



Order of Procedure for Weathertightness  
Installation Requirements

Part I

AMB Warranty new roofing or reroof project list of AMB Weathertightness installation procedures and requirements.

Part II

AMB Weathertightness Warranty Program and Training Document

Part III

Shop Installation details for required Weathertightness

\*Sealants Note-When SM Sealants mentioned, comparable Butyl sealants may be used\*

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## Part I

### LIST OF AMB WEATHERTIGHTNESS INSTALLATION PROCEDURES/REQUIREMENTS

1) AMB provides in this Manual enhancements to installation procedures necessary for issuance of Long-Term AMB Warranty.

2) No metal joinery is to occur without butyl sealants well placed and generously installed. All metal attached to walls, other surfaces and where lapping must have adequate butyl sealants placed.

3) Long-Term Weathertightness Warranty installations must be sealed to where they will fully withstand wind pressures, winter conditions and severe rain storms. In addition, if wall panels are included in Long-Term Warranty, they are to be sealed in same manner. Any detailing of Reversed J-Clips may not be installed as they trap or back water-up, rust-out and are very troublesome. Superior application must be employed on entire job to prevent backing or trapping water at any installation condition. AMB requires continuous concealed cleating to be accomplished and not with any reversed J-clips. Continuous concealed cleating with generous butyl sealant applications in, behind and around the joinery of metal on the entire project must be installed. Drip edges with hemmed edges turned back under to receive concealed cleats and locked onto concealed cleats in lieu of J-clips are to be used on the entire project siding installation and roof flashings where applicable.

4) The original project valley flashings detailed must be modified to include AMB snow valley configuration having integrated cleat and valley in one piece and not with panel cleat and valley pan flashing individually/separately formed. Valley will mirror NRCA details for such an application. The Middle component of the W valley must be no less than 1.5-inches and / or must equal height of panel ribs.

5) Integrated valley flashing with panel cleat and valley flashing must be fabricated in one piece and will require minimum of 36-inch girth flat stock. Sealant placements must occur in all hemmed over Zee closures and over any cleat and in each case requires butyl sealant embedded in all those hemmed configurations at eaves, roof to side wall, hips and ridges, roof to head wall, pitch brake/elevation change-ups, rakes, expansion joints, etc.

6) All metal joinery, no matter where or how it occurs, must have Butyl sealants embedded.

7) All end-laps, no matter where they occur, are to have minimum of 6-inch laps with 3/16 X 2.5 inch triple bead SM 5227 Butyl tape and SM 5430 butyl Sealants.

8) All surface sealant will be color coordinated one part urethane in either NP-1 or preferably Permthane SM7108 and/or to acquire proper color, GeoCel will be accepted.

9) Cleaning all metal surfaces to receive sealants must occur with Naphtha or Xylene (N or X) clean rags, and installer may surface clean any contamination with Paint thinner and then either of N or X.

Roof surface can be slippery where using paint thinner, and for that reason, AMB recommends not having broad use of any paint thinner on the job. For slick places, use painters alcohol for final clean up or Xylene as Xylene or Naphtha flashes-off very rapidly and, thereby, does not harm paint finish.

10) Adhesion testing two or three times a day is required and especially when changing types of work being performed or if change of locations or weather conditions occur. Surfaces must be cleaned with cleaner before installing any sealants; this includes all metal sent from factory.

11) Anytime temperature drops to 40-degrees or lower, warming boxes must be used to protect and keep all sealants warm.

12) AMB is well aware Installers do not like to use Butyl Tapes or any Butyl. SM5430 specifically is not as messy as other manufacturer's tube butyls.

13) By installing beads of SM tube butyl onto the butyl tape sealants, the metal will (grease) slide in-together without any hassle and provide superior seal. This always prevents damaging the tape sealants when there is joinery metal or the roof panels are installed over T-flashing or other cleats.

14) All panel pans at terminations at top of system or behind Zee outside closures and under coverflashings are to be turned up as water dams without cutting the corners. If snipping any corners, they must be sealed at each inside corner with one part Urethane sealant or butyl.

15) Back seal outside Zee closures as well as perimeter sealed with butyl tape and butyl tube sealants are required over the entire roof installation.

16) Thoroughly perimeter seal all outside closures with tape and tube sealants.

17) All flashings must have slopes so as to drain.

18) Flashings are to be made of same gauge and type metal as the roof panels.

19) To help reduce oil canning, Installer must fabricate and use pencil rib or striated configuration in the panels. The panel will have bad oil canning if it is not fabricated with either pencil or striated configuration.

20) Only use Pop Rivets to secure end closures / caps.

21) All other fasteners must be #12 or #14 listed as longlife, one piece heads with EPDM rubber washers part way concealed up into head of fastener. Fasteners information must be provided for AMB approval process. Longlife stitching fasteners required on 8-inch centers in hems of ridge and all non-sliding hemmed to cleat/Zee closures. All metal endlaps on the entire project must have longlife fasteners set at 3-inch centerings through the sealants. All other locations must have longer longlife fasteners.

