

Roofit.Solar

# Double Seam 2023

## Safety and Installation

## Manual



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## Acronyms

<b>BIPV</b>	Building Integrated Photovoltaics (i.e. metal integrated photovoltaics)
<b>DC</b>	Direct Current
<b>JB</b>	Junction box
<b>m.a.s.l.</b>	Meters above sea level
<b>PV</b>	Photovoltaic
<b>STC</b>	Standard Test Conditions (T= 25°C, Solar Irradiance = 1000 W/m <sup>2</sup> , AM = 1.5)
<b>VDC</b>	Volts of direct current

## Definitions

<b>Buyer</b>	A person or party that purchases the Product/s from the Roofit Solar Energy OÜ.
<b>Product/s</b>	Roofit Solar Energy OÜ BIPV (i.e.i.e., metal integrated photovoltaics)
<b>Warranty Period</b>	The period beginning on the date of purchase of Product/s by the Buyer
<b>PV layer</b>	The Photovoltaic part of the Roofit.Solar Product
<b>PV system</b>	System composed of two or more Roofit.solar Products combined with an inverter and other electrical accessories.

## Introduction

This manual contains essential information about electrical and mechanical installation that must be followed before handling, installing, and maintaining our Product. In addition, this manual also contains safety information one needs to be familiar with.

## Disclaimer of Liability

All the information contained in this manual is the intellectual property of the Roofit Solar Energy OÜ and is based on the technologies and experience acquired and accumulated by the company. This manual does not constitute a warranty, either explicit or implicit. Roofit Solar Energy OÜ does not assume responsibility and expressly disclaims liability for any loss, damage, or expenses arising from or in any way related to the installation, operation, use or maintenance of our Product. Roofit Solar Energy OÜ assumes no responsibility for any infringements of patents or other rights of third parties that may result from the use of our Product.

Roofit Solar Energy OÜ reserves the right to make changes to the Product, the specifications, or the installation manual without prior notice. Failure to comply with the requirements listed in this manual will void the warranty provided by the Roofit Solar Energy OÜ.

The mechanical and electrical installation of PV systems must be carried out with all applicable codes, including electrical codes, building codes and electric utility interconnection requirements. These requirements may vary from country to country. Contact local authorities for applicable regulations. The product must be installed by a qualified person. The electrical connection must be made by a certified electrician. Planning the location of the product on the roof should be carried out by a competent professional with experience in planning PV systems.



## General Considerations

**The distributor of our Products is required to provide this manual to the PV system owners.**

The Product is designed to meet the requirements of the IEC 61215 and IEC 61730 standards. Perform structural analysis of the roof before installing Roofit.Solar Products.

Observe all relevant laws, regulations, guidelines, and safety measures when handling solar modules. For your safety, do not attempt to work on a rooftop until the necessary safety precautions have been identified and taken. Sufficient protective equipment (e.g., harnesses, insulated rubber gloves and tools, etc.) is required throughout the installation process.

Roofit.Solar Products can be combined with other components to form a photovoltaic system. In this case, installation and operating instructions issued for these additional components must be also followed.

NB! PV system generates DC electricity when exposed to light and therefore can cause an electrical shock or burn if not handled properly. PV modules are running on voltage higher than 30VDC and currents exceeding 30mA, thus all contacts with bare wires without proper safety measures can be dangerous for health. The danger increases when multiple Products are connected to provide higher system voltage or current levels. Dangerous voltages can also occur at night or even when the modules are not connected to an electrical circuit or load.

The Products can only be rendered inoperative by removing them from sunlight, or by fully covering their front side with fabric, cardboard, or other completely opaque material, or by working with Products face down on a smooth, flat surface.

A PV system can produce a higher output than the rated specifications. Industry standard ratings are made at STC. Reflection from snow or water can increase sunlight, therefore boosting current performance and power. In addition, colder temperatures can substantially increase voltage and power. This must be taken into consideration during the system design done by a competent person experienced in PV system planning (for more information see the section Electrical Installation).

## Main Precautions

### Always follow the safety precautions listed below when dealing with Roofit.Solar Product:

- Do not keep the Product packages open outdoors until they are ready to be installed.
- Transport and store the Products in appropriate packaging in a ventilated, rainproof, and dry location.
- Always use electrically insulated tools and gloves while working on the electrical connection of the Product.
- Be careful with the sharp edges and corners of the Product.
- DO NOT disconnect/connect electrical connections under load.
- DO NOT install the Product in adverse conditions (rain, strong or gusty winds, wet or frosted roof surfaces, etc.).
- DO NOT use mirrors or other magnifiers to concentrate sunlight onto the Product.
- DO NOT overbend or apply stress to the cables.

Observe the recommended cable bend radius following the supplier's data sheet.



- Ensure that all electrical connections are properly secured and protected from unwanted interference.
  - Before installation, make sure that all the QC4.10 connectors have dust caps on.
- Remove the dust caps only prior making electrical connections.



- DO NOT lift the Product by grasping junction boxes.
- DO NOT drop the Product or drag it over any surface.
- DO NOT attempt to install or service the PV system unless you are qualified to do so.
- DO NOT attempt to open the junction box, repair, modify or disassemble the Product.
- DO NOT leave the Product unsecured. If it falls, the glass layer could break.  
The Product with a broken glass layer cannot be repaired and must not be installed.
- DO NOT apply paint or adhesive to the Product surface or attempt to remove any markings, labels or parts attached to the Product by the manufacturer.
- DO NOT drill holes in the PV layer of the Product.
- Always mount the Product so that the junction box is unobstructed and does not carry any of the weight of the Product.
- Avoid stepping or placing heavy load on the modules during the installation.  
Doing so may cause microcracks/ cracks that are invisible to human eye.



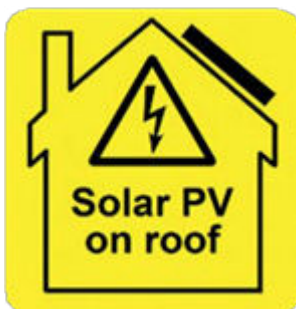
## Fire Safety

Consult your local authority for guidelines and requirements for building or structural fire safety. Roofit.Solar Products have been tested according to the Fire Test in IEC 61730 Part 2 and classified as Class A. Also, Roofit.Solar Products have been tested according to CEN/TS 1187 and labelled as Broof (t2) in accordance with EN 13501-5:2016. In addition, the metal sheet has been tested according to the EN 14782:2006 Self-supporting metal sheet for roofing, external cladding, and internal lining.

Roof constructions and installations may affect the fire safety of buildings.

Improper installation may lead to hazards in the event of a fire.

Use appropriate components such as fuses and grounding connectors as required by the local authorities.



**Inform firefighters about the existence of a photo- voltaic system in the building.**



**In case of fire, stay away from all elements of the PV system, until the area is safe.**

## **Fire safety switch combiner box**

A combiner box is recommended by Roofit.Solar for the buildings with PV systems to secure the house and the inverter(s) from unexpected overvoltage.

The combiner box is equipped with an emergency disconnect mechanism that shuts down the PV system and protects it from overvoltage caused by the lightning strikes.

Depending on the roof specifications, the combiner can be available in different sizes and includes fireman's switch, which disconnects the DC power lines between the solar modules and the inverter(s).

