



# D.I. ROOF SEAMERS

*Forming the Future Together™*

## CURVER 1000

### PLEASE DISTRIBUTE TO THE ROOFING CREW

Contact us at 1-888-343-0456 or online at [www.diroofseamers.com](http://www.diroofseamers.com)

D.I. Roof Seamers  
915 Highway 45  
Corinth, MS 38834

**Please Note: The Curver 1000 produces CONVEX curves ONLY!**

**DUE TO THE PROCESS OF CONTINUOUS IMPROVEMENT, THE PRODUCTS AND PROCEDURES IN THIS GUIDE, ARE SUBJECT TO CHANGE WITHOUT NOTICE.**

GUIDE REVISION INFORMATION				
ACTIVITY	ADDENDUM RELEASE #	PAGES REVISED	RELEASE DATE	AUTHOR
MOST RECENT	#7	1	9/14/23	RAN
PREVIOUS REVISION	#6	4	8/3/2022	RAN
PREVIOUS REVISION	#5	All	4/29/2021	RAN
PREVIOUS REVISION	#4	3rd	2/7/2017	RAN
PREVIOUS REVISION	#3	1st	11/19/2015	ECC
PREVIOUS REVISION	#2	All	11/04/2015	ECC
PREVIOUS REVISION	#1	Original Release	10/29/2015	MLW/ECC

# READ THIS FIELD GUIDE COMPLETELY BEFORE OPERATION!

## CURVER 1000 SAFETY GUIDELINES

- Operators must always use PPE (Personal Protection Equipment).
- Never operate the machine while under the influence of drugs or alcohol.
- Operators **MUST** ensure that the cap feed and exit are clear of all obstructions.
- **KEEP** hands and feet clear of all tooling.
- Always unplug the machine when not in use.
- Always unplug the machine from the power source before adjusting, cleaning, or providing any routine maintenance.
- NEVER operate the machine in damp or wet conditions.
- Do NOT operate the machine when wearing long sleeves or loose-fitting clothing.

## CURVER 1000 OPERATING GUIDELINES

- Follow all safety suggestions, warnings, etc. in this guide and posted on the machine itself.
- If any inconsistencies appear in your cap or if you have any questions, problems, concerns, etc., **STOP** immediately and contact Technical Support at **1-888-343-0456**.
- Cleaning the machine may be required based on job site conditions. It is imperative that tooling be kept clean and free of debris. Failure to do so will result in damage to the material finish and material slippage.
- Tooling requires daily inspection.
- The machine must be level during operation.

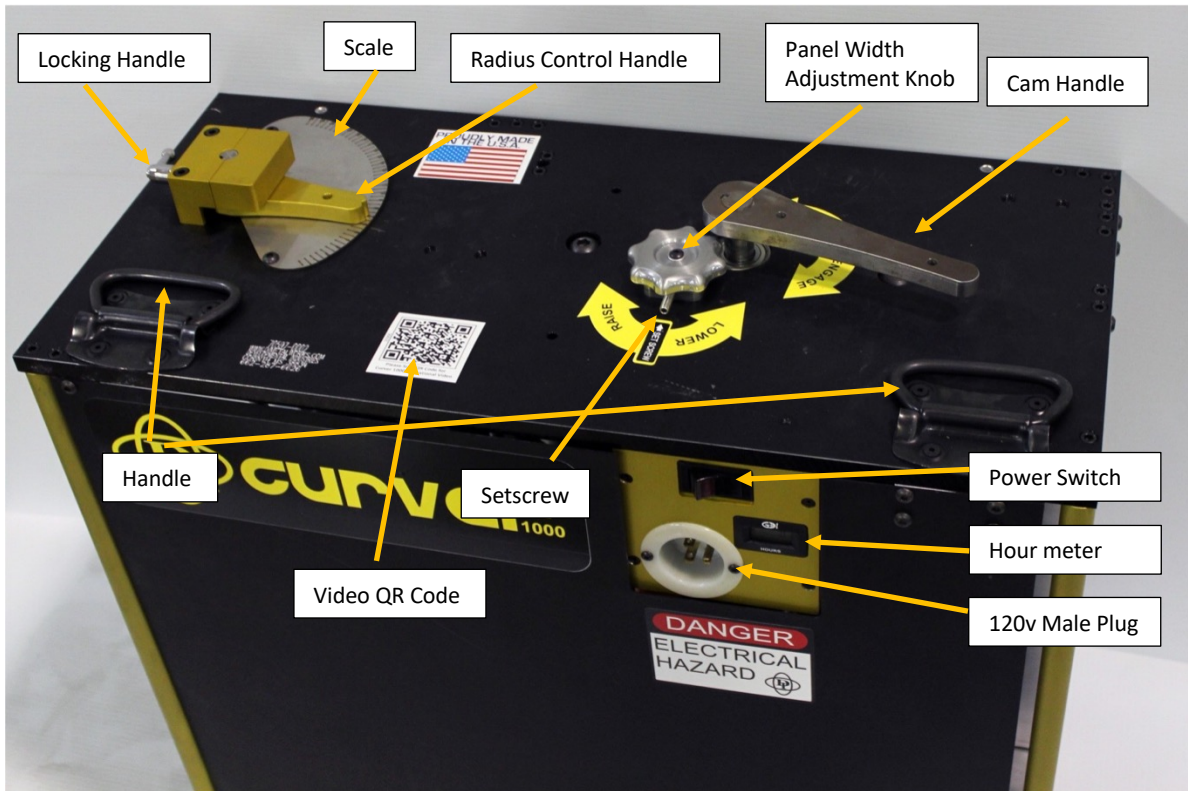
## **CURVER 1000 OPERATING GUIDELINES—CONTINUED**