22) During on-site Orientation, AMB Inspector will review the fasteners with installer. Installer must submit Fasteners for approval.

23) If site rollforming, use attached Roll-Former panel detail for the roof installation and as well use nothing but full-length panels for roof and for walls. Must install butyl sealant in female leg of same sealant used in roof panel. Must be used on siding applications in lieu of specified flat panels.

24) This list of instructions will be reprinted in the AMB project Weathertightness installation manual being sent to Contractors/Installers and to Architect by Contractor/Installer and will be used during AMB on-site Orientation scheduled to occur as first 5% of roof panels are being installed.

25) During on-site Orientation, AMB Inspector will review details and above items with Installer.

ADDITIONALLY, PART II, AND PART III AMB PRINCIPLES OF WEATHERTIGHTNESS, TRAINING DOCUMENTS & INSTALLATION REQUIREMENTS

## Part II

GENERAL WEATHERTIGHT PRINCIPLES AND INSTALLATION REQUIREMENTS FOR AMB WARRANTED METAL ROOF INSTALLATIONS

## WEATHERTIGHTNESS INSTALLATION REQUIREMENTS

1. **Metal to Metal Laps-** Regardless of type system, location, or system detail (vertical or horizontal) on entire metal roof, project must be entirely installed by use of **non-skimming SM5227 Triple Bead Butyl Tape sealants with all in 3/16" thick & 7/8" and 2.5" wide for all applications.** Additionally **SM5430 butyl tube sealant (also available in 5-gallon pails) must be used between metal to metal glands**. Fasten with premium (**stainless Steel or long-life**) Fasteners with EPDM washered in #12 or #14 fasteners **thru sealant** at AMB and Manufacturer required spacing and order of fastening. **No other manufacturer of sealants other than Schnee-Morehead (SM) is acceptable and no other type SM sealant other than stated above is allowed to be used. Any other will cause rejection. Both sealants are white in color and shall not carry a date of SM manufacturing older than 4 months. Before application of sealants, always perform cleaning of metal surfaces to receive sealants with clean rags, Zylene / Napha, and prime with #733 Sonneborn metal primer product by Sonneborn application procedures and drying cure-time test by not tacky to the fingers. Perform adhesion tests two or three times during each day of application. Never apply sealants below 40-degrees unless sealant is kept in warmer box and warmer blanket on roof up to time of use.**
2. **Metal to Metal-** Never use sheet metal screws on metal roofs to fasten metal to metal in weather exposed conditions. This includes **any type accessories**, as in example, "dektite" flashings. All fasteners shall be as listed. This includes Pop Rivets.
3. **Panel End Laps-** Installation of **non-skimming Butyl type sealants** are required between overlapping panels and at ribs; tape mastic is required in panel lap and at top of the rib for a minimum of 12" up-slope from the end of the panel. All fasteners are into backup stiffener plates and must penetrate the sealant tape.
4. **Rib Terminations-** Install non-skimming Butyl sealant between vertical male and female legs of ribs and across all angles.
5. **Terminating End of Eave, Rake, or Roof to Wall-** Install metal end closures at all terminations, and tape mastic and urethane sealant is required around perimeter of closures. Fasteners should be stainless or long-life.
6. **Terminating End of Counter Flashing-** Box closed and filled with non-skimming Butyl sealant and fasten with stainless steel or long-life fasteners.
7. **Flashing Termination-** Flashings must never terminate at a vertical surface with a "knife" edge. Use counter flashings or other counter measures to seal "knife" edge.
8. **Closures-** Accurately fit snugly, with specified butyl sealants, closures at ridge, hip, high side eaves, high side roof to wall and side roof to wall flashings. **Install SM5227 butyl tape mastic at full perimeter of all and any closures and being the bottom - the top - the ends of closures which is the side of ribs for a full seal. The closure ends are to have an end flange the same as the top and bottom flanges when field fitting the closures.** SM5430 Butyl caulking may be used on the top of tape to accomplish solid seal and help slide the closure in place. All closures must be fastened behind closure in bottom flange and through the panel with a minimum of five (5) fasteners in the flat of panel or **no more than 2.5-inches apart** and with one (1) at each end of the closure near the rib. Seal all overlapping or end butted joints of closures with butyl tape mastic and butyl caulk sealants, depending on the panel configuration and Manufacturer's specification. **Installer must install generous amounts of butyl caulking and / or extra short (pig tail length) piece of butyl tape over top of all ribs in line with top flange of closure before installing the cover flashing over the closures filling all hems with butyl caulking. Should any of the above be left off / deleted from the installation, the roof installation will be rejected.**
9. **Clip Fastening-** Fasten all clips with two (2) fasteners per clip into sub-structure to prevent rotation and any potential binding of movable parts for expansion.