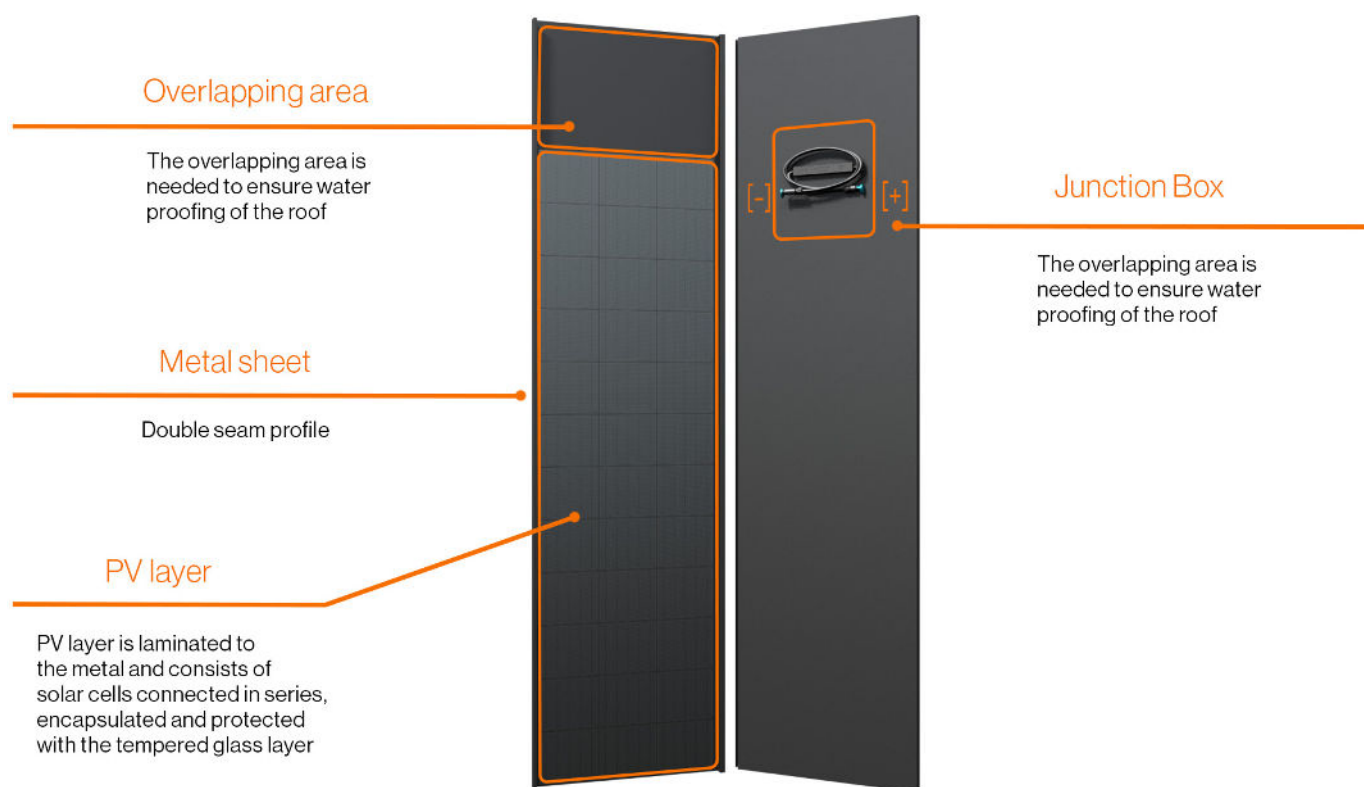
The device can be triggered locally, as it is installed outside of the building with an easy access that can be activated in case of a fire.



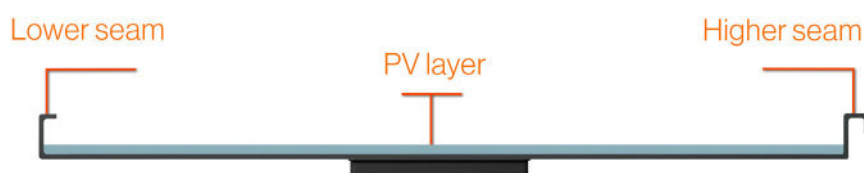
## → Roofit.Solar Product Information

The Roofit.solar Product is a building integrated photovoltaic (PV) product used as a construction material placed on a roof of a building.

### Illustration of the Product



View from the Front   View from the Back



View from the Bottom Edge

## Connectors

The Roofit.Solar Product has a junction box containing positive and negative QC4.10 terminals.  
The junction box has been designed to be electrically interconnected in series with IP68 protection grade.

Type	Ambient temperature	Degree of protection	Rated voltage	Rated current
QC4.10 Connectors	-40 to + 85 °C	IP68	1500 V	41 A

## Bypass diodes

The junction box contains three bypass diodes wired in parallel with the PV cell strings.  
In case of partial shading, the diodes bypass the current generated by the unshaded cells, thereby limiting the Product heating and performance losses. Bypass diodes are not overcurrent protection devices.  
In the event of a known or suspected diode failure, installers or maintenance providers should contact the supplier.

### Specifications of the bypass diode

Rated bypass current	Rated reverse current	Rated voltage	Operating Temperature
16 A	30 A	1500 VDC	-40 to +200 °C

# → Product environment

## Product location

Proper measures must be taken to ensure the performance and safety of the Product when installed or operated in areas with heavy snow, extreme cold, strong wind, near coastal areas or deserts where salt fog may manifest.

The operating temperature range of the product is between  $-40^{\circ}\text{C}$  and  $85^{\circ}\text{C}$ .

The maximum altitude for the installation of a 1000 V Roofit.Solar Product is 2000 m.a.s.l.

Ensure the Product is not subject to wind or snow exceeding the maximum permissible load.

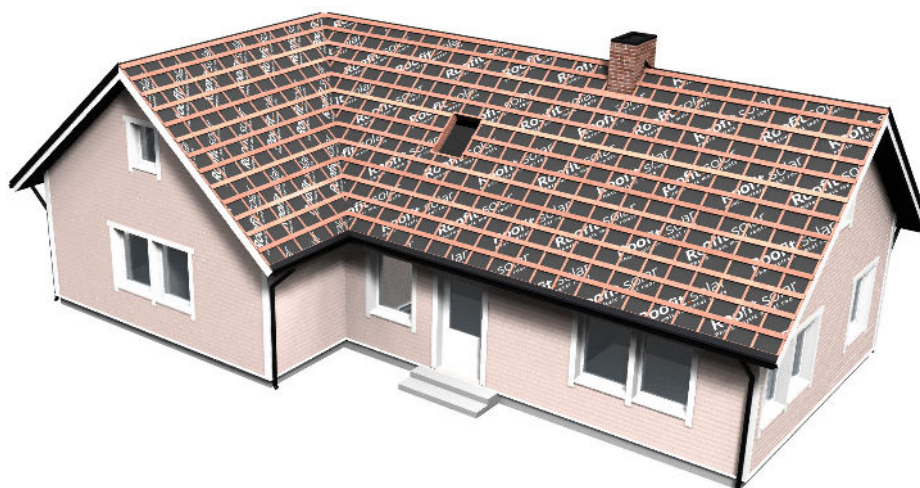
The maximum permissible designed snow load is 4000 Pa with a safety factor of 1,5. The maximum permissible designed wind load is 1600 Pa with a safety factor of 1,5.

Roofit.Solar is not responsible or liable for Products damaged during lightning. Therefore, surge protection is recommended for Products to be installed in locations with high probability of lightning strikes.

The Product should not be installed in locations where any type of corrosive agents and/or flammable gasses may be generated or collected.

## Roof Support Structure

Ensure the installation method and supporting system of the roofing materials are strong and durable enough to install the Product and meet its load conditions. The supporting system must be installed according to local, national, or international standards.



