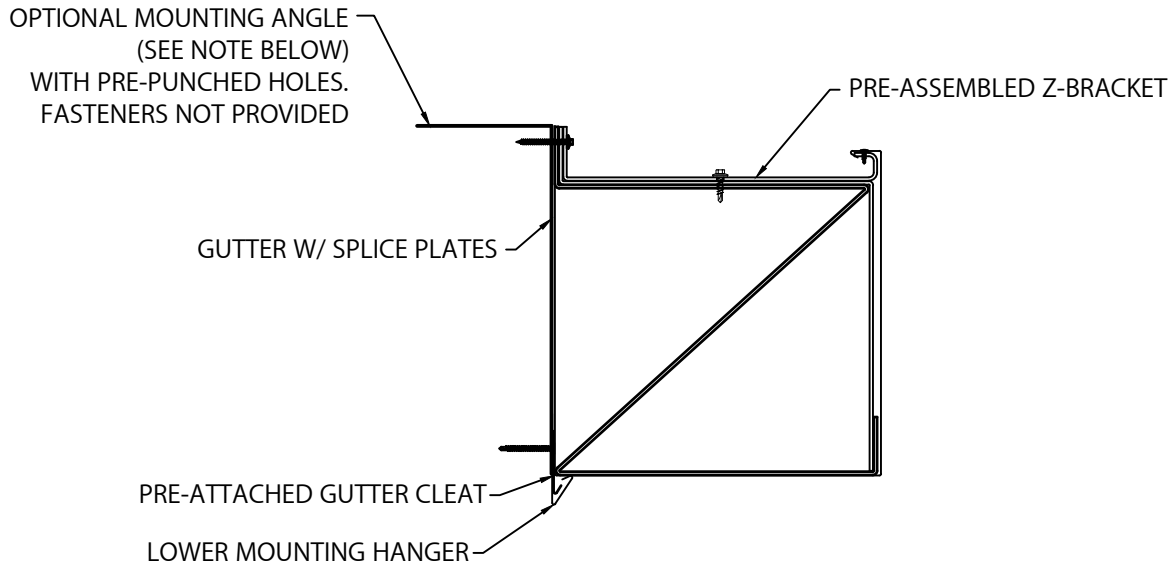


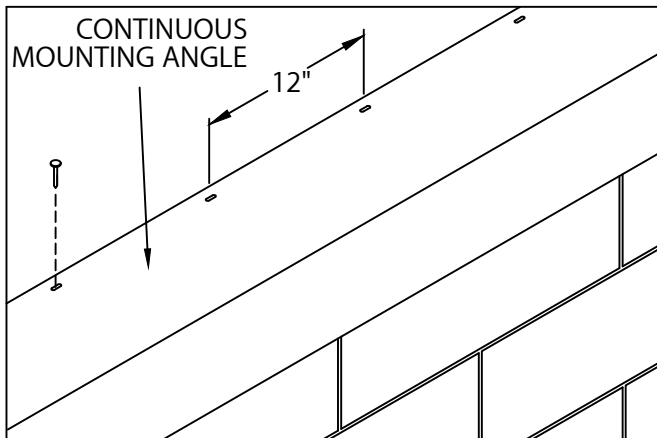
# SOPREMA INDUSTRIAL XL GUTTER

BOX VERSION

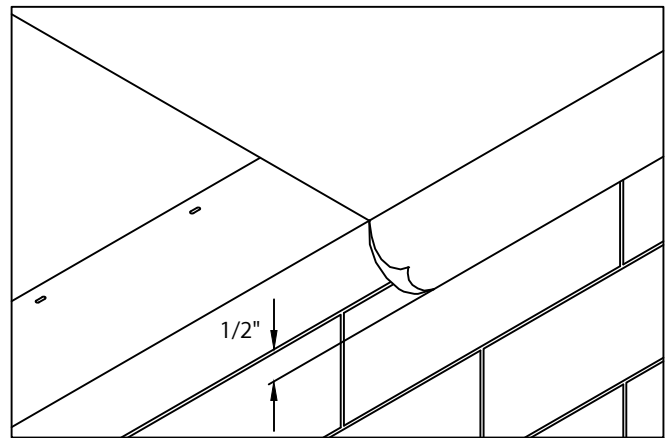
## INSTALLATION INSTRUCTIONS



NOTE: IF EXTERIOR OF THE BUILDING CONSISTS OF A INSULATED PANEL, EIFIS, OR OTHER NON-STRUCTURAL MATERIAL, A MOUNTING ANGLE IS REQUIRED WITH THE LOWER MOUNTING HANGER.



1. OPTIONAL CONTINUOUS MOUNTING ANGLE  
POSITION CONTINUOUS MOUNTING ANGLE OVER THE ROOF EDGE AND FASTEN 12" O.C. WITH APPROPRIATE FASTENERS FOR SUBSTRATE (SEE NOTE ABOVE). FASTENERS NOT PROVIDED.



2. MEMBRANE INSTALLATION  
POSITION MEMBRANE OVER THE ROOF EDGE AND DOWN OUTSIDE FACE OF WALL, COVERING MOUNTING ANGLE AND OR TREATED WOOD NAILER(S) COMPLETELY. ALLOW  $\frac{1}{2}$ " EXCESS MEMBRANE. IMPORTANT! OUTSIDE EDGE OF TREATED WOOD NAILER(S) (MINIMUM 2 x 4) SHALL BE ALIGNED FLUSH WITH THE WALL.



