

SERVICE[®] **PARTNERS**

YOUR SUCCESS

IS OUR BUSINESS

Gutter Catalog

(800) 356-2149



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Introduction and History of Gutters

The purpose of a Gutter and Downspout system is to collect rainwater from the roof and direct it away from the building foundation by means of downspouts, splashblocks, or underground drain lines.

The standard size for residential dwellings is **5" K-Style** gutter. A larger size or **6" K-Style** gutter is used for larger roofs and commercial buildings. **Half-Round** Gutters are typically sized 1 inch wider than K-Style Gutters to provide the equivalent capacity. **Half-Round** Gutters in most cases are not seamless. They are usually available in 20' lengths.

Downspout diameters are sized according the roof area they drain. A rule of thumb used in the industry is that 2X3 inch Downspout will suffice for 600 sq. ft. roof; and a 3X4 inch Downspout for 1,200 sq. ft. The typical downspout size for 5 inch K-Style Gutter is 2X3 inches, but 3X4 inches is preferable because it is less likely to become clogged and easier to clean out. Vertical Downspouts are used to capture and distribute rain water to storm drainage systems, or by means of splash blocks, to areas away from the building's foundation walls to prevent the build up of water in the soil and possible resulting structural or basement moisture problems. Downspouts are typically rectangular and of the same materials as the Gutter to prevent destructive galvanic actions.

An improperly functioning Gutter and Downspout system can contribute to water and ice backing up against fascias and under roof shingles, can damage soffits, and discolor or deteriorate siding materials. Faulty Gutters and Downspouts can also lead to soil erosion adjacent to buildings and serious water foundation displacement problems in basements and crawl spaces. Gutters should be sloped a minimum of 1 inch every 40 feet of run, standing water may indicate a sagging or incorrectly pitched Gutter.

Unfortunately, Gutter systems take more abuse from extreme weather conditions, particularly ice and snow, than any other component of the building envelope. They are also subject to damage from ladders and being stepped on, as well as from falling tree limbs and debris. In heavy snow areas, snow guards may be used to prevent Gutter tear off.

Gutters are often sized according the roof area they drain. Wider Gutters may be required for certain hard surface roofing materials, such as slate tile, or used on steeply-pitched roofs, to prevent water from shooting over the Gutter. Gutters should be positioned tight against roofing materials and fascia.

Before 1960, most Gutters were made of wood or metal and a "Half-Round" shape. During the 1960's, roll-formed metal Gutter technology was introduced that allowed metal Gutters to be made lighter, and less expensively. Initially available primarily in galvanized steel, roll formed Gutters are now available in COPPER, ALUMINUM, GALVANIZED, and PAINTED STEEL. When first developed, the portable roll forming equipment we now call Gutter Machines were described as Seamless Roll Formers. The description came from the idea that a standard size roll of Aluminum Gutter Coil could form approximately 1000' of Gutter at one time. As no residence had need for any Gutter that long, the term Seamless was coined.

Both surfaces of continuous Gutter have a meticulously controlled coating of thermally set polyester acrylic paint applied before they are roll formed. The inside surface is coated with the same type finish applied at 10% of the face coat thickness. This is applied to provide a "buffer" between the layers of aluminum as they are coiled to protect the sheen of the outside coat. This coat has a high modulus of expansion, which allows it to be stretched drastically before it fails. The aluminum sheet still shows no sign of missing paint as it is rolled through the forming machine at the job site.

The principal reason aluminum gutters are popular, is because **Aluminum does not rust**. Aluminum has the property that when it does oxide, (rust), and the oxide forms a protective coating to prevent further oxidation. Also aluminum is pound for pound stronger than steel (that's why aircraft are covered in aluminum, not steel).

GUTTERS AND COMPONENTS ARE AVAILABLE AT THE FOLLOWING LOCATIONS:

- **Fredericksburg, VA**
10848 Houser Dr, Fredericksburg, VA 22408
- **Raleigh, NC**
3208 Spottswood St, Unit 105, Raleigh, NC 27615
- **Pottstown, PA**
1000 Armand Hammer Blvd, Pottstown, PA 19464
- **Lakeville, MA**
260 Kenneth Welsh Dr, Lakeville, MA 02347
- **Colonie NY**
8 Selena Dr, Colony NY 12205
- **Mooreville, NC**
135 Denver Bus Park, Mooreville, NC 28115
- **Tampa, FL**
9201 F King Palm Dr, Tampa, FL 33619
- **Orlando, FL**
7407 Monetary Dr, Orlando, FL 32809
- **Miami, FL**
300 NE 187th, Miami, FL 33179
- **West Palm, FL**
2213 Vista Pkwy Suite 10, West Palm Beach, FL 33411
- **Jacksonville, FL**
5808 Mining Terrace, Jacksonville, FL 32257
- **Tallahassee, FL**
3747 Peddie Dr, Tallahassee, FL 32303
- **Fort Myers, FL**
9353 Laredo Ave Suite 130, Fort Myers, FL 33905
- **Indianapolis, IN**
8026 Woodland Dr, Indianapolis, IN 46278
- **West Des Moines, IA**
2420 Grand Ave Suite 300, West Des Moines, IA 50265
- **Jefferson City, MO**
307 Wilson Dr, Jefferson City, MO 65109
- **Duluth, GA**
1600 Cross Point Way Suite A, Duluth, GA 30097
- **Birmingham, AL**
440 Republic CR, Birmingham, AL 35214
- **Tuscumbia, AL**
407 hwy 20, Tuscumbia, AL 35674
- **Byram, MS**
5650 Terry Rd, Byram, MS 39272
- **Jackson, TN**
107 South Wide Dr, Jackson, TN 38305
- **Houston, TX**
7150 Bus Park Dr Suite 100, Houston, TX 77041
- **Oklahoma City, OK**
4210 Will Rogers Pkwy, Oklahoma City, OK 73108
- **Arlington, TX**
841 North Great South West Pkwy, Arlington, TX 76011
- **San Antonio, TX**
1811 Shipman Dr Suite 118, San Antonio, TX 78219
- **Austin, TX**
15855 Long Vista Blvd, Austin, TX 78728
- **Puyallup, WA**
926 Valley Ave, Puyallup, WA 98371
- **Marysville, WA**
3800 136th St, Marysville, WA 98271
- **Kent, WA**
8609 South 208th St, Kent, WA 98031
- **Tigard, OR**
16320 SW 72nd Ave, Tigard, OR 97224
- **Vancouver, WA**
16320 SW 72nd Ave, Tigard, OR 97224
- **Eugene, OR**
1820 Prairie Rd Units C&D, Eugene, OR 97402
- **Fresno, CA**
2898 S Orange Ave, Fresno, CA 93725
- **Anaheim, CA**
1086 N Kraemer St, Anaheim, CA 92806
- **San Marcos, CA**
120 Mata Way, San Marcos, CA 92069
- **Camarillo, CA**
300 Camarillo Ranch Rd Unit D, Camarillo, CA 93012
- **Valley Gutter, CA**
15148 Bledsoe St Unit B, Sylmar, CA 91342
- **Denver, CO**
3950 Nome St Unit H, Denver, CO 80239
- **Knoxville, TN**
1301 Mitchell St, Knoxville, TN 37917
- **Las Vegas, NV**
4030 Industrial Center Dr Suite 503, North Las Vegas, NV 89030
- **Phoenix, AZ**
2440 S 8th Place, Phoenix, AZ 85034



COLORS AVAILABLE BY LOCATION

X indicates that color is a stock item at that location. Subject to change without notice.

