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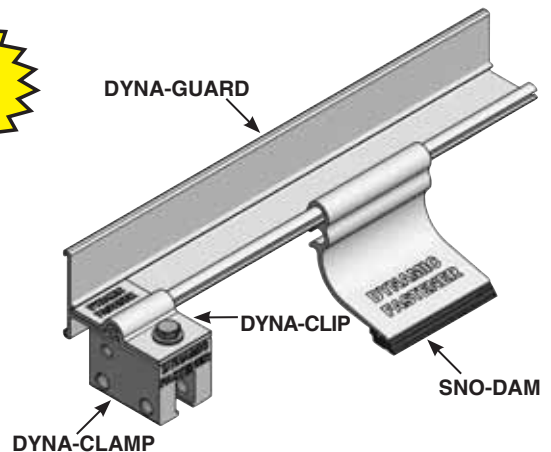
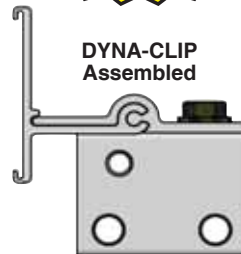


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Congratulations to Aaron Zook
of Greensfork, Indiana, who
won a \$100 gift card in the
SWM Subscription Giveaway.
Aaron subscribed three of his
associates who had not already
been receiving our magazines.



METAL ROOFING MAGAZINE

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ON THE COVER:

Photo courtesy of AceClamp®.
Cover design by Kevin Ulrich.

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Onward and Upward

As the world (or at least the United States) continues to open and we attempt to settle into a “new normal,” we find ourselves in a unique situation ripe with opportunities.

We’ve heard from some companies that business is better than ever and they are having a hard time keeping up. If you’re experiencing a slower time instead, this could be your chance to add products and/or services to your line or even to refocus your marketing efforts.

Perhaps you’ve considered adding solar installation as a service you offer—flip to page 18 for “Solar Success” and learn about installation options, attachment maintenance, and what to know before you start. Or you could take the time to familiarize yourself with fastener options (including a troubleshooting guide) in “Fasteners for Metal Roofing” starting on page 36. Also learn the ins and outs of keeping your gutter roll former in tip-top shape in “Gutter Machine Maintenance” on page 24. What other ways

have you made the most of these changing times? Have you experienced a slowdown or is your business booming? If you’re open to sharing how your business has been affected and what changes you’re making, see my email address above.



Here at Shield Wall Media, we certainly haven’t been sitting idly by. We’re continuing the revamping of our main website and have completely overhauled our digital Buyers’ Guides, Classifieds, and Help Wanted sites. Head to www.metalroofingmag.com to take a look. Browse product categories, search for building materials for sale near you, or add your own Help Wanted listing. We’ll keep you posted on the changes coming to our main website soon. If there’s something you’d

like to see there or even an article topic that you feel would be beneficial, send me a note. We love hearing from our readers—you’re the industry experts and know what you need better than anyone else. **MR**

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Suppliers Staying the Course

States have begun lifting the shelter-in-place orders that were enacted to minimize the spread of the COVID-19 virus. While many construction and manufacturing companies were allowed to continue working as essential businesses, according to our trade surveys, many experienced difficulty in obtaining materials for their projects. Here are updates on some of the companies supplying the rural construction, metal roofing, and roll forming markets that are up, running, and ready to supply your needs as you ramp up your construction jobs.

A.B. Martin Roofing Supply

www.abmartin.net

A.B. Martin remains open during normal business hours. Located in Pennsylvania, the company was not affected by the governor's COVID-19 shutdown orders, as it continues to provide building materials that are considered essential to homeowners and businesses.

AceClamp

www.aceclamp.com

AceClamp provides critical products to both the medical and military industries so is able to continue to provide AceClamp products for the foreseeable future. Sales and support staff are abiding by safety guidelines to ensure they can remain fully staffed with no disruptions in service. Additionally, they have the ability to operate sales remotely and have off-site engineers available to help spec new projects. Regarding shipping orders, staff may begin to work alternating shifts to comply with social distancing, but they expect minimal impacts on shipping.

Acu-Form

www.acuformequipment.com

The roll-forming equipment company remains open and operating at normal capacity. The company is monitoring COVID-19 around the clock and taking precautions to ensure the health of workers and customers.

ASC Machine Tools

www.ascmt.com

Identified as an essential business, ASC Machine Tools, headquartered in Spokane, Washington, has been called upon to maintain operations, distribute critical parts, and provide services that support its customer base.

ATAS International

www.atas.com

ATAS International is continuously monitoring the current situation. As they navigate the uncharted waters associated with COVID-19, they consider the health, safety, and welfare of their employees, customers, and vendors their top priority. At the current time, they believe it is in the best interest of all parties that they continue with business operations and remain open. Members of their sales team are available to communicate via phone and e-mail during this time. Visit www.atas.com/rep-finder for contact information for your specific sales team.

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www.atlasfasteners.com

The COVID-19 pandemic has brought uncertainty to just about every aspect of our lives. From a business standpoint, forecasting for the upcoming months can be a challenge during these unprecedented times. From the start of the pandemic, Atlas has committed to remaining fully operational to provide their partners the best service possible. As they remain in operation, they have taken extensive measures to abide by social distancing and sanitary guidelines. They have requested all office personnel to work from home and require manufacturing and distribution personnel to wear masks and gloves to protect themselves and others from the COVID-19 virus.

In hopes of providing a sense of comfort and relief in these uncertain times, Atlas is ready to take on your building product needs.

BECK America

www.beck-fastener.com/en/home.html

BECK America continues to remain open for business and current operating hours and shipping timelines are unchanged. They are using their logistic network to assist customers who are working through warehouse closures by drop shipping directly to their customers.

The Bradbury Group

blog.bradburygroup.com/blog/covid19-update

The Bradbury Group has limited some of its travel, but sales and service teams continue to make calls. They will contact customers prior to any visit that is scheduled and can also connect remotely via meeting software or other means.

DB Building Fasteners

www.selfdrillers.com

DB Building Fasteners is no longer allowing non-employees into shipping and will-call areas. Special protocol is now in place for third-party freight companies, requiring everyone to remain outside warehouses while DB

employees load trailers. Truck deliveries and pickup in and near the Ontario warehouse will continue. All office employees that are able to work remotely are currently doing so. Warehouse and production areas now have implemented two shifts, one in the morning

and one in the afternoon, to help maintain a safe distance between workers.