Any penetration (e.g., a chimney, pipes etc.) to the Roofit.Solar Product must be properly sealed to prevent leaks. Always keep the back of the Product free of foreign objects which are not part of the support structure.

## Roof Slope

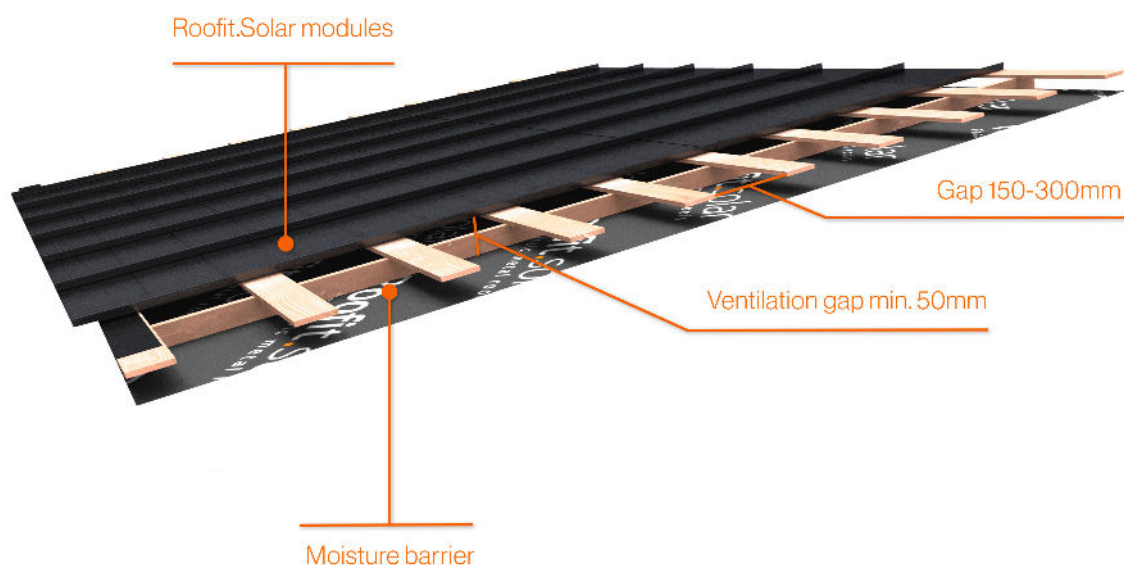
For the purposes of waterproofing as well as maintenance, it is strongly recommended the roof is at slope of more than 10 degrees.



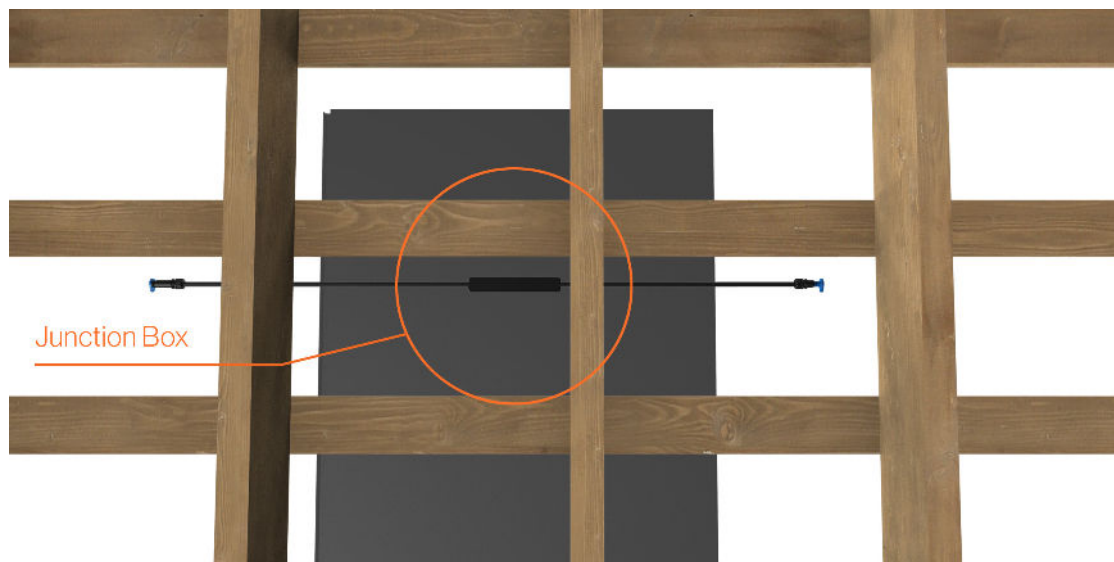
## Location of battens

Battens serve as a support for the Product, and therefore, must be installed on the same level and form an even surface to eliminate the possibility of damage to the glass layer during the installation.

Roofit.Solar recommends 150-300 mm gap between the horizontal battens. Ventilation gap between the Product and the moisture barrier should be at least 50 mm.



Special attention must be paid to the positioning of the battens in respect to the installation of the Product. Each Product has a junction box that must be placed in between the battens to guarantee safe installation.



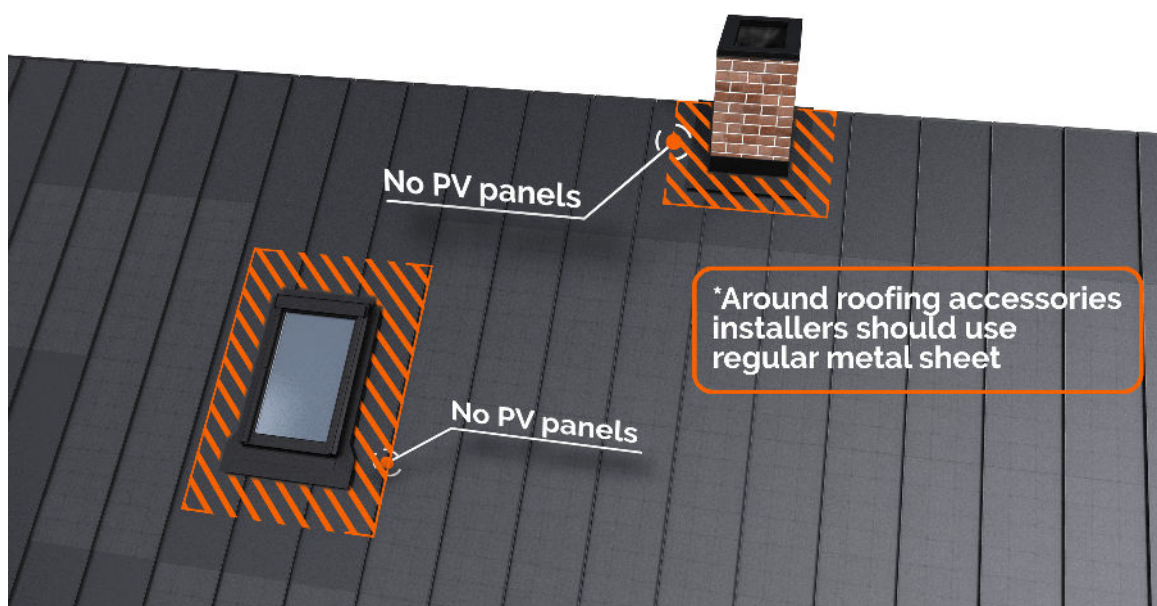


## Roofit.Solar PV system planning

The PV layer of the Roofit.Solar Product must not be cut or bent.

Depending on the roof design, Roofit.Solar Products can cover the whole roof or be combined with regular metal roofing materials.