	Almond	Black	Blue	Bronze	Buckskin	Brown	Clay	Colonial	Cream	Coppertone	Dark Gray	Eggshell	Green	Hi-Gloss	Ivory	Light Pecan	Linen	Low Gloss	Mill	Musket Brown	Red	Satin	Sandcastle	Territone	Tuxedo	Harvest Brown	Wicker	Woodbeige
Fredericksburg, VA	X	X		X			X	X	X	X	X	X	X	X				X		X	X			X	X		X	
Raleigh, NC	X	X		X		X	X	X	X	X	X	X	X	X				X		X	X			X	X		X	
Pottstown, PA				X		X	X	X	X	X	X	X	X	X				X		X	X			X	X		X	
Lakeville, MA	X	X	X	X		X	X	X	X	X	X	X	X	X	X			X		X	X		X	X			X	
Colonie, NY	X	X		X		X	X	X	X		X	X		X	X		X			X			X	X	X		X	
Mooresville, NC	X	X	X	X		X	X	X	X		X	X	X	X	X		X	X		X	X		X	X			X	
Tampa, FL	X	X		X		X	X	X	X	X	X	X		X	X		X	X		X			X	X	X		X	
Orlando, FL	X	X		X		X	X	X	X	X	X	X		X	X		X	X		X			X	X	X		X	
Miami, FL	X	X	X	X		X	X	X	X	X	X	X	X	X	X		X	X		X	X		X	X	X		X	
West Palm, FL	X	X		X		X	X	X	X	X	X	X		X	X		X	X		X			X	X	X		X	
Jacksonville, FL	X	X		X		X	X	X	X	X	X	X		X	X		X	X		X			X	X	X		X	
Tallahassee, FL	X	X		X		X	X	X	X	X	X	X		X	X		X	X		X			X	X	X		X	
Fort Myers, FL	X	X	X	X		X	X	X	X	X	X	X	X	X	X		X	X		X	X		X	X	X		X	
Indianapolis, IN	X	X		X		X	X	X			X	X	X				X	X		X			X	X	X		X	
West Des Moines, IA	X	X		X		X	X	X	X		X	X	X	X	X			X		X	X			X	X		X	
Jefferson City, MO		X		X			X											X		X							X	
Duluth, GA	X	X		X			X	X	X	X	X	X		X			X	X		X				X	X		X	
Birmingham, AL	X	X		X		X	X	X	X	X	X	X	X		X		X	X	X	X	X		X	X	X		X	
Tuscumbia, AL	X	X		X		X	X	X				X					X	X		X				X			X	
Byram, MS	X	X		X		X	X					X			X			X		X			X		X		X	
Jackson, TN	X	X	X	X		X	X	X	X	X	X	X	X	X	X		X	X	X	X	X		X	X	X		X	
Houston, TX	X	X		X			X	X			X						X	X		X				X	X		X	
Oklahoma City, OK	X	X		X			X	X			X						X	X		X				X	X		X	
Arlington, TX	X	X		X			X	X			X						X	X		X				X	X		X	
San Antonio, TX	X	X		X			X	X			X						X	X		X				X	X		X	
Austin, TX	X	X		X			X	X			X						X	X		X				X	X		X	
Puyallup, WA		X	X	X	X	X	X	X	X		X		X	X	X	X		X		X	X			X	X	X	X	
Marysville, WA		X	X	X	X	X	X	X	X		X		X	X	X	X		X		X	X			X	X	X	X	
Kent, WA		X	X	X	X	X	X	X	X		X		X	X	X	X		X		X	X			X	X	X	X	
Tigard, OR		X	X	X	X	X	X	X	X		X		X	X	X	X		X		X	X			X	X	X	X	
Vancouver, WA		X	X	X	X	X	X	X	X		X		X	X	X	X		X		X	X			X	X	X	X	
Eugene, OR		X	X	X	X	X	X	X	X		X		X	X	X	X		X		X	X			X	X	X	X	
Fresno, CA	X	X	X	X	X	X	X	X	X		X		X	X	X		X	X		X	X	X	X	X	X	X	X	X
Anaheim, CA	X	X	X	X	X	X	X	X	X		X		X	X	X		X	X		X	X	X	X	X	X	X	X	X
San Marcos, CA	X	X	X	X	X	X	X	X	X		X		X	X	X		X	X		X	X	X	X	X	X	X	X	X
Camarillo, CA	X	X	X	X	X	X	X	X	X		X		X	X	X		X	X		X	X	X	X	X	X	X	X	X
Valley Gutter, CA	X	X	X	X	X	X	X	X	X		X		X	X	X		X	X		X	X	X	X	X	X	X	X	X
Denver, CO	X	X		X	X	X	X	X	X			X			X		X	X		X			X	X			X	
Knoxville, TN		X		X			X						X	X			X	X									X	
Las Vegas, NV	X	X		X	X	X	X	X	X		X				X		X	X		X			X	X	X		X	X
Phoenix, AZ	X	X		X	X	X	X	X	X		X				X		X	X		X			X	X	X		X	X

SERVICE[®] PARTNERS

Thickness	.027 x 11 3/4	.032 x 11 3/4	.027 x 15	.032 x 15
1/2	30/80	30/68	38/80	38/68
3/4	46/122	46/103	59/122	59/103
1	62/165	62/139	79/165	79/139
1 1/4	79/209	79/176	100/209	100/176
1 1/2	96/255	96/215	122/255	122/215
1 3/4	114/301	114/254	145/301	145/254
2	132/349	132/295	168/349	168/295
2 1/4	150/398	150/336	191/398	191/336
2 1/2	169/449	169/379	215/449	215/379
2 3/4	189/500	189/422	240/500	240/422
3	208/553	208/467	266/545	266/467
3 1/4	229/604	229/512	292/607	292/512
3 1/2	249/661	249/559	318/661	318/559
3 3/4	271/718	271/606	345/718	345/606
4	292/775	292/655	373/775	373/655
4 1/4	314/834	314/704	401/834	401/704
4 1/2	337/894	337/755	430/894	430/755
4 3/4	360/955	360/807	459/955	459/807
5	384/1018	384/860	489/1018	489/860

pounds/footage pounds/footage pounds/footage pounds/footage

Based on 16" coil center opening

Estimated Yields

Aluminum Coil

11 3/4" x .027	2.627 feet per lb
11 3/4" x .032	2.216 feet per lb
15" x .027	2.058 feet per lb
15" x .032	1.736 feet per lb.

Copper Coil (16oz)

11 3/4"	1 foot per lb.
15"	.75 feet per lb.

Galvanic Compatibility

**Galvanic Series
Table 1**

Magnesium
Zinc
Aluminum
Cadmium
Stainless Steel
Lead
Tin
Copper
Titanium
Silver
Gold

To avoid excessive galvanic corrosion between metals, the following metal pairs are acceptable when dissimilar metals are used:

ALUMINUM-----ZINC
 ALUMINUM-----GALVANIZED STEEL
 ALUMINUM-----STAINLESS STEEL
 COPPER-----STAINLESS STEEL
 GALVANIZED STEEL-----STAINLESS STEEL

Edge devices of a single metal are also acceptable if face, clip fastener is all the same material (e.g. aluminum).

In extremely corrosive environments, such as salt water environments, chemical plants or paper mills, use of corrosion-resistant materials approved by the owner or specific should be considered.

DO NOT USE COPPER IN COMBINATION WITH STEEL, ZINC OR ALUMINUM.

Be sure fasteners are electrolytically compatible with the other roof edge system components.

Corrosion potential can be roughly predicted by knowing the placement of the two metals in the Galvanic Series (table 1). The farther apart the metals are in the Galvanic Series, the greater the potential for corrosion. In the table 1, Galvanic Series, the metals high on the list are potentially corroded (sacrificed), while those low on the list are protected. Frequently, the corrosion rate of the “sacrificed” metals will be low, even if there is a potential for corrosion. Thus, there will generally be little corrosion between the metals which are close to each other in the list; however, when they are in contact, the lower on the list than Zinc, will be protected by the Zinc, which is “sacrificed” to save the steel. Pairs of metals, such as aluminum and stainless steel, will show no perceptible corrosion between them because of their proximity to each other on the list. On the other hand, pairing Cooper with Zinc or aluminum, or even steel, must be avoided because Copper is far from them in the Galvanic Series, and the potential for corrosion is great.

Note edited from an article November 1994 issue roofing/siding/insulation magazine.



Manufacturer's Twenty (20) Year Limited Warranty
For
Service Partners, LLC
Continuous Aluminum Gutter Coil and Aluminum Gutter Accessories
Pro-Rated/Non Transferable

Service Partners, LLC, (the "manufacturer") hereby warrants that the finish on the manufacturer's painted continuous aluminum gutter coil and painted aluminum gutter accessories specified herein (the "material") will not crack, peel, blister, chip, or flake under Normal Use and Normal Service for (20) twenty years from the date of the material's installation. The material is specifically intended to move only rainwater off the roofline and away from a dwelling (Normal Use). The purchaser is responsible for keeping the material free of tree leaves and other debris that may accumulate in/on or around the material (Normal Service). If, upon proper inspection by the manufacturer or its authorized representative, a defect is identified and acknowledged, the manufacturer will be responsible for the cost of refinishing, repairing, or replacing the defective material, or where applicable, issue a refund. All remedies herein shall be based upon the material's cost and be prorated from the installation date as follows: 100% for year one, 90% for year two, 80% for year three, 65% for year four, 50% for year five, 25% for years six through ten, 20% for years eleven through sixteen, 16% for year seventeen, 12% for year eighteen, 8% for year nineteen, 4% for year twenty, zero (0) percent for any claim made beyond twenty years. Any refinishing or replacement of defective material or refund shall be approved in advance and be at the manufacturer's sole option. The basis of determining the material's cost under this warranty shall be, at the manufacturer's sole option, one of the following alternatives: (i) for refinishing, the then prevailing area finishing cost; (ii) replacement or refund of material, the lesser of the price of the manufacturer's material at the time of settlement or the original purchase price of the material.

This warranty is valid only when payment for the material is made in full. This warranty covers the material only. The manufacturer is in no way responsible for the forming, shaping, or the installation of the product, which is the responsibility of the distributor, dealer, contractor, or applicator. This warranty applies only to the finish applied to manufacturer's continuous aluminum gutter coil and aluminum gutter accessories manufactured and sold by the manufacturer and excludes any products with a finish applied by another entity.

This warranty does not cover damage or deterioration caused by faulty installation, hail, ice, windstorms, foreign objects, fire, lightning, earthquakes, erosion, explosions, normal weathering (including chalking and fading), riots, vandalism, civil commotion, misuse, abuse, or other occurrences beyond the control of the manufacturer.

THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES AND REPRESENTATIONS, EXPRESSED OR IMPLIED, AND ALL OTHER OBLIGATIONS OR LIABILITIES ON THE PART OF THE MANUFACTURER AND IS LIMITED TO A DURATION OF TWENTY (20) YEARS. THE MANUFACTURER MAKES NO WARRANTY, EXPRESSED OR IMPLIED, OTHER THAN THAT SET FORTH HEREIN, OR REQUIRED BY LAW. The manufacturer does not warrant that any of the materials shall meet or comply with the requirements of any present or future safety code or regulation of any state, municipality, or other jurisdiction.

Liability of the manufacturer is limited to the purchase price. THE MANUFACTURER SHALL IN NO EVENT BE LIABLE FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES OF ANY KIND WHATSOEVER WHETHER ALLEGED TO HAVE RESULTED FROM DELAY IN DELIVERY OF NON-CONFORMING MATERIAL, DEFICIENCIES IN MATERIAL, OR ANY OTHER CAUSE WHATSOEVER, AND WHETHER ARISING FROM BREACH OF CONTRACT, BREACH OF WARRANTY, TORT, INCLUDING NEGLIGENCE, STRICT LIABILITY OR OTHERWISE. The remedy set forth above shall be exclusive.

Some states do not allow limitations on how long an implied warranty lasts, or the exclusion or limitation of incidental or consequential damages, so the above limitations or exclusions may not apply to you.

This warranty gives you specific legal rights, and you may also have other rights which vary from state to state.

All claims under this warranty must be made in writing within the warranty period, and within thirty (30) days after the appearance of any alleged defect. This warranty is not effective unless signed and dated by the installing dealer at the time of installation, countersigned by the purchaser and the original sent to the manufacturer within thirty (30) days of installation. This warranty extends to the original purchaser and installation address and cannot be assigned or otherwise transferred.

Manufacturer Authorized Dealer: _____
Products Installed: _____

Installation Date: _____

Purchaser: _____ Installation Address: _____

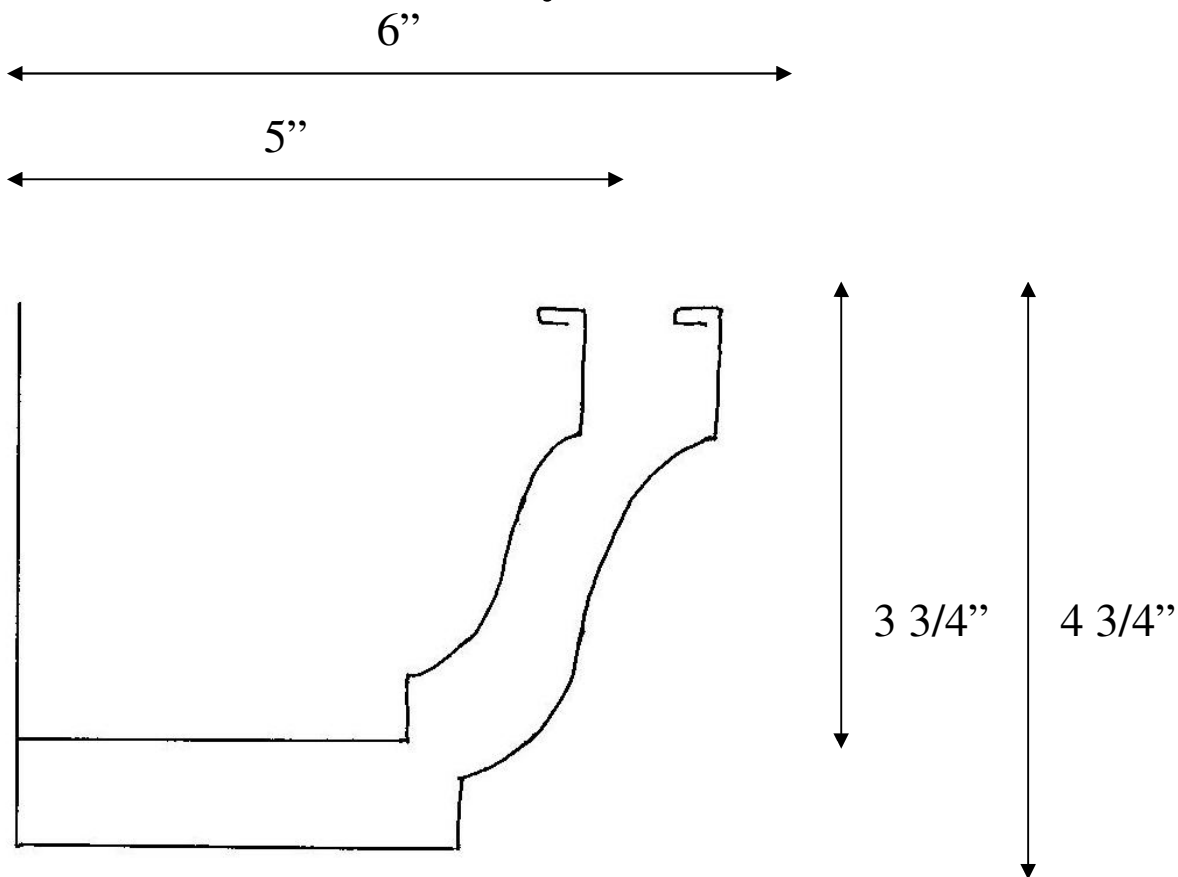
To validate warranty, return completed form to: Service Partners, LLC, 10848 Houser Drive, Fredericksburg, VA 22408



Gutter Coil

Item Code	Description	Pcs./Box
C113427(color)	11 3/4" x .027	*Partial/Full Roll
C113432(color)	11 3/4" x .032	*Partial/Full Roll
C117827(color)	11 7/8" x .027	*Partial/Full Roll
C1527(color)	15" x .027	*Partial/Full Roll
C1532(color)	15" x .032	*Partial/Full Roll

K-Style Gutter Profile





Downspout

Item Code	Description	Pcs./Box
DS238(color)	2x3 8'	80' per box
DS2310(color)	2x3 10'	100' per box
DS2315(color)	2x3 15'	150' per box
DS348(color)	3x4 8'	80' per box
DS3410(color)	3x4 10'	100' per box
DS3415(color)	3x4 15'	150' per box
DS4510(color)	4x5 10'	100' per box



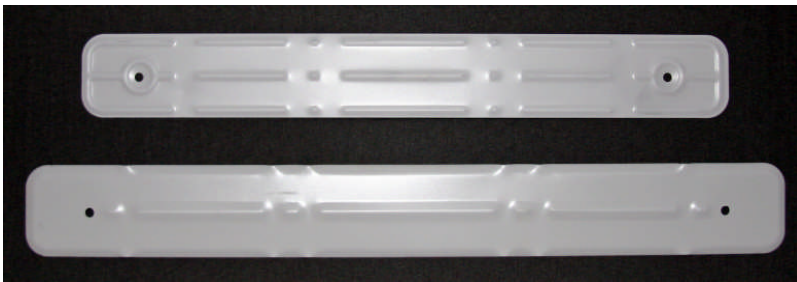
Elbows

Item Code	Description	Pcs./Box
E23(A)(B)(color)	2x3 A or B	30 per box
E23C(color)	2x3 C	50 per box (2 shown in pic)
E34(A)(B)(color)	3x4 A or B	15 per box
E34C(color)	3x4 C	16 per box
E45(A)(B)(color)	4x5 A or B	25 per box



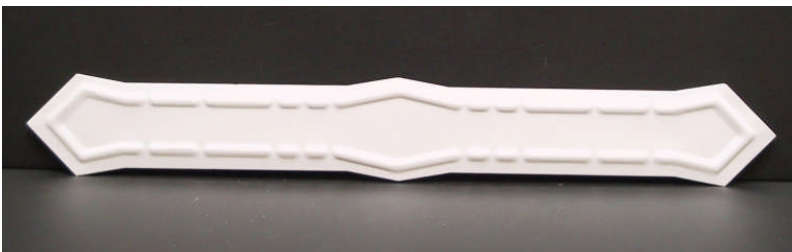
Endcaps

Item Code	Description	Pcs./Box
EC5(color)	5" Left/Right	25 each per box
EC6(color)	6" Left/Right	25 each per box



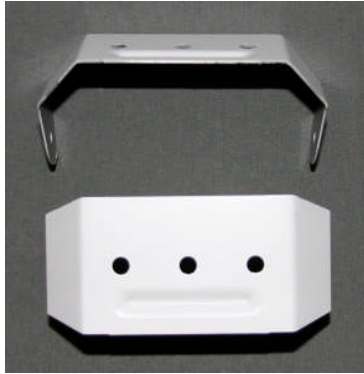
Pipebands

Item Code	Description	Pcs./Box
PB23(color)	2x3 Pipeband	100 per box
PB34(color)	3x4 Pipeband	100 per box



Pipestraps

Item Code	Description	Pcs./Box
PS(color)	Pipestrap	100 per box



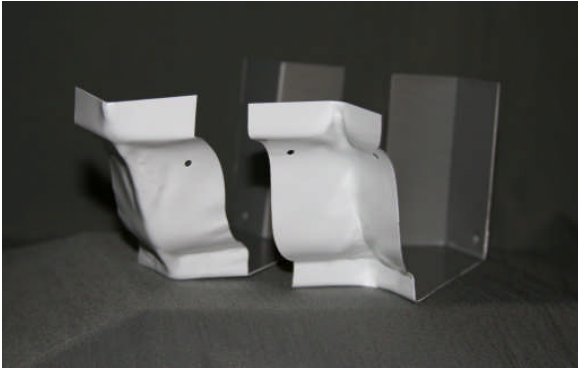
Pipe Clips or U Clips

Item Code	Description	Pcs./Box
PC23(color)-BX	2x3 Pipe Clip	100 per box
PC34(color)-BX	3x4 Pipe Clip	50 per box