Dean Steel Buildings

www.deansteelbuildings.com

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PARTNER UPDATES

to place orders should call first. Ordering is being accomplished through phone or other telecommunication services. Deliveries will be taken at the gates whenever possible.

Extrutech Plastics

www.epiplastics.com/index.html

Extrutech Plastics resumed production of essential products on March 30 to produce wall and ceiling panels for the food processing, agricultural, and clean room facilities throughout North America.

FILC/DripStop

www.dripstop.com

Filc d.o.o., makers of DripStop, has received numerous cancellations and prolongations of orders mainly from customers in the automotive industry and in hard affected regions. This has led to production interruptions and

stoppages mostly on the lines producing products dedicated to these markets. All other production lines are running normally. Due to the restricted travel policy, on-site technical support has been curtailed but continues to be available by using remote means such as video calls. Contact the company if you have concerns regarding your company's operation needs.

Levi's Building Components

www.levisbuildingcomponents.com

Levi's provides this simple, sincere message: "We're still open for business! Call to order today at 877.897.7020."

Maze Nails

www.mazenails.com

As of April 10, Maze Nails is open and in full operation at the Maze Nail plant in Peru, Illinois. We're taking all

the personal health precautions suggested for "essential businesses"—ones that are strongly encouraged to continue running so that the economy does not sputter down to nothing. We want to be smart—so we are erring on the side of caution as situations arise.

As we enter our 172nd year with this unforeseen challenge—thank you for your good business. We certainly owe our past and future success to your unwavering support of our 100% MADE IN USA nails. And—as you may recall—we also added a line of very popular screws from U2 Fasteners to our 2020 catalog—so please give those your consideration, too.

Maze Nails continues to keep all of our people as busy as possible—either at work or operating from home—so that we do not lose key players.

Please continue to let us know however we can be of service in this tough time.

MFM Building Products

www.mfmbp.com

MFM offices, manufacturing, and warehouse will remain open, conducting business as usual as an "essential" business entity per the state of Ohio Governor's mandate. It has, however, suspended all outside visitors to its facilities.

MWI Components

www.mwicomponents.com/

[covid-19-procedure-updates](#)

MWI is continuing to monitor the guidelines for our industry as they are released to the public. We are taking the necessary precautions to ensure the well-being and safety for both our employees and customers. Currently, MWI is maintaining production operations as usual with updates to the Will Call and Inbound Receiving procedures. Contact MWI Components' for information regarding these procedures.

Petersen Aluminum/PAC-CLAD

www.pac-clad.com

Petersen's PAC-CLAD manufacturing facilities remain open and operational. Contact information for local factory reps



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is listed in Petersen Aluminum's COVID-19 Updates section on their website.

Plyco Corporation

www.plyco.com

Plyco's products serving the food and agricultural sectors and potentially FEMA required structures is deemed to be part of the "Critical Infrastructure Industries." It will remain open for business as usual to support all of its customers that fall into these categories and require its products.

RapidMaterials

www.rapidmaterials.com

RapidMaterials is open online 24/7 and shipping daily Monday through Friday.

Rigidply Rrafters

www.rigidply.com/hours-of-operation-during-covid-19

At the direction of state and federal guidelines, Rigidply is open during normal business hours, including all manufacturing and delivery operations.

Rigidply continues to follow CDC guidelines. Rigidply requests that all personnel involved with Rigidply deliveries maintain 6' separation. Delivery paperwork will be completed and signed by the Rigidply driver, including the name of the person receiving the material. Compliance with all other CDC guidelines is requested, as well.

For customer pickup, please call in your order and proceed directly to our yard for loading. Rigidply's showroom and sales counter is open to customer visits by appointment.

Rigidply appreciates your business and our relationship with you. Let us know how we can help you. Stay safe.

Safe-Way Doors

www.safewaydoor.com

Currently several state guidelines support the garage door industry as an essential industry. As a result, Safe-Way Doors remains open at its manufacturing facility in Indiana as well as its company-owned DCs in Tennessee and Missouri.

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PARTNER UPDATES

SmartBuild Systems

www.smartbuildsystems.com

SmartBuild Systems is announcing their SmartBuild e-Modeler! This powerful new feature allows distributors to embed SmartBuild's powerful design software directly into their website. End users will be able to build the custom post frame structure they've been dreaming of. Plus, you can do business a lot more efficiently. Every time the end user edits their structure, material lists and pricing automatically update for you so you can provide accurate quotes in no time, close more business, and make more money. Even as the country starts to open back up, social distancing will likely not entirely go away. The more you can shift your business to internet-based, the safer it will be for your customers, your team, and yourself. Why wait? Get SmartBuild e-Modeler today and compete with the big boys for a fraction of the price!

ST Fastening Systems

www.stfasteningsystems.com

ST Fastening Systems' operation has been deemed essential and necessary under the current order restricting business oper-

ations, as required for the supply chain to support its critical customers. Both of the manufacturing plants in Tyler, Texas, and the service center in Cincinnati, Ohio, are open for business.

Triangle Fastener Corporation

www.trianglefastener.com

As a manufacturer and distributor in the supply chain for critical products and industries (Medical/Pharmaceutical, Food & Food Packaging, HVAC, Steel & Steel Products, Technology, National Defense, etc.), Triangle Fastener is designated as an essential business. As a result, all 23 locations remain open and will provide safe pickup or deliveries. TFC Paint shops remain open as well as the TFC Tech Center.

UFP Industries

www.ufpi.com/en/covid19

UFP Industries (UFPI) serves a wide range of customers, including essential businesses such as health care manufacturers, food suppliers, building products dealers, and infrastructure contractors. Consequently, UFPI continues to operate and serve its customers' critical needs. Certain customers whose products



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haven't been deemed "critically essential" are taking temporary furloughs and UFPI is responding accordingly with its facilities and employees. It has created continuity plans to ensure plants receive raw materials, run production, and ship to customers without disruption. UFP Industries has many different sources of supply and to date has not experienced significant supply bottlenecks.

