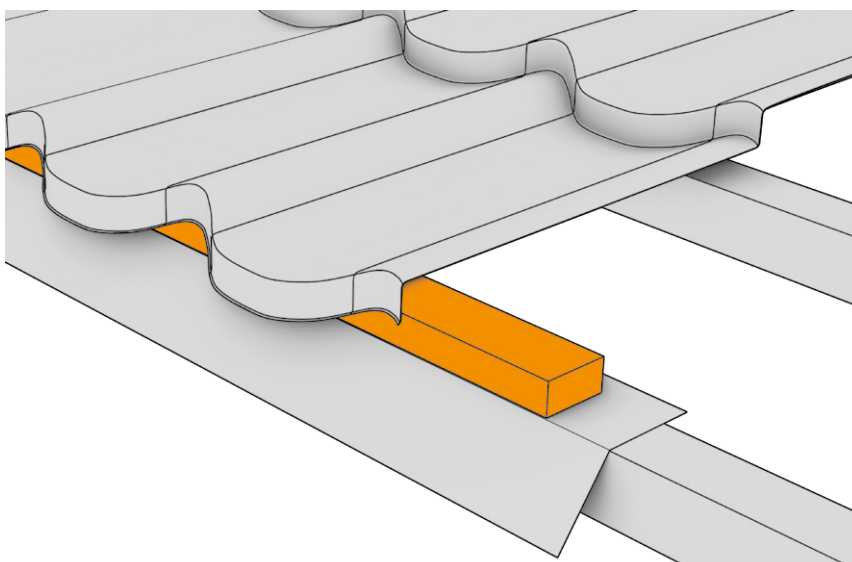


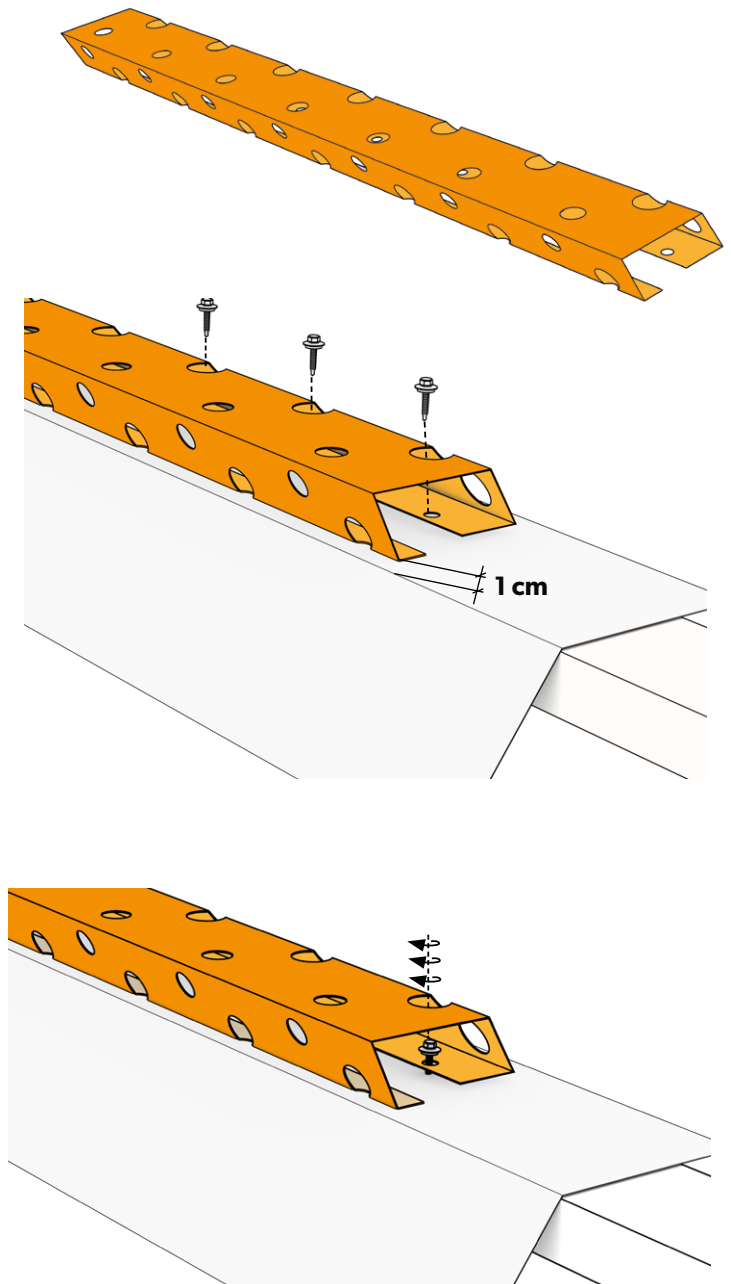
FIG.2.1





**FIG.3**

The universal ventilation flashing must be installed using installation holes in the bottom flashing edge. The screws should be passed through the larger pilot hole in the upper flange as shown in the cross section to the right (**Fig. 3**).