However, all penetrating roof elements should be surrounded by standard metal sheets. In the case of complex geometry, shadow analysis is needed to determine the appropriate area for the installation of the Products.





# → Electrical interconnection

## Electrical connection accessories

### Extension cable with QC4.10 male/female connectors



Extension cable (> 1 m)

Customized length.

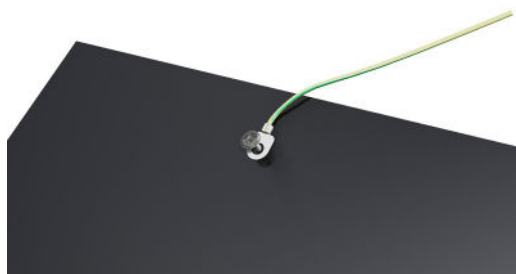
Extension cables are needed if the connection distance between the modules is more than 1 m.

### DC cable with QC4.10 male/female connectors



DC cables are used to connect Roofit.solar DC Strings with the inverter.

### Grounding cable



### Spanner



Spanner is used for the disassembly of connectors.

## Wiring Considerations

Roofit Solar Energy OÜ recommends that all wiring is double insulated with a minimum temperature rating of 110°C. All wiring should use flexible copper (Cu) conductors. The minimum wiring sizes are determined by the applicable codes. Roofit Solar Energy OÜ recommends a size not less than 4 mm².

The insulation should be suitable for the type of installation method used and must meet SKII (Safety Class II) and IEC 61730 requirements. The polarities of cables and terminals must be matched when making the connections, failure to do so may result in damage to the Product and to person. Ensure that all electrical connections are secure and tight.

## Series and Parallel Wiring

Voltages are additive when Products are connected directly in series, and currents are additive when the Products are connected directly in parallel. PV circuits should be designed according to the best practice guidelines of the respective country.

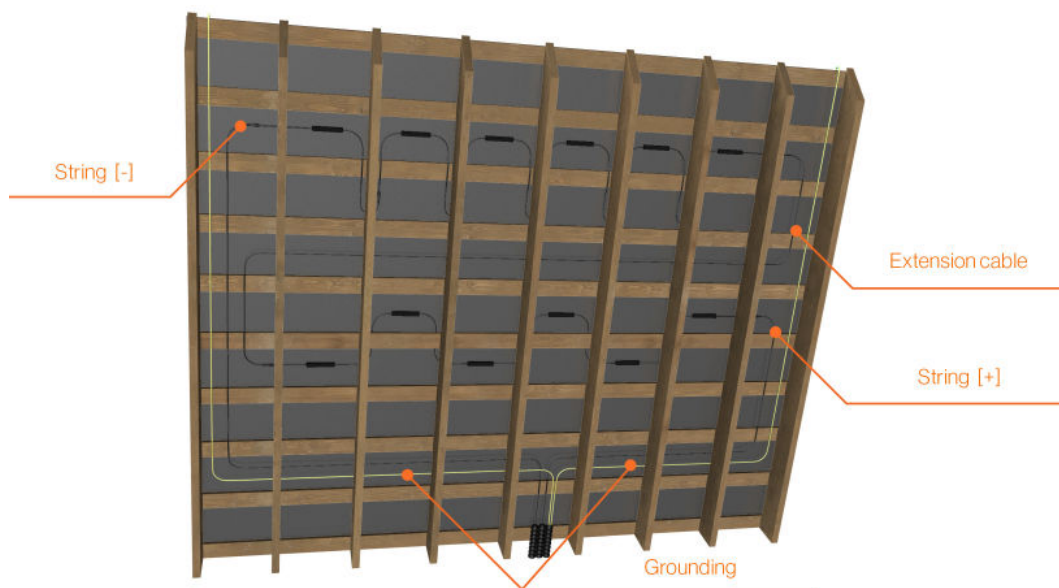
The maximum number of Products that can be connected in series string must be calculated in accordance with applicable regulations so that the specified maximum system voltage of the Products and all other electrical DC components are not exceeded in open-circuit operation at the lowest temperature expected at the PV system location.

In addition, the maximum number of strings that can be connected in parallel cannot exceed 2 without proper protection. An overcurrent protection device is required for each series string if more than two series strings are connected in parallel.

The maximum system voltage of the Roofit.Solar Product is DC 1000V according to the safety assessments of the IEC61730. The correction factor for the open-circuit voltage can be calculated based on the following formula:

$$C_{voc} = 1 - \beta * (25^{\circ}\text{C} - T_{\min})$$

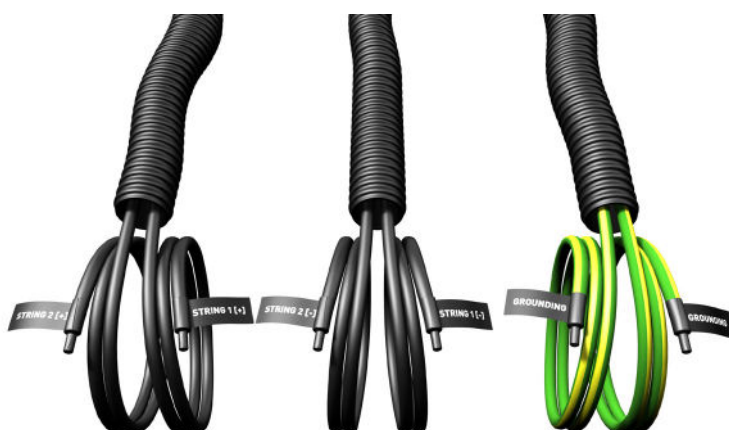
$T_{\min}$ , °C is the lowest expected ambient temperature at the system site.  $\beta$ , %/°C is the temperature coefficient of the selected Product Voc (Refer to datasheet). A properly rated overcurrent protection device must be used when the reverse current could exceed the maximum fuse rating of the Product.



The inverter (String [-], String [+]), the grounding and extension cables connecting the Roofit.Solar Products should be positioned on site (i.e., between battens) before the installation. Loose cables should be fixed to the wooden structure with the help of cable holder clips.

