

# SEAMLESS ALUMINIUM SYSTEMS

## 5" Seamless Gutter Machine

(Series 555)

- Free Floating Stainless Steel Forming Rollers.
- Mechanical Guillotine utilizing double rack and pinion shear.
- Fuse protected electrical controls with jog/run and forward/reverse switches with exit end.
- 15 amp., 110v., weatherproofed double outlet auxiliary power source.
- Two Independently mounted easily reversible reel stands, with two adjustable width reels.
- One year parts warranty.
- Runs Aluminium, Copper and Standard Terne-Coated Steel.
- 5" Machine – 2.5m in Length (500 kgs) 6" Machine – 3.1m in Length (590 kgs)
- Front Pull Guillotine Style Shear
- Speed – approximately 35ft per minute.
- Machines are also available for 150 mm and combo.



## Seamless Aluminium Health & Safety Data Sheet

**Product Description:** Organic Coatings: Polyester, and A.R.S. (Polyurethane Based)

**Composition:** Aluminium Alloy, Sheet or Coil coated with a Primer, Polyester Top Coat and a Backing Coat. The Organic Top Coat is typically between 1.15% and 3.69% by weight of product.

**Intended Use:** Building, and General Rainwater Systems.

**Health Hazards:** When handling the product in sheet or coil form there is a risk of laceration of the skin. Polyester Compositions under normal conditions of storage are not toxic. Pigments within the pre-treatment and paint systems, may contain one or more of the Substances listed below. For which occupational exposure limits have been established by The Health & Safety Commission. These limits should always be observed.

Substance:	OEL 10 min (b)	OEL Notes	8 HR(a)
Basic Chromium Chromate	0.05 mg/M3	-	As Cr
Aluminium	10ppm	20ppm	
Lead Chromate Pigment	0.15 mg/M3	-	

- a** Long term exposure limit – 8 hour time weighted average
- b** Short term exposure limit – 10 minute time weighted average
- s** Occupational Standard Limit
- m** Maximum Exposure Limit
- c** Manufacture Data
- d** Limits in mg/M3, all other data in parts per million ppm.
- skin** There is a risk of absorption through unbroken skin.

### Precautions In Handling & Use

Protective clothing should be worn to prevent laceration of the skin.

### First Aid Procedure

**Eye Contact:** Irrigate copiously with clean fresh water for at least ten minutes, holding the eyelids apart.

**Skin Contact:** Wash skin thoroughly with soap and water or use a proprietary skin cleaner.

**Fire Prevention:** Under normal conditions of storage and use, polyester compositions are not flammable but may be consumed by fire. The major products of combustion/decomposition of polyester composition are detailed below.

## Rainwater Gutter Capacity & Running Outlets in Litres Per Second, Dimensions in Millimetres

Gutter Profile	Size	Outlet Size Gutter Capacity	Round Pipes 63 - 75 - 100	Square Pipes 75 x 75 75 x 100 100 x 100
	125 x 100	2.84	1.96 2.71 4.94	3.47 4.63 6.18
	150 x 125	3.68	1.96 2.71 4.94	3.47 4.63 6.18

Alloy	Thickness	Temper	YS (Mpa) Min	UTS (Mpa)	Elong A50(%) Min Values	Minimum Recommended Bend Radius (180%) t=Metal Thickness	Primer	Silicone Modified Polyester	High Durability Polyester	Polyurethane Polyamide ARS
3003	0.20 1.20	H44	115	145-185	7	1.5t	Primer	Yes	No	No
		H46	140	170-210	6	1t	Film Thickness (microns)	25	25	30
		H48	160	min 190	4	2t	Flexibility	4-5T	1-2T	0-1T
3105	0.20 1.20	H42	105	130-180	7	0t	Hardness	H	H	2H
		H44	120	150-200	6	0t	Abrasion Resistance	Good	Good	Excellent
		H46	150	175-225	5	0.5t	Corrosion Resistance (Acetic acid salt spray)	Fair (Cracks on bends)	Good	V. Good
		H48	170	min 195	2	1t	U.V. Resistance	V Good	Good	V Good
		H47	175	200-240	7	0t				