



PASSION FOR INNOVATIONS

# SIMPLE, RELIABLE AND EASY TO INSTALL

## Technical manual

Mounting IMS-Solar on an unisolated and isolated trapezoid steel roof.

CORRUGATED

TRAPEZOID STEEL ROOF

ROOF TILE

# Simple, reliable and easy to install in 5 steps on a steel roof

- 1** Measure, stake out and drill
- 2** Riveting IP-fix
- 3** Click IP insert profiles
- 4** Click cable bracket and opti bracket
- 5** Insert solar panels

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**This extensive manual describes the installation of the mounting system for solar panels on a steel roof. Follow these instructions carefully and perform the actions in the correct order. If you lose the manual, you can always download it from [www.ims-solar.com](http://www.ims-solar.com).**

## 1. General installation conditions

### General information

This installation manual should be kept for future reference. For project-specific regulations and recommendations, it is additionally necessary to use and keep the “project report” from the IMS-Solar.Pro.Tool in conjunction with this installation manual.

The contents of this installation manual have been carefully and reliably compiled. However, IMS-Solar B.V. accepts no liability for the use of this document.

IMS-Solar B.V. reserves the right to amend this document based on developments or experience without further notice. Consult the IMS-Solar website ([www.ims-solar.com](http://www.ims-solar.com)) for the latest version of this document.

Should you not comply to the rules stated in this document may cause all warranty and product liability claims to become void.

### Stability and conditions of the roof

It's important to check the conditions of the roof upfront. The roof should be in good condition and should have enough strength to bear the weight of the solar panels including additional materials. In addition, the roof must also meet the standards for wind and snow load. Please note that the load reserve of the roof is not exceeded anywhere. Check the stability of the roof and adjust if necessary. If in doubt, contact a specialist.

## Safety warnings

- Installation should be carried out by qualified technical constructors.
- Before starting installation the roof should be clean, dry etc.
- Should installation take place at a slanted roof please make sure to use fall protection materials such as edge protection and safety nets.
- If the surface of the roof is slippery due to rain or there is a strong wind, please avoid installation!
- It is recommended to follow the drawings in detail. Omitting or adding parts at your discretion may negatively affect the functioning of the mounting system and is therefore strongly discouraged!
- Chlorine fumes, aggressive fumes and fumes from rotting fruit can affect the durability of the rivets. IMS-Solar recommends choosing a different mounting method if these vapors are present.
- Place rubber fuses at the top between the panels if the slope of the panels is less than 12 degrees. With less slope, the pressure underneath is less; this prevents movement.
- Always wear appropriate protective shoes and clothing.
- Always wear work gloves for protection. Also to avoid damage to the solar panels; don't hold them without gloves.
- Never stand in a gutter!
- Use a lifting aid/lift installation to move materials.
- Use of a ladder should always take place on a solid surface and should be placed at an angle of 75 degrees, about one meter sticking out above the roof edge. Secure the top of the ladder by using a rope or fastener if possible.
- Please make sure to be informed about the last developments by checking the most recent version of the manual and guarantees.

## Coverage of application

- Solar panels: of all brands and models with a frame height of 30 or 35 mm.
- Wind zones: 1 to 3, terrain category II en III (NEN 1991-1-4).
- Roof height: 3 - 15 m. Should the roof be higher please contact your supplier.
- Type of roof: trapezoid steel roof.
- Slope of the roof: between 15 - 60 degrees (35 degrees will be optimal). Roof slopes of 5 to 12 degrees are possible with using our panel fuse.



## Windload

Due to the influence of the wind, the distance of the solar panels to the top and bottom of the roof is at least 30 cm.

The same applies for the distance of the solar panels to both sides of the roof. Please do not place solar panels partly or entirely within this area! Also think about sufficient room to move for maintenance work.

## Standards, regulations and legislation in the Netherlands

To prevent accidents it's important to follow the mounting manual and regulations. Please pay attention to the below norms, regulations and legislation.

## Removal and disassembly

Removal of the products accordingly to local laws and regulations.

## Maintenance

Our mounting materials are made to function maintenance-free and to stand out in durability, functionality and ease of installation. It is when installing solar panels a minimum inclination angle is recommended keep at least 10 degrees to support the self-cleaning ability.