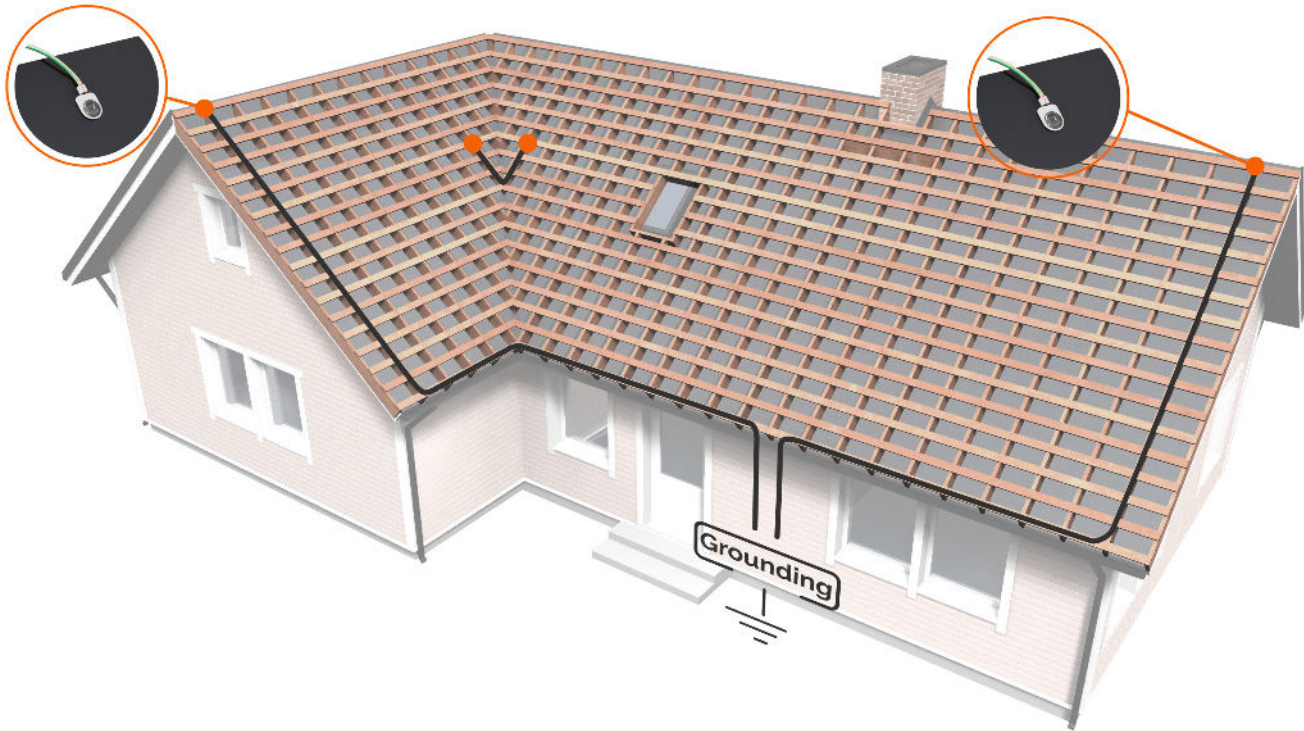
DO NOT group together positive, negative, and grounding cables to avoid ground fault and short-circuit. Insulate bare DC cables and mark them accordingly for the time between PV system and inverter installation. Each type of the cables should be separately routed to the protective tubes and taken to the technical room where they will later be connected to the inverter.

### An example of 2 strings



NB. Roofit.Solar PV system must be equipped with DC arc-fault circuit protection. DC arc- fault circuit protection provides supplementary protection against fires that may arise because of arcing faults in PV system components or wiring. Therefore, inverters with arc fault circuit interrupter (AFCI) must be used for the Roofit.Solar PV system installation.

## Grounding



Each PV system must be connected to the grounding cable to ensure electrical safety. All Roofit.Solar products that are seamed with each other are galvanically connected. Roofit.Solar recommends 2 grounding cables per roof, to provide the possibility to measure ground connection quality.

If the building has more than one type of active surface on the roof (i.e., Roofit.Solar Products covering different sides of the roof), they can be connected in one grounding circuit to minimize the number of grounding cables as shown in the picture. Double grounding of the PV system is recommended even when applicable regulations, code requirements and standards do not require any safety-related grounding.

The grounding should be initialized by screwing a self-tapping A2 or A4 stainless steel screw, ST 4.8 according to DIN 7981C with a length between 10 mm and 16 mm. The screw is connected to the grounding conductor on the uppermost metal sheet of the roof under the ridge cap. The grounding is finalized by connecting the grounding conductors to the equipotential grounding.

