Fig 14 ... junction with hand-formed double-lock cross welt

This detail is mainly for use in Traditional roofing because it allows no longitudinal movement. However, with the cross welt not clipped, it is sometimes used in Long Strip roofing as described with Fig 15 and shown on Fig 15b (p52).

When pre-patinated copper sheets have been specified, it is better to use the pre-formed cross welt as some of the patina will be lost in the hand-forming (see Figs 15 and 15a). The pre-formed version also tends to give cleaner lines.

In both Traditional and Long Strip roofing, the double-lock cross welt can only be used with roof pitches at and over 20degrees. If sealed they can be used with roof pitches down to 6degrees.

In Traditional roofs the cross welts will occur at 1725mm centres maximum (see Table G, p9).

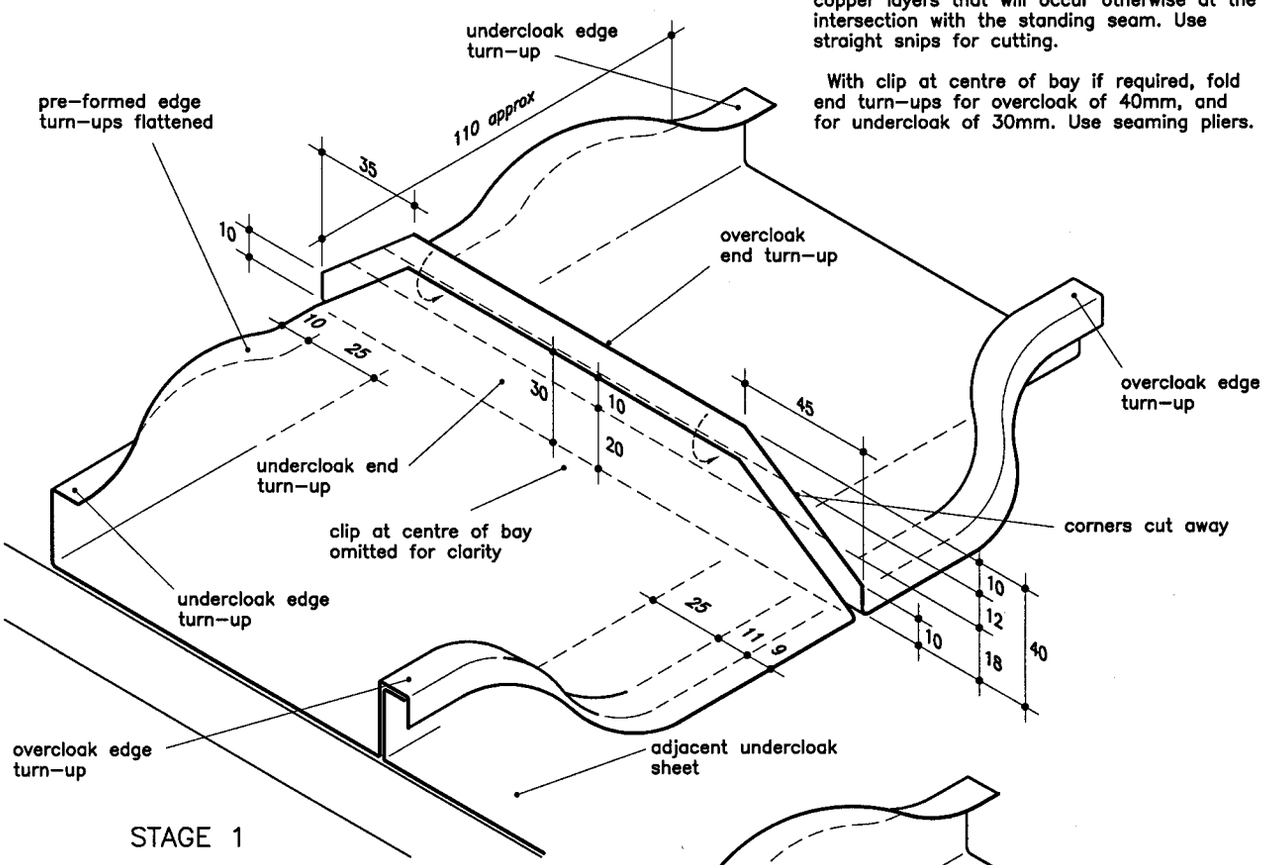
Temper: soft, quarter- or half-hard. With quarter- or half-hard the clip at the centre of the bay is not required; and in Long Strip roofing must not be provided.
Thickness: 0.6mm or 0.7mm