## Warranty

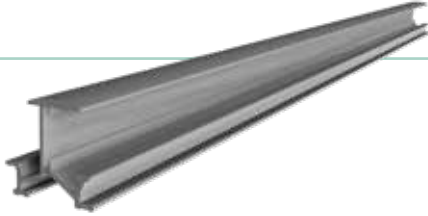
Warranty according to the general conditions of IMS-Solar BV can be found at [www.ims-solar.com](http://www.ims-solar.com).

## Liability

IMS-Solar BV shall not be held liable for any damage or injury caused by a failure to not (strictly) comply with our safety regulations and instructions in this manual or due to negligence during installation our product and/or any involved accessories.



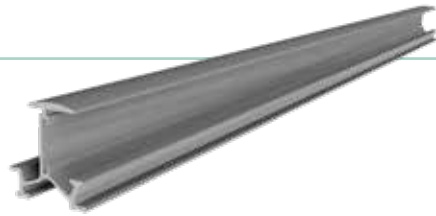
## 2. Parts overview



- **14031** IP-30 insert profile 6,2m  
Dimensions: 6200 x 52,9 x 51,93 mm



- **14032** IP-30 insert profile black 6,2m  
Dimensions: 6200 x 52,9 x 51,93 mm



- **14051** IP-35 insert profile 6,2m  
Dimensions: 6200 x 52,9 x 56,93 mm



- **14052** IP-35 insert profile black 6,2m  
Dimensions: 6200 x 52,9 x 56,93 mm



- **14041** IP-30 insert profile light 6,2m  
Dimensions: 6200 x 52,9 x 44,8 mm



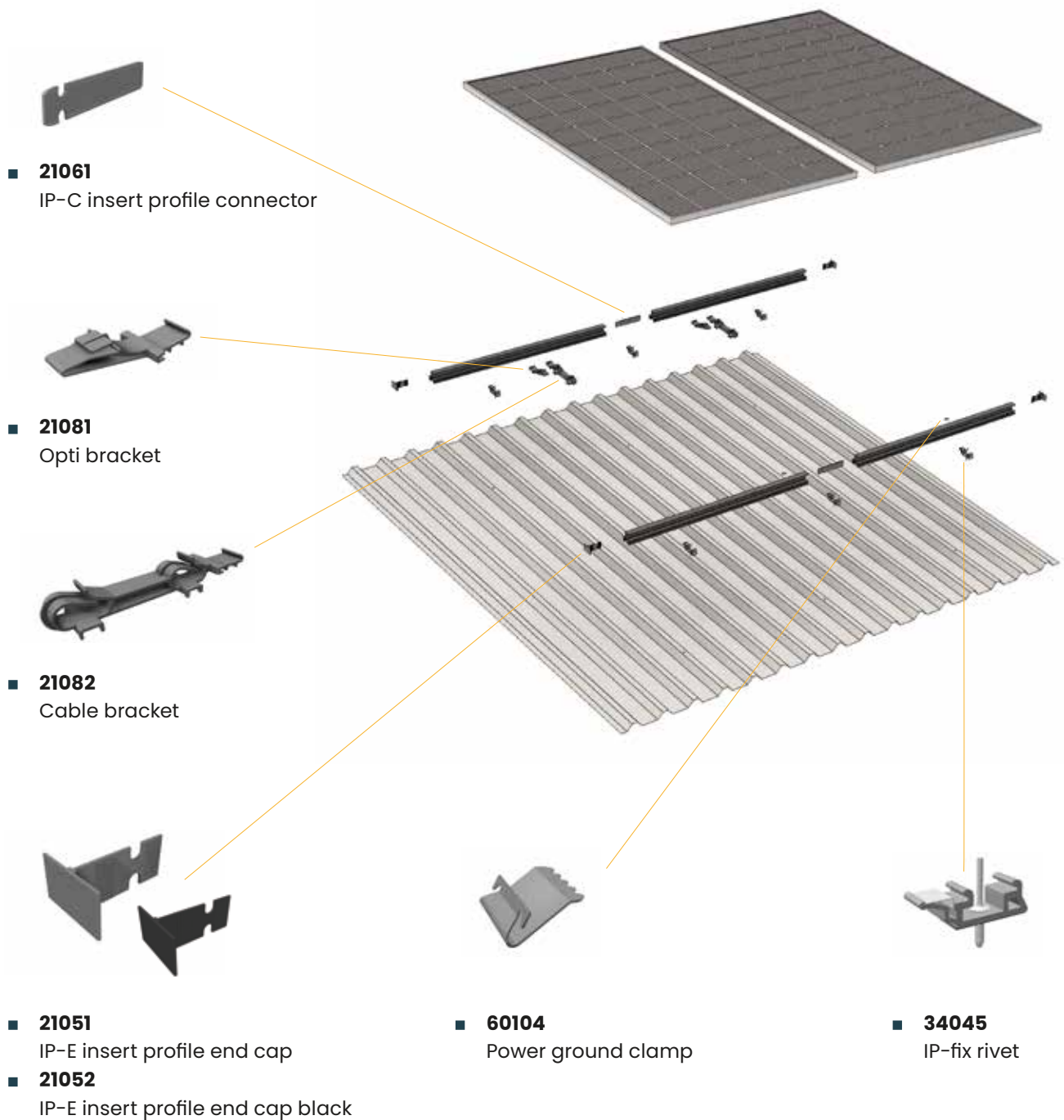
- **14042** IP-30 insert profile light black 6,2m  
Dimensions: 6200 x 52,9 x 44,8 mm