# ➤ Mechanical Installation

## Accessories for installation

**Flat-head Screw**



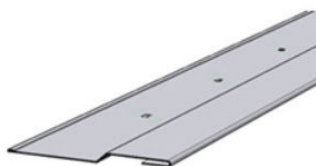
Used for fixing fastening clips

**M82 butyl sealant**



Supports waterproofing of seams in the overlapping area for horizontal joints

**Overlapping fastening element**



Used in case of horizontal joints

**Fastening clip**



Used for fixing the Products to the battens

**Cable fastening clip**



Used for fixing loose cables to the battens

**Hand seaming tool**



First seamer folder

**Hand seaming tool**



Second seam folder

**Electric seamer**



Can be used if no pressure is applied to the PV layer

**Metal cutter**



**Screwdriver**

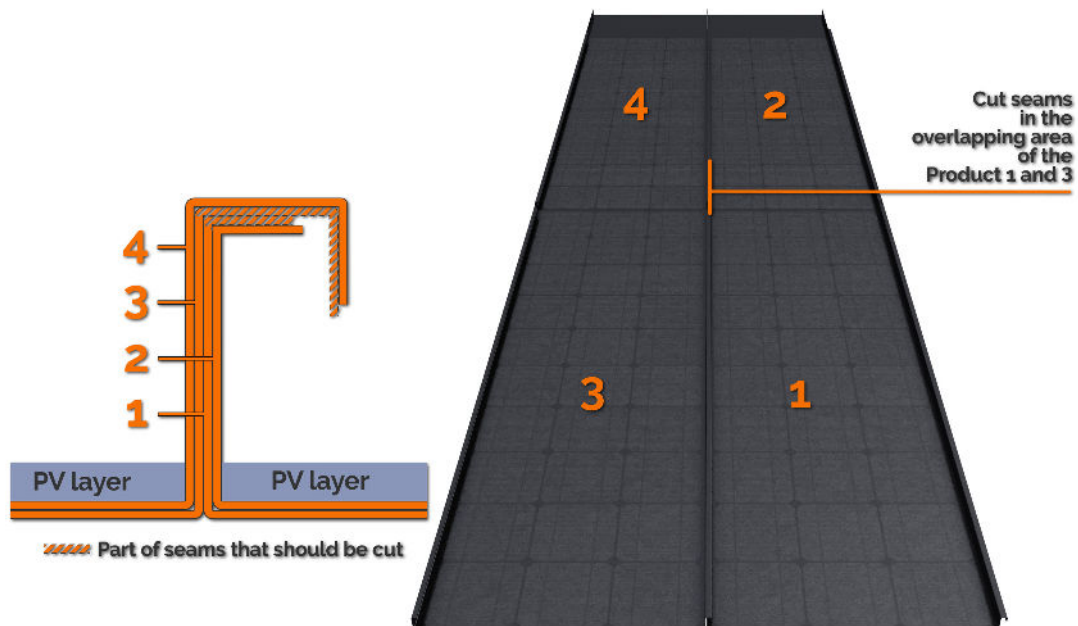




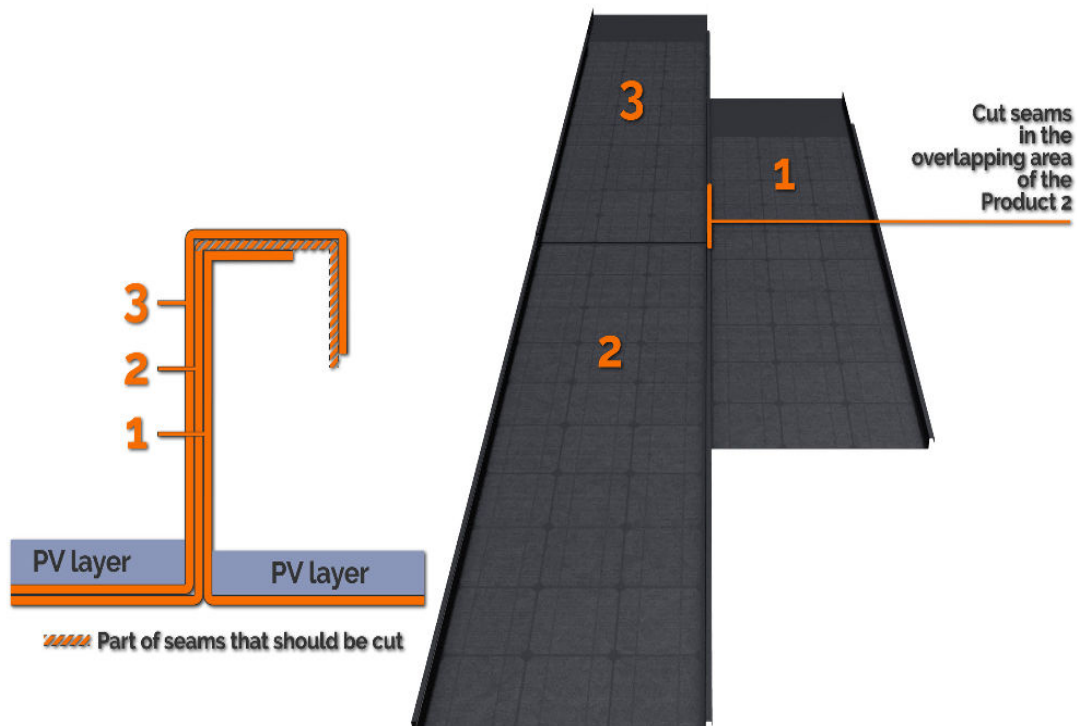
## Preparation of the Products

Cutting the seam is only necessary if more than 2 seams are overlapped. The seam cut should be done only in the overlapping area.

### Case 1



### Case 2

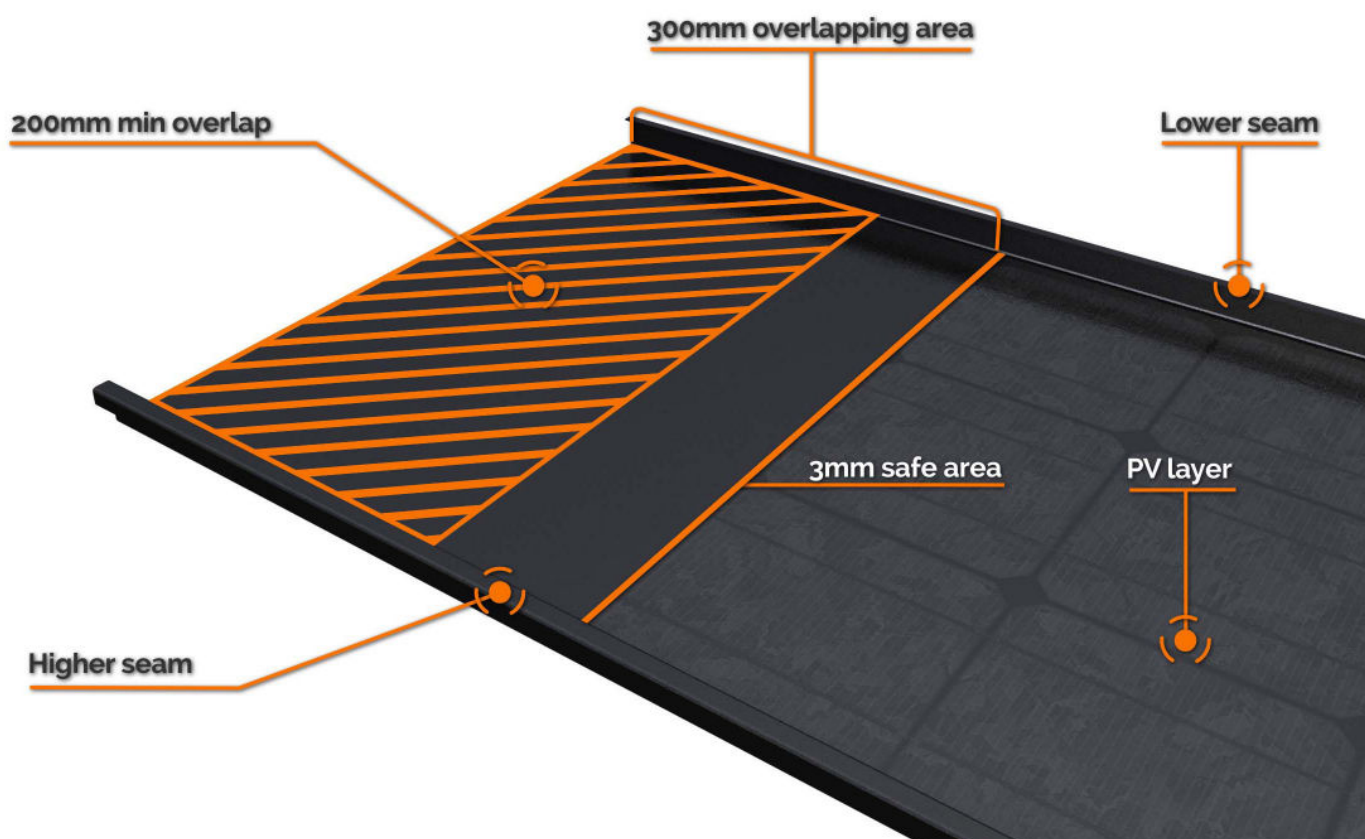




## How to cut seams in the overlapping area for horizontal joint

The seam needs to be cut according to overlapping coverage area.

The gap between the PV layers can be changeable ensuring a minimum distance of 3 mm between the PV layers and the overlapping area of minimum 200 mm.