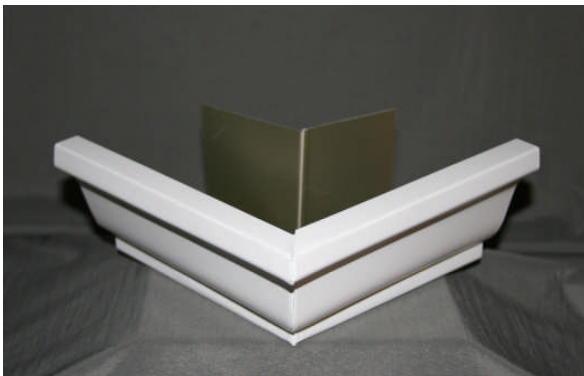
Pipe Cleats

Item Code	Description	Pcs./Box
CLEAT2X3-BX	Pipe Cleat	100 per box
CLEAT3X4-BX	Pipe Cleat	50 per box

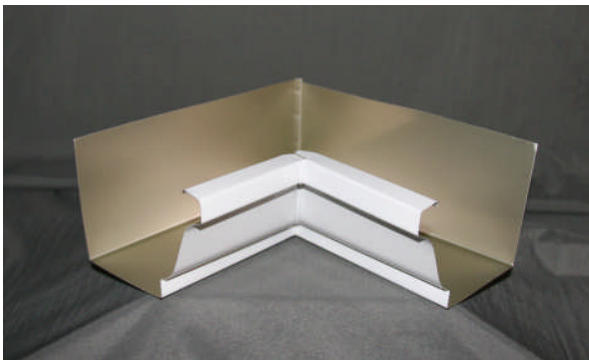


Outside & Inside Strip Mitre

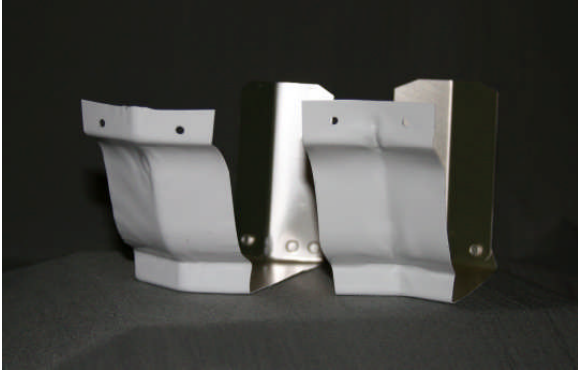
Item Code	Description	Pcs./Box
MS(I)(O)5(color)	5" Inside or Outside	20 per box
MS(I)(O)6(color)	6" Inside or Outside	20 per box



Outside & Inside Box Mitre



Item Code	Description	Pcs./Box
MBX(I)(O)5(color)	5" Inside or Outside	20 per box
MBX(I)(O)6(color)	6" Inside or Outside	20 per box



Outside & Inside Bay Mitre

Item Code	Description	Pcs./Box
MBY(I)(O)5(color)	5" Inside or Outside	20 per box
MBY(I)(O)6(color)	6" Inside or Outside	20 per box

Outlets



Item Code	Description	Pcs./Box
OUT238POPIN	2 3/8" Round Outlet	250 per box



Item Code	Description	Pcs./Box
OUT234POPIN	2 3/4" Round Outlet	250 per box



Item Code	Description	Pcs./Box
OUT338POPIN	3 3/8" Round Outlet (Used for 3x4 Downspout in 6" Gutter)	100 per box



Item Code	Description	Pcs./Box
OUT345OVAL	3x4 Oval Outlet for 5"	50 per box



Item Code	Description	Pcs./Box
OUT23RECT	2x3 Rectangular Outlet	30 per box



Item Code	Description	Pcs./Box
OUT34RECT	3x4 Rectangular Outlet	50 per box



Item Code	Description	Pcs./Box
OUT45OVAL	4x5 Outlet	50 per box

Gutter Hangers



Item Code	Description	Pcs./Box
HG5	5" Gorilla Hanger no clip	1000 per box
HG6	6" Gorilla Hanger no clip	700 per box



Item Code	Description	Pcs./Box
HGC5	5" Gorilla Hanger with clip	1000 per box
HGC6	6" Gorilla Hanger with clip	700 per box



Item Code	Description	Pcs./Box
HQ5	5" Quickscrew	500 per box
HQ6	6" Quickscrew	300 per box



Item Code	Description	Pcs./Box
HS5	5" Supreme Screw-on	400 per box
HS6	6" Supreme Screw-on	300 per box

Hangers for Copper Gutters



Item Code	Description	Pcs./Box
HG6B	6" Brass Hanger w/o Clip	50 per box



Item Code	Description	Pcs./Box
HGC5B	5" Brass Hanger w/ Clip	100 per box
HGC6B	6" Brass Hanger w/ Clip	50 per box

Gutter Hangers Continued



Item Code	Description	Pcs./Box
HG5SST-BX	5" Gorilla SST w/o Clip	100 per box
HG6SST-BX	6" Gorilla SST w/o Clip	100 per box
HGC5SST-BX	5" Gorilla SST w/Clip	100 per box
HGC6SST-BX	6" Gorilla SST w/Clip	100 per box



Item Code	Description	Pcs./Box
ROOFSTRAP-BX	Roofstrap	100 per box



Item Code	Description	Pcs./Box
W5H	5" Wrap Around Hanger	100 per box
W6H	6" Wrap Around Hanger	100 per box

Gutter Screws



Item Code	Description	Pcs./Box
SC15BX-1000	#10 x 1 1/2" Gutter Screws	1000 per box

Zip Screws



Item Code	Description	Pcs./Box
SC12(color)	#8 x 1/2" Zip Screws	1000 per box

Pop Rivets



Item Code	Description	Pcs./Box
PRIVET(color)	Pop Rivets	100 per bag

Brick Nails



Item Code	Description	Pcs./Box
NAIL114PBK	1 1/4" Premium Brick Nail	100 per box



Item Code	Description	Pcs./Box
NAIL114EBK	1 1/4" Economy Brick Nail	50# per box
NAIL114EBK5LB	1 1/4" Economy Brick Nail	5# per box

Gutter Wedges



Item Code	Description	Pcs./Box
GW56-BG	Mill Finish	50 per bag



Item Code	Description	Pcs./Box
GW5(color)	5" Gutter Wedge	100 per bag
GW6(color)	6" Gutter Wedge	50 per bag

Paint



Item Code	Description	Pcs./Box
PT(color)	Paint can	each/12 per box

Gutter Sealer

Rusco



Item Code	Description	Pcs./Box
SCPW98T1	White Squeeze Tube 4oz	12 per box
SCPS98TI	Aluminum Squeeze Tube 4oz	12 per box
SCPSW	Caulk Gun 10.6oz	24 per box

Geocel



Item Code	Description	Pcs./Box
GEOCEL2321-67001	Squeeze Tube 5oz	24 per box
GEOCEL2320-67101	Caulk Gun 10.3oz	24 per box

Splashblocks



Item Code	Description	Pcs./Box
SPLASHGRN	Green Plastic	20 bundle/240 skid

Draintile Adapters



Item Code	Description	Pcs./Box
A2x3	2x3 Plastic Adaptor	each/24 bag
A3x4	3x4 Plastic Adaptor	each/24 bag

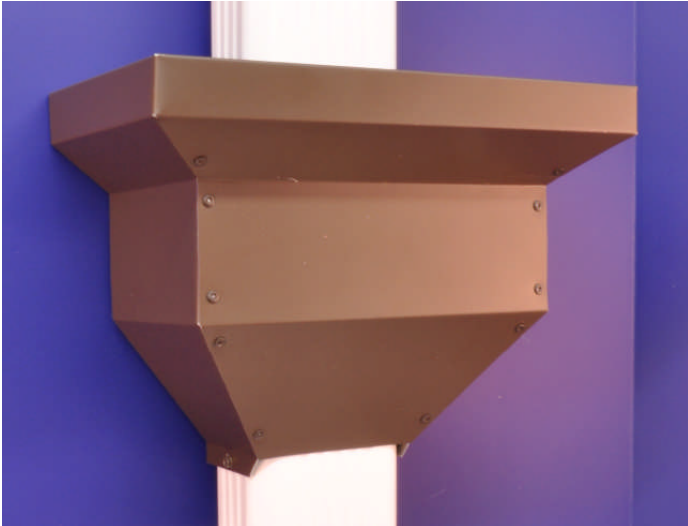
Conductor Heads/Scupper Box



Item Code	Description	Pcs./Box
CON2x3	2x3 Conductor Head (white or brown)	each
CON3x4	3x4 Conductor Head (white or brown)	each