TRADITIONAL ✓ LONG STRIP ✓

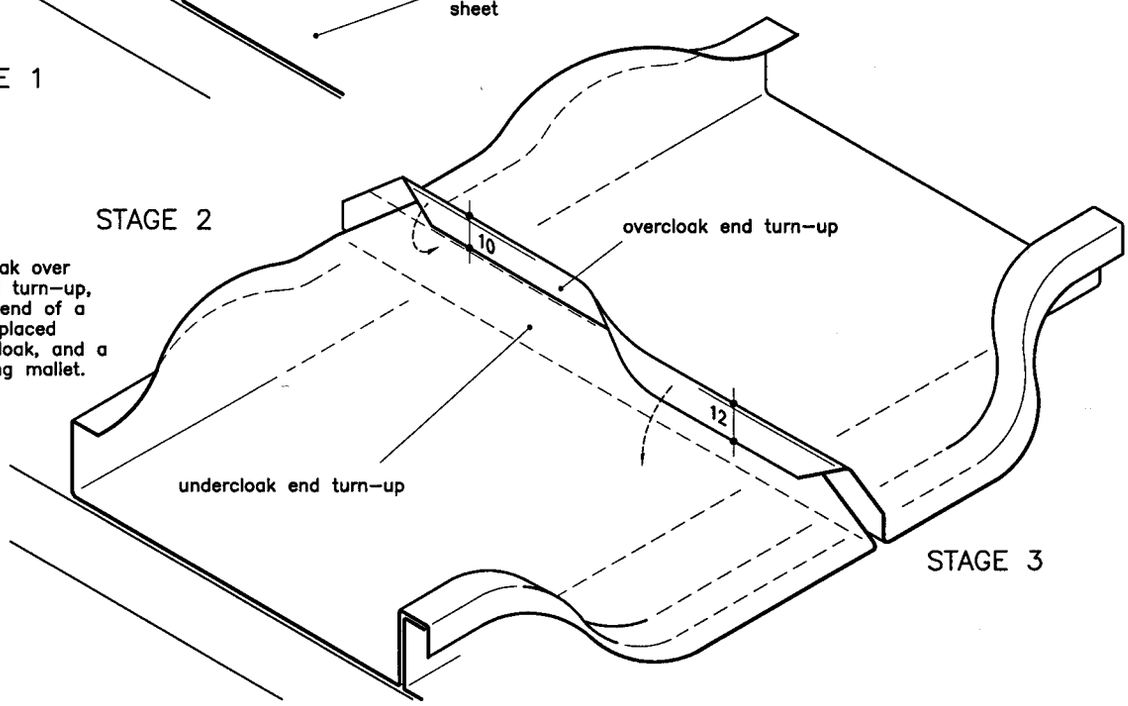
Stage 1
Flatten pre-formed edge turn-ups of overcloak and undercloak at the ends of the sheets or trays to be joined, to allow marking out and cutting.

Cut away the corners to reduce the bulk of copper layers that will occur otherwise at the intersection with the standing seam. Use straight snips for cutting.

With clip at centre of bay if required, fold end turn-ups for overcloak of 40mm, and for undercloak of 30mm. Use seaming pliers.



STAGE 1



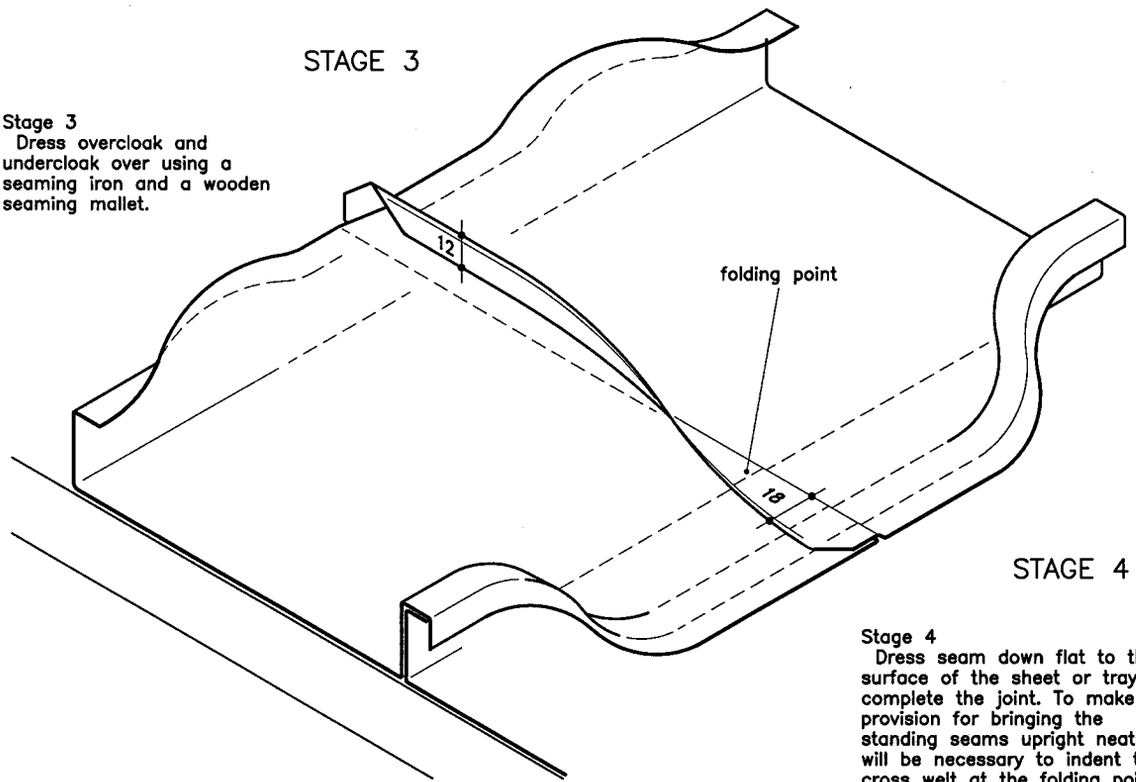
STAGE 2

Stage 2
Dress overcloak over undercloak end turn-up, using the flat end of a seaming iron, placed against undercloak, and a wooden seaming mallet.

STAGE 3

STAGE 3

Stage 3
Dress overcloak and undercloak over using a seaming iron and a wooden seaming mallet.



STAGE 4

Stage 4
Dress seam down flat to the surface of the sheet or tray to complete the joint. To make provision for bringing the standing seams upright neatly, it will be necessary to indent the cross welt at the folding point with the blade head of a hammer, to start the fold.

Stage 5
Reform the edge turn–ups flattened for Stage 1 and complete the double–lock standing seams (see Figs 1 and 2).

In reality the adjacent undercloak sheet or tray would be in position beneath the overcloak edge turn–up, but for clarity this has been omitted from the description. As drawn the copper roofing would be completed in sequence, working from right to left.

STAGE 5