



SnapTable PRO®

Manual

SnapTable PRO Manual

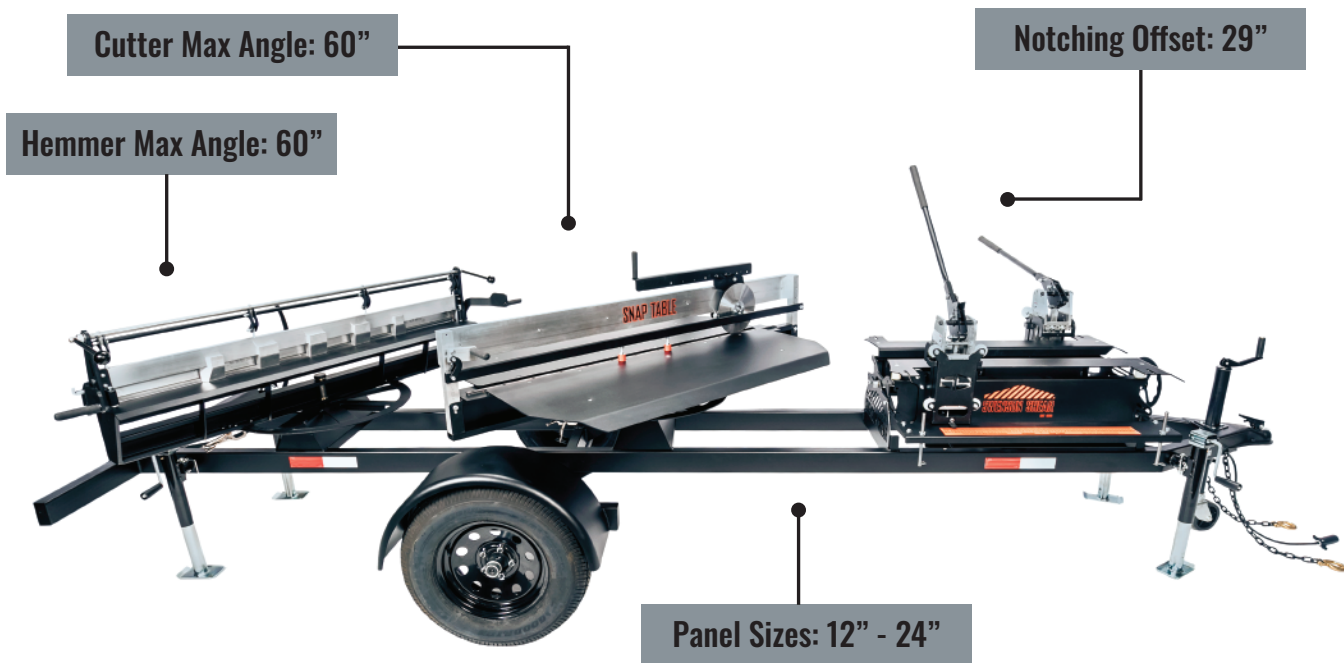


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Read the entire manual before attempting to operate this piece of equipment.

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SnapTable PRO Setup Precautions

PRECAUTIONS

Notchers - Do not lift notcher from the front as dies are sharp.

1. Make sure the safety pin is securely in place before lifting
2. The handles need to be facing up
3. Lift from handles

Slitter Blade - Keep fingers out of the way of the blade.

Although the cutting wheel and bottom blade are not sharp to the touch, they will cut if fingers are in the slitting path.

SNAPTABLE PRO SETUP

When you receive your SnapTable PRO you will also receive a components box that has all the loose parts that you will need to install onto your SnapTable PRO before you use your SnapTable PRO.



You will find four white panel guide rollers complete with t-handle, half inch by three shoulder bolt and sleeve that goes inside the white roller.

To install, you slide the carriage bolt through the slot in the corner of the notching station from underneath, slide the panel roller on top with insert in place and tighten with the t-bolt and you will do this on all four corners of the notching station.

With your SnapTable, you will have received three jacks in the box that should then be installed on the hubs located on the frame of the machine. You will also find two notcher handles inside your components box with a safety pin. To attach handles, remove the preexisting bolts and attach. Use the center hole position for initial use, handle position can be changed to suit operator's preference.

Attach Slitter Handle to outside frame of slitter carriage using the two bolts included in components box.

You will need to remove the cotter pin that's holding the notchers into that locked position. Once the notcher has been released, you loosen the $\frac{9}{16}$ bolt and lock nuts and you will see that the notcher has multiple locations depending on the height of the user to adjust for optimal operation. Use a $\frac{9}{16}$ wrench to tighten the bolts and your setup is complete.

SnapTable PRO General Maintenance



The dove tail slide should be cleaned and oiled lightly. Cleaning is required to remove surface sand or dirt. Lightweight oil is ideal for keeping the dove tail slide and lever system working smoothly. Most SnapTable PRO parts are either powder coated for weather protection or are made of aluminum to resist corrosion. Do NOT use WD40 or any lubricants that are sticky. We recommend using a CRC Food Grade Silicone spray for the dove tail slides located inside of the notcher. Household cleaning products may be used on the machine. Use a scotch bright pad for aluminum and stainless-steel parts.

WARRANTY - All tools are covered by a 2-year manufacturers' warranty. The warranty does not cover normal wear and tear. Any attempt to modify the SnapTable PRO, not advised to do so by tech support, will void warranty. Using the wrong profile will result in damaging your notchers and will void the warranty.

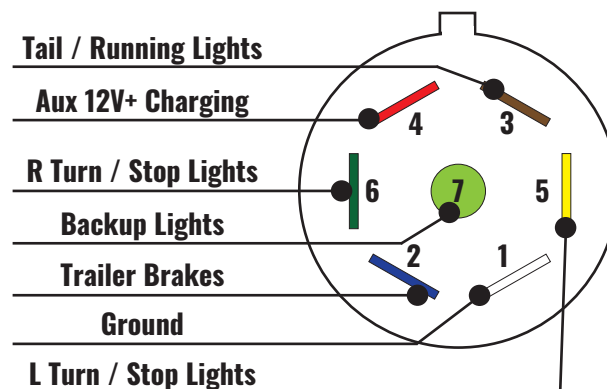
SNAPTABLE PRO SPECIFICATIONS

Length: 16 feet, 6 inches
Width: 6 feet, 9 inches
Weight: 1,150 pounds

The towable SnapTable PRO meets the Department of Transportation standards and has a two-inch ball hitch.

Trailer

(view looking at end of plug)



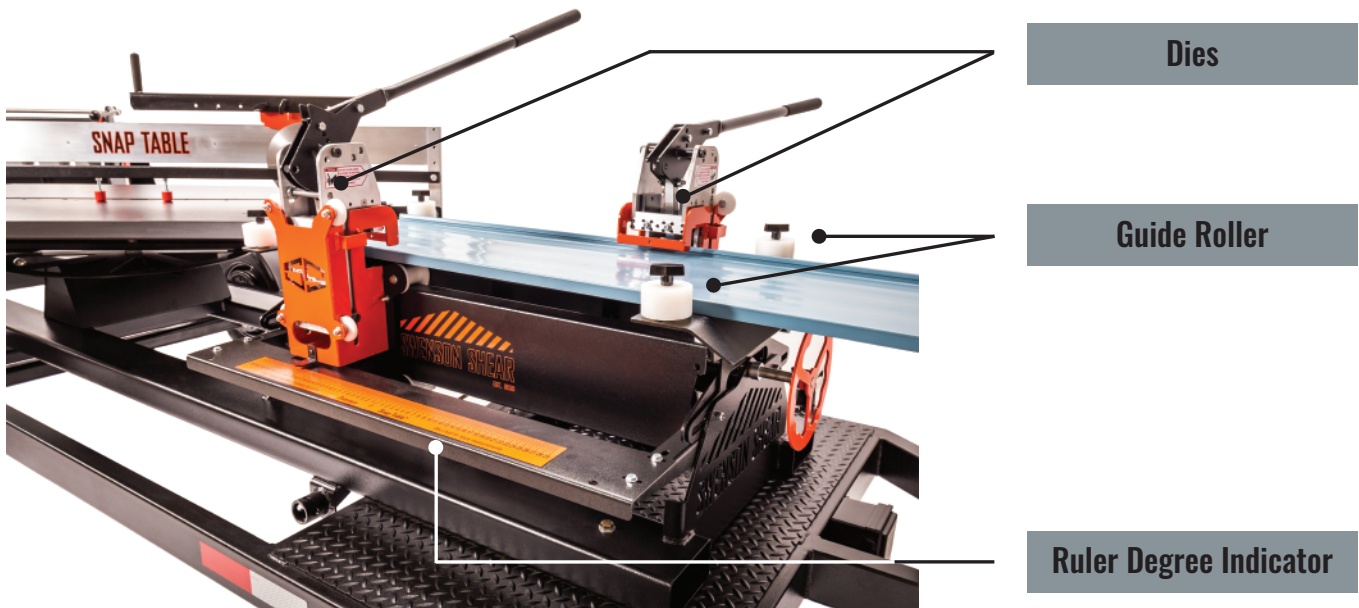
SNAPTABLE PRO TRAILER REGISTRATION

You will receive a manufactures certificate of origin in the mail along with the invoice. Register your trailer at your local DMV office as "Special Construction Equipment".

This manual will aid in the use and operation of the SnapTable, if you need additional assistance, please call Swenson Shear's Technical Support Line: 877-588-8748, option #2.

Due to the specificity of our tool, we have created technical support videos for your use. These can be found on our YouTube Channel and Website.

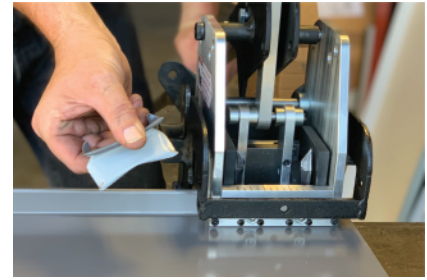
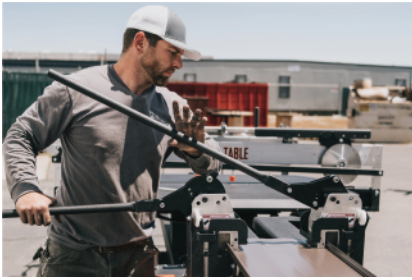
Preparing Notching Station For Use



1. Loosen the T-Handles at the front of the table, and under the ruler, table to allow notcher travel and rail width adjustment.
2. Loosen the white plastic guide discs on the four corners of the SnapTable PRO and move them inward on the slots until they fit against your panel.
3. Position notchers across from each other at the "90" offset position (0 on the ruler degree indicator) with handles away from operator. You will need to square your notchers prior to use (see note below for instructions).
4. With notchers in the open position, slide the panel onto the table and, using the wheel on the front of the table, adjust the table width so that the panel ribs line up approximately with the notcher dies.
5. Make sure your male and female ribs coordinate with the notchers and that each panel rib fits snugly in the notching dies. To check this, lower the dies onto the panel until seated, but refrain from cutting through.
6. With both notchers settled over the panel ribs, lock the panel width adjustment by tightening the T-Handle at the front of the table found on the right of the wheel.
7. Adjust the white guide rollers on the four corners of the SnapTable PRO inward toward the panel. Guide rollers should be touching panel to keep it on track. Tighten the bolts.
8. Raise both notchers to the open position. The table is now correctly adjusted for your panel width and is ready to use.

NOTE: Notchers are squared prior to shipping but will need to be checked prior to use. In order to square your notchers, you need to make sure that the concentric on the carriages are tight against your notchers so the notchers cannot move inside the carriage. Once they are tightened you can square your notchers by using a straight edge square. Once the notchers are squared, lock notchers in place and adjust ruler to zero out the notchers. The male notcher is typically positioned on the ruler side of the table. The above exercise is crucial for proper handling of your table. NEVER force notchers to cut. Try repeating the above adjustment procedures to assure correct alignment of the notcher dies and panel rib.

How To Use Notching Component



1. Adjust the width of the notching table using the front wheel to match your panel width. The dies should be directly over the ribs.
2. Set notchers to the desired slope using degree indicator on the operator side of the machine.
3. Starting with the non-operator side, lower the notcher handle until you feel the dies 'bite' the panel and keep it in place.
4. On the operator's side, bite the panel and keep it in place.
5. Swapping back to the non-operator's side, fully notch the panel by bringing the handle all the way down until it has cut through the panel.
6. Now pull the operators side handle until it cuts all the way through the panel.
7. With the notcher still in the closed position, remove the coupon (blank piece of rib that has been notched out of the sidewall).
The female blank may stick in the notcher, it may be necessary to raise the notcher 1-2" and lower it again to loosen this coupon.
8. Return both notchers to the open position which leaves your handles facing away from the operator's side of the table.

Note: Not removing the coupon after every use may damage your notchers.

HOW TO SET UP NOTCHERS TO DIFFERENT SLOPES OR PITCHES

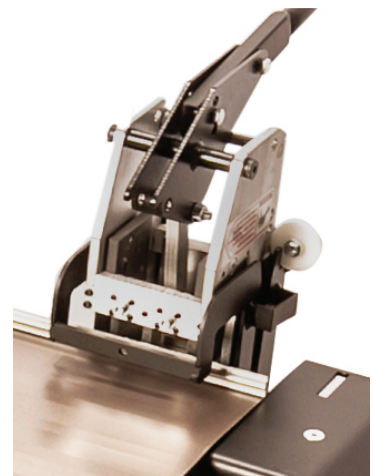
Off-sets are changed by using the off set calibrated ruler on the operator side of the table. Select the column on your offset chart that corresponds to the total panel coverage of the panel. Set the pointer on the notcher to the correct offset position on the ruler. Once desired angle is found, tighten the T-Handle on the underside of the ruler bracket to ensure notchers do not move from set position. *Reminder: The opposing notcher moves concurrently in the opposite direction so each movement of the notcher is doubled.

HOW TO SWAP FROM STANDARD TO ANGLED

What you need:

- $\frac{9}{16}$ Wrench
- Extension
- Ratchet

1. Slide carriage over to the side so you're out of the way of the cross beam.
2. Remove the bolts that go through the top of the carriage, you will need to loosen the NY lock nut from the bottom of the carriage. Note: leave the bolt and 2 washers, they are spacers.
3. Remove the bolts on the front, the bolt will stay in.
4. Grab the angled notcher (be careful with the knives – they are sharp!), put the 2 bolts through the sub-carriage and slide the angle notcher forward over the bolts.
5. Reinstall the bolts by starting them by hand and tighten.

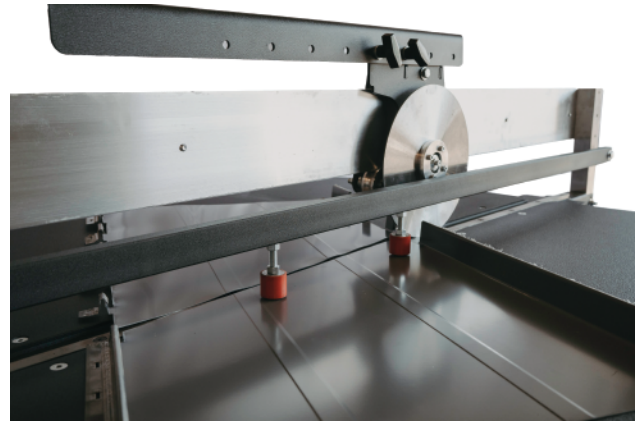


HOW TO SQUARE YOUR NOTCHERS, NOT YOUR PANEL

If your notchers wobble or if they are getting stuck on the panel to where it can't fall through, it could be because notchers aren't squared in carriages. All you need is a $\frac{3}{4}$ " wrench. On the inside of the rollers there are spacers, you only need to adjust the top spacer. Using the wrench, slide it in between the roller and the frame, twist half a turn on each side until it is snug.

Disclaimer – using the wrong profile will damage the notcher.

How To Use The Slitting Component



AFTER THE PANEL IS NOTCHED

1. Park the slitter blade on the side of the table opposite your position. NEVER push slitter blade across the panel to shear, ALWAYS pull slitter across the panel towards you.
2. Slide the notched panel down the table to the slitter.
3. Adjust the slitter to the desired slope.
4. Pull the slitter across the panel slowly and smoothly. Trying to cut too fast may compromise the quality of cut.

Note: If oil canning occurs, raise the slitter blade.

ADJUSTING SLITTER BLADE

The Slitter Blade will only need to be adjusted when changing panel thicknesses. For thicker panels, drop blade down, for thinner panels raise the slitter blade.

Never go above an 1/8" reveal. Slitter is not intended to cut through ribs.

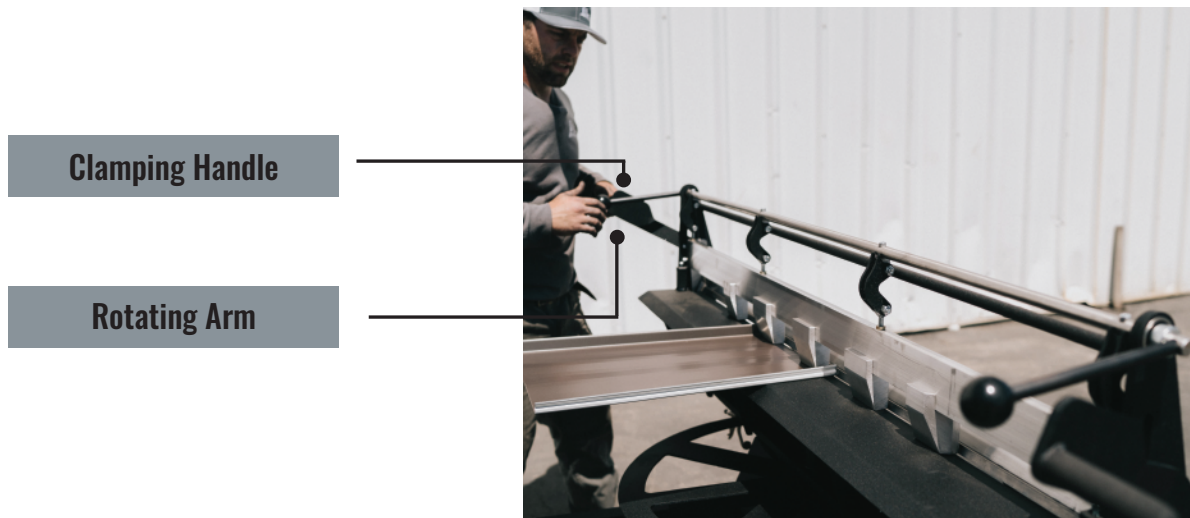
1. Using a $\frac{9}{16}$ wrench, loosen the lock bolt.
2. Loosen the nut between the aluminum post and the metal frame.
3. Depending on blade depth, loosen the bolt to tighten the nut or vice versa. Repeat the same steps on the opposite side of the slitter.
4. Tighten the lock bolt on both sides prior to use.

ADJUSTING FOR DESIRED ANGLE

1. Unclamp the Vice Grip beneath the Table
2. Adjust to the angle needed
3. Tighten the clamp on the Vice grip and lock into place

Maximum cutting angle - 60 inches

How To Use Hemmer Component



AFTER THE PANEL IS NOTCHED AND CUT

1. Slide notched panel down to the hemmer station.
2. Make sure the station is set to the appropriate slope.
3. Slightly lift the operator handle at the top to allow the panel to hit the back of the fencing of the hemmer bar.
4. Clamp panel by pulling the handle in a downward position until you feel it lock into place.
5. Grab rotating handle and move in a circular motion. The panel is now hemmed.
6. Unwind rotating handle back towards the original position.
7. Slide panel off hemming die and move forward through hemmer.

**If you would like a tighter hem, return the hemmed panel to the hemming station and press down with the hemming bar.*

ADJUSTABLE SHOES

The shoes allow for even amount of pressure across the panel for the perfect hem. These shoes should be adjusted depending on the length of the hem you are trying to create.

TO ADJUST SHOES

All that is needed is an allen wrench. Loosen the nuts to slide the shoes around. To completely remove the shoes, remove the nuts and pull the shoes off.

ROTATING TABLETOP

Tabletops can be rotated 180 degrees for a trailing edge hem. Just unclamp the vice grip and re-clamp when you've reached the desired angle.

Maximum Hemming Angle - 60 inches

SnapTable PRO Helpful Hints

- When notching your panel, set the "female side" by pulling it towards you slightly biting the panel. Notch your "male side", followed by the female side then release the panel by pushing the handle away from you. From here, you will be able to pull your panel through to the next station. *Sometimes your panel may stick to the notchers and most times this is simply due to the force of notching. You will need to push down on your panel to get the panel to unstick. Recheck your alignments to be sure there is not too much give.
- Would recommend doing all straights, then adjust and do angles (ex. 2/12, then 6/12, then 8/12).

FREQUENTLY ASKED QUESTIONS

How do I hem a trailing edge instead of leading edge?

Rotate the Hemmer to 180 degrees for trailing edge hems.

What if I do multiple profiles?

One set of notchers are included with each SnapTable PRO purchase. Additional notchers are available to accommodate multiple profiles.

What if I need to close the rib of the standing seam panel?

Follow these steps to create your tab over:

- Once notchers are set at correct offset, shift the notcher to add an additional inch on female rib.
(Example: if you are doing a 9/12 valley- move to 10/12 on offset chart). This allows you to snip back 1" of female rib to create the tab bringing you back to correct offset.
- Notch, then cut panel to length.
- Use your Tin Snips to cut 1" back on pan against the rib, cut top of rib back 1", cut up and remove outside of rib, then fold it over with your hand. Snip excess to clean up tab.
- At the hemming station, both sides of standing seam must hit flush against fencing inside the hemmer. Clamp down and hem over.

What gauge thickness will the machine allow for?

The suggested maximum panel thickness is 20-gauge.

How do I swap profiles?

For a standard set of Notchers, insert safety pin and lift the notcher directly up to remove notcher from carriage, then insert new notchers into carriage.

To change from a standard set of nothcers to an angle set, you will need: $\frac{9}{16}$ wrench, extension and rachet.

- Slide carriage over to the side so you're out of the way of the cross beam.
- Remove the bolts that go through the top of the carriage, you will need to loosen the NY lock nut from the bottom of the carriage. Note – leave the bolt and 2 washers – they are spacers.
- Remove the bolts on the front, the bolt will stay in.
- Grab the angled notcher (be careful with the knives – they are sharp!) put the 2 bolts through the sub-carriage and slide the angle notcher forward over the bolts.
- Reinstall the bolts by starting them by hand and tighten.

Can I do an up hem?

Yes

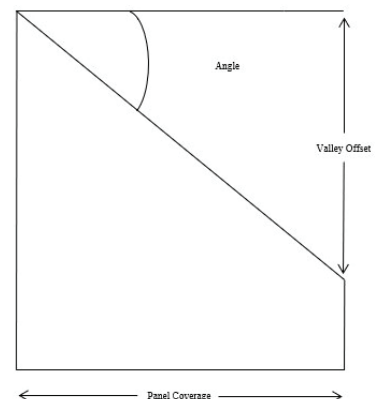
- Fully open the hemmer and pull out the hemming bar.
- Using the higher handle (nobbed one) and push that back to its original position.
- Finish bringing the lower handle down.
- Slide the panel through and clamp down.
- Rotate the lower handle slightly up, while holding it, grab the hemming bar and rotate until its flat against your panel.
- Hem up.

Hip and Valley Offset Chart

1. Select column on top representing the panel coverage width in inches.
2. Select the slope of the roof in the left column.
3. Match row and column to find the offset required on the SnapTable ruler for the angle desired.
4. Move notcher pointer to the calculated offset number on the SnapTable ruler.
5. Bump notchers as necessary to correct for construction variations affecting the angle of cut.

HIP/VALLEY		PANEL COVERAGE										
Pitch	Angle	12	13	14	15	16	17	18	19	20	21	22
Short to Long Offset Distance (Spread between short and long dimension)												
1.00	45.10	12.04	13.05	14.05	15.05	16.06	17.06	18.06	19.07	20.07	21.07	22.08
1.50	45.22	12.09	13.10	14.11	15.12	16.12	17.13	18.14	19.15	20.16	21.16	22.17
2.00	45.39	12.17	13.18	14.19	15.21	16.22	17.23	18.25	19.26	20.28	21.29	22.30
2.50	45.61	12.26	13.28	14.30	15.32	16.34	17.37	18.39	19.41	20.43	21.45	22.47
3.00	45.87	12.37	13.40	14.43	15.46	16.49	17.52	18.55	19.58	20.62	21.65	22.68
3.50	46.17	12.50	13.54	14.58	15.63	16.67	17.71	18.75	19.79	20.83	21.88	22.92
4.00	46.51	12.65	13.70	14.76	15.81	16.87	17.92	18.97	20.03	21.08	22.14	23.19
4.50	46.88	12.82	13.88	14.95	16.02	17.09	18.16	19.22	20.29	21.36	22.43	23.50
5.00	47.29	13.00	14.08	15.17	16.25	17.33	18.42	19.50	20.58	21.67	22.75	23.83
5.50	47.73	13.20	14.30	15.40	16.50	17.60	18.70	19.80	20.90	22.00	23.10	24.20
6.00	48.19	13.42	14.53	15.65	16.77	17.89	19.01	20.12	21.24	22.36	23.48	24.60
6.50	48.68	13.65	14.78	15.92	17.06	18.20	19.33	20.47	21.61	22.75	23.88	25.02
7.00	49.18	13.89	15.05	16.21	17.37	18.52	19.68	20.84	22.00	23.15	24.31	25.47
7.50	49.70	14.15	15.33	16.51	17.69	18.87	20.05	21.23	22.41	23.58	24.76	25.94
8.00	50.24	14.42	15.62	16.83	18.03	19.23	20.43	21.63	22.84	24.04	25.24	26.44
8.50	50.78	14.71	15.93	17.16	18.38	19.61	20.83	22.06	23.28	24.51	25.73	26.96
9.00	51.34	15.00	16.25	17.50	18.75	20.00	21.25	22.50	23.75	25.00	26.25	27.50
9.50	51.90	15.31	16.58	17.86	19.13	20.41	21.68	22.96	24.23	25.51	26.78	28.06
10.00	52.47	15.62	16.92	18.22	19.53	20.83	22.13	23.43	24.73	26.03	27.34	28.64
10.50	53.04	15.95	17.27	18.60	19.93	21.26	22.59	23.92	25.25	26.58	27.90	29.23
11.00	53.60	16.28	17.64	18.99	20.35	21.71	23.06	24.42	25.77	27.13	28.49	29.84
11.50	54.17	16.62	18.01	19.39	20.78	22.16	23.55	24.93	26.32	27.70	29.09	30.47
12.00	54.74	16.97	18.38	19.80	21.21	22.63	24.04	25.46	26.87	28.28	29.70	31.11

Disclaimer: The snaptable offset chart and ruler are intended to provide an approximate starting point for the correct angle calculation on a given roof. Every roof is different and adjustments will be necessary to account for construction variables. Swenson makes no warranty as to the suitability of a particular ruler setting to achieve the correct roof slope. Likewise, the cut angle and width of the hem are entirely dependent on accurate measurements by the operator and test cutting to assure proper fit on the roof.



10/2019