False Conductors

**** Call for color availability on False Conductors ****



The Camden

Item Code	Description
CON23CAMDEN	2x3
CON34CAMDEN	3x4
CONR4CAMDEN	4" Round

Height: 9 in
Width: 12 in
Depth: 7 ¼ in



The Victorian

Item Code	Description
CON34VICTSM	3x4
CONR4VICTSM	4" Round

Height: 15 in
Width: 11 ¾ in
Depth: 7 ¼ in

CON34VICTLG	3x4
CON45VICTLG	4x5
CONR4VICTLG	4" Round

Height: 16 ½ in
Width: 14 in
Depth: 9 in

False Conductors Continued

**** Call for color availability on False Conductors ****



The Stratford

Item Code	Description
CON34STRATFRD	3x4
CONR4STRATFRD	4" Round

Height: 13 in
Width: 13 ¾ in
Depth: 8 in



The Oxford

Item Code	Description
CON23OXFORD	2x3
CON34OXFORD	3x4
CONR4OXFORD	4" Round

Height: 14 ¼ in
Width: 10 ¼ in
Depth: 7 ½ in

False Conductors Continued

**** Call for color availability on False Conductors ****



The Sedona

Item Code	Description
CON34SEDONA	3x4
CONR4SEDONA	4" Round

Height: 14 ¾ in

Width: 11 ½ in

Depth: 7 ¼ in



Copper Victorian

Item Code	Description
CON34VICTSM	3x4
CONR4VICTSM	4" Round

Height: 15 in

Width: 11 ¾ in

Depth: 7 ¼ in

CON34VICTLG	3x4
CON45VICTLG	4x5
CONR4VICTLG	4" Round

Height: 16 ½ in

Width: 14 in

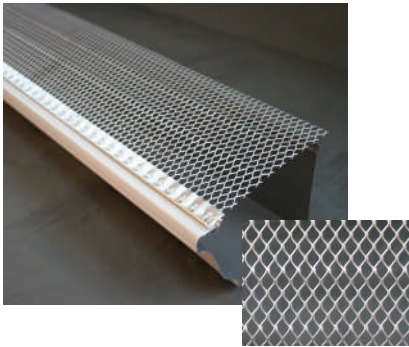
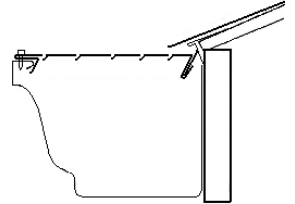
Depth: 9 in

Gutter Guard Products



Clean Sweep

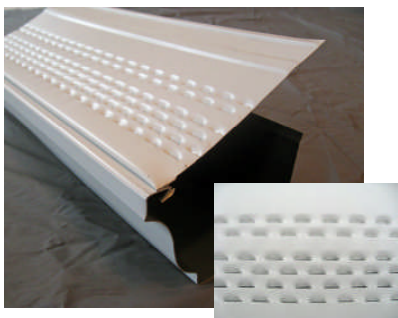
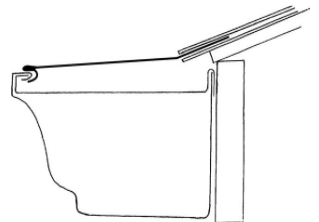
<u>Item #</u>	<u>Packaging</u>
5" GG5CLN(color)-LF	4' sections – 200' per bx
6" GG6CLN(color)-LF	4' sections – 200' per bx



Drop In Gutter Screen

<u>Item #</u>	<u>Packaging</u>
5" GGDROP5-BX	4' sections – 200' per bx
6" GGDROP6-BX	4' sections – 200' per bx

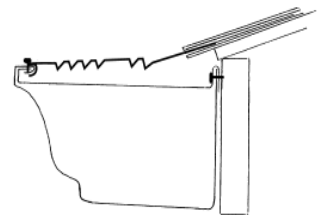
Aluminum economy guard that goes under the shingles.



Louvered Gutter Guard

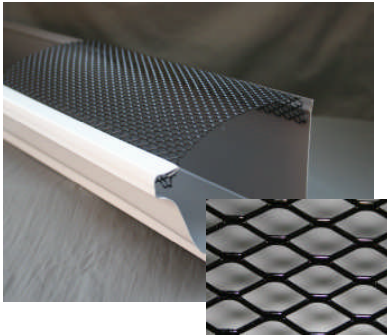
<u>Item #</u>	<u>Packaging</u>
5" GG5(White/Brown)	4' sections – 100' per bx
6" GG6(White/Brown)	4' sections – 100' per bx

Slides up under first row of shingles and then can either be screwed to the top of the gutter or you can use the tabs to fasten down.



* all gutter guards not available at all locations *

Gutter Guard Products

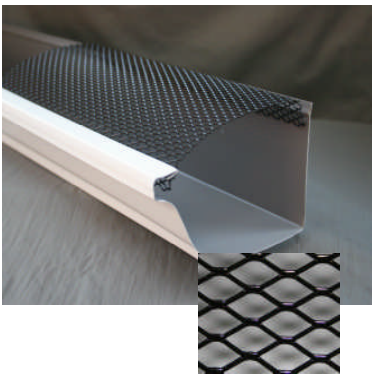
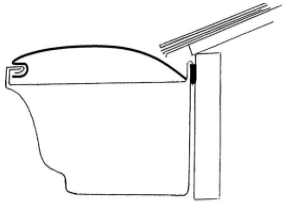


EZ Lock Gutter Guard

<u>Item #</u>	<u>Packaging</u>
5" GG5EZ	4' sections – 100' per bx
6" GG6EZ	4' sections – 100' per bx

This is a powder coated steel gutter guard. It installs by spring tension and does not disturb the shingles.

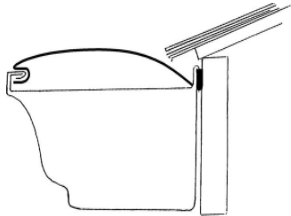
** This product is also available in Copper **



EZ Lock Small Hole Gutter Guard

<u>Item #</u>	<u>Packaging</u>
5" GG5EZFMESH-BX	4' sections – 100' per bx
6" GG6EZFMESH-BX	4' sections – 100' per bx

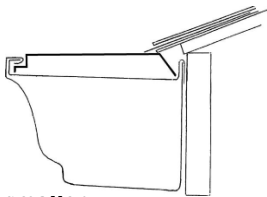
This is a powder coated steel gutter guard. It installs by spring tension and does not disturb the shingles. The holes are smaller than the regular EZ Lock.



Step Down Gutter Guard

<u>Item #</u>	<u>Packaging</u>
5" GG5MESHSD-BX	4' sections – 100' per bx
6" GG6MESHSD-BX	4' sections – 100' per bx

This is a powder coated steel gutter guard. It installs by spring tension and does not disturb the shingles. The holes are smaller than EZ Lock. The back edge is bent down to hold screen up, which helps eliminate debris from accumulating on the back edge of the gutter.



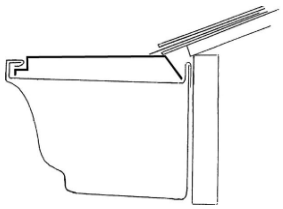
* all gutter guards not available at all locations *

Gutter Guard Products



Micro Mesh Gutter Guard

	<u>Item #</u>	<u>Packaging</u>
5"	GG5EZMICRO-BX	4' sections – 100' per bx
6"	GG6EZMICRO-BX	4' sections – 100' per bx



This is a powder coated aluminum micro mesh gutter guard. It snaps under the front of the gutter and rests under the shingles along the back of the gutter. The directional expansion allows maximum water flow while the micro openings are small enough to stop the smallest debris, even the grit of the shingles. This is an excellent product to use near the ocean where salt spray and other extreme environmental conditions cause many products to corrode.



E-Z-Smooth Flow

Item # GG5EZSMOOTHWHT

PKG- 6' sections 240' per bx

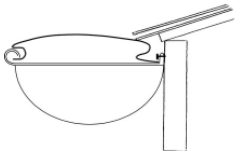
SERVICE
PARTNERS

This effective and simple-to-install aluminum gutter guard recesses into the gutter and fastens to the front with stainless steel screws (provided). With thousands of holes, the rain water passes through the canals, making it E-Z for air flow to dry the debris and blow it away. Available in white, mill finish, and black, which allows ice to melt quicker. Available in 5", 6", 7"



Double Lock Half Round Gutter Guard

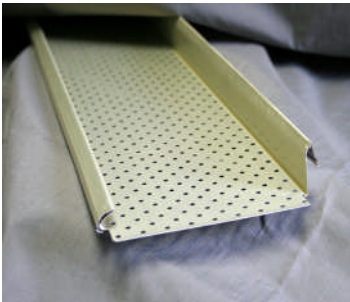
	<u>Item #</u>	<u>Packaging</u>
6"	GG6EZHR-BX	4' sections – 100' per bx



This is a powder coated steel gutter guard. It installs by snapping in and needs no screws for installation. This is a small hole gutter guard.