- 10. Moving Parts**- Do not use any pop rivets on horizontal moving surfaces of panels or clips. Approved fasteners are to be stainless washered fasteners
- 11. Vented Ridge, Hips, & High Side Roof to Wall**- AMB does not support use of Vented ridge on metal roof installations. When installing Vented ridge be sure Water diverter (water dam) extends well back inside & under cover flashing and is back sealed into cavity and with an upwards water dam at angle with tail end turned upward as hook min. of 1.5" to 3".
- 12. Panel Fasteners**- All fasteners installed in the flat of the panel should be installed at a maximum of 6-inch O.C. and many locations at 4-inches O.C. All fasteners should be stainless steel or long-life. Fasteners must be placed so that they penetrate the #65 Butyl tape applied between the panels or parts being fastened.
- 13. Replacement Fasteners**- Stripped, crooked or damaged gaskets or fasteners must be replaced with the next larger long-life washered premium fasteners.
- 14. Holes**- Any fastener hole or required patches of holes bigger than the maximum available screw shank diameter must be repaired with a washered patch over the hole. Location does not play a role in how this repair is affected unless the fastener is going to penetrate a purlin, and then the purlin must be missed, unless it is the point of fixity for the panels.
- 15. Fasteners**- Stainless Steel or Long-life Washered fasteners of #12 or #14 must be used. Any fastener, regardless of location, that is over tightened, not fully seated on the washer or damaged **must be replaced. Caulking Is Not Acceptable Over Any Fastener.**
- 16. Hems W/Cleats or Base Plates & Hem combinations**- Always solid fill hems with SM5430 Butyl tube sealant.
- 17. Curbs & Dektites**- Fasteners at these locations should be at maximum 3" O. C. for all curb installation and 1-1/2" up to 2" O. C. for Dektites. All fasteners must be stainless steel or long-life stitching fasteners. All curbs and Dektites should be installed with SM5227 3/16" X 7/8" Butyl tape mastic with non-skimming SM5430 Butyl tube sealant. 3-inch and greater flanges must have 3/16" X 2.5" & 3/16" X 7/8" SM5227 Butyl tape side by side installed.
- 18. Curbs**- Never install curbs so as to block drainage between ribs. Always provide diverters or terminate ribs up-slope to allow for adequate drainage.
- 19. Curb Fastening**- Do not attach curbs to purlins or any supporting sub-structure. Fasten all curbs to the panel to maintain the integrity of the "floating" system.
- 20. Penetrations**- Divert installation of all vent stack penetrations so that they penetrate the roof panel in the flat at least 3-inches away from Ribs for good drainage. Never penetrate panel through any rib location.
- 21. Eave Strut Flashing**- All corners of eave strut flashings and rake flashings must be treated as separate flashings and sealed accordingly. Refer to requirements for metal lapping and capping.
- 22. Flashing Caps-Counter Flashings**- All flashings must be a minimum of 4" wide.
- 23. Flashing (Endlaps) Overlaps**- All flashing overlaps for any lapping application must be sealed with SM5227 tape and SM5430 tube sealant with 6" minimum lap.
- 24. Drip-edge & Overhang**- All flashings at hips, ridges, high side eaves, high side roof to wall, curb flashings, rakes, etc. must have a minimum 7/8" overhang drip edge.
- 25. Gutter Installation**- Install gutter brackets at recommended spacing, 2.5 feet to 3 feet O.C. to prevent sagging. Straps placed on top of panels must be installed using tape mastic to prevent leakage. Use stainless steel or long-life fasteners. **Gutters are never covered in any Weathertight Warranty.**
- 26. Panel Seaming**- Seaming panels must extend fully from the eave to the ridge. Hand seam any area not accessible to machine seaming due to cover flashings, curb, wall, eave or other obstacles.
- 27. Damaged Side (major rib) Seams**- Any side seam damaged by kinking or seamer damage must be repaired using a Manufacturer



approved (rib cap) patching cap. Fastening is to be at 12" O.C. minimum through the seam itself and at 12" along the length of the cap. Repair cap should be installed with SM5227 tape mastic between panel and cap and fastened with stainless steel bolts with integral washers and cap nuts.