800-356-3521  
www.soprema.us

310 Quadral Dr.  
Wadsworth, OH 44281  
f: 330-334-6257

DATE: 11/30/23  
DRN BY: MLM  
CKD BY: MM

SHT.# 1 OF 7  
DWG# 33112-41343

B

# SOPREMA INDUSTRIAL XL GUTTER

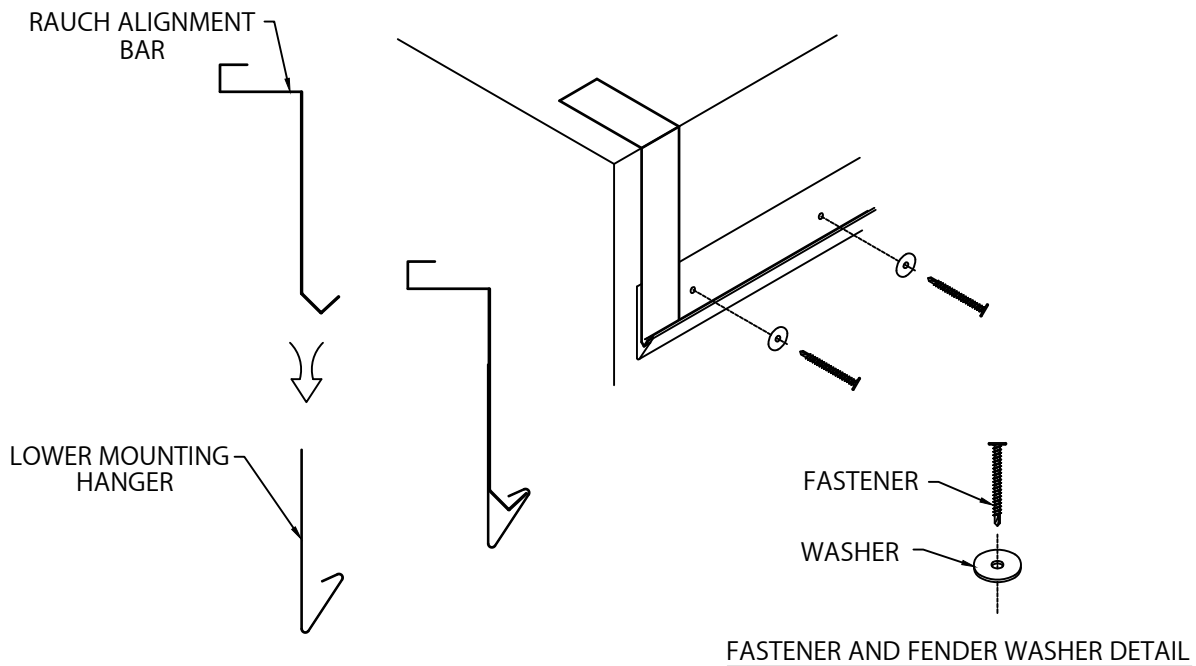
BOX VERSION

## INSTALLATION INSTRUCTIONS

STEP 3A. LOWER MOUNTING HANGER NOTE: MOUNTING ANGLE IS NOT SHOWN FOR CLARITY.

REMOVE PROTECTIVE FILM FROM LOWER MOUNTING HANGERS.

STARTING AT THE CORNER, ROTATE THE PROVIDED RAUCH ALIGNMENT BAR INTO THE LOWER MOUNTING HANGER AND REST ON THE WALL AS SHOWN. FASTEN THE LOWER MOUNTING HANGER WITH PROVIDED FASTENERS, 12" O.C. THRU PRE-PUNCHED HOLES. REMOVE RAUCH ALIGNMENT BAR BY ROTATING AWAY FROM THE WALL.



NOTE: RAUCH ALIGNMENT BAR IS NOT PART OF ASSEMBLY. IT IS A TOOL PROVIDED WITH THE GUTTER TO HELP WITH THE ALIGNMENT OF THE INSTALL. THE RAUCH ALIGNMENT BAR HELPS THE CONTRACTOR HOLD THE LOWER MOUNTING HANGER IN PLACE AS IT IS GETTING FASTENED TO THE WALL. THE RAUCH ALIGNMENT BAR IS INTENDED TO RECESS THE GUTTER TOP APPROXIMATELY  $\frac{1}{4}$ " FROM THE TOP OF THE WALL, TO ALLOW FOR WALL VARIATIONS.