* all gutter guards not available at all locations *

Gutter Guard Products



Leaf Relief New

Item #

5" GG5RELIEF-PC

6" GG6RELIEF-PC

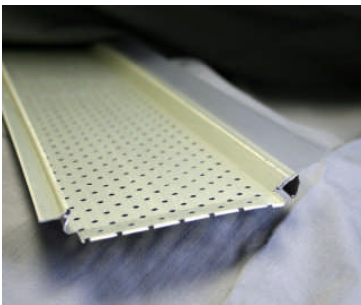
Packaging

7.5' sections - 320' per bx/48pcs bx

7.5' sections - 255' per bx/34 pcs bx

This gutter guard is made of aluminum and designed to fit on new gutters. When installed with new gutters you do not need to use hangers.

* All Leaf Relief must be installed flat to function properly.



Leaf Relief Retro

Item #

5" GG5RELIEFRETRO-PC

6" GG6RELIEFRETRO-PC

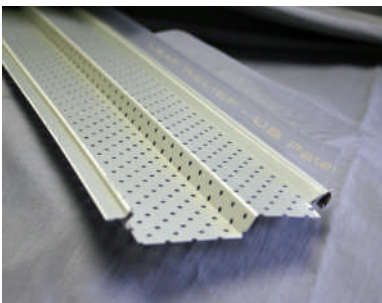
Packaging

10' sections - 320' per bx/32pcs bx

10' sections - 320' per bx/32pcs bx

This gutter guard is made of aluminum and designed to fit on existing gutters with hangers that do not have premounted screws in them.

* All Leaf Relief must be installed flat to function properly.



Leaf Relief Retro Zip

Item #

5" GG5RELIEFRETROZIP-PC

6" GG6RELIEFZIP-PC

Packaging

10' sections – 320' per bx/32 pcs bx

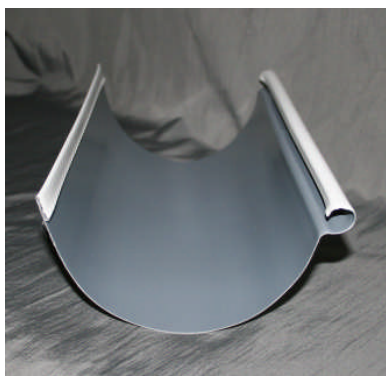
10' sections – 320' per bx/32 pcs bx

This gutter guard is made of aluminum and designed to fit on existing gutters with quick screw hangers.

* All Leaf Relief must be installed flat to function properly.

* all gutter guards not available at all locations *

Half Round Material



6" Half Round Gutter

Item Code: HRGUTTER6(color)

Classic half round gutter with "reverse bead" available in all standard colors and copper. Standard .027 gauge.



Round Downspout

Item Code: DSR410(color)-LF

Plain smooth 4" round downspout available in all colors in .019 aluminum and copper.

Thicker gauges available up to .032 aluminum.



Round Elbows

Item Code: ER4(color)

Plain smooth 4" round elbow available in all colors in .019 aluminum and copper.

Thicker gauges available up to .032 aluminum.

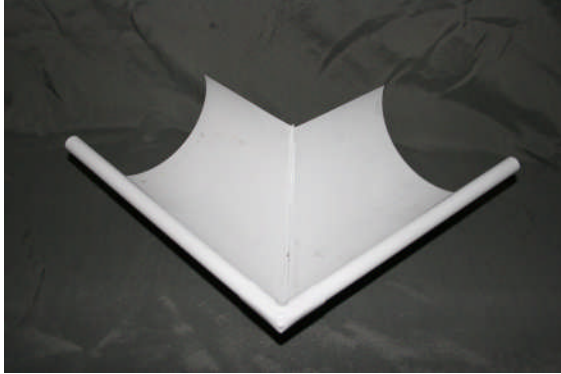


Half Round Endcaps

Item Code: HREC6(color)

Used to cap the ends of 6" half round gutter.

Half Round Material Continued



6" Half Round Box Mitres

Item Codes: HRMBX(O)(I)6(color)

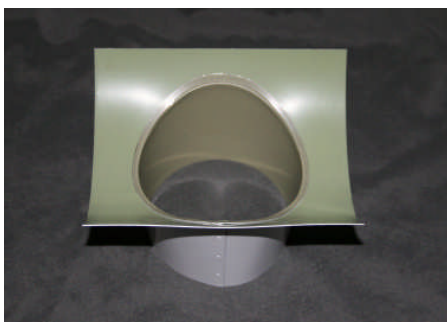
A simple way to do corners in half round gutter.



6" Half Round Strip Mitres

Item Code: HRMS(O)(I)6(color)

A low cost method to install corners in half round gutter.



Half Round Outlet

Item Code: HROUTLET4(color)

Used inside the 6" gutter where the 4" downspout is connected to the gutter.

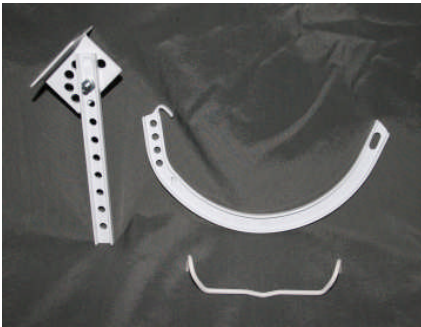
Half Round Material Continued



#10 Combo Hanger

Item Code: HR106(color)

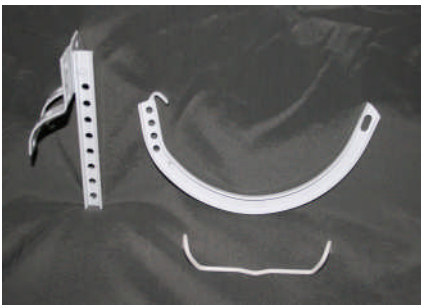
A very common hanger used to attach half round gutter to a standard, flat fascia board. Includes the hanger and a spring clip to lock the gutter into the hanger. The correct way to install these is to: 1) snap a chalk line on the fascia showing where the top of the hanger should be including pitch, 2) screw one #10 combo hanger every two feet, 3) put the half round gutter in the installed #10 combos, 4) go back and put your spring clips in.



#30 Shank

Item Code: HRSHK30(color)

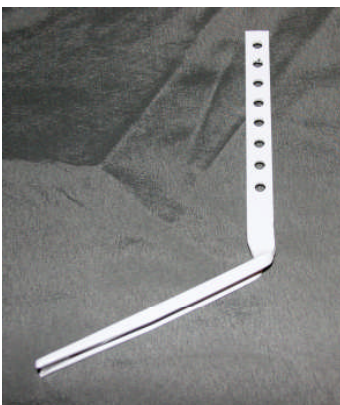
An adjustable shank where the angle of the mounting bracket can be varied as required. Used for angled fascia and sometimes crown molding. The gutter is pitched by installing the circles progressively lower to the outlet by using the multiple attachment holes in the shank. Circle and spring clip sold separately.



#6 Shank

Item Code: HRSHK6(color)

A special shank used to attach half round gutters to crown molding. Sometimes they work sometimes they don't. The gutter is pitched by installing the circles progressively lower to the outlet by using the multiple attachment holes in the shank. Circle and spring clip sold separately.



#12 Shank

Item Code: HRSHK12(color)

A special shank that is nailed to the roof. A very strong system that should be installed under the roofing. The gutter is pitched by installing the circles progressively lower to the outlet by using the multiple attachment holes in the shank. Angle of hanger matches a 4/12 roof pitch and can be bent slightly from there by hand. Circles sold separately. (A #25 shank is the same as a #12 other than it is bent to a 6/12 roof pitch).

Half Round Material Continued



Half Round Fascia Bracket

Item Code: HRFB6(color)

A very strong inexpensive method of attaching half round gutter to flat fascia. Made of .032 material, you can nest two hangers inside of each other to double the thickness.



Spring Clip

Item Code: HRCLIP(color)

Used to lock half round gutter into either a #10 combo hanger or a half round circle. When you purchase a #10 combo or a circle, you get one spring clip with each hanger. Available separately if needed.



6" Half Round Hidden Hanger

Item Code: HRHHSW6 (includes wedge below)

An inexpensive quick method of installing half round gutter. As the back of half round gutter is "round" it is very important to use the half round gutter wedge with this type of hanger.



Half Round Gutter Wedge

Item Code: see hanger above

Used with half round hidden hangers to support half round gutter. Should be used with all jobs where half round hidden hangers are used.