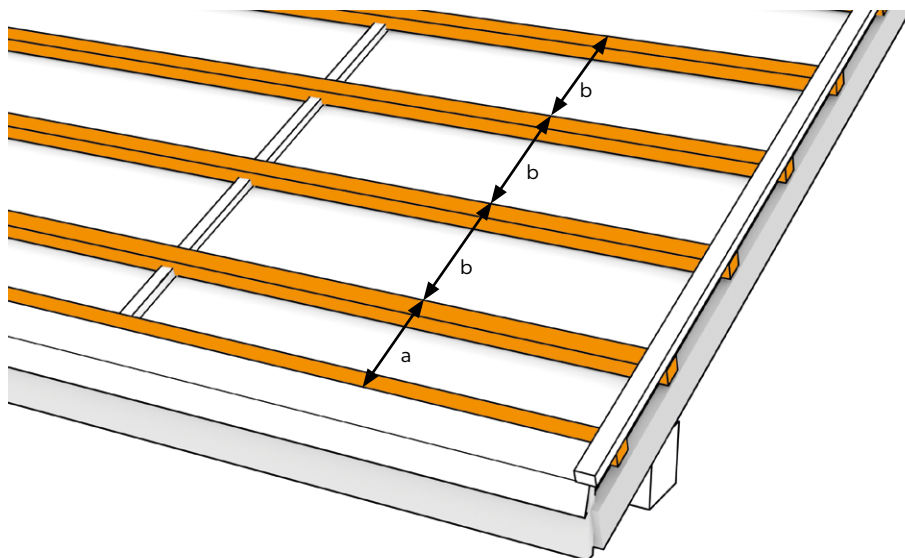


## 5. Batten spacing

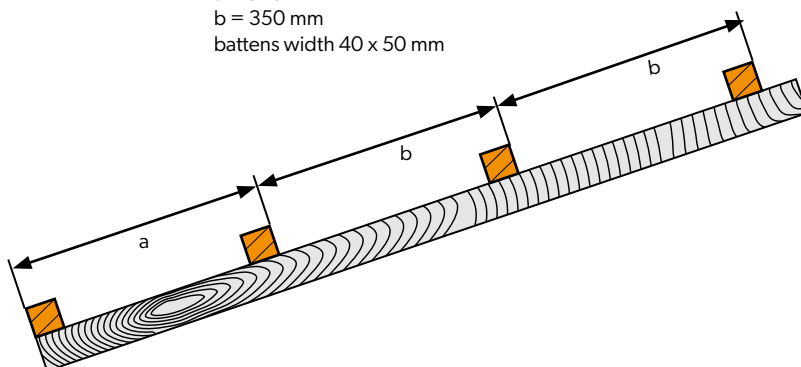
The contractor must make every effort to place battens with unprecedented precision and prepare the roof for the installation of compact sheet roof tiles. Accurate arrangement of the battens is critical and highly affects the final result. The most important thing is the spacing of the main battens, which must be equal to the length of the tile modules (for tiles with a module length of 350 mm, it must be 350 mm).

The distance between the lower edge of the first batten and the upper edge of the second batten from the eaves side should be 320 mm **(as shown in Fig. 4 - also applies to tiles with a module length of 350 mm)**.