800-356-3521  
www.soprema.us

310 Quadral Dr.  
Wadsworth, OH 44281  
f: 330-334-6257

DATE: 11/30/23  
DRN BY: MLM  
CKD BY: MM

SHT.# 2 OF 7  
DWG# 33112-41343

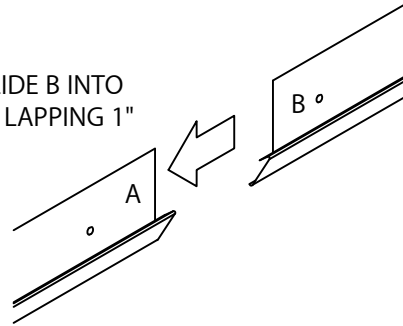
B

# SOPREMA INDUSTRIAL XL GUTTER

BOX VERSION

## INSTALLATION INSTRUCTIONS

SLIDE B INTO  
A. LAPPING 1"

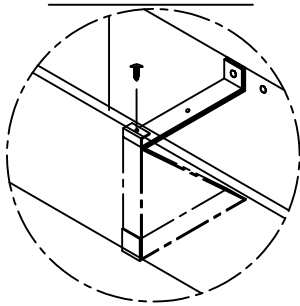


### STEP 3B. LOWER MOUNTING HANGER INSTALLATION

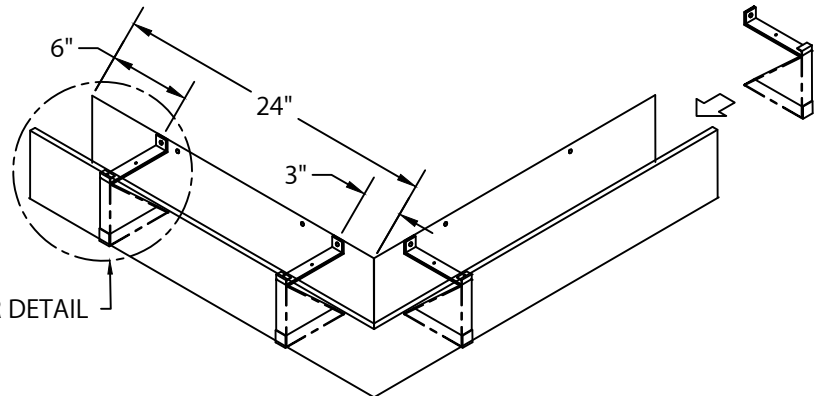
REMOVE PROTECTIVE FILM FROM LOWER MOUNTING HANGER PRIOR TO INSTALLING.

SLIDE NEXT PIECE INTO MOUNTED PIECE WITH RAUCH ALIGNMENT BAR ON THE FAR END TO ALIGN THE NEXT LOWER MOUNTING HANGER. LAPPING 1". FASTEN 12" O.C. THRU PRE-PUNCHED HOLES.

FASTENER DETAIL



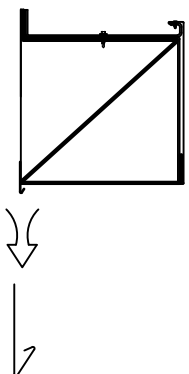
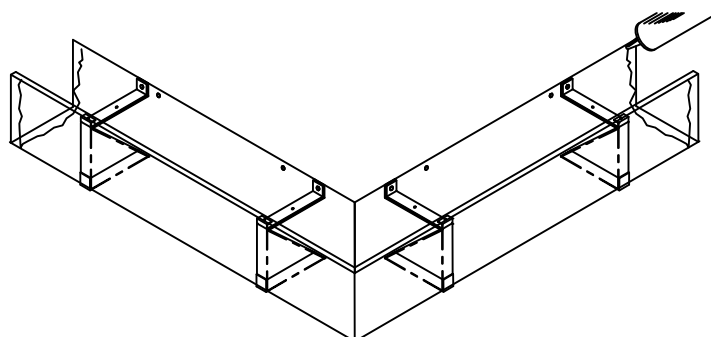
SEE FASTENER DETAIL



### STEP 4A. MITER Z-BRACKET INSTALLATION

**NOTE:** PRIOR TO MOUNTING ON WALL, ATTACH PRE-ASSEMBLED Z-BRACKETS IN THE MITER ON THE ROOF.

SLIDE THE PRE-ASSEMBLED Z-BRACKET IN AS SHOWN. Z-BRACKET SHOULD BE 3" FROM CORNER AND 6" FROM THE END OF THE MITER LEG. FASTEN PRE-ASSEMBLED Z-BRACKET TO GUTTER USING PROVIDED SMALL SELF DRILLING FASTENER INTO THE 1" LIP OF THE GUTTER.



### STEP 4B. MITER INSTALLATION ON WALL

STARTING WITH THE MITERS, PUSH ASSEMBLED GUTTER DOWN INTO LOWER MOUNTING HANGER UNTIL PRE-ATTACHED GUTTER CLEAT SNAPS INTO PLACE. FASTEN GUTTER TO NAILER THRU PRE-SLOTTED HOLES 12" O.C. WITH PROVIDED FASTENERS. FASTEN PRE-ASSEMBLED Z-BRACKETS WITH PROVIDED FASTENERS THRU PRE-PUNCHED HOLES INTO NAILER. APPLY A HEAVY BEAD OF NON-CURING SEALANT TO THE INSIDE OF EACH MITER END AS SHOWN.