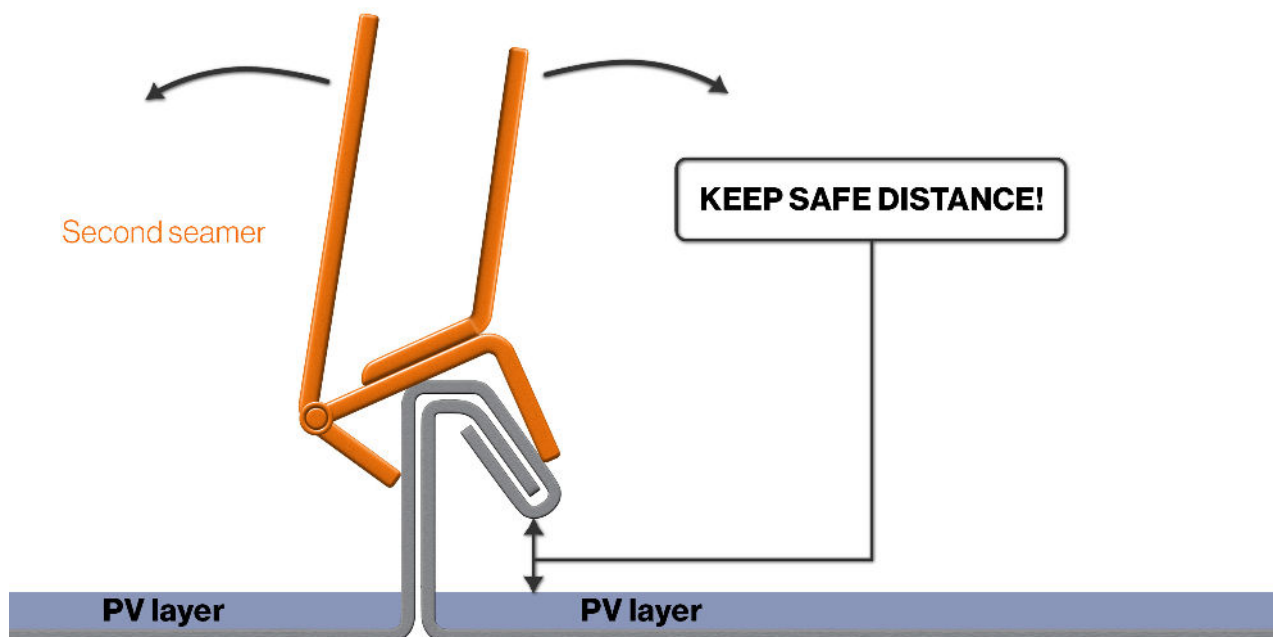
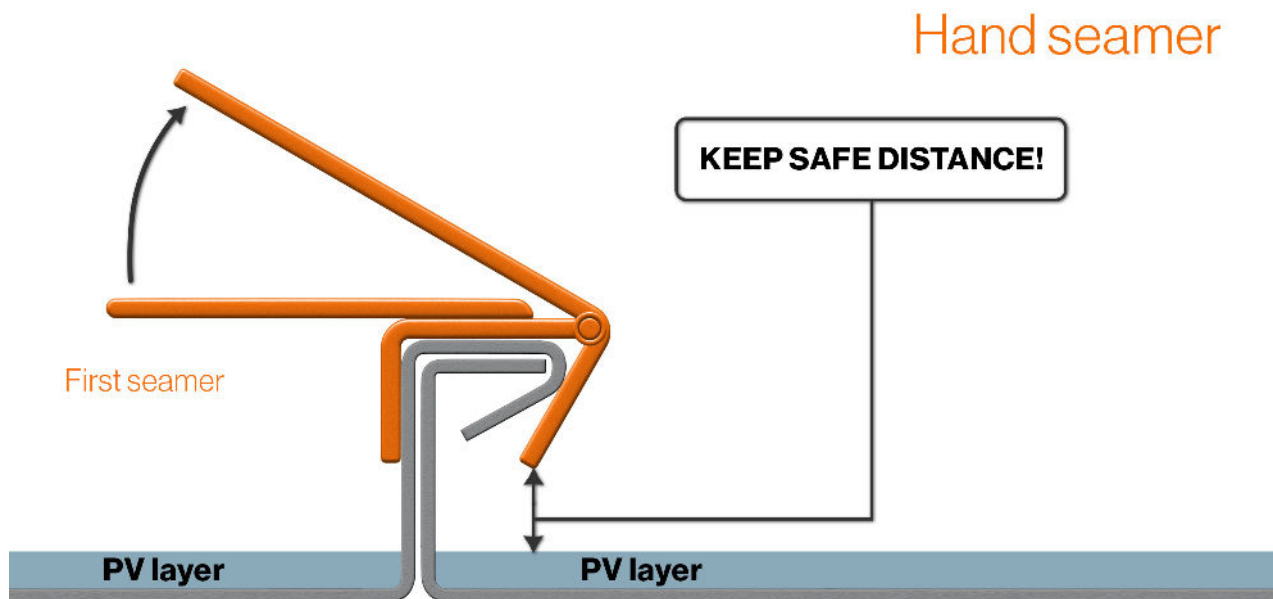


## Seaming of the Roofit.Solar Products

The Product must be fastened with clips according to the double seam metal installation instructions. Fastening screws must be fully tightened.

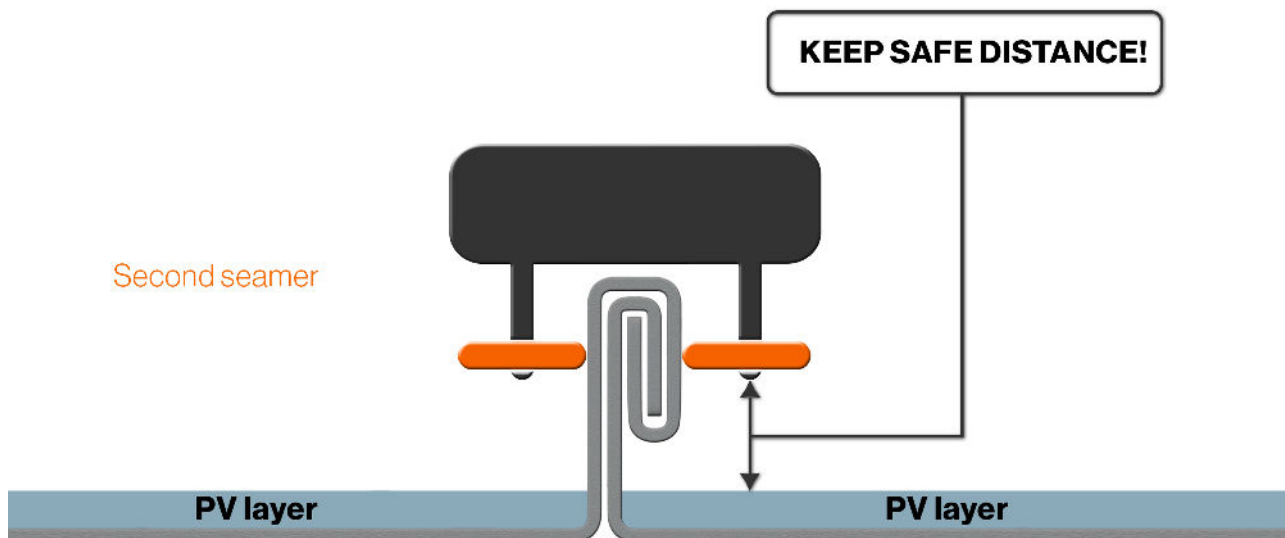
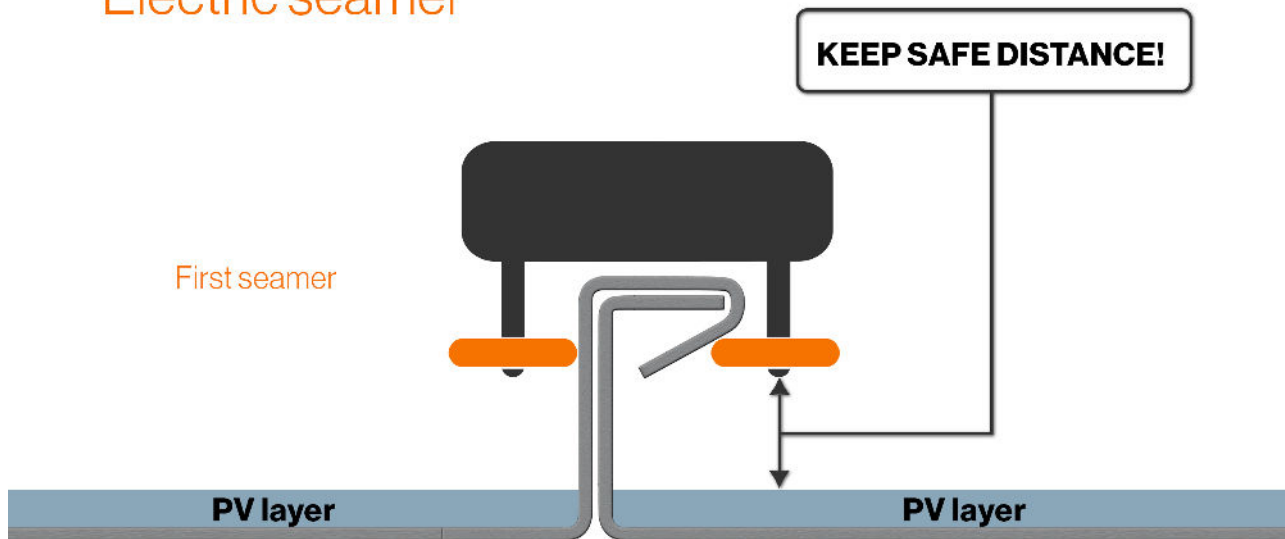
Special attention is required during the seaming process of the Products with hand seaming tools or an electric seamer. Make sure the hand seaming tools or the rollers of the electric seamer do not touch the PV layer.