- The Curver 1000 is designed to curve U-shaped panels that are 12 inches to 18 inches wide with 5/8" to 3/4" legs.
- Panels must always be supported on the feed side and the exit side of the Curver 1000. Panels **MUST** be kept level entering and exiting the Curver 1000.
- When not in use, always store the machine in a dry place to prevent damage to the machine. NEVER operate it in inclement weather, such as rain or snow.
- Small kinks in the vertical legs of the panel will not interfere with the curving process and should be considered acceptable if there is no damage to the pan section of said panel.
- Before operating the machine, you must ensure that the panels are free of all debris and contaminants such as sand, snow, excessive fluids, sealant/mastic, tools, extension cords, etc.
- Remove any protective plastic film that might have been applied to the metal panels by the manufacturer.
- Test and check your initial formed roof panels before forming additional panels. Field adjustments may be necessary for your application. Extra panels may be required for setup.
- Metal roof panel handlers must follow the newly formed roof panel radius as the material exits the machine. Mark the ground with flagging or cones to alert others of the area where the material exits the machine.
- Formed roof panels need to be well supported when they are moved to the roof. (straps and spreader bar)
- This machine requires a 20-amp, 100–125-volt AC power supply. Poor performance and motor damage can result from the use of an improper power supply.

### **IMPORTANT**

#### ***Required extension cord size:***

Distance (FT)	0-100	100-200	200-300
Wire Gauge (AWG)	10	8	6



## Operation Procedure

1. Remove the machine from the shipping container and place the unit on a stable and level platform with the controls facing up.
2. In most cases, the machine will ship to you preset to the radius submitted on your order. It is not uncommon for adjustments to be needed in the field. This is often due to differences between field materials and test materials.
3. To adjust for the panel width:
  - a. Insert a 1/8" Allen Wrench into the setscrew and turn counterclockwise to unlock the Panel Width Adjustment Knob.
  - b. Place the Cam Handle in the disengaged position.
  - c. Turn the Panel Width Adjustment Knob counterclockwise to accommodate wider panels and clockwise for narrower panels.

- d. It may be necessary to trim the vertical legs on the leading end of the panel to a 45° angle if there are issues with the panel feeding into the tooling.



- e. While holding your panel level, insert the panel into the tooling. Turn the Panel Width Adjustment Knob the appropriate direction until the panel slides easily into the tooling.
  - f. Once the desired setting is reached re-tighten the setscrew in the adjustment knob to lock in your setting.
4. To adjust the panel radius:
    - a. Turn the Locking Handle counterclockwise.
    - b. Adjust the Radius Control Knob to a position that produces the desired radius for your application. Note: The indicators on the scale are for reference only and do not correspond with the actual radius of the panel.
    - c. Return the Locking Handle to the locked position to lock in your setting.
    - d. Move the Cam Handle back into the engaged position.
  5. As the cap enters and exits the machine it must be supported every 10 feet.
  6. Verify you completed panels radius on the roof before proceeding with other panels.