Van Mark

www.van-mark.com

Van Mark of Farmington Hills, Michigan, is open for business as they work within the constraints of Michigan's COVID-19 executive order. Van Mark is an essential supplier with only essential staff on-site and others working remotely to serve our customers' needs. Customers should send in orders as usual and Van Mark will endeavor to get them shipped as soon as they can. Please be safe and healthy and rest assured that Van Mark is taking every precaution to do the same.

Western Building Supply

www.westernbuildingsupplyllc.com

Western Building Supply (WBS) specializes in the supply

and manufacturing of premium building materials and ready-to-erect structures for simple and complex projects. Led by a team of passionate craftsmen with an entrepreneurial spirit, the business of building runs deep in our DNA. We supply and manufacture our materials locally and leverage our in-house fleet for seamless job site delivery. Our proximity to the supply source and control over the manufacturing process give WBS the advantage of speed, flexibility, and quality control. The result: WBS provides its customers with the highest quality building materials in half the average lead time.

Wick Buildings

www.wickbuildings.com/blog/covid-19-update

At this point, the construction of Wick Buildings meets the criteria of essential work as currently defined. Therefore, it is continuing all activity.

We also have the ability to deliver materials to job sites in all states. So if any of our materials-only builders would still like to receive a delivery, they may. Any decision made by a builder in an affected state to take delivery of a project is at their sole discretion. **MR**



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got news?

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Send us news of your:

- Milestone anniversary
- New product, material, or service
- New program for the advancement/betterment of the trade
- Outstanding achievement
- Business location change/expansion
- Accolades/awards
- Staff promotion/staff addition
- Public service work/engagement
- Trade association involvement
- Branding changes
- Sponsoring/exhibiting at a trade show
- Merger/acquisition
- Case studies
- Joint projects with an industry partner

Send us a notice of your successful completion of a challenging or unusual project and you may see it featured as a Project of the Month. We would also need 4-5 high-resolution images and details about the products used in the project.

**Got questions? Call 920-224-5146
or email jessica@shieldwallmedia.com**

*News announcements and projects to be considered for
Project of the Month placement can also be mailed to
Metal Roofing, ATTN: Jessica Franchuk, PO Box 255, Iola, WI 54945.*

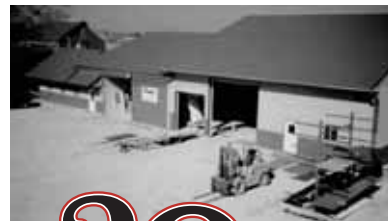


INDUSTRY NEWS

Ramco Supply Celebrates 20 Years of Metal Manufacturing Excellence

This year, Ramco Supply, a leading metal roofing manufacturer and pole barn supplier, celebrates 20 years of providing exemplary service and quality metal roofing and siding products for customers throughout Indiana, Ohio, Michigan, and Illinois.

Marvin Ramer, founder and owner, began retailing metal roofing and siding in 2000 out of a 40' x 60' pole building he had built on his personal property in Rochester, Indiana. The company quickly began to grow, filling orders from customers across northern Indiana. The company has expanded many times and, in 2009, they purchased a 20-acre property to house a new state-of-the-art facility to help meet increased demand. In 2013, Ramco purchased a 10-acre lot in Woodburn, Indiana, and a new facility was erected in 2014.



On reaching such a milestone, Ramer stated, “From our early humble beginnings, I never would have imagined we would grow into the size and type of company we have become today.” Ramer also attributed much of his continued success to his employees and loyal customers. “Our employees are the best at what they do. I thank them for their hard work and dedication. Most importantly, I want to thank our customers for their business and trust.”

With the mission to practice honest business, Ramco Supply's team is committed to bringing value to their customers, vendors, and community.

For more information, visit www.ramcosupply.com.

METALCON 2020 Plans Underway

As Las Vegas begins to reopen, METALCON 2020, the metal construction industry's largest international event for metal construction products, technologies, and solutions, announces new programming and educational sessions for its 30th anniversary “Build Back Better” conference and trade show at the Las Vegas Convention Center from Wednesday, Oct. 21 through Friday, Oct. 23, 2020.

CONSTRUCTION ROLLFORMING SHOW PREVIEW

WINTER 2019
Vol. 2, No. 4

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3 BIG IDEAS FOR INVENTORY MANAGEMENT

REASONS TO CONSIDER SBA FUNDING

PRODUCT PROFILES ROLL-FORMING EQUIPMENT

Rollforming Magazine is dedicated exclusively to this section of the construction trade. Roll-formed metal wall and roof panels comprise a large portion of the agricultural, commercial, post-frame and residential construction markets.

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NEWS

“We are happy to hear Las Vegas is reopening and getting back on track,” said Show Director Judy Geller. “The health and well-being of our exhibitors, attendees, and staff are our No. 1 priority. We are working closely with our vendors and venues, as well as the state and local government, to create a clean and healthy environment. We will be implementing very specific safety measures throughout METALCON that will not only meet state and local regulations but also go above those to ensure the safest and healthiest event possible.”

With registration opening in early June, METALCON is launching two exciting programs, new for 2020 (on Tuesday, Oct. 20, the day before METALCON officially opens):

The Architect’s Experience at METALCON: To ensure metal is on every architect and designers’ palate, METALCON is launching The Architect’s Experience at METALCON. Provided by the two top A/E/C educators (the Ron Blank affiliate CE Academy and PSMJ Resources, Inc.) and designed specifically for architects and designers, this exclusive experience offers a combination of comprehensive education and a unique exhibit floor experience. Architects and designers will learn about and see firsthand the beauty and durability of metal while earning AIA Continuing Education Units (CEUs).

CONNECT! The Women’s A/E/C Network at METALCON: With women making up just 9.9% of the United States construction workforce (source: NAWIC), their future success relies on working together to advance women in the industry. Leaders from A/E/C industry women’s associations will come together to help create change, drive diversity, ensure equality, and influence the industry. All are welcome to join this afternoon of learning, conversation, and networking.

Attendees will have the opportunity to earn CEUs in a selection of deeper-dive educational sessions on a variety of topics: Safety, Office Technology, Field Technology, The Building

Envelope, Equipment, Sales—How to Sell More and Proactively and Productively, Roofing, Walls, Fire Safety, Technology, and Green/Sustainability. Returning for its fifth year, attendees can become certified in the 8-hour Metal Roof Installation Training Program led by industry expert Jim Bush, Vice President of Sales & Marketing for ATAS International.