- **14061** IP-35 insert profile light 6,2m  
Dimensions: 6200 x 52,9 x 49,8 mm



- **14062** IP-35 insert profile light black 6,2m  
Dimensions: 6200 x 52,9 x 49,8 mm



- **60101**  
Use the IMS mounting tool for securing various parts. Make sure you use the right movement as described; upwards or downwards.



### 3. Installing IMS-Solar

#### Tools required



Drillmaster



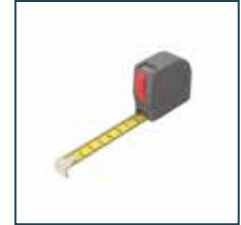
Riveting tool



IMS mounting tool



Pencil



Measure tape

#### Installation

Before installing the mounting materials the roof sheets need to be cleaned with a brush. Remove algae, moss and debris to reduce unevenness during the installation. The position of the roof compared to the sun is essential to receive optimal results. Surrounding buildings or trees can create shade, which will have a negative effect on the result and efficiency of the solar panels. Therefore, check the surroundings in advance.

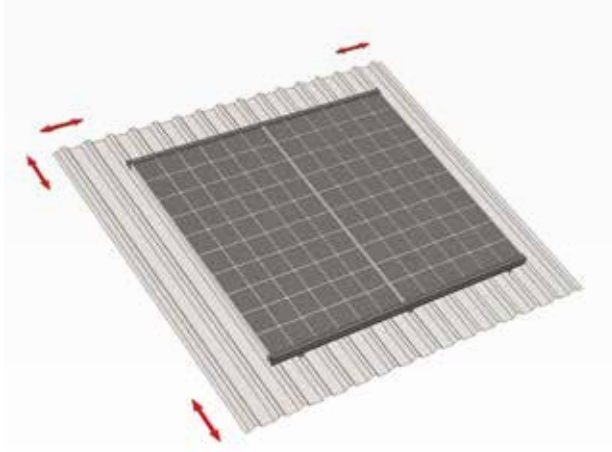
This manual is only suitable for unisolated and isolated steel roofs.

In preparation, it is important to adjust the drill size (mold) to the size of the solar panel + 14 mm (module size). Use of the mold is advised to prevent the drill from slipping. It is important that the rubber rings on the cross joint are adjusted so that they rest on a raised rib of the roof. This protects both the roof and the drilling mold from damage during installation.

The drill guide on the right side must be aligned so that the position of the drill hole is above the horizontal center of the raised rib of the trapezoidal sheet. The vertical spacing between the drill holes is the vertical height of the solar panel + 14 mm.

## Step 1. Measure, stake out and drill

As indicated earlier, it is important that the distance of the solar panels to the top and bottom of the roof is at least 30 cm.