Gutter Tools and Accessories



Item Code	Description	Pcs./Box
TLECCRIMP	Endcap Crimper	each



Item Code	Description	Pcs./Box
TLDSCRIMP	Downspout Crimper	each

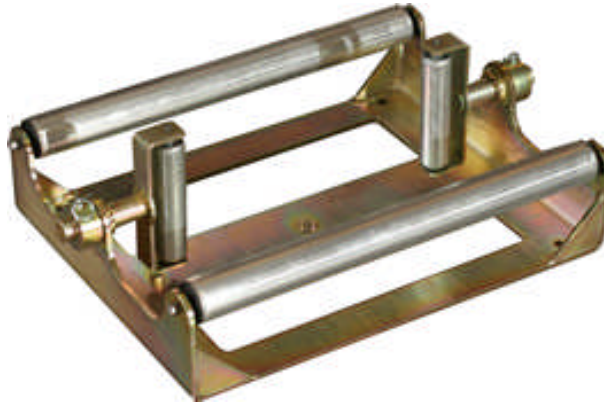


Item Code	Description	Pcs./Box
TLHSAW238	2 3/8" Holesaw w/arbor & bit	each
TLHSAW338	3 3/8" Holesaw w/arbor & bit	each



Item Code	Description	Pcs./Box
TLZIPBIT2	2 1/4" Bit	each
TLZIPBIT4	4 1/4" Bit	each
TLZIPBIT6	6 1/4" Bit	each
TLZIPBIT8	8 1/4" Bit	each

Gutter Machine Accessories



Item Code	Description	Pcs./Box
TLCRADLE56	5/6 Combo Coil Cradle	each



Item Code	Description	Pcs./Box
GMSTANDECON	Run Out Stand-economy	each



5" Seamless Gutter Machine



The "Iron Man" Edge

State of the art design delivers special standard features

Polyurethane Drive train

- Eliminates the need to load coil prior to transportation (less material waste)
- Rollforms 24 gauge steel
- Eliminates slippage from cold weather and condensation

.002 Chrome Plated Steel Forming Rollers

- Rollforms all standard metals with minimal or no adjustment
- Color coded adjustment stations
- Free-floating forming rollers produce less pressure and allow for more product uniformity

Electrical and Control System

- Push button control safety wiring
- Entrance and exit control selector switch - jog / run

Specifications:

Power: 3/4 H.P., 110 volt, single phase, 13.6 amp totally enclosed fan cooled motor

Dimensions: Length – 95 1/2" Height – 48" Width – 24"

Weight: Approximately 950 lbs.

Drive: Powered polyurethane drive rollers via chains and sprockets

Shear: Front Pull Guillotine

Speed: Approximately 35 feet per minute

Controls: Push button entry and exit end manual controls with "job" feature

Recommended 11 3/4" top 12 3/8" wide

Materials	Maximum Gauge
-----------	---------------

Painted Steel	24g
Galvanized Steel	24g
Aluminized Steel	24g
Ternecoat Steel	24g
Aluminum	.032
Copper	16oz, 3/4 hard



6" Seamless Gutter Machine

The "Iron Man" Edge
State of the art design delivers special standard features

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- Eliminates the need to load coil prior to transportation (less material waste)
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.002 Chrome Plated Steel Forming Rollers

- Rollforms all standard metals with minimal or no adjustment
- Color coded adjustment stations
- Free-floating forming rollers produce less pressure and allow for more product uniformity



Electrical and Control System

- Push button control safety wiring
- Entrance and exit control selector switch - jog / run

Specifications:

Power: 3/4 H.P., 110 volt, single phase, 13.6 amp totally enclosed fan cooled motor

Dimensions: Length – 120" Height – 48" Width – 24"

Weight: Approximately 1300 lbs.

Drive: Powered polyurethane drive rollers via chains and sprockets

Shear: Front Pull Guillotine

Speed: Approximately 35 feet per minute

Controls: Push button entry and exit end manual controls with "job" feature

Recommended 15"

Materials	Maximum Gauge
Painted Steel	24g
Galvanized Steel	24g
Aluminized Steel	24g
Ternecoat Steel	24g
Aluminum	.032
Copper	16oz, 3/4 hard



Combo Machine 5" & 6"

The "Iron Man" Edge

State of the art design delivers special standard features

Polyurethane Drive train

- Eliminates the need to load coil prior to transportation (less material waste)
- Rollforms 24 gauge steel
- Eliminates slippage from cold weather and condensation



.002 Chrome Plated Steel Forming Rollers

- Rollforms all standard metals with minimal or no adjustment
- Free-floating forming rollers produce less pressure and allow for more product uniformity

Electrical and Control System

- Push button control safety wiring
- Entrance and exit control selector switch "job" run
- 3/4 HP, 100 Volt Single Phase Motor, 13.6 amp totally fan enclosed motor

Structural Steel Frame

- Welded steel frame

Modular Turnstyle Upright System

Dimensions: Length - 122" Height – 48" Width -24"

Weight: Approximately 1400 lbs

Drive: Powered polyurethane drive rollers via chains and sprockets

Shear: 5" & 6" both have Front pull guillotine

Speed: Approximately 35 feet per minute

Controls: Push button entry and exit end controls with "jog" feature

Recommended: 5" 11 3/4" – 12 wide 6" 15" wide

IRONMAN JUNIOR 5" SEAMLESS ROLLFORMER

Polyurethane Drive Train

- Eliminates the need to load coil prior to transportation (less material waste)
- Eliminates slippage from cold weather and condensation

.002 Hard Chrome Plated Steel Forming Rollers

- Rollforms all recommended materials with minimal or no adjustment
- Free-floating forming rollers produce less pressure and allow for more product uniformity

Electrical and Control System

- Push button entry and exit end controls with safety wiring and "jog" feature
- 3/4 HP, 110 volt, single phase motor, 13.6 ampere

Structural Steel Frame

- Welded tubular frame

Modular Turnstile Upright System & Transfer Bars

- Transfer bars (ease of coil loading)

Specifications:	
Power:	3/4 HP, 110 volt, single phase, 13.6 ampere, totally enclosed fan cooled (T.E.F.C.) motor
Dimensions:	Length - 81" (205.7 cm), Height - 48" (122.0 cm), Width - 24" (61.0 cm)
Weight:	Approximately 686 lbs. (311.2 kg)
Drive:	Powered polyurethane drive rollers via chains and sprockets
Shear:	Front pull guillotine
Speed:	Approximately 35 feet per minute
Controls:	Push button entry and exit end controls with "jog" feature
Recommended Materials:	<ul style="list-style-type: none"> • Aluminum - .032 Maximum Gauge • Copper - 16 oz.-20 oz. 3/4 hard Maximum Gauge • Galvalume-26
Options:	<ul style="list-style-type: none"> • Machine mount cradles • Additional runout support stands • CE Certified wiring • Additional turnstiles • Additional spools • 12 volt, DC power • Trailer riser pad



IRONMAN JUNIOR 6" SEAMLESS ROLLFORMER

Polyurethane Drive Train

- Eliminates the need to load coil prior to transportation (less material waste)
- Eliminates slippage from cold weather and condensation



.002 Hard Chrome Plated Steel Forming Rollers

- Rollforms all recommended materials with minimal or no adjustment
- Free-floating forming rollers produce less pressure and allow for more product uniformity

Electrical and Control System

- Push button entry and exit end controls with safety wiring and "jog" feature
- 3/4 HP, 110 volt, single phase motor, 13.6 ampere

Structural Steel Frame

- Welded tubular frame

Modular Turnstile Upright System & Transfer Bars • Transfer bars (ease of coil loading)

Specifications:	
Power:	3/4 HP, 110 volt, single phase, 13.6 ampere, totally enclosed fan cooled (T.E.F.C.) motor
Dimensions:	Length - 107.5" (cm), Height - 48" (122.0 cm), Width - 24" (61.0 cm)
Weight:	Approximately 960 lbs. (435.4 kg)
Drive:	Powered polyurethane drive rollers via chains and sprockets
Shear:	Front pull guillotine
Speed:	Approximately 35 feet per minute
Controls:	Push button entry and exit end controls with "jog" feature
Recommended Materials:	<ul style="list-style-type: none"> • Maximum width 15" • Aluminum - .032 Maximum Gauge • Copper - 16 oz. 3/4 hard Maximum Gauge • Galvalume 26
Options:	<ul style="list-style-type: none"> • Machine mount cradles • Additional runout support stands • CE Certified wiring • Additional turnstiles • Additional spools • 12 volt, DC power • Trailer riser pad

IRONMAN JUNIOR 5/6" SEAMLESS ROLLFORMER

Polyurethane Drive Train

- Eliminates the need to load coil prior to transportation (less material waste)
- Eliminates slippage from cold weather and condensation

.002 Hard Chrome Plated Steel Forming Rollers

- Rollforms all recommended materials with minimal or no adjustment
- Free-floating forming rollers produce less pressure and allow for more product uniformity

Electrical and Control System

- Push button entry and exit end controls with safety wiring and "jog" feature
- 3/4 HP, 110 volt, single phase motor, 13.6 ampere

Structural Steel Frame

- Welded tubular frame

Modular Turnstile Upright System & Transfer Bars

- Transfer bars (ease of coil loading)



Specifications:	
Power:	3/4 HP, 110 volt, single phase, 13.6 ampere, totally enclosed fan cooled (T.E.F.C.) motor
Dimensions:	Length - 107.5" (273.1 cm), Height - 48" (122.0 cm), Width - 24" (61.0 cm)
Weight:	Approximately 1,075 lbs. (487.6 kg)
Drive:	Powered polyurethane drive rollers via chains and sprockets
Shear:	5" - Front pull guillotine, 6" - Front pull guillotine
Speed:	Approximately 35 feet per minute
Controls:	Push button entry and exit end controls with "jog" feature
Recommended Materials:	<ul style="list-style-type: none"> • Maximum width 5" - 11 3/4" to 12" • Maximum width 6" - 15" • Aluminum - .032 Maximum Gauge • Copper - 16 oz. 3/4 hard Maximum Gauge • Galvalume 26
Options:	<ul style="list-style-type: none"> • Machine mount cradles • Additional runout support stands • CE Certified wiring • Additional turnstiles • Additional spools • 12 volt, DC power • Trailer riser pad