800-356-3521  
www.soprema.us

310 Quadral Dr.  
Wadsworth, OH 44281  
f: 330-334-6257

DATE: 11/30/23  
DRN BY: MLM  
CKD BY: MM

SHT.# 3 OF 7

DWG# 33112-41343

B

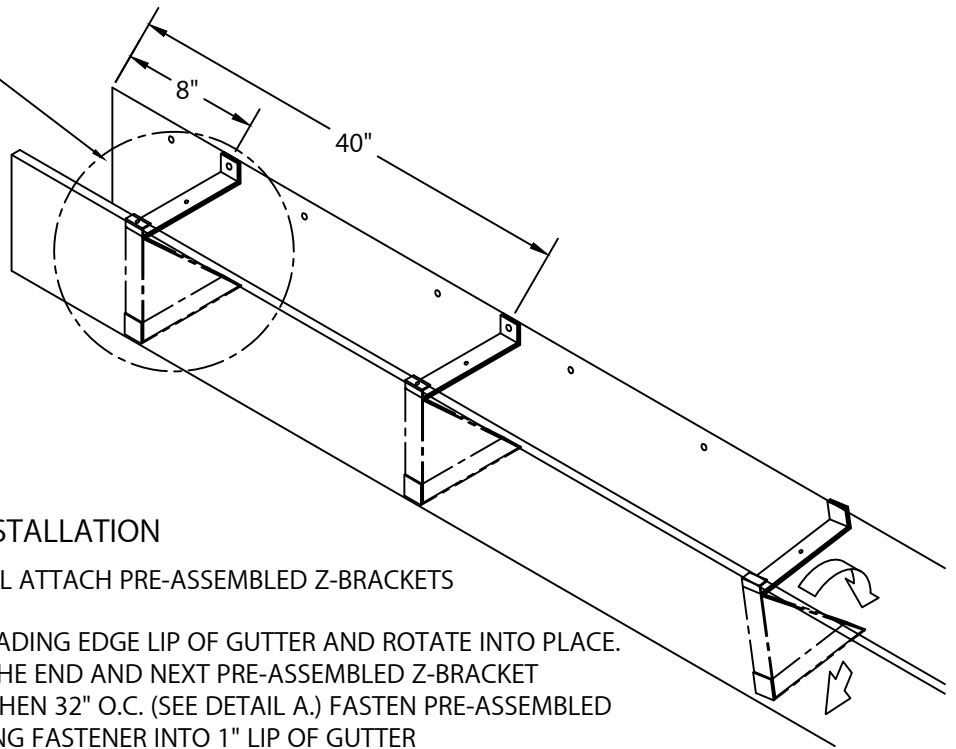
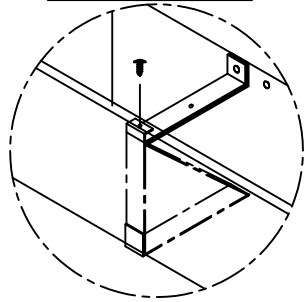
# SOPREMA INDUSTRIAL XL GUTTER

BOX VERSION

## INSTALLATION INSTRUCTIONS

SEE FASTENER DETAIL

FASTENER DETAIL

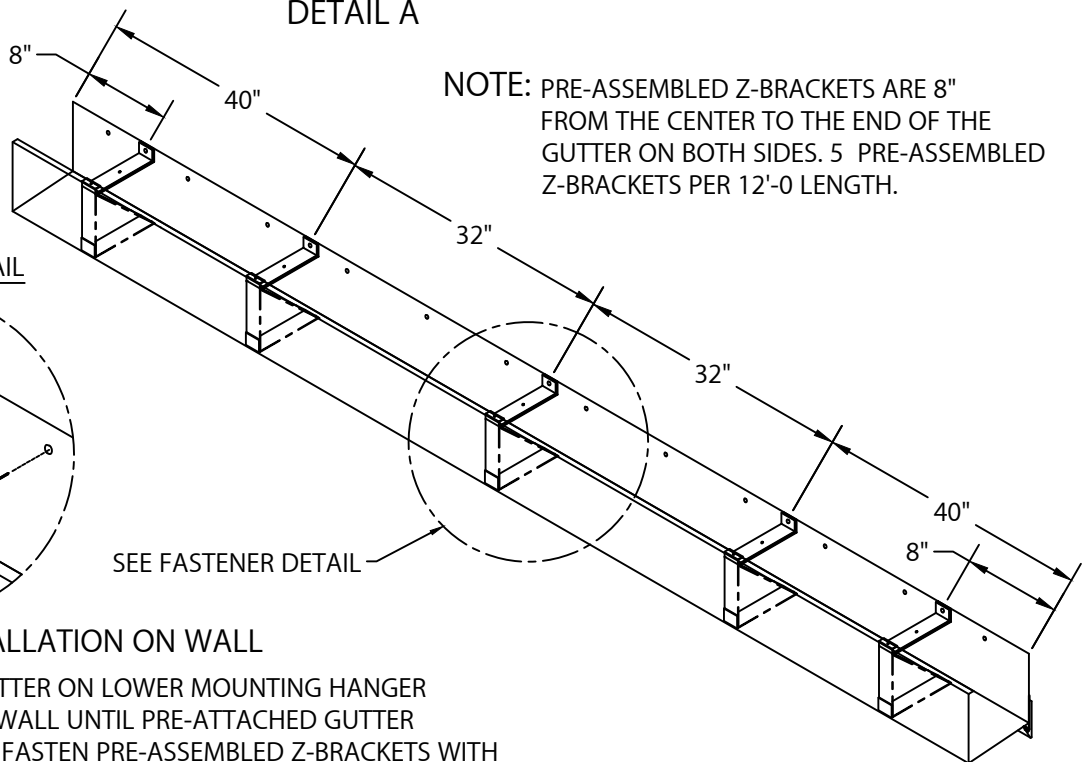


### STEP 5A. GUTTER Z-BRACKET INSTALLATION

NOTE: PRIOR TO MOUNTING ON WALL ATTACH PRE-ASSEMBLED Z-BRACKETS IN THE GUTTER ON THE ROOF TOP. SLIDE OR HOOK Z-BRACKET UNDER LEADING EDGE LIP OF GUTTER AND ROTATE INTO PLACE. FASTEN HANGER STARTING 8" FROM THE END AND NEXT PRE-ASSEMBLED Z-BRACKET SHOULD BE 40" FROM THE END AND THEN 32" O.C. (SEE DETAIL A.) FASTEN PRE-ASSEMBLED Z-BRACKETS WITH SMALL SELF DRILLING FASTENER INTO 1" LIP OF GUTTER