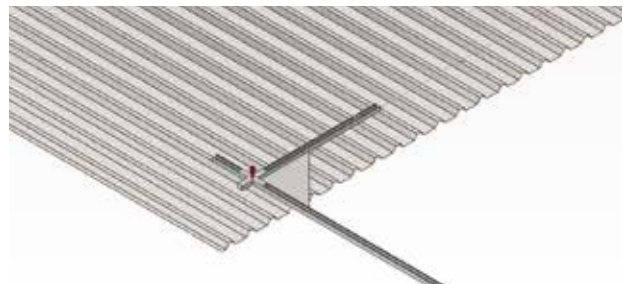
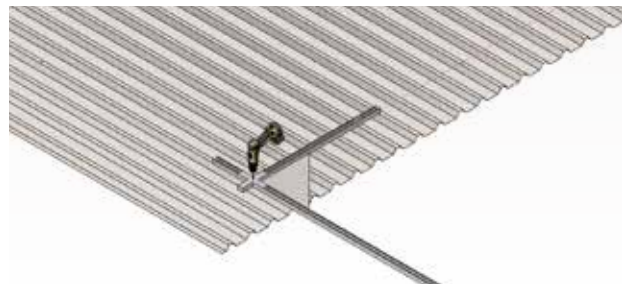


The same applies for the distance of the solar panels to both sides of the roof. It is important to first check the carrying capacity of the substructure. After that, the module field can be measured based on the outcome of the IMS calculation program. Mark the positions of the first and last IP-fix on the bottom row.

Use the drilling mold to determine the exact position and prevent the drill from slipping. The drill size is 6.5 mm; with this size the first and last IP fix on the bottom row are pre-drilled.

Place the positioning pins in the first and last drilled hole and stretch a string between them. This indicates the bottom row of IP-fix. Now the mounting points on the raised ribs can be marked in the correct position.

Insert the positioning pin through the drilling mold into the pre-drilled hole of the bottom row of IP-fix; this allows you to move from position to position both vertically and horizontally, so that the exact location of the drill-hole can be determined and drilled. Horizontally it is important to first determine the position of the first and last raised rib in order to stretch a string between them as well.





## Step 2. Riveting IP-fix

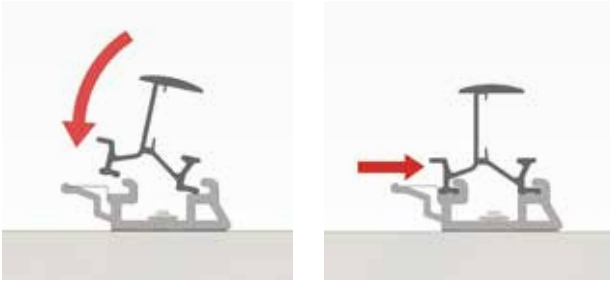
Rive the IP-fix into the pre-drilled holes. It is important that the metal spring is pointing upwards. For mounting the IP-fix, use the rubber underlay, the rivet and a cordless riveting tool. The rivet and IP-fix are mounted using the riveting tool.

It is important to use a rivet nose piece for the IMS-Solar sealing rivets.

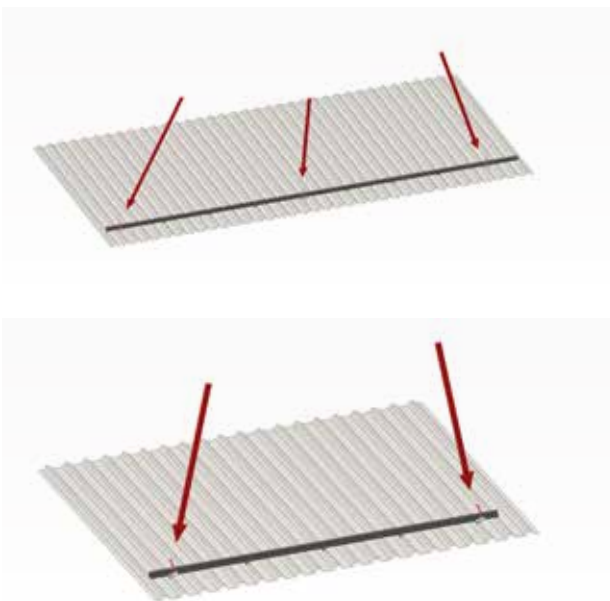


### Step 3. Click IP insert profiles

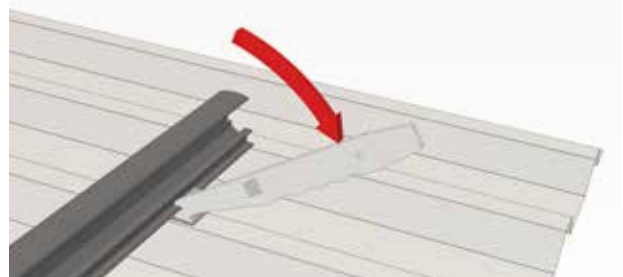
When all IP-Fixes have been mounted, the horizontal IP insert profiles are secured here become. This is done by moving them from top to bottom clicking into place at the bottom wider part of the front always downwards is aimed. Always start and end with a whole length of IP insert profile.