At METALCON, industry experts from leading companies exhibit the latest products, equipment, and technology together with education and training sessions—all located on the show floor. Top influencers share their knowledge with designers, builders, developers, contractors, fabricators, and suppliers from more than 50 countries in the popular METALCON theatre, conveniently located off the center aisle.

For more information, visit www.metalcon.com. **MR**



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Solar Success

Options and Considerations Prior to Installation



Clamps can be used to attach solar panels to a wide variety of seam types, as shown below.

By Carol Marston

Before diving too deeply into solar panel attachment options, let's look at the structure just below the Photovoltaic (PV) Solar Panels: the roofing material itself. Standing Seam Metals Roofs (SSMRs), for example, have been gaining in popularity over the last several years, especially in the residential market. This has happened for several reasons, first and foremost being that metal roofs are very durable, and with life spans from 30 to 50 years, they will far outlast the current Photovoltaic Systems (which can endure for approximately 20 to 25 years, or more).



One option is to use a full clamp system, where clamps and accessories are all fully assembled at the factory so that the installer can take the clamp out of the box and onto the roof without having to first make the component roof-ready.

to use will be determined by the kind of metal roof (standing seam with concealed fasteners or exposed fastener metal roofs). SSMRs with concealed fasteners allow attachments to be secured directly to the standing seam ribs. If the metal roof has exposed fasteners, like corrugated panels, then safely securing will only be accomplished by fastening directly through the panel and into structure below. Be sure to check the roofing manufacturer's warranty, as some manufacturers will void the warranty if the panel is breached. Additionally, all solar array systems should be engineered and designed with consideration for wind uplift loads. In snow country, you'll need to take into account the snow loads plus the weight of the solar array, as well.

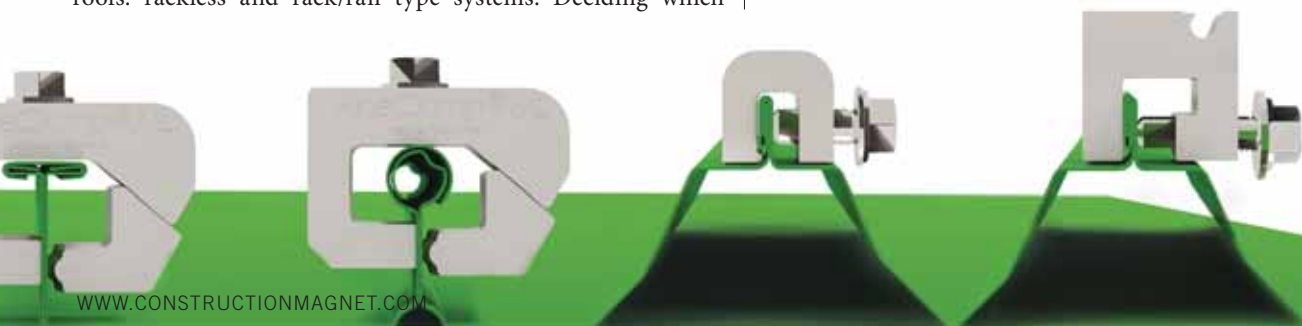
What to Know Before Beginning

Secondly, metal roofs are strong and typically hold up in adverse weather conditions, including heavy rains with high winds. Lastly, metal roofs can have a cooling effect due to reflective coatings and can reduce energy consumption by up to 20%, which complements solar arrays perfectly. For these reasons, if you are planning on installing a solar system and the client's roof has seen its better days, now would be the perfect time for them to invest in a new metal roof. At this point, it is worth noting that SSMRs do work better from a structural standpoint when one is considering various mounting attachment solutions.

There are two types of solar mounting systems for metal roofs: rackless and rack/rail type systems. Deciding which

Now let's look at the skill set or knowledge base needed for a successful installation. The solar installer needs more than a cursory understanding about roofing. The panels in a SSMR installation are designed to expand lengthwise to accommodate the vast changes in temperature from winter to summer and night to day. Each roof panel is attached to the purlins with a clip. The base is fastened to the purlin and the top portion of the clip is formed to fit within the raised rib portion of the panel.

The clip is designed to allow the panel to move back and forth over the formed clip as the temperature changes. If the PV array rackless mounts or the mounts securing the rails to the





Systems installed on low-sloped metal roofs may be more affected by high snow loads. Be sure to follow the local codes for wind uplift and snow loading for whatever the roof slope is.

roof panel are tightened over these clips, they likely will inhibit the thermal expansion, resulting in the panel buckling during extreme changes of temperature.

Another type of clip is a two-part assembly, which allows the top part of the clip that fastens into the roof panel rib to move laterally with the expanding panel, while still being connected to the base portion of the clip (which is secured to the purlins). Attaching the mounts over this type of clip won't hinder the thermal expansion. However, the solar installer should contact the roofing contractor who installed the roof and ask what kind of clip was used and how to identify where

the clips might be located. Often there is a ripple in the rib where the clip can be found.

Then, there are the “mechanics” of installing the solar “hardware” (rails, mounts to the roof, and clamps that hold the PV panels to the rails) and the recommended tightening torque values for each fastener. Contact the clamp manufacturer to find out the number of non-penetrating clamps needed to meet the local building codes for wind uplift and snow load requirements. Those design load values, vertical for wind uplift resistance and lateral (parallel to the roof rib) for snow load and dead-load resistance are based on stringent third-party testing for the specific roof panel configuration and material type and thickness. They are usually published with an identified safety factor as well.

Check with your local code official and ask what they require as a safety factor for design loads in their jurisdiction. Be sure to follow the correct installed torque recommendation from the manufacturer. If connected too loosely, it will not keep the PV array in place during a high windstorm. If installed too tightly, you may damage the roof rib by breaching the coating, which will result in rusting. You may also experience, as a result of overtightening, distorted roof ribs and potentially a fastener penetrating through part of the roof panel rib, creating leaks.