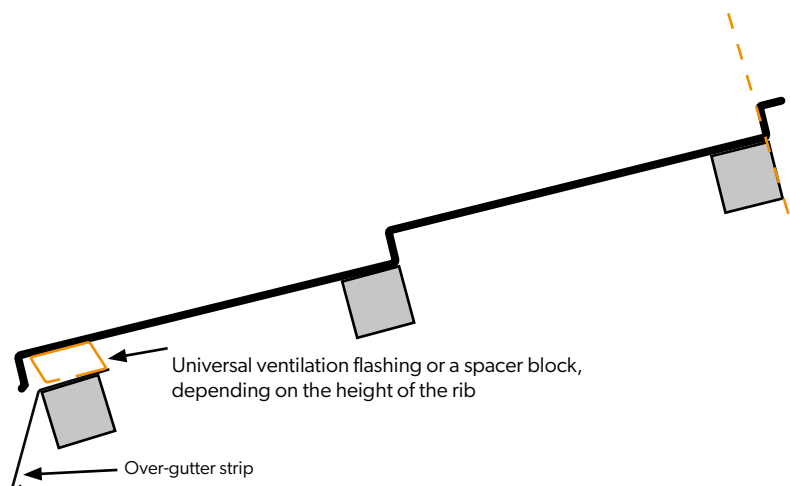
FIG.4



a = 320 mm  
b = 350 mm  
battens width 40 x 50 mm



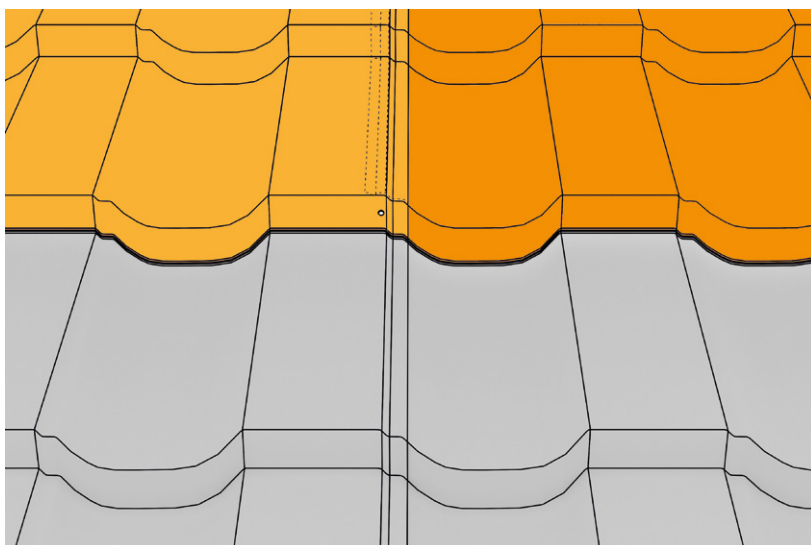
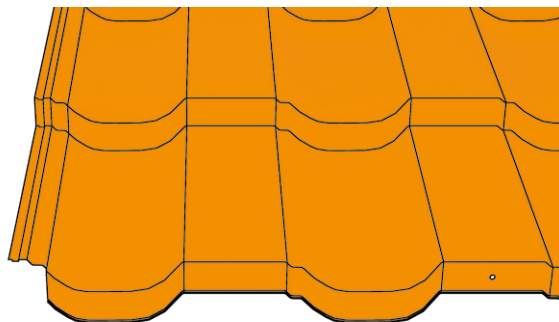
**With a properly battened roof, the last rib should be flush with the upper edge of the batten.**



## 6. EASY LINK corner cutout

A special cut and profiling of the edge rib, which allows for a perfect fit and levelling of the sheets without visible longitudinal joints (applies to asymmetrical ALFA and HETA tiles, **Fig. 5**).

**FIG.5**



## 7. How to join the sheets

Installation is carried out from the eaves to the ridge in longitudinal rows. Each next sheet in a row is sewn to the previous one (sheet below) through the middle and rightmost assembly holes and only then screwed to the battens (**Fig. 6**).

In the case of the version without holes, the sheet is screwed directly to the battens in the undercutting of its rib (**Fig. 6.1**).