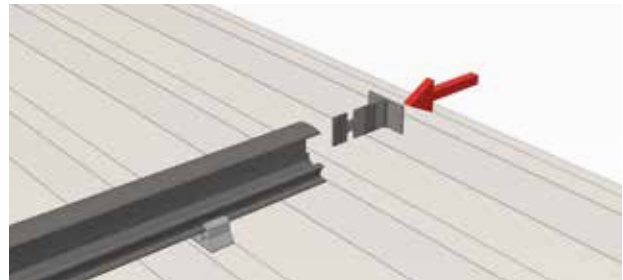
Prevent the rails from sliding due to heat, cold or wind by securing 3 IP-Fixes per IP insert profile of 3 meters or more. Or 2 IP-Fixes per IP insert profile of 3 meters or less.



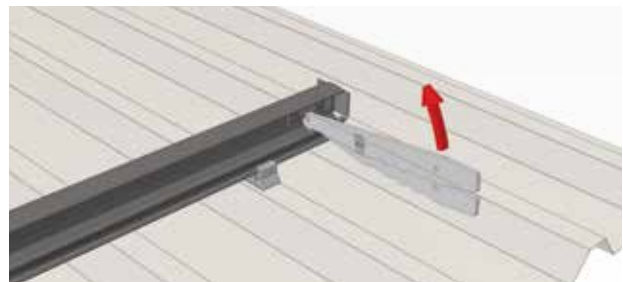
Bend the IP insert profile with the mounting tool left and right of the IP-Fix, by one movement downwards.



If the setup is wider than 6,2 meters, the IP insert profiles must be connected to each other with the IP-C insert profile connector. This is pushed in from the side halfway between the raised edges in the already mounted profile.

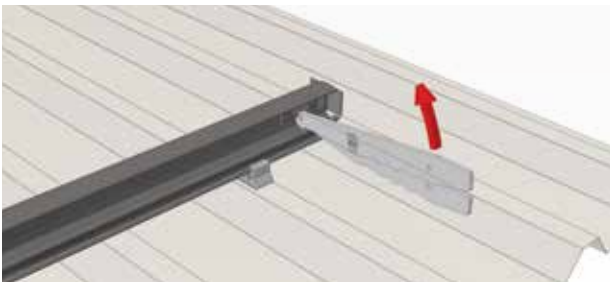
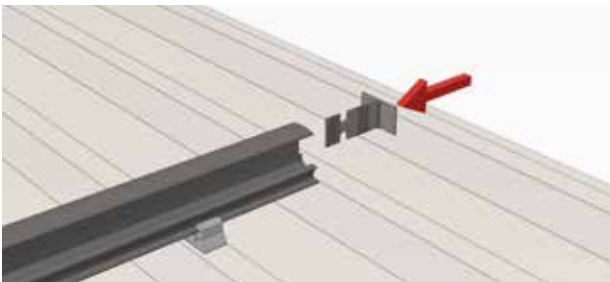


Then secure it on one side by making the correct movement upwards with the mounting tool (make sure that this lock is on the same side in all connections).



The next IP insert profile slides over the protruding part of the IP-C insert profile connector in such a way that a space of at least 5 mm between the two IP insert profiles remains open. This allows the IP insert profile to expand with heat and contract with cold. The system can continue to carry the load of the module without too much stress being applied.

Then the IP-E insert profile end caps can be mounted. Slide it in from the side between the raised edges until it can go no further. Secure the IP-E insert profile end caps by moving the mounting tool upwards.