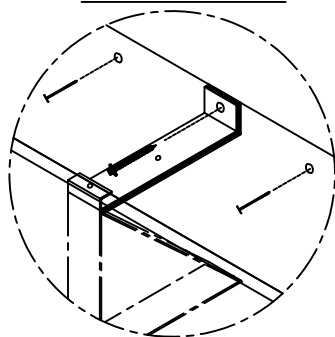
### TYPICAL XL GUTTER INSTALLATION

#### DETAIL A



NOTE: PRE-ASSEMBLED Z-BRACKETS ARE 8" FROM THE CENTER TO THE END OF THE GUTTER ON BOTH SIDES. 5 PRE-ASSEMBLED Z-BRACKETS PER 12'-0" LENGTH.

FASTENER DETAIL



SEE FASTENER DETAIL

### STEP 5B. GUTTER INSTALLATION ON WALL

REST 12'-0" ASSEMBLED GUTTER ON LOWER MOUNTING HANGER AND ROTATE AWAY FROM WALL UNTIL PRE-ATTACHED GUTTER CLEAT SNAPS INTO PLACE. FASTEN PRE-ASSEMBLED Z-BRACKETS WITH PROVIDED FASTENERS THRU PRE-PUNCHED HOLES OF PRE-ASSEMBLED Z-BRACKET INTO NAILER. FASTEN GUTTER TO NAILER THRU PRE-SLOTTED HOLES 12" O.C. WITH PROVIDED FASTENERS.



800-356-3521  
www.soprema.us

310 Quadral Dr.  
Wadsworth, OH 44281  
f: 330-334-6257

DATE: 11/30/23

DRN BY: MLM

CKD BY: MM

SHT.# 4 OF 7

DWG# 33112-41343

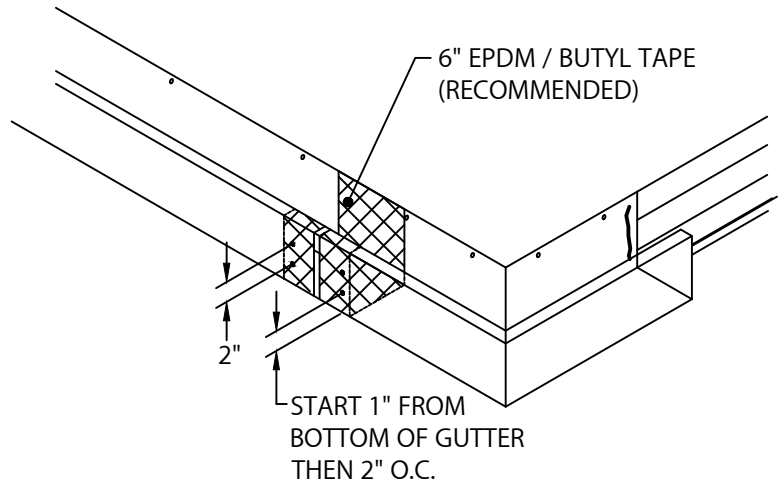
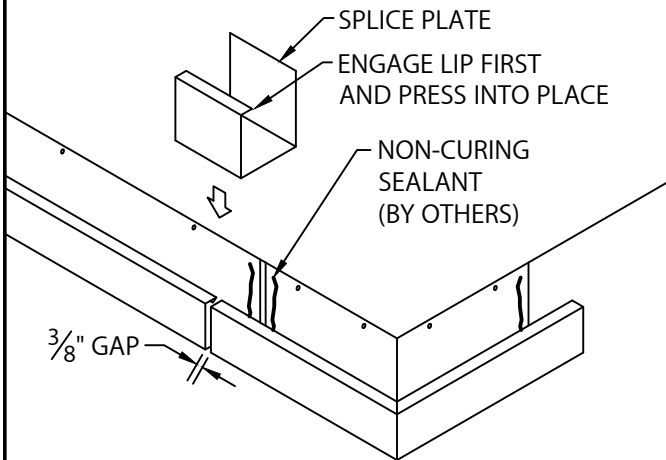
B

# SOPREMA INDUSTRIAL XL GUTTER

BOX VERSION

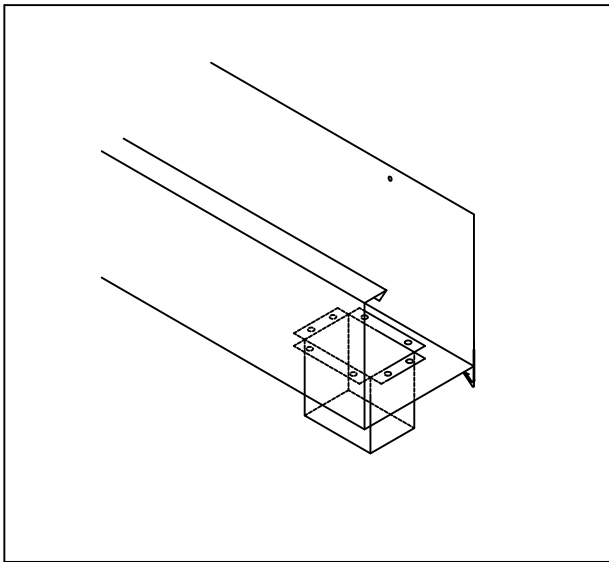
## INSTALLATION INSTRUCTIONS

NOTE: Z-BRACKETS NOT SHOWN FOR CLARITY.



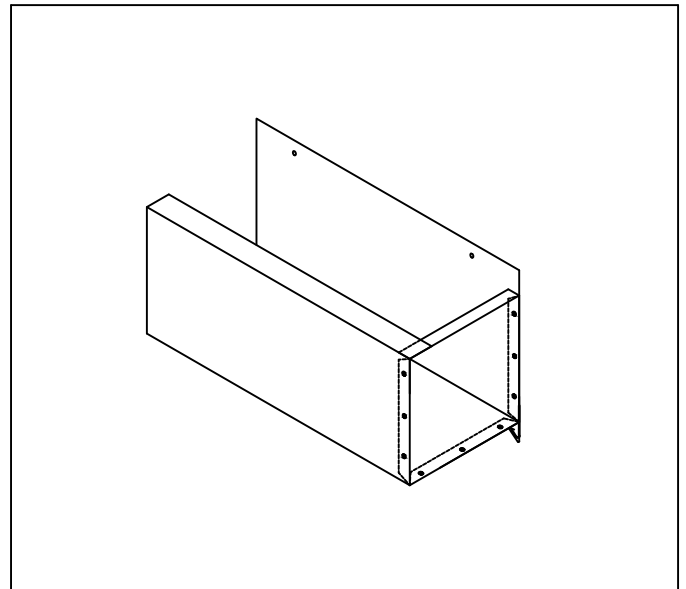
### STEP 6. SPLICE PLATE INSTALLATION

APPLY A HEAVY BEAD OF NON-CURING SEALANT TO INSIDE END OF GUTTER. LEAVE A  $\frac{3}{8}$ " GAP AT SPLICE JOINT. PLACE 6" WIDE SPLICE PLATE AT JOINT. RIVET SECTIONS WITH PROVIDED  $\frac{1}{8}$ " STAINLESS STEEL POP RIVETS AT SPLICE JOINT 2" O.C. AS SHOWN, STARTING 1" FROM BOTTOM OF GUTTER. THE MANUFACTURER RECOMMENDS THE APPLICATION OF EPDM / BUTYL PRESSURE SENSITIVE TAPE CENTERED OVER THE SPLICE PLATE AND LAPPING THE GUTTER SECTIONS A MINIMUM OF 1".



### STEP 7. OUTLET INSTALLATION

DETERMINE OUTLET LOCATIONS AND FIELD CUT HOLE IN A NEAT WORKMANLIKE MANNER. INSERT ALUMINUM OUTLET, FASTEN WITH PROVIDED  $\frac{1}{8}$ " STAINLESS STEEL POP RIVETS, 2" O.C. IN EACH FLANGE AND SEAL WITH NON-CURING SEALANT.



### STEP 8. END CAP INSTALLATION

INSTALL ENDCAPS AT ALL TERMINATIONS. FIELD RIVET WITH PROVIDED  $\frac{1}{8}$ " STAINLESS STEEL POP RIVETS AT 2" O.C. AND SEAL WITH NON-CURING SEALANT



800-356-3521  
www.soprema.us

310 Quadral Dr.  
Wadsworth, OH 44281  
f: 330-334-6257

DATE: 11/30/23  
DRN BY: MLM  
CKD BY: MM

SHT.# 5 OF 7  
DWG# 33112-41343

B

# SOPREMA INDUSTRIAL XL GUTTER

BOX VERSION

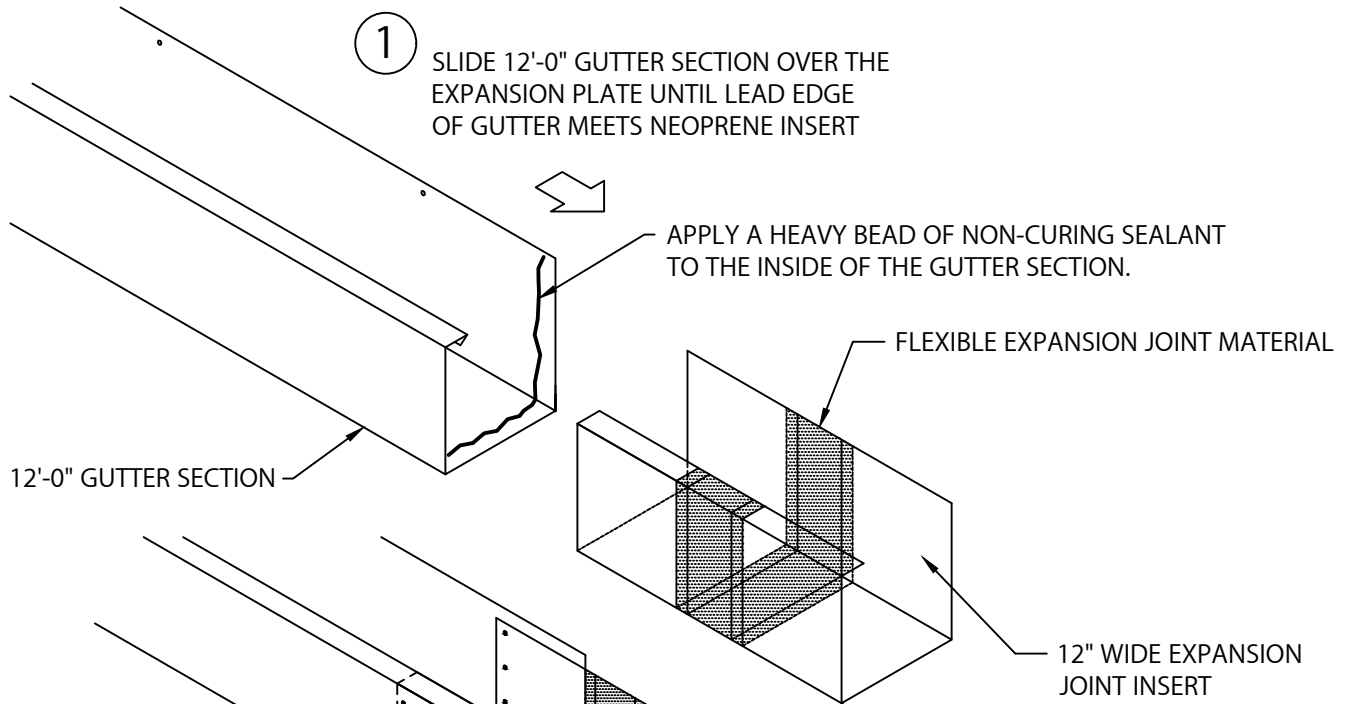
## INSTALLATION INSTRUCTIONS

### EXPANSION JOINT INSTALLATION

(STYLE 2 EXPANSION JOINT SHOWN)

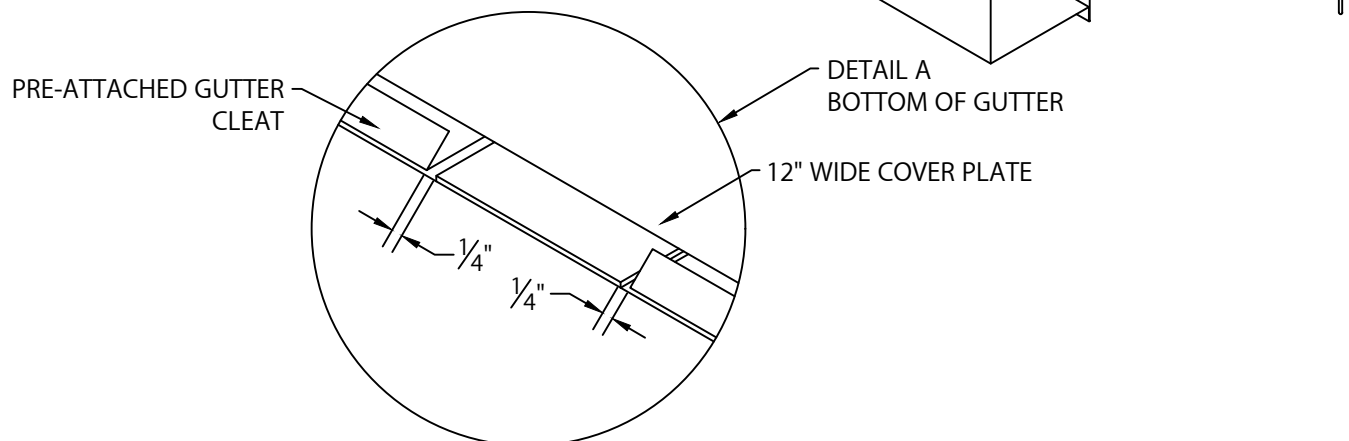
NOTE: Z-BRACKETS NOT SHOWN FOR CLARITY.

- ① SLIDE 12'-0" GUTTER SECTION OVER THE EXPANSION PLATE UNTIL LEAD EDGE OF GUTTER MEETS NEOPRENE INSERT



- ② RIVET EXPANSION JOINT INSERT TO GUTTER

- ③ SLIDE COVER PLATE OVER THE EXPANSION JOINT LEAVING A  $\frac{1}{4}$ " GAP TO THE END OF THE GUTTER. INSTALL SECOND GUTTER SECTION LEAVING  $\frac{1}{4}$ " GAP TO THE EXPANSION JOINT COVER PLATE. SEE DETAIL A.



800-356-3521  
www.soprema.us

310 Quadral Dr.  
Wadsworth, OH 44281  
f: 330-334-6257

DATE: 11/30/23

DRN BY: MLM

CKD BY: MM

SHT.# 6 OF 7

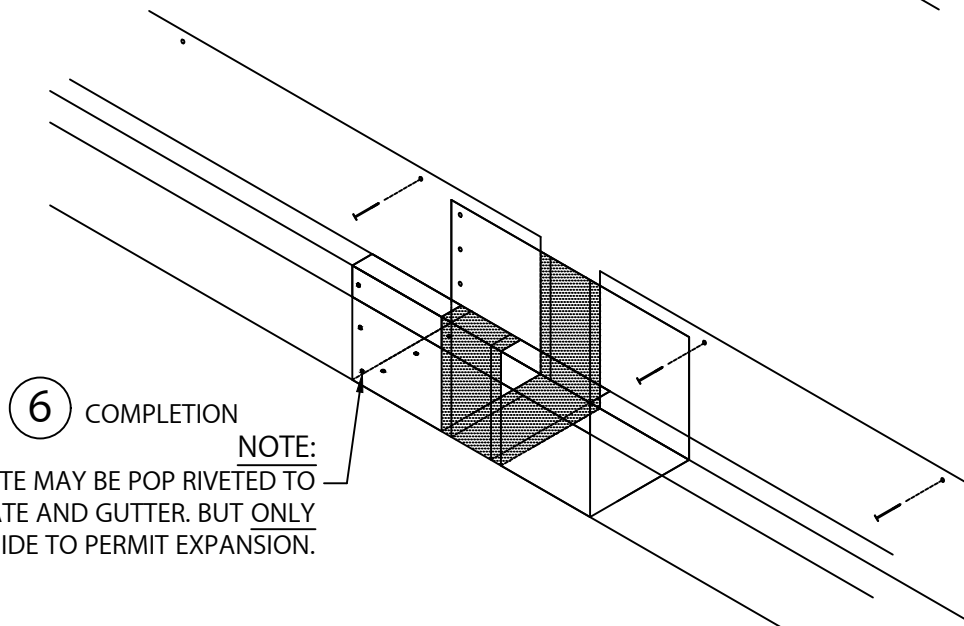
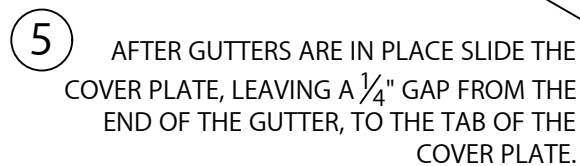
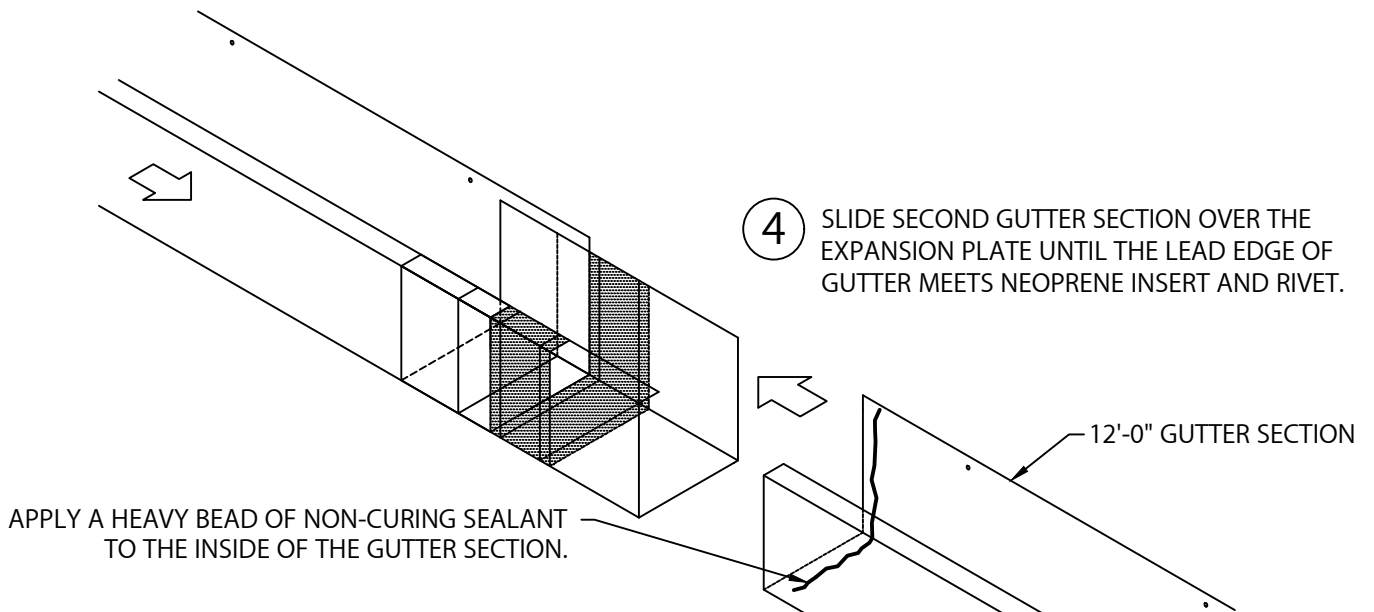
DWG# 33112-41343

B

# SOPREMA INDUSTRIAL XL GUTTER

BOX VERSION

## INSTALLATION INSTRUCTIONS



NOTE: THIS STEP IS NOT NECESSARY ON STYLE 2 (SHOWN).



800-356-3521  
www.soprema.us

310 Quadral Dr.  
Wadsworth, OH 44281  
f: 330-334-6257

DATE: 11/30/23  
DRN BY: MLM  
CKD BY: MM

SHT.# 7 OF 7

DWG# 33112-41343

B