28. **Hip Ends**- All hip ends terminating at eave corners shall be fully sealed off using non-skimming Butyl or urethane sealant.
29. **Valleys**- At eave locations in valleys, a drip edge, **minimum of 1"**, must be maintained. Drip edge must be butyl tape and tube sealant sealed under the valley flashings along both inside eave flashings at inside corner.
30. **Valley End Laps**- End laps must always be **12-inch** and secured at each side of center line to prevent separation. Use stainless steel or long-life washered fasteners on maximum 2" O.C. and make sure **fasteners penetrate lowest down-slope row of a double row (triple row of SM5227 tape on slopes 4-inches or less or buildings higher than two stories) of SM5227 triple bead butyl tape. SM5430 tube sealant must be placed between two or three rows of tape mastic set in endlap.**
31. **Systems 6 in 12 Slope & Greater** do not require fasteners in valley laps, but most install fasteners min of 2.5-inches O.C. in the lap through the sealants. When the Valley laps are fit, snugly solid and without voids, Lap Fasteners may be eliminated if over 6:12 slope. Use beads SM5430 sealant on top of SM5227 tapes to assist sliding metal parts into place and eliminating voids or damage to butyl tapes.
32. **Panel & Flashing Cutting**- Cutting off any panel or flashing with metal cutting blade saw or gas saws or hack saw is not permitted. Always use appropriate cutting tools, such as, nibblers, snips or shears. These approved tools provide the correct cut to protect adjacent material from damage and to have undamaged metal and paint. Paint touch-up normally is required. Any panel or metal cut that is not a factory cut or not hemmed over is a **Knife edge**, and Knife edges are to be sealed over with color matching surface sealants or covered over by installation of metal Cap flashings.
33. **Panel Separation**- During installation of panels, should any separation appear at the

base of the ribs or other locations, these areas must be sealed. Use additional fasteners to secure the area or clean and re-install the affected area entirely. This must be done prior to installation or re-installation of additional components.

34. **Sealants**- **never apply externally exposed surface sealants to correct any panel improperly fitted or screw improperly applied. Remove, clean and re-install affected area using described proper installation methods with over-sized fasteners.**
35. **Common Sense** - At all times use common sense in installation methods. All of the above general guidelines are to be used with a common sense approach. For example, if spacing of fasteners is producing separation of panel-to-panel connections, increase the number of fasteners to maintain consistent pressure and seal on tape mastic.
36. **Clean-up**- Remove all debris, metal shavings, metal nibbling shavings and drill shavings at end of every day. Sweep roof thoroughly daily, or more often in damp or rainy conditions. If sweeping is not possible, wash roof down with low pressure water source. Shavings will rust and stick to metal roof over night.
37. **Sketches**- Please refer to your project installation plans and drawings. Always go to the project Manufacturer or AMB when in doubt about any installation detail. The Plan details within the AMB documents are for typical project conditions.
38. **Installation acceptance**- Failure to comply with any AMB weathertight principles and installation requirements for metal roof installations and / or repair work will normally cause **immediate rejection of non-conforming work with entire project installation rejected until the work is accomplished in compliance with AMB Weathertight installation requirements and as applicable, to each and every project.**
39. **Required materials**- Metal forming equipment must carry UL / FM listing, metal panel system must carry UL / FM listing or at least be under application for UL listing and sending documentation of all requirements to AMB. All Butyl sealants are to be manufactured by

Schnee-Morehead (SM) and using only SM5227 Butyl Tape mastic and SM5430 butyl tube or 5-gallon sealants. Surface sealants may be SM7108 or Sonneborn NP-1 or GeoCel 2300 tube sealants in matching colors to panel color. No surface sealants are allowed in metal to metal seals. Do not use Butyl on metal surfaces exposed to UV. All fasteners must be UL listed and manufactured of Stainless Steel or Long-life rated material listed by supplier at point of purchase as LONGLIFE.

**40. Valley Size and Valley End Laps-** End laps must be 12", snugly fitted and secured at each side of center line to prevent separation. Because of winter ice conditions that may form in the valleys, the Installer is to leave off the fasteners, but to seal each and every valley lap with a quadruple line of butyl sealants. Only as a "have to" case, where voids in lap exist, can stainless or long-life fasteners be used in Valley endlaps, making certain fasteners penetrate the tape mastic and butyl sealants freshly placed between the two metal parts. **The valley is to be shop broke out of three (36-inch) foot wide flat stock so to fashion an integrated cleat into each side of valley to receive hemmed roof panels and to have a greater open valley, all accomplished with use of larger girth flat stock.**

**41. Panel & Flashing Cutting-** Cutting any panel or flashing with gas saws or hack saws is not permitted. Always use appropriate cutting tools; such as, nibblers, snips or shears. These approved tools provide the correct cut to protect adjacent material from damage and provide minimal damage at point of cut with the paint at the knife edge; this prevents rust problems from occurring. Also install Cap flashings over any flashings with knife.