Many installers will use a torque wrench to apply the correct torque initially and then go back and double-check before proceeding with the installation of the next row of PV panels. Some roof panel designs and materials experience a slight amount of seam compression initially, resulting in a final torque value a little

Don't Forget About Warranties

Coordinate with the original roofing manufacturer and the roofing contractor before any work is done in order to comply with the roof system warranty. Some roofing manufacturers will consider their warranty voided if there are any penetrations through their roof surface without their knowledge. Non-penetrating fasteners, such as the AceClamp product line, fulfill this requirement. No holes means no leaks. Our AceClamp warranty is a 20-year Limited Warranty. See the AceClamp website for details: www.aceclamp.com.

lower than first applied and would require re-torquing to the spec.

Beyond the “mechanics” of installation, knowledge in wiring the PV panels correctly, installing the ancillary hardware, inverters, rapid shutdown devices, wiring the grounding path accurately, etc., is also required. As with roofing design and installation, nationwide codes are often modified for the local conditions of high wind zones along the coast as well as higher than average snow loads in northern and mountainous climates for accessories mounted on rooftops. The fire marshal may require a certain setback to allow access to the roof by emergency personnel around the full PV array in case of a fire.

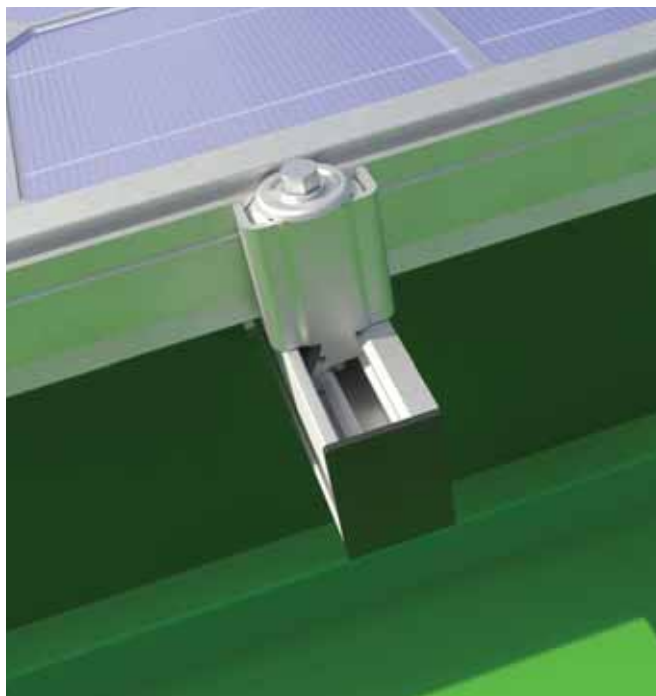
If the project is located in the Snowbelt, the building owner should be consulted about the possibility of including a snow-retention system on the roof below the PV array over any entrances or exits to the building, walkways, prized plantings, parking areas, etc. It's best to consider these systems while the array is still on the drawing board because space may be needed at the eave over the structural wall, leaving adequate space below the PV array.

We recommend a 3' to 4' space, and the reason being is to allow the snow to begin to slide off the panels and collect while slowly melting off the roof, all while being held back by the snow rails. Many expensive gutters have been lost due to snow “avalanches” careening down the roof and catching the gutter edge before crashing to the ground. This aspect of the system has often been an afterthought in the past, but more installers are discussing snow retention as an accident preventive practice.

How Attachments Work with Different Roof Types

There are a variety of roll-formed roof panels on the market and new ones being developed every day. Clamp manufacturers have tried to keep up with the new rib configurations by creating clamp profiles that work to conform strictly to the roof panel rib to minimize the distortion when tightening. The illustration on the bottom of pages 18-19 shows the current variety of AceClamps and the standard roof panels that they can be used with. Common roof panel materials are steel, aluminum, zinc, and copper. Steel panels are manufactured from 22-gauge to 26-gauge material. Aluminum is usually 0.040" or 0.032". Copper 16 and 20 oz, and zinc 2-gauge. As the material thickness decreases and/or hardness decreases, more load testing may be required to determine the optimum installed torque and resulting vertical and lateral design loads. Those load ratings will allow the engineers to determine how many and where to place the clamps to best keep the array in place during severe winds or snow.

Exposed fastener or corrugated roof panels require different types of mounts, which are fastened through the panel and usually into the purlins or rafters. Proper sealing and caulking are required to keep water from penetrating the roof during the service life of the PV panels. Be sure to choose the correct sealant to withstand the UV from the sun and the temperature variations from season to season.



Non-penetrating metal roof clamps help protect the roofing panel's finish and warranty.

Low-Sloped Versus Steep-Sloped Roofs

When necessary precautions are taken, low-sloped to steep-sloped roofs can be suited for solar arrays. A low-slope roof is one that is equal or less than 2:12 pitch (9.5 degrees). Anything higher is considered a “steep” slope. Generally speaking, either type of roof is a good candidate for solar. The steeper roof will require more attention to safety-related material handling and personnel techniques. Systems installed at the lower slopes may be more affected by high snow loads. Be sure to follow the local codes for wind uplift and snow loading for whichever slope the roof is.

Using a Full Clamp System

Time saved during installation provides more opportunities for a contractor to get to the next job faster, as well as cost savings for the final customer. AceClamp products are all designed with the contractor in mind. Clamps and accessories are all fully assembled at the factory so that the installer can take the clamp out of the box and onto the roof without first having to assemble setscrews, washers clips, or whatever to make the component roof-ready. Our new Solar Snap™ rail system is designed in the same way—bolts and connectors are assembled and “snap” into the rails securing the L-Foot or PV panels quickly and securely. By design, you'll also feel a tactile sensation of the slide nut snapping and locking into place, just another way for our customers to feel confident that the components were safely and securely installed.



We replaced setscrews during the early stages of our AceClamp design after seeing firsthand the difficulty a contractor had while trying to insert setscrews into a competitor's clamp body on a cold day in northern New York. AceClamp's factory-assembled patented "sliding pin" design on all of our A2 series allows both sliding pins to be equally tightened across the standing seam rib using a 9/16" nut driver—a quick check with a torque wrench and off to the next A2 clamp. Not only is installation a breeze, but the sliding pins also minimize the possibility of scouring or damaging the coating during installation.