FIG.6

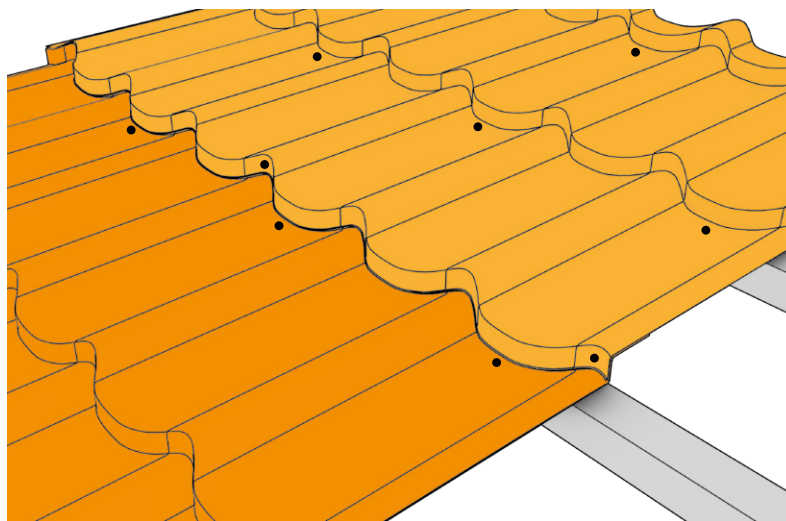
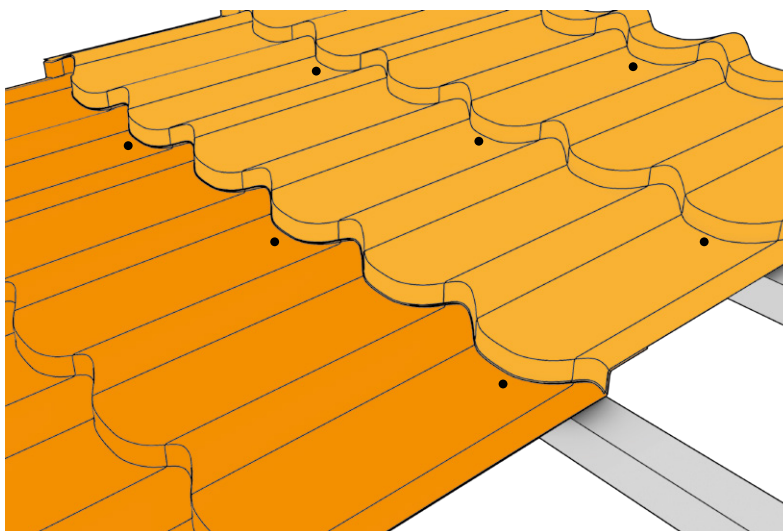


FIG.6.1



## 8. The sequence of sheets installation

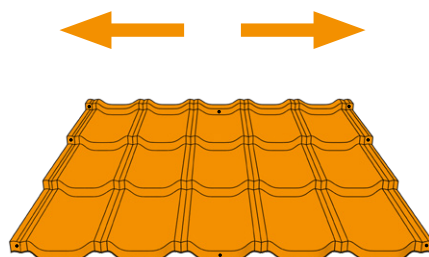
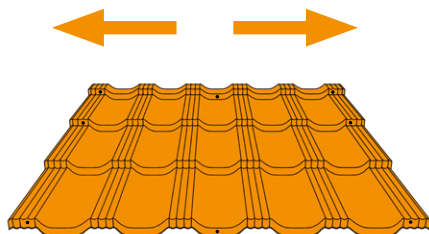
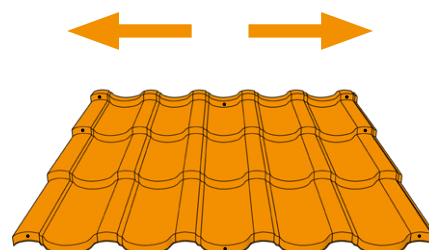
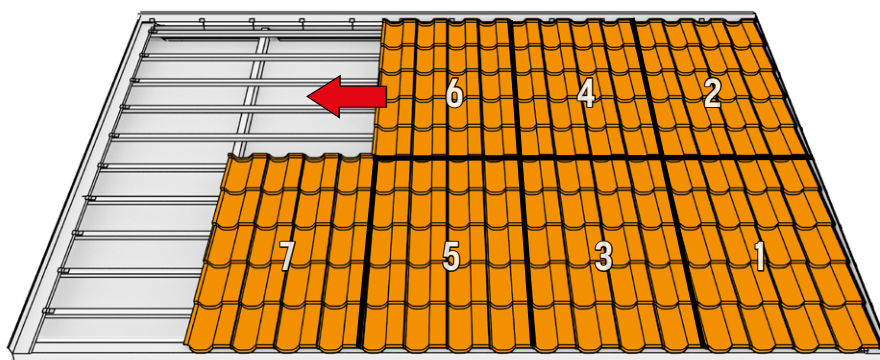
The installation of CLASSIC SERIES sheet roof tiles should be carried out from the eaves towards the ridge.

The correct sequence for installing steel roof tiles is from right to left (**Fig. 7**). In the case of compact tiles: STIGMA, BAVARIA Roof and GAMMA can also be installed in rows from left to right.

Place the first edge sheet and tighten it to the battens with farmer screws. Sew each next sheet in a row to the previous one (sheet below) through the middle and right assembly holes, then tighten them to the battens.

In the case of the version without holes, the sheet is screwed directly to the battens in the undercutting of its rib.