**42. Sealant Use- Never Apply Externally Exposed Sealant To Correct Any Panel Defect Or Screw Improperly Applied. Remove, Clean And Re-Install Affected Area Using Proper Installation Methods As Defined In This Document- Refer To Limited Surface Caulking Procedures.**

**43. Clean-Up- Before and after Installing -** At any location to receive sealants, clean and prime the glands to receive sealants. By use of a Garden sprayer and Napha or Xylene, flush out all locations to receive new seals and use metal primer on clean rags to prime all surfaces

as well. The suggested cleaning fluids flash-off rapidly, lessens hazards, and cut the contaminations and old sealants very quickly. **When work is complete** - Remove all debris, metal shavings, metal nibbling shavings and drill shavings at end of every day. Sweep roof thoroughly daily, more often in damp or rainy conditions. If sweeping is not possible, wash roof down with low pressure water source. **A good practice is to provide your tradespeople with battery operated auto vacuum cleaners and have them at the place of installation activity. Supervise employee immediately on the progress of work vacuum-up, ensuring all metal particles and shavings which are created at every portion of the work are cleared up.**

**44. Underlayment and Seals in Ice & Watershield**

– At all flashing locations opened and removed and / or where roof panels have been removed, the entire exposed area is to have an uninterrupted layer of stick-down Ice and Watershield applied. Also where the roof abuts any vertical (object) projection, such as, curbs, walls or pipe and duct the ice, Watershield is applied to turn up side of the vertical object a minimum of four (4) inches and leading edge and corners caulked-off (with modified plastic cement in tube or trowel grade) to perfect superior seal. Projection of existing masonry walls shall have a second layer (flashing) of ice and Watershield applied on the vertical surface exceeding the first layer top edge by one inch and down the wall to a four (4) inch (leg) turn onto the more horizontal surface of the roof itself with corners caulked-off (with modified plastic cement in tube or trowel grade) to perfect superior seal.

**45. Cover Flashing Creating Open Cavity**

– All locations where installation of cover flashings creates small to larger open cavity will not be accepted unless such locations have been fully filled (stuffed) with non-faced treated Fiberglass wool before placement of Cover flashing. Example of locations to be filled: **1) High-side (mono slope) Eave**-behind panel end-dam closure to outside eave cover, **2) Ridge**- to place in-between panel end-dam closure to panel end-dam closure each side of ridge, **3) High-side roof to wall**-behind panel end dam closure to masonry wall, **4) Sidewall to roof**-behind Z closure to masonry wall and **5) Rake**-behind closure to outside rake cover.

**46. Project Documents and Procedural Requirements** - Please refer to original project specifications as above AMB Installation Weathertightness procedural Items with procedure details all correlated. The sketches within this document are for typical condition reference for localized repair.

**47. Punch-Out, Clean-up, Paint Touch-up and Installation Discrepancy** - Failure to comply with any of the above Weathertight principles and installation requirements for metal roof installations and / or repair work will normally cause immediate rejection for any location for non-conforming work, but in the case of this project, will create rejection of the entire project installation until the work is accomplished in compliance with the original project documents. AMB above requirements and Manufacturer's requirements as applicable with the current project repair documents have the greater authority and standards to comply with. Final cleaning and punch-out is to include surface damage repair including paint touch up in accordance with Manufacturer's paint repair specifications using the finish Manufacturer's prescribed touch-up product. Do not wait to end of project to acquire. Severe damage will require panel or damage roof component to be removed and replaced.

**PROJECT WEATHERTIGHTNESS CLOSE-OUT:**

**48. Final Acceptance - Acceptance Of Project Shall Only Occur Upon Passing Final Inspection or Re-inspection with AMB Weathertightness Installation Having No Outstanding Efficacy Providing Any Required Closing Documents. Final Inspection And/Or Any Required Re-Inspection Must Have the Responsible Contract Parties In Attendance. Required Re-Inspections Will Create Additional Costs.**

**49. Assistance** – In the event there occurs lack of understanding as to how to accomplish corrective action at any one condition,

**Contractor must stop work** on such condition and seek clarification as to how to proceed. An AMB Consultant will be available by phone, E-mail and fax to assist. **At any time the Inspector is not on project and Contractor is in need of assistance AMB should be immediately contacted.** During the pre-construction Orientation, parties directly involved with the roofing project shall exchange contact names and phone numbers. AMB will conduct a pre-construction orientation at which time will occur both project sit-down document and roof-top reviews.

**50.** Mock-ups of all flashing conditions as exist on the roof will be developed before making the flashings up. Moreover, the project requirement may call to make-up a mini scaled roof with all flashing conditions including any valleys as detailed prior to starting subject project. Always check first.

**51.** When needing help with a special detail condition, make sketch of it on the job and send the detail and photo(s) by PDF to AMB together with sketch as to proposed configuration of the conditions.