Roof and Solar Maintenance

Spot-check the resulting torque on the bolts for the clamps and racking after any severe wind event. If there have been significant accumulations of snow, be sure to check for any displaced mounts or damage to the racking components. Remove any buildup of leaves and debris under the PV panels. Proper airflow is necessary to keep PV panels operating at optimum efficiency. Clean PV panels as required by the panel manufacturer.

Significant roof repairs may require partial or full removal of the solar array. Removal should be handled by the original installer of the existing solar panel array and coordinated with the roofing specialist.

On the Horizon for Solar Attachments

The combination of researching industry reports about some of the racking systems that failed during the recent hurricanes in Puerto Rico and rummaging through piles of rails in the salvage yards enabled our engineers to develop a new solution. The engineers developed Solar Snap™, an adaptive racking system. Less storm damage means that the system will be up and producing electricity sooner. We have also designed this new system for the speed of installation. L-Foot connections snap into the side of the rail and are torqued into place. The solar clamps that secure the PV panels also snap into place and are then torqued to specification. Very few loose parts—listen to hear the "snap" to know that you have installed the systems correctly. **MR**



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Gutter Machine Maintenance

Add Life to Your Equipment with Preventative Care and Cleaning

By Englert® Inc. staff

Regular, preventive maintenance is probably the single best thing you can do as a gutter roll forming machine owner and operator to keep your business humming and save money on repairs in the future.

Anyone who has ever had a gutter machine out of service and lost money on downtime and repairs will tell you: Don't ignore preventive maintenance. The basics will keep your roll former healthy *and* give you a chance to catch anything serious before it becomes a major problem. All of this depends on *you*.

Every new machine sold in the marketplace comes with an operating and maintenance manual. We have had several gutter machines in our repair shop, ranging from one that was nine months old and looked like it had been in the field for 10 years, to another that was 10 years old and looked as good as the day it first saw service.

If you're serious about getting the best "mileage" out of your machine, follow these suggestions every month your machine is in service:

1. Most modern gutter machines feature a polyurethane drive roller system with chromed free floating forming rollers that have to be routinely cleaned.

Turn on your machine and spray the neoprene rollers with a product like Formula 409®, a household cleaner whose original application was as a commercial solvent and degreaser for industries that struggled with particularly difficult cleaning problems.

Let your machine run for a few seconds, then turn it off and wipe down the rollers with a clean cloth. Remove as much dirt and grime as you can.

Then turn the machine on and jog it forward—keeping your hands away from the machine. Turn the machine off again and wipe off the other sides of the rollers and the bottom roll. Wipe away any excess dirt or liquid. Repeat if necessary.



GUTTER OPPORTUNITIES

2. Once the neoprene rollers are clean, use a shop vacuum to clean out the rest of the machine and wipe it down with a clean cloth.
3. Use a clean cloth to wipe down the skate (metal) rollers with Formula 409. Cleaning these rollers may require more effort and “elbow grease” than the neoprene rollers.

Repeat these steps once a month and remember to make sure the neoprene rollers are completely dry before running material through the machine. Rollers that are not dry will slip and make a mark on the bottom of the gutter material.

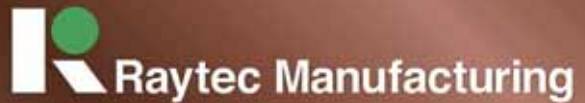
Wiping down the entire machine also gives you the opportunity to closely inspect it. As with any mechanized piece of equipment, keeping the machine clean at all times will increase its life and make regular maintenance easier.

4. At least once a year, oil all of the chains in your roll former using motorcycle chain oil. The guillotine blade should be oiled every day with 3-in-1 oil. Do *NOT* use WD-40—it is not a lubricant. The WD stands for water displacement and the product is made with a cleaning and degreasing solvent known as Stoddard Solvent that can ultimately get sticky and gummy—not lubricating. It will create wear on the blade and not give you a good cut on the material.

Finally, two operating notes that can save you on repairs and machine malfunctions: If you are running your machine's electric-powered motor from a wall socket or even a generator, use a 10-gauge, 15-amp extension cord. Anything less and the roll former may perform erratically.

And last, never leave material in any machine with polyurethane rollers. When you are done using the machine for the day, calculate the length of the machine into the last piece needed, and then empty the machine. Material left in the machine acts like a trough, catching dirt and debris. Consequently, when the machine is turned on, the roller runs through the residual dirt and will soil the product and the rollers. **MR**

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Metal Shingles by EDCO

Styles, Profiles, and Colors for All Facets of the Building Industry



EDCO Infinity® Textured Steel Shake
in color Granite Gray Enhanced

We recently chatted with EDCO about their award-winning line of metal roofing products to find out the best uses and installation basics. Here's what they had to share:



EDCO ArrowLine® Slate in color T-Tone Blend

Metal Roofing Magazine (MR): Can you give us a brief history on metal shingles—why were they created and what was the demand like back then? How are they different from other roofing options on the market?

EDCO Products (EP): Metal shingles were created as a longer-lasting, aesthetically pleasing, and more environmentally sustainable roofing product compared to other materials in the marketplace. Metal roofing continues to gain acceptance in the marketplace and our goal is to continue to outpace the industry and grow market share through the look and quality of our product.

MR: Since their creation, how has the popularity of metal shingles grown or changed?

EP: Next to traditional asphalt, metal has become the material of choice for home and business owners alike. Consumers want products that provide a unique look, that last longer, and are less harmful to the environment.

MR: What are the benefits of metal shingles versus other roofing types? What should a contractor know to sell these

PRODUCT FEATURE

options to their customers?

EP: EDCO metal shingles are a lifetime product that provide a superior look and significantly better quality than competitive materials. When compared with standing seam roofing, EDCO offers a more natural finish, similar to natural wood shakes or slate tiles.

MR: What are the typical warranties of metal shingles?

EP: All of EDCO's metal roofing comes with a Lifetime Non Pro-Rated Limited Warranty. It's the best and most comprehensive warranty in the industry.

MR: Are any metal shingles energy-certified and are there any tax credits for the homeowner?

EP: Our Arrowline Roofing Collection offers Energy Star Rated Panels. Certifications vary by color and tax credits vary by state.