FIG.7



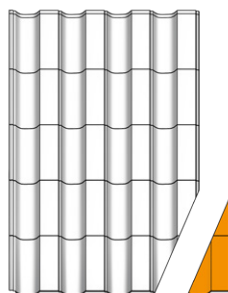
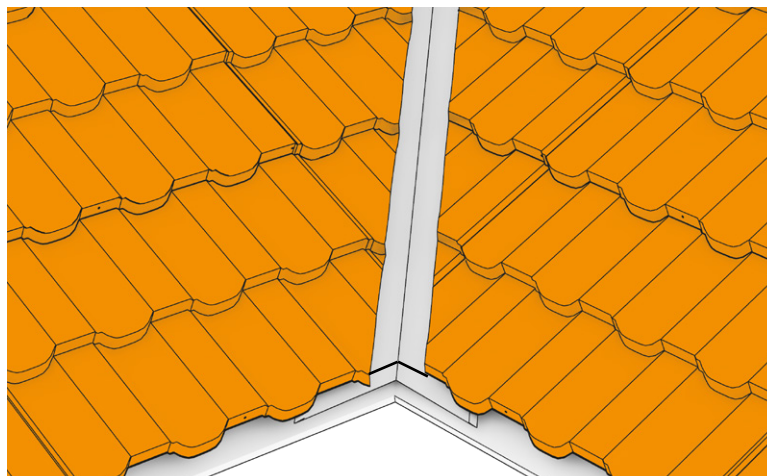
**In the case of symmetrical STIGMA, BAVARIA Roof, and GAMMA tiles, it is also possible to install them in rows from left to right.**



## 9. Finishing the valley gutter

Cutting sheets to the valley gutter should be carried out in the valley line, which will ensure an aesthetic finish (**Fig. 8**). As a sealing of the valley gutter, we recommend the use of an expansion seal up to the height of the sheet overlap.

FIG.8



## 10. Installation of ridge tiles

The ridge batten must be installed on supports in order to provide continuity of the roofing ventilation space (**fig. 9**). The ridge tiles are fastened with short screws 4.8 x 20 mm „sheet steel“ in every second crest of the wave, using the ridge tape or profiled seals.

FIG.9

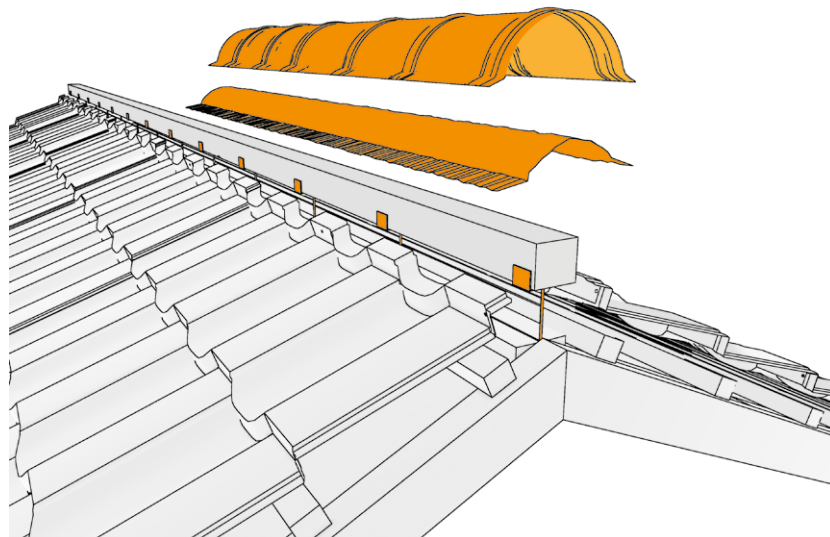
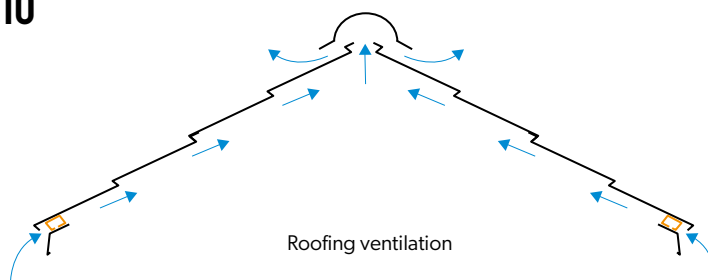


FIG.10



## 11. Installation of wind braces

Due to the fact that at the edge of the roof slope we often deal with a strong influence of the wind, we must remember to install the wind brace flashing appropriately.