## Step 4. Mounting cable bracket and opti bracket

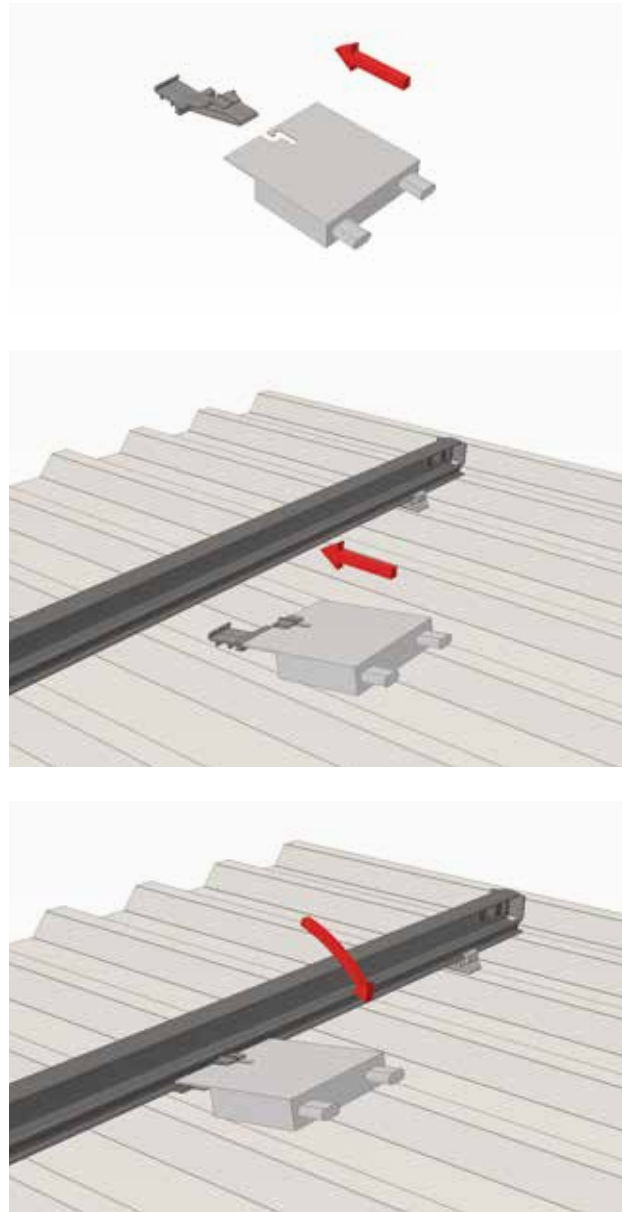
### Install cable bracket

- Click the cable bracket onto the IP insert profile by first hooking it onto the back and then clicking it upwards at the front.
- Slide the cables into the conductor, the 'plus' into one and the 'minus' into the other. Fasten with the ty-raps.



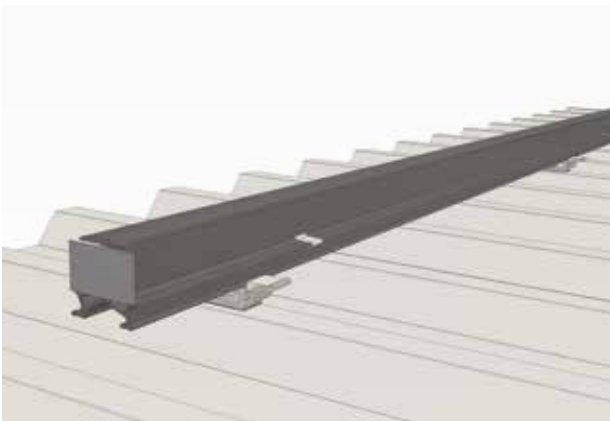
### Install opti bracket

- Click the opti bracket onto the IP insert profile by first hooking it to the back and then clicking it upwards at the front.
- Click the optimizer onto the bracket.
- Connect the optimizer.

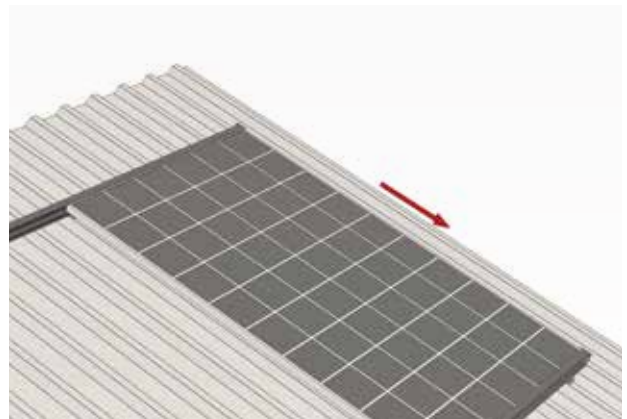
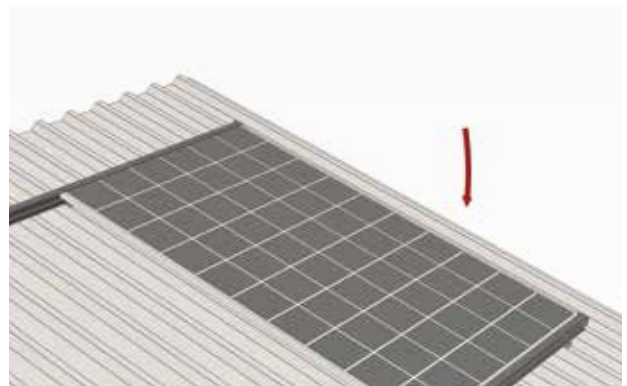
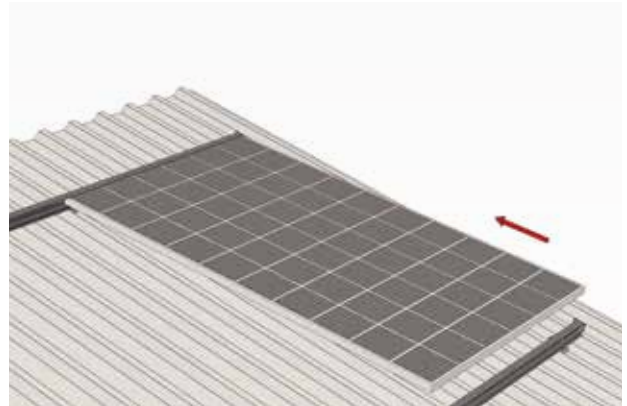


## Step 5. Insert solar panels

When all IP insert profiles are attached, the solar panels can be inserted. Make sure that one power ground clamp is slid onto the IP insert profile to ground each solar panel.



Insert the solar panel into the upper IP insert profile and then lower it into the lower part. Slide the module downwards so that the solar panel is located both above and below in the profile. This way they are held in place by gravity and therefore do not need to be secured further. If the angle is less than 12 degrees, place a rubber fuse at the top between the panels. The next panel can now be slid in and installed, right next to the panel that is already there.

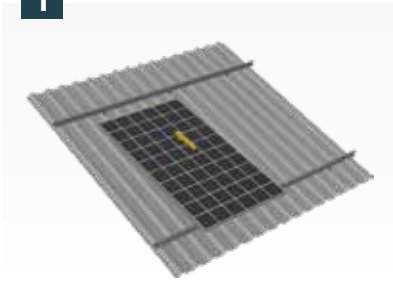


## 4. EPDM Module Securing Installation Instructions

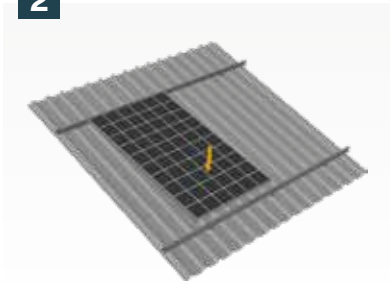
The installation of the module securing is only necessary when the solar modules have an angle of less than 12 degrees of inclination.

Install the module securing on the top between the solar modules. After installing the module securing, the next solar module can be immediately installed.

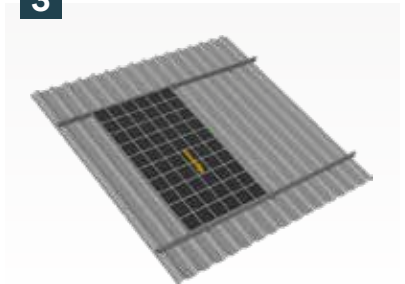
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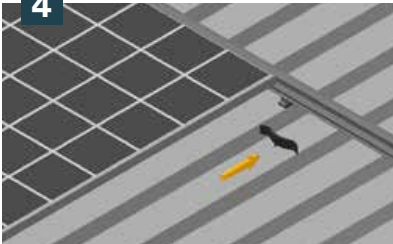
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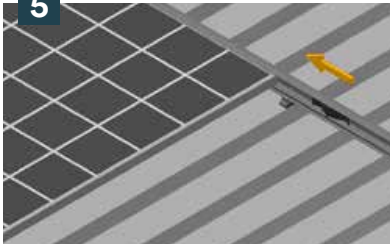
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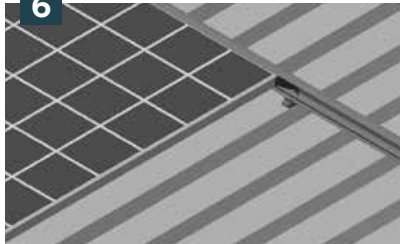
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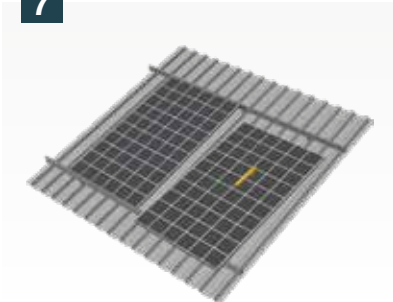
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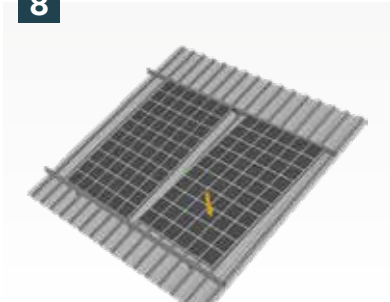
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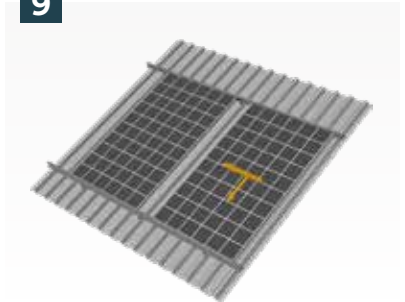
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8



9



## 5. Installation instructions Alu angle bracket



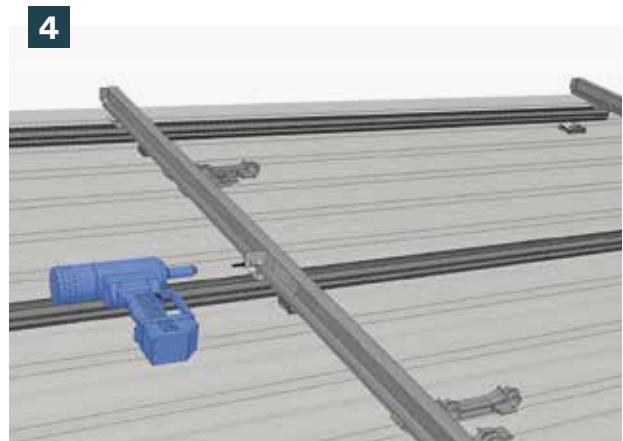
Make sure the solar panels around the place where the Alu angle bracket is placed are removed.



Place the Alu angle bracket at the bottom of the IP insert profile where the last solar panel is to be placed stepwise.



Two holes now need to be drilled first. Use the Alu angle bracket as a template for this. Use one of the two holes. Drilling should be done with a steel drill size 6.5.



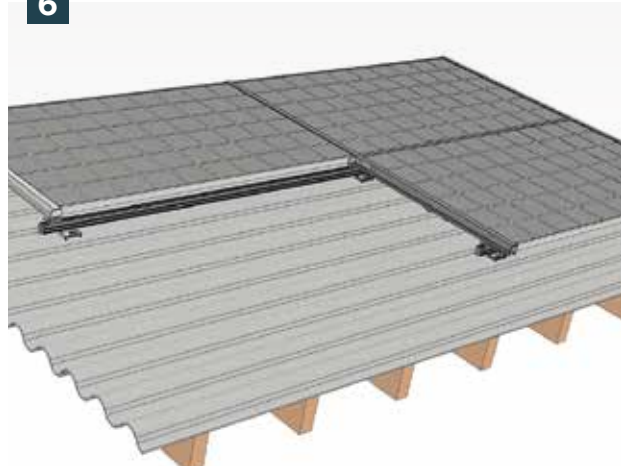
Rivet the Alu angle bracket into the pre-drilled holes. Use the two supplied pop rivets for mounting. The rivets are mounted using the rivet pliers. It is important to use a rivet nosepiece for the IMS-Solar sealing rivets.

5



The assembly is now complete.

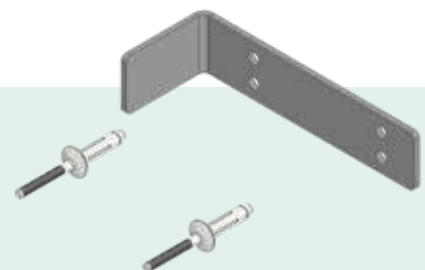
6



The solar panels can be put back in place.

#### ■ 20153

The use of the Alu angle bracket is only necessary if the solar panels are installed stepwise.





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