MR: How does the installation differ from other metal roofing types? What knowledge, skills, tools, etc., would a contractor need to have or plan for if they've never installed metal shingles before?

EP: Metal Shake and Slate panels install in a similar manner to traditional asphalt shingles, from bottom to top, left to right. EDCO roofing differs from other metal roofs, especially ribbed panel roofing, in that it has no exposed fasteners where leaks could form.

Installers new to EDCO roofing will utilize their knowledge of flashing and roof prep, which is going to be similar to that used on an asphalt roof. Tools needed will include a sheet metal break or similar way to fold metal; metal shears, snips, or specialty ferrous metal cutting saw blade; and a screw gun.

MR: Can metal shingles be installed over an existing asphalt shingle roof?

EP: While we recommend removing any older materials before installing EDCO metal roofing, it can be installed over a single layer of asphalt shingles if allowed by local building codes.

MR: Are metal shingles used primarily for residential? Commercial? Agricultural? Or a mix?

EP: Metal Shingles are used in all facets of the building industry and have gained increasing popularity in the residential side over the past 10 to 15 years as homeowners have become more informed to the advantages of metal roofing.

MR: Does EDCO offer options for a variety of different building styles/types?

EP: We currently offer two different profiles, four different finish styles, and 41 different color options in our Metal Roofing line. We have a style and color to meet everyone's needs. **MR**

For more information on EDCO's metal shingles and other products, visit www.edcoproducts.com.



EDCO ArrowLine Shake in color Statuary Bronze



Metal shingles were created as a longer-lasting and more sustainable roofing product compared to other materials in the marketplace.



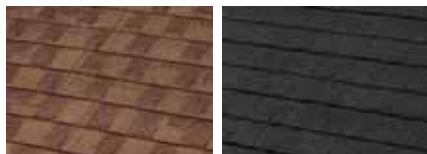
EDCO ArrowLine Slate in color Statuary Bronze

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METAL SHINGLES

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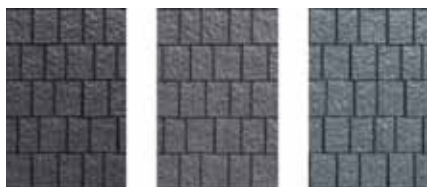
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The Old World tile color prevails with the Tuscan Sun color by DECRA Metal Roofing Systems. Providing a color reminiscent of natural clay, this profile is available in both the DECRA Tile and Villa Tile profiles. It is a CRRC-approved color, meeting California Title 24 requirements as a cool-rated color (Tuscan Sun CC). It is readily available and makes a fine addition to the expanding color palette of metal tiles available.

www.decra.com

EDCO Products



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Charcoal HD

Stone HD

EDCO Products is proud to introduce its latest innovation in roofing, Generations Slate. This metal shingle combines the popular ArrowLine Slate Roofing panel with our advanced HD coating technology to produce a truly authentic slate appearance. Generations Slate is available in the three HD colors shown above. Manufactured with the strength of steel and a multilayered PVDF cool chemistry finish, Generations Slate can reduce energy bills and does not support mold and algae growth. Have the beauty of slate at a fraction of the cost and weight, backed by a lifetime warranty.

www.edcoproducts.com

Graber Post Buildings



Graber Post Buildings' Boral Steel Roofing gives you the durability and lifetime of metal panels while providing an attractive asphalt shingle look. We offer a wide range of different profiles and colors that will make matching each house a breeze. We carry matching stone-coated trim accessories and vents that will provide the perfect matching finish to each roof. Let Graber Post Buildings supply that new look for your next roofing project!

www.graberpost.com

Isaiah Industries



Since 1980, Isaiah Industries has been a leading manufacturer of fully interlocking PVDF-coated steel and aluminum shingles. Available profiles include shake, shingle, slate, and tile. We offer a fully scripted in-home sales presentation that helps homeowners assess whether a metal roof is a wise decision for their home.

www.isaiahindustries.com

METAL ROOFING PRODUCT PROFILES

METAL SHINGLES

TAMKO



TAMKO's MetalWorks steel shingles offer the classic looks of slate, tile, and wood in a full array of colors, all of which are Energy Star qualified, making them a beautiful choice for residential and commercial applications. MetalWorks pair well with TAMKO's Synthetic Guard Plus Underlayment, or the steel shingles may be applied over up to two layers of existing asphalt shingles. Offered with a limited warranty.

www.tamko.com

Rare Manufacturing



Rare Manufacturing recently launched a completely redesigned Slate profile with a new look and improved install features. The panel has an aggressive new look and is now a four-way interlocking system. Featuring a hidden fastener design and larger exposure, allowing for easier estimating and installation. Rare metal roof panels are investment-grade roofing products, manufactured from high-quality PVDF coating and heavy duty corrosion-resistant steel to ensure they last a lifetime.

www.raremanufacturing.com

Roser USA



Roser USA's newly released SteelSlate Shingles are easy to install utilizing panel bending or universal channel for transitions and can be easily fastened to the roof deck with standard roofing nails or screws. The 26-gauge Zincolume-coated steel base panels are available in four natural tones: Charcoal, Granite, Coffee, and Weathered Timber. They hold up to the weather with Class IV impact resistance and 120mph wind resistance ratings. Includes a 50-year (transferable) warranty against manufacturing defects.

www.roser-usa.com

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project of the

Howard County Fairgrounds, Greentown, Ind.



PHOTO COURTESY OF SKY SQUID DRONES (WWW.SKYSQUIDDRONES.COM)

New Home and Roof for Historic Round Barn

Steel Coil in Slate Gray by Coated Metals Group Protects 110-Year-Old Structure

Built near the turn of the century in approximately 1910, the Howard County Fairgrounds' Round Barn in Greentown, Indiana, didn't always reside at its current location. It was built by a farmer in the southeastern region of the county, about five miles from the fairgrounds and its current home. The barn took a year to build, using lumber cut from the original farm's surrounding woods and topped by a wood shake roof.

The unique round building served its purpose until the farmstead was passed along to another family. At the

end of the 1990s, the nearby Greentown Lion's Club (that has a pioneer village with historic local buildings) thought the round barn might be a good addition to the village's collection. At the time, the new property owner wasn't interested; 10 years later, the farmer passed away and his widow gifted the round barn to the Lion's Club.