In this case, we use the WIND BRACE III. First, install the wind brace tray (**Fig. 11**). This element must be installed using installation clips both from the roof area side and external side. Before covering the roof, glue the expansion gasket of expansion range up to 3 cm (according to the sheet rib height) to the bottom area of the flashing.

At the external element of the wind brace, use a farmer screw and when necessary, apply 15 - 30 cm overlap when connecting the wind braces.

In the edge sheets, overlapping the wind brace channel, the mounting holes should be sealed with screws in the points where the sheet overlaps the flashing (applies to the product version with ready mounting holes).

**The correct arrangement of fasteners on the slope should cover all extreme mounting points and every second point inside the slope (Fig. 13).**

FIG.11

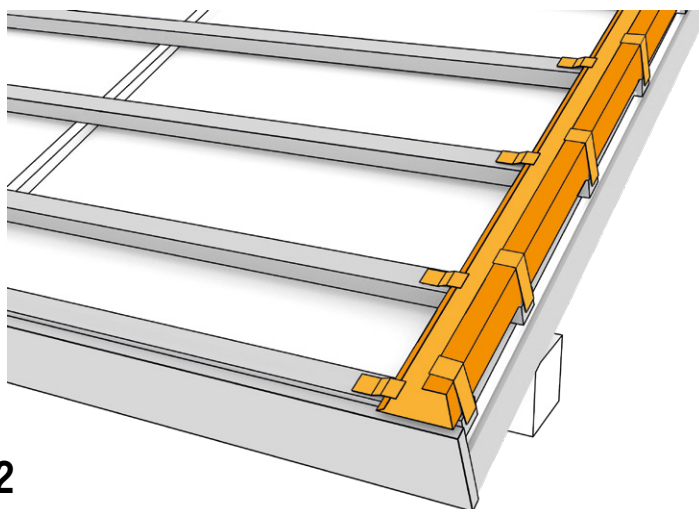


FIG.12

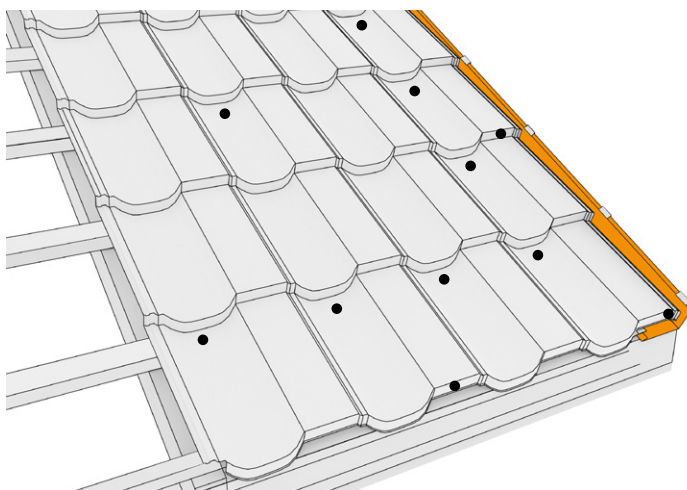
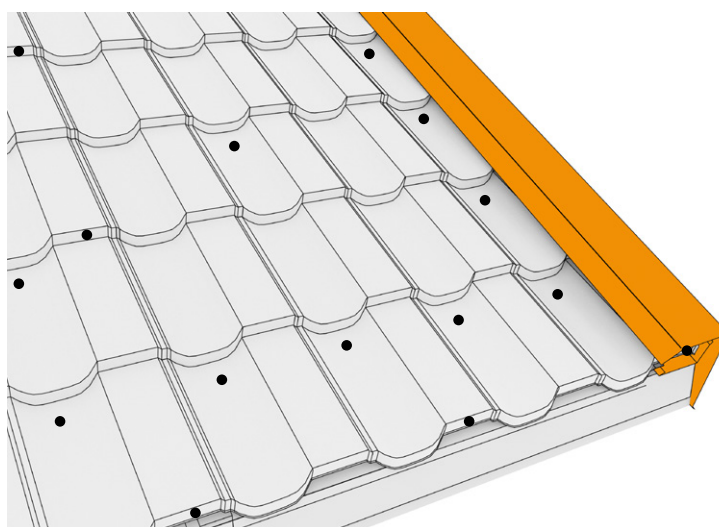


FIG.13



## 12. Installation of wall flashings

The first step is to prepare and attach the grips to the roof slope, which will be used to attach the wall flashing (**Fig. 14**). Such grips can be prepared from the strips of the steel sheet bent at right angles. Since these grips will have to be bent in the next step, attaching them to the wall flashing, they must be correspondingly higher than the flashing.