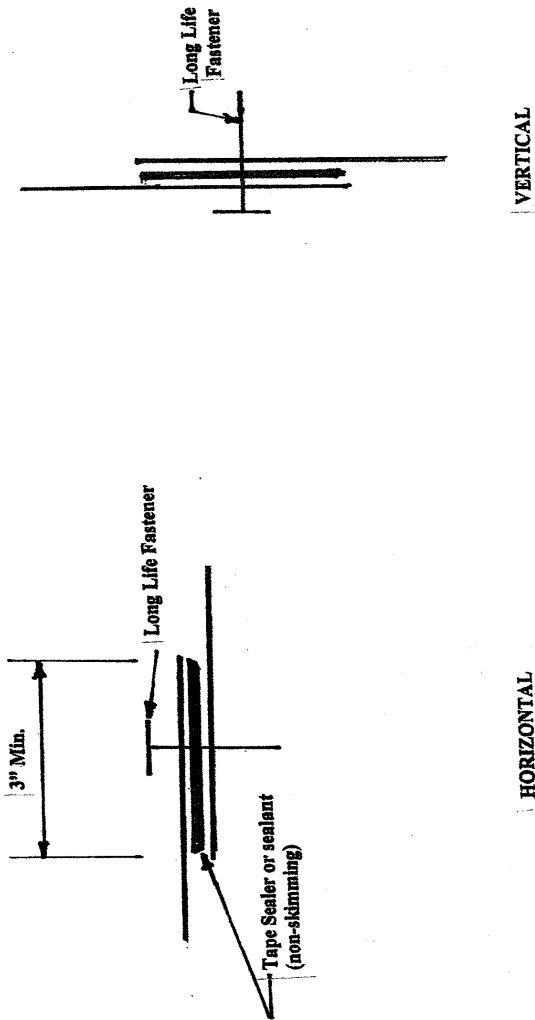
**52. Required materials-** Metal forming equipment must carry UL / FM listing, metal panel system must carry UL / FM listing or at least be under application for UL listing and sending documentation of all requirements to AMB. All Butyl sealants are to be manufactured by Schnee-Morehead (SM) and using only SM5227 Butyl Tape mastic and SM5430 butyl tube or 5-gallon sealants. Surface sealants may be SM7108 or Sonneborn NP-1 or GeoCel 2300 tube sealants in matching colors to panel color. No surface sealants are allowed in metal to metal seals. Do not use Butyl on metal surfaces exposed to UV. All fasteners must be UL listed and manufactured of Stainless Steel or Long-life rated material listed by supplier at point of purchase as LONGLIFE.



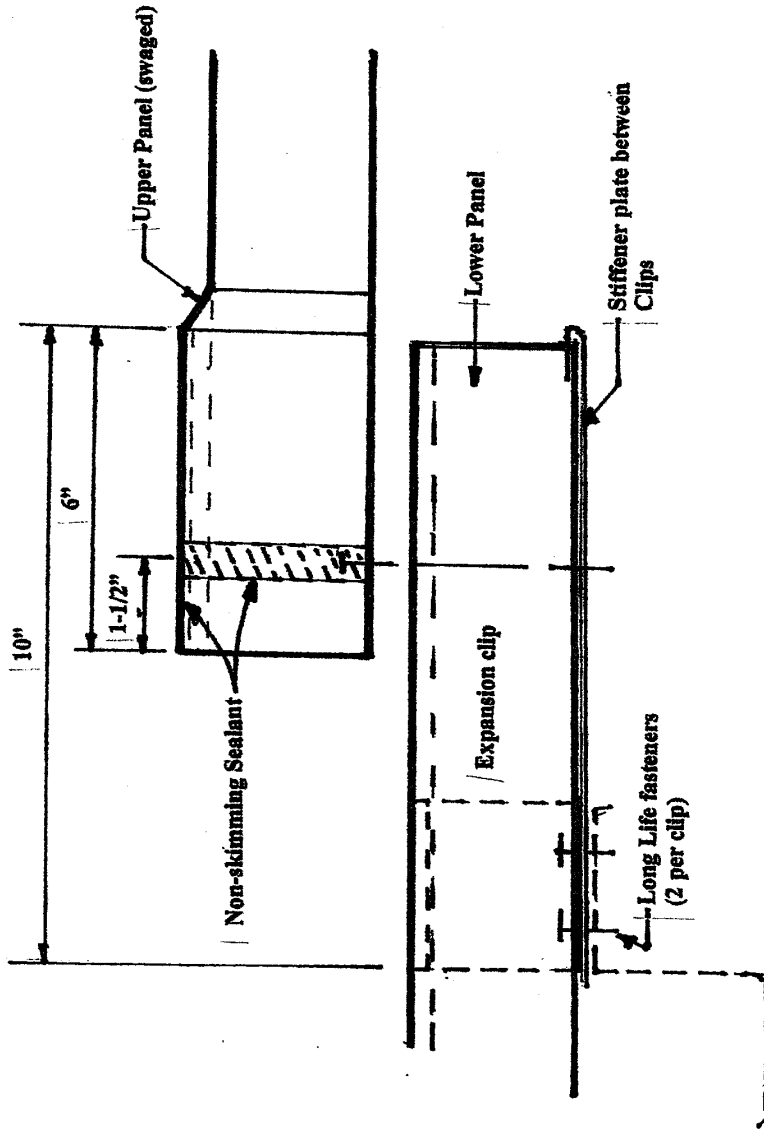
### PART III

#### INSTALLATION DETAILS FOR REQUIRED WEATHERTIGHTNESS

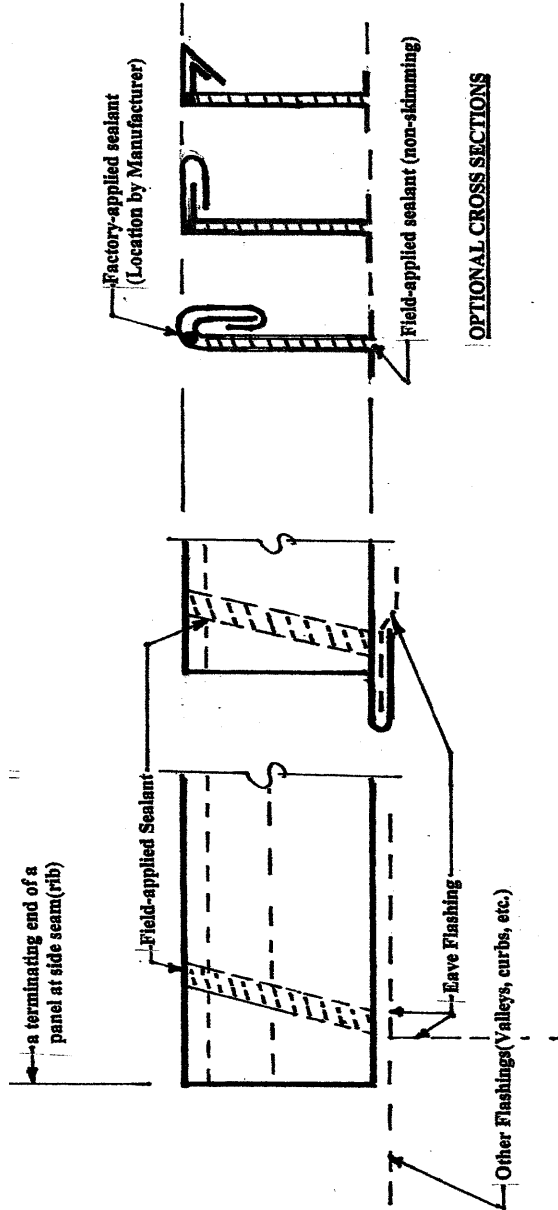
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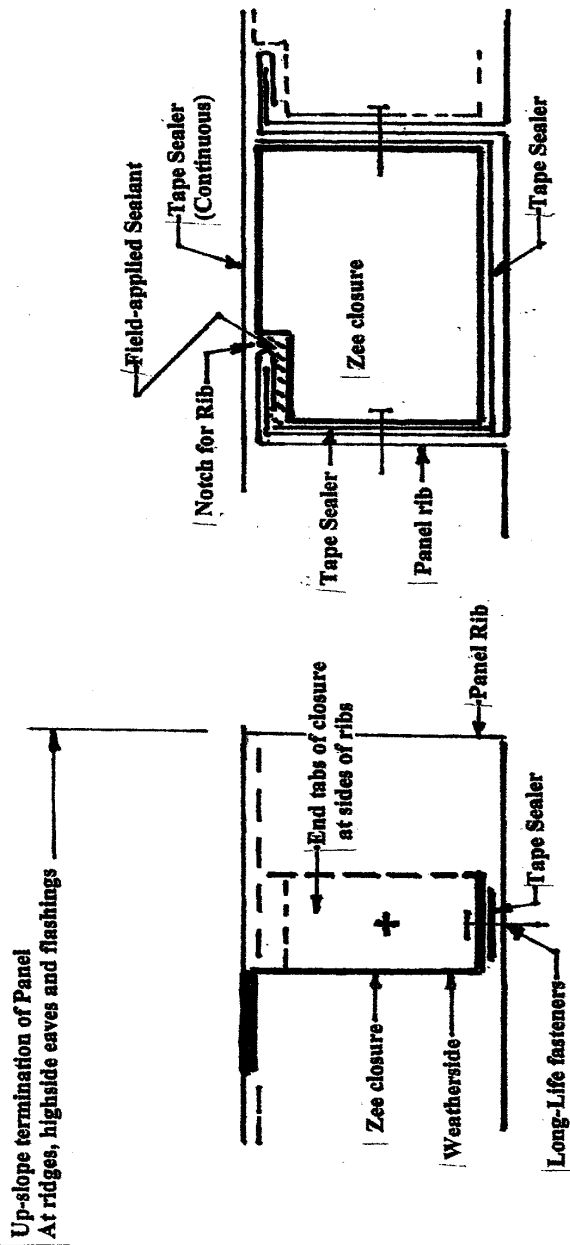
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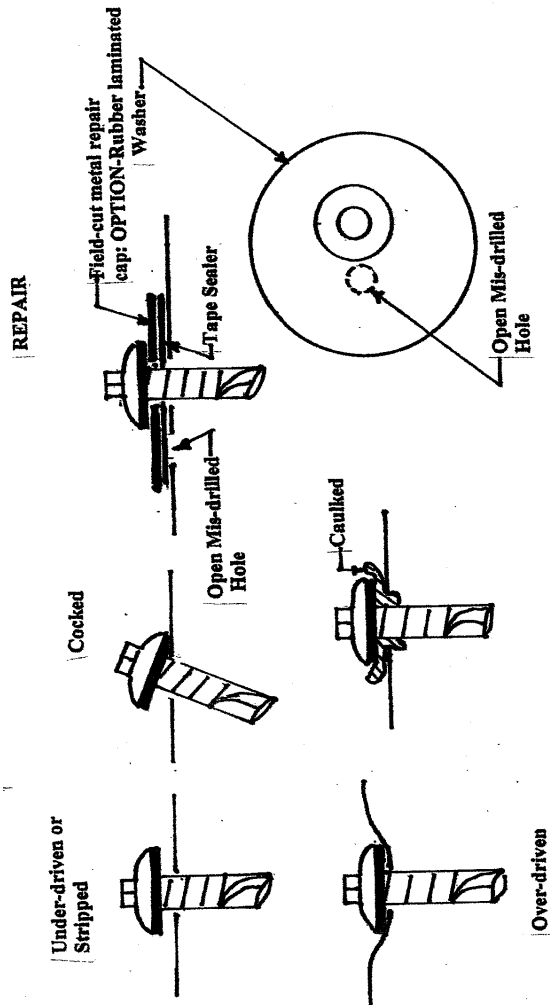
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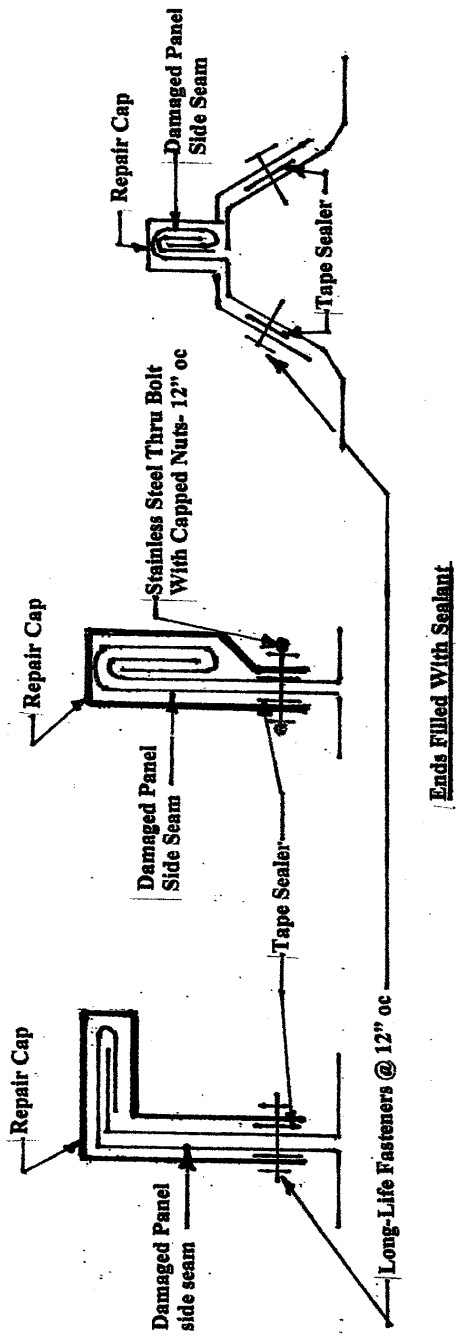


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## **DISCLAIMER!**

All details and illustrations used in this manual are for examples only. AMB has made every effort to assure that the details are representative of proven water tight principles. Although many details may look similar, no one company has been used to promote its product over any other company.

AMB reserves the right to change, alter, or modify any of the details written or sketched as used in this Standard Weathertightness Program Manual. These changes would occur in specific installation details for customized training sessions for different manufacturers.

## **INSTALLER WARNING!**

The intent of this Standard Weathertightness Program Manual is to provide you, the Installer, with an understanding of basic weathertight installation principles. These are general principles and are intended for use on any performance rated metal roof panel. The Installer is always responsible for all safety issues on the jobsite, as well as any other regulations, either local or national in scope. Not in any way, either expressed or implied, does AMB Warranty II, LLC. (AMB) assume or undertake to perform any of the Installer's responsibilities, legally or contractually.