### Hand seamer



## Electric seamer

### Electric seamer



## First column installation

The installation starts from the right side.

According to the roof planning the column can consist of:

**Case 1: Roofit.solar modules. No additional metal needed.**

**Case 2: Start with the metal and continue with Roofit.Solar modules.**

**Case 3: Start with the Roofit.solar module and finish with the additional metal on top.**

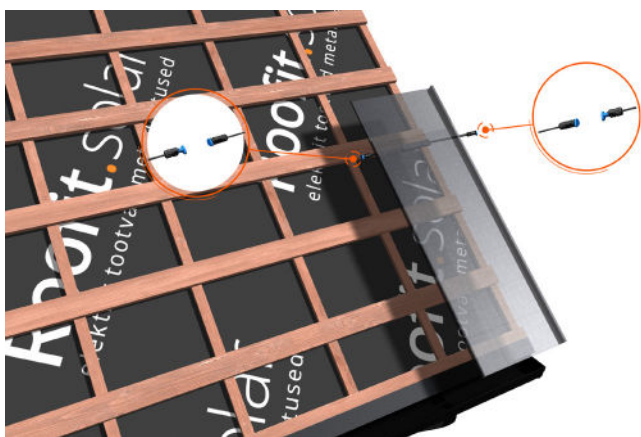
NB: Case 2 is preferable than case 3 during the planning of the roof layout, due to an easier installation process.

## Case 1: The column starts and finishes with Roofit.Solar module

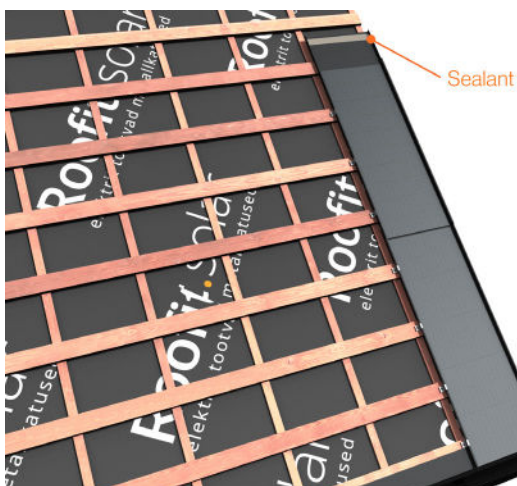
Follow the instructions “How to cut seams for horizontal joint”.



A seam cut of the lower Roofit.Solar Product should be performed if any additional Roofit.Solar Product or metal will be installed on the top.



The PV cables with female and male connectors should be in accessible positions before fastening the modules to the battens. Roofit.Solar Products should be placed in parallel to the eave and fastened with the fastening clips.



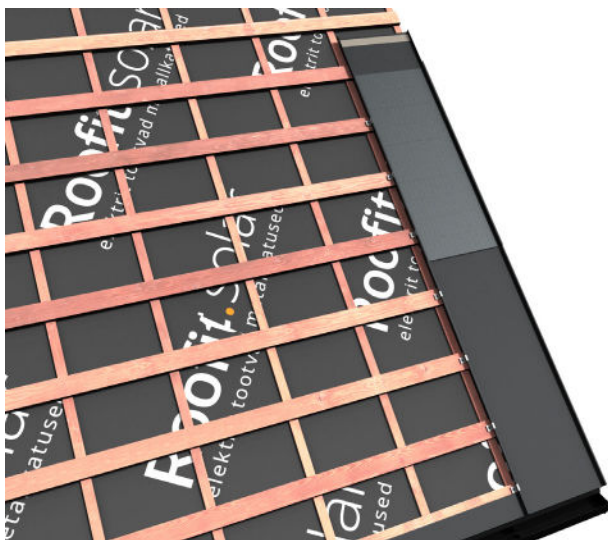
A sealant is placed on the upper edge of the overlapping area.  
The next module is placed according to the system plan

## Case 2: The column starts with a standard metal sheet

Follow the instructions “How to cut seams for horizontal joint”.



The bottom sheet shall be installed as required in the Installation manual of the double seam metal with metal folding under the eave. Attach the sealant to the upper edge of the standard metal sheet.



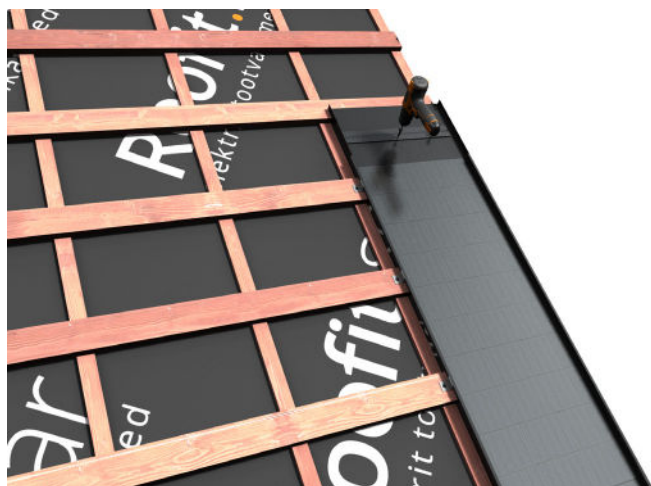
Install Roofit.Solar Product with a minimum overlap of 200 mm of the non-PV metal sheet.



### Case 3: The top of the column completed with a metal sheet



Prepare the top metal part (cut seams and roll back the bottom part).



The seams in the Roofit.Solar Products overlapping area should be cut.  
The fastening element is screwed through the overlapping area.



The top metal sheet must be aligned with the adjoining edge of the previous module.  
The folded end of the metal sheet must be inserted under the overlapping element attached before.

## Maintenance

Regular inspection and maintenance of the Products is necessary, especially within the Warranty Period. It is the user's responsibility to report any damages to the supplier within 4 weeks after the Product delivery.

### **Cleaning**

Dust accumulation on the glass may reduce power output and even cause regional hot-spot effects. Industrial emissions or bird droppings may also affect, and the degree of severity depends on the transparency of the foreign objects. Usually, the accumulated dust does not reduce the transparency much, as light intensity is still homogeneous and the reduction in power output is typically not visible.

Negative environmental effects, such as foreign objects casting shadows or laying directly on the roof, may adversely affect the power output of the Product. Roofit.Solar advises that the PV part of the system should not be obstructed at any time. The Product cleaning frequency depends on the environmental factors.

In many cases the glass is sufficiently cleaned by naturally occurring rain and the necessity to explicitly clean it is reduced.

When cleaning the Product, it is recommended to wipe the glass surface with a damp sponge or soft cloth – without touching any electrical connections. Do not clean the glass with an acidic or alkaline cleaning agent.

### **Visual inspection**

Inspect the Products visually to detect any possible defects such as glass breakage.

It is recommended to implement the following preventive maintenance every 12 months (if accessible):

Check if the connectors are intact and encapsulated (i.e., the cables are not exposed).

Check the sealing gel of the junction box to locate any possible cracks or crevices.

### **Decommissioning and Disposal**

Roofit.Solar is strongly committed to protecting the environment. The Products are durable for decades and built of non-hazardous materials. When the Products have reached the end of their life cycle, they should be disposed in accordance with local recycling regulations.

## Customer Support

Technical support shall be provided to the owner of the Roofit.Solar system by the Buyer For more information, please visit Roofit.Solar website **[www.roofitsolar.com](http://www.roofitsolar.com)**