When preparing the flashing, its upper edge should be rolled, which will enable a secure connection with the previously prepared grips without the need for additional fasteners.

Before installation, the flashing should be applied to the roof edge in order to adjust it, taking into account the type of the wall and slope angle. Install the cut and bent flashing to the battens using flat installation clips. Make sure that the flashing abuts the wall along its whole length.

If it is necessary to connect the wall flashing, use a 50 mm overlap but the overlap should be increased in case of roof inclination below  $25^\circ$ .

Then, the flashing is attached to the wall with previously prepared grips (**Fig. 15**).

FIG.14

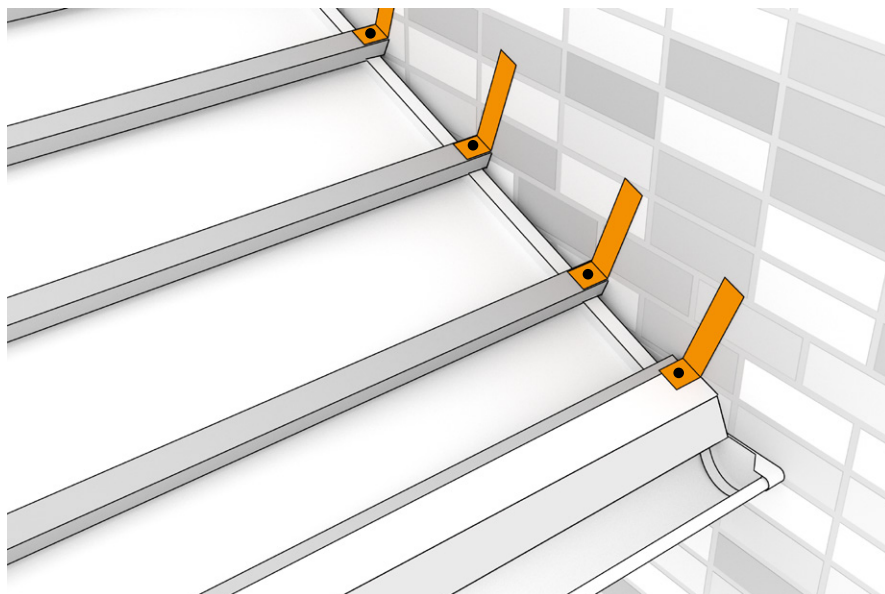


FIG.15

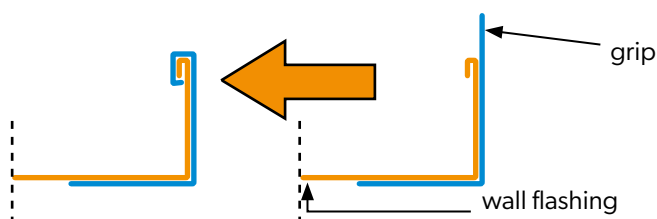
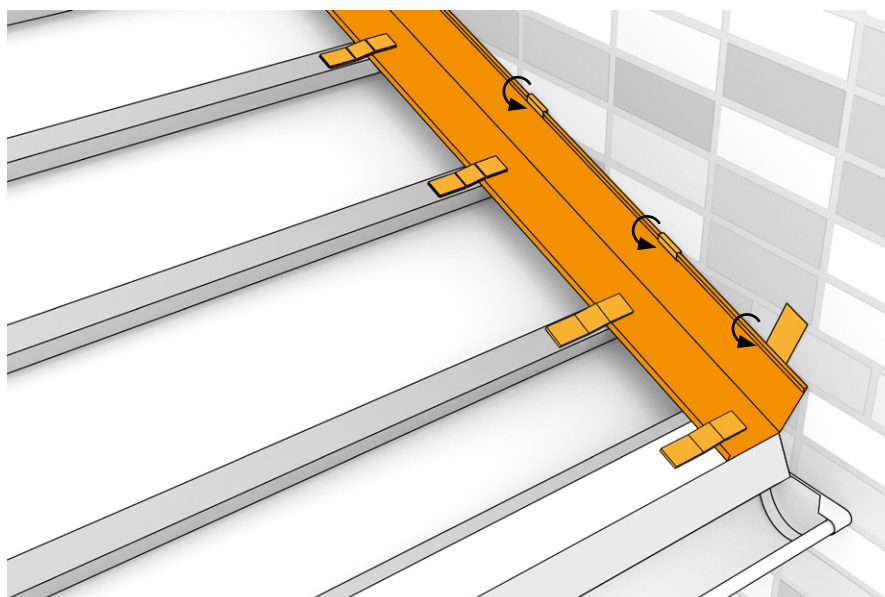


FIG.16

As in the case of the wind brace installation, in the edge sheets overlapping the flashing, the mounting holes should be sealed with screws (for the product version with ready mounting holes - **Fig. 16**).

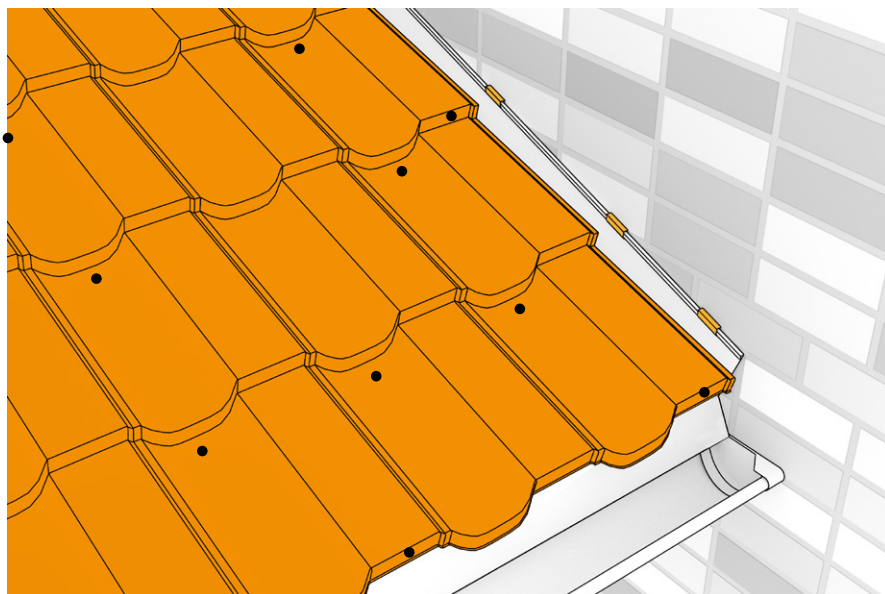
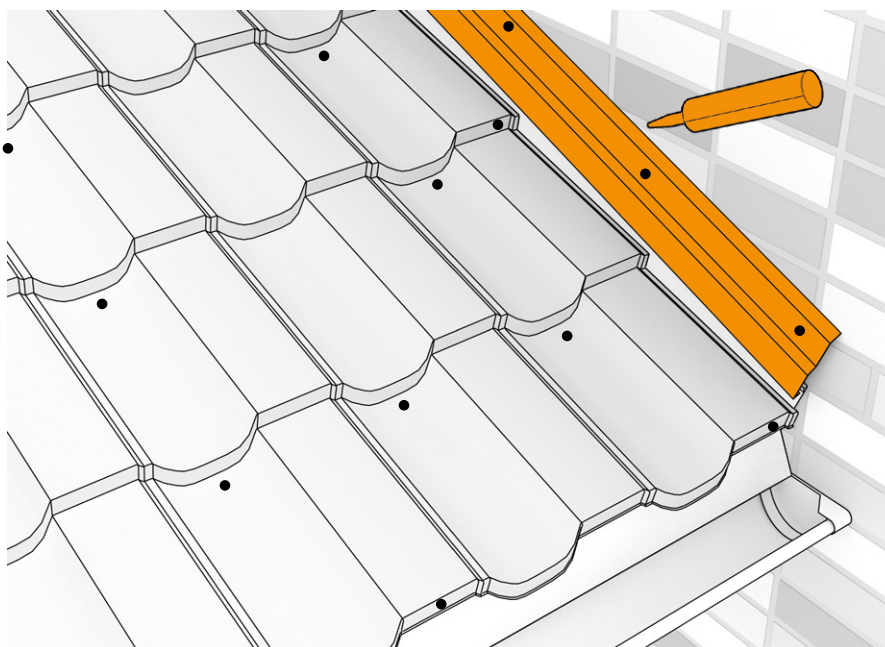


FIG.17

The joint with the wall should be protected with an expansion strip and, if necessary, additionally sealed with roofing sealant.

The expansion strip must be attached to the wall (**Fig. 17**).





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41-303 Dąbrowa Górnicza