IRONMAN 7" SEAMLESS ROLLFORMER

Polyurethane Drive Train

- Eliminates the need to load coil prior to transportation (less material waste)
- Rollform 24 gauge steel
- Eliminates slippage from cold weather and condensation

.002 Hard Chrome Plated Steel Forming Rollers

- Rollforms all recommended materials with minimal or no adjustment
- Free-floating forming rollers produce less pressure and allow for more product uniformity

Electrical and Control System • Push button entry and exit end controls with safety wiring and "jog" feature • 3/4 HP, 110 volt, single phase motor, 13.6 ampere

Structural Steel Frame • Welded tubular frame

Modular Turnstile Upright System & Transfer Bars • Transfer bars (ease of coil loading)



Specifications:	
Power:	3/4 HP, 110 volt, single phase, 13.6 ampere, totally enclosed fan cooled (T.E.F.C.) motor
Dimensions:	Length - 149" (378.46 cm), Height - 49" (124.46 cm), Width - 24" (61.0 cm)
Weight:	Approximately 1,490 lbs. (675.85 kg)
Drive:	Powered polyurethane drive rollers via chains and sprockets
Shear:	Front pull guillotine
Speed:	Approximately 35 feet per minute
Controls:	Push button entry and exit end controls with "jog" feature
Recommended Materials:	<ul style="list-style-type: none"> • Maximum width 18" • Painted steel - 24 Maximum Gauge • Aluminized steel - 24 Maximum Gauge • Ternecoat steel - 24 Maximum Gauge • Aluminum - .032 Maximum Gauge • Copper - 16 oz. 3/4 hard Maximum Gauge
Options:	<ul style="list-style-type: none"> • Machine mount cradles • Additional runout support stands • CE Certified wiring • Additional turnstiles • Additional spools • Alcoa style hook • 12 volt, DC power • Box gutter • Roof flange 1" • Trailer riser pad

IRONMAN 5 1/2" FASCIA GUTTER

Polyurethane Drive Train

- Eliminates the need to load coil prior to transportation (less material waste)
- Eliminates slippage from cold weather and condensation
- Rollforms all standard metals with minimal or no adjustment

Electrical and Control System

- Push button entry and exit end controls with safety wiring and "jog" feature
- 3/4 HP, 110 volt, single phase motor, 13.6 ampere

Modular Turnstile Upright System



Specifications:	
Power:	3/4 HP, 110 volt, single phase, 13.6 ampere, totally enclosed fan cooled (T.E.F.C.) motor
Dimensions:	Length - 132 1/2" (336.55 cm), Height - 48" (122.0 cm), Width - 24" (61.0 cm)
Weight:	Approximately 1,300 lbs. (589.7 kg)
Drive:	Powered polyurethane drive rollers via chains and sprockets
Shear:	Front pull guillotine
Speed:	Approximately 35 feet per minute
Controls:	Push button entry and exit end controls with "jog" feature
Recommended Materials:	<ul style="list-style-type: none"> • 14" and 15" wide • Aluminum - .032 Maximum Gauge • Copper - 16 oz. 3/4 hard Maximum Gauge
Options:	<ul style="list-style-type: none"> • Machine mount cradles • Fixed upright system • Additional runout support stands • CE Certified wiring • Additional turnstiles • Additional spools • Flange assembly for roofwing

IRONMAN 6" HALF-ROUND SEAMLESS ROLLFORMER

Reverse Curl Front Hem Bar

- Unique reverse bead profile (standard single side painted coil)
- 12 forming stations; .002 hard chrome rollers

Polyurethane Drive Train

- 5 station polyurethane drive train
- Eliminates slippage from cold weather and condensation
- Rollform a broad range of materials (aluminum, copper, steel)

Hardcoat Anodized Radius Forming Rollers

- Free-floating rollers produce less pressure and more product uniformity
- Aluminum forming roller (reduces machine weight)

Structural Steel Frame • Welded tubular frame

Modular Turnstile Upright System • Transfer bars (ease of coil loading)



Specifications:

Power:	3/4 HP, 110 volt, single phase, 13.6 ampere, totally enclosed fan cooled (T.E.F.C.) motor
Dimensions:	Length - 162" (411.48 cm), Height - 50" (127.0 cm), Width - 24" (61.0 cm)
Weight:	Approximately 1,300 lbs. (589.7 kg)
Drive:	Powered polyurethane drive rollers via chains and sprockets
Shear:	Front pull guillotine
Speed:	Approximately 35 feet per minute
Controls:	Push button entry and exit end controls with "jog" feature
Recommended Materials:	<ul style="list-style-type: none"> • Maximum width 11.875" (30.16 cm) • Painted steel - 26 Maximum Gauge • Galvanized steel - 26 Maximum Gauge • Aluminized steel - 26 Maximum Gauge • Ternecoat steel - 26 Maximum Gauge • Aluminum - .032 Maximum Gauge • Copper - 16 oz. 3/4 hard Maximum Gauge
Options:	<ul style="list-style-type: none"> • Machine mount cradles • Additional runout support stands • CE Certified wiring • Additional turnstiles • Additional spools • 12 volt, DC power • Trailer riser pad

5" Panther Gutter Machine

- Front pull guillotine
- Seven station aluminum box
- Emergency shutdown switch
- Easy adjust entrance guides
- Two quick release runout stands

Standard Upright System

- 2 spool turnstile upright & 2 aluminum spools
- New aluminum spools less than half the weight of steel spools
- Modular upright system distributes the weight of the coils to the floor of the vehicle, not the machine
- Coil tension brake
- Transfer bar

Specifications:	
Dimensions:	Top of spools to the bottom of machine 46". Width 23". Length 96" with straight blade guillotine. 99" with front pull guillotine.
Construction:	3/8" steel frame welded on a jig fixture for accuracy. Fully enclosed with 7 gauge steel sides. All parts individually plated or painted prior to assembly.
Drive/Forming Rollers:	Twelve drive forming rollers - 5 bottom, 7 top. Rollers are 1045 high carbon steel with .002 industrial hard chrome.
Weight:	1,200 lbs.
Power:	3/4 HP, high torque sealed motor. 20-1 gear reduction unit. Machine plugs directly into 110-120V outlet.
Production:	Approximately 35 feet per minute
Recommended Materials:	<ul style="list-style-type: none"> • Maximum width 11 3/4" to 12 3/8" • Aluminum - .032 Maximum Gauge • Painted steel - 26 Maximum Gauge • Copper - 16 oz. 3/4 hard Maximum Gauge
Options:	<ul style="list-style-type: none"> • Straight blade guillotine • Additional runout support stands • 220 volt/50hz. • Single, double or triple spool upright available • Turnstile machine mount cradle • CE Certification • 12 volt DC power • Trailer riser pad



6" Panther Gutter Machine

- Front pull guillotine
- Seven station aluminum box
- Emergency shutdown switch
- Easy adjust entrance guides
- Two quick release runout stands

Standard Upright System

- 2 spool turnstile upright & 2 aluminum spools
- New aluminum spools less than half the weight of steel spools
- Modular upright system distributes the weight of the coils to the floor of the vehicle, not the machine
- Coil tension brake
- Transfer bar



Specifications:	
Dimensions:	Top of spools to the bottom of machine 52". Width 25". Length 127" with straight blade guillotine. 129" with front pull guillotine.
Construction:	3/8" steel frame welded on a jig fixture for accuracy. Fully enclosed with 7 gauge steel sides. All parts individually painted prior to assembly.
Drive/Forming Rollers:	Fourteen drive forming rollers-8 bottom, 6 top. Rollers are 1045 high carbon steel with .002 industrial hard chrome.
Weight:	1,690 lbs.
Power:	3/4 HP, high torque sealed motor. 1 HP reduction gear. Machine plugs directly into 110 - 120V outlet.
Production:	Approximately 35 feet per minute
Recommended Materials:	<ul style="list-style-type: none"> • Maximum width 15" • Aluminum - .032 Maximum Gauge • Painted steel - 26 Maximum Gauge • Copper - 16 oz. 3/4 hard Maximum Gauge
Options:	<ul style="list-style-type: none"> • Straight blade guillotine • Additional runout support stands • 220 volt/50hz. • Single, double or triple spool upright available • Machine mount cradle • CE Certification • 12 volt DC power • Trailer riser pad

Installation/Maintenance Tips

1. When installing seamless aluminum gutters, make sure they are sloped properly so that all of the water will drain out. It is recommended to have one inch of slope for every 40 feet of gutter.
2. Fasteners or Hangers have to be spaced every 2 feet to insure they are properly secured to the structure.
3. You will need a minimum of one 2x3 Downspout per 600 square feet of roof area.
4. You will need a minimum of one 3x4 Downspout per 1200 square feet of roof area.
5. Splash blocks can be used at the bottom of downspouts to avoid landscape erosion.

Gutter Cleaning Tips

Gutters need to be cleaned out several times a year more if you live in a heavily wooded area. The dark colored stains that run down your gutters are called “Tiger Striping”. There are many products on the market to clean these but a simple homemade solution will work as well.

If you take:

1/3 cup detergent
2/3 cup Soilax
1 quart liquid bleach
3 quarts of water

CAUTION:

Greater concentrations may cause damage to the finish.
Don't use abrasive, solvent type cleaners, or paint removers.