After standing for 100 years with minimal upkeep, including a reroof in the '50s with another shake roof, the barn was beginning to deteriorate. Part of the roof had caved in, and the Lion's Club faced the choice of

Project Overview

Location: Greentown, Indiana

Building: Round Barn at Howard County Fairgrounds

Roofing Contractor: Heritage Goodhew (www.heritagegoodhew.com)

Roofing Panel: Coated Metals Group Slate Gray pre-painted steel coil

Fasteners: Hidden using ASMI Supply clips

Insulation: Hand-formed

Underlayment: 15# felt paper



PHOTO COURTESY OF TIM BATH/NOVINO TRIMLINE

PHOTO COURTESY OF SKY SQUID DRONES (WWW.SKYSQUIDDRONES.COM)



PHOTO COURTESY OF SKY SOUND DRONES (WWW.SKYSOUNDROBOTS.COM)

attempting to move the barn as-is, or tear it down and reassemble (while fixing it up). They ultimately chose the latter and hired a firm with the necessary experience.

Between 2011 and 2012, the teardown and reassembly/renovation were completed. Several large donors helped with the funding of the barn's total reconstruction, and the previous barn owner offered ash wood from the same property as the original lumber for much of the interior construction (including a hayloft floor).

During the rebuild, Lion's Club members searched for a more durable roofing alternative after seeing the condition of the second shake roof. After some investigation, they found Heritage Goodhew, roofing contractors with experience in round barn roofing. The new metal roofing material was chosen for its longevity and minimal maintenance.

The very first use of the reconstructed barn was a

wedding and reception, and today it also hosts reunions, parties, photo shoots, and more. It can be rented out during the nicer summer months, except for during the annual County Fair. One side of the building is used by the historical society during the event, while the other half is filled with antique farm displays. The July Fair brings in many visitors to the Fairgrounds, where the barn is surrounded by a log cabin, sheriff's building, and more. As new structures are brought into the pioneer village, metal roofs are slowly being added.

The Round Barn also hosts Santa Claus at Christmastime, when the pioneer village puts on a drive-through light display. Sponsored by local businesses, the barn and the other buildings are all lit up for both a walk-through and drive-through Christmas event, with Santa greeting children and other visitors inside the Round Barn. **MR**



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Fasteners for Metal Roofing

Selecting the Best Type for Your Application and Why It Matters

By Andrew Mullen

A fastener is the common way metal roofing panels are secured to a roofing system substrate. The selection and installation of roofing system fasteners and screws has a direct effect on the performance and service life of these systems. Understanding how a fastener is chosen and performs within the roofing system is an important aspect of being a professional installer. While it would be logical to assume the roofing fasteners that come in a metal roofing package are expected to give corrosion-free performance for the life of the panel they are securing, that is not necessarily true. Many factors affect the corrosion resistance and holding power of a fastener, including selection of the proper fastener installation tool.

There are two main types of metal roofing systems, exposed fastener and concealed fastener, and four typical substrates that these systems will be secured to. The correct fastener type will be determined by a combination of factors, including the type of roofing system, the substrate, the panel alloy, and the expected life cycle.

What Is the Substrate?

To determine the proper fastener for an application, you should first identify the substrate that fastener will secure into. You will find four typical types of roofing substrates in residential, agricultural, and commercial roofing applications:

Wood: Fasteners for wood can be found with sharp points, TP-17 points, and with “micro-bits” to aid panel penetration. Not all wood substrates are the same—a fastener that performs well in a dimensional lumber application (such as a 2' x 4') may not be the best choice for a roof deck comprised of OSB or particleboard. Many top-tier fastener manufacturers communicate pull-out strengths for a variety of different types of wood, which can be helpful when determining what fastener will provide the holding strength required by your project. While the popularity of plywood, OSB, and engineered board substrates increases, the industry standard of a #9 or #10 fastener is meeting competition from larger #12 diameter fasteners with course thread pitches designed for use in these “chipboard” wood substrates.

Metal Decking: Corrugated metal decking substrates are commonly found in 22-gauge galvanized metal but can be

all the way up to 16-gauge thickness in some highly specified buildings. Commercial roofs with steel decks commonly have insulation thicknesses thicker than 2" and have created the need for long length fasteners, sometimes up to 16" in length. Look for a fastener with a #1 self-drilling point and a thread pitch of 10 to 13 TPI to self drill and tap into the metal deck substrate.

Steel: For steel beam or metal purlin substrate applications, there are two main styles of fasteners available: a "Tapper" or tapping screw and self-drilling screws. A tapping fastener requires the installer to predrill a hole into the steel substrate for the tapping fastener to be driven into. The fastener manufacturer should have data available suggesting a drill bit size for your application, keeping in mind the predrill size may change with the thickness of the substrate, even though the fastener diameter remains the same. Tapping fasteners are commonly available as a #14 fastener in full 302 and 304 series austenitic stainless steel to provide a high level of corrosion resistance.

Self-drilling fasteners are manufactured with integral self-drilling points, eliminating the need for predrilled holes. To use these fasteners, you must first determine the thickness of all steel/metal you will be securing into. Common self-drilling screws are found in #1, #3, and #5 drill points. The thread pitch of a self-drilling fastener is matched to the capabilities of the drill points, so you do not use a coarse thread fastener in a fine thread application and vice versa. Be sure to select a self-drilling fastener with drilling capacity to meet your application needs. If you choose a fastener with too small of a drill point for your application, such as a #1 point for 12-gauge steel, the excessive torque may snap the fastener (or worse, your wrist). If you choose a fastener with too large of a drill point, such as a #5 point for 16-gauge steel, the fine threads on the #5 self-drilling fastener may strip out, leading to the inability to secure the panel. Self-drilling fasteners come in a variety of corrosion-resistant choices, including zinc alloy capped head, stainless steel capped head, and full stainless bi-metal self-drilling fasteners.

Masonry: While rare, there are some instances where metal roofing and cladding panels are installed onto masonry substrates. In these applications, a predrill of the substrate must be done—typically ½" to 1" deeper than the planned fastener penetration. These holes must be drilled and cleaned of dust prior to fastener installation. The fastener manufacturer should suggest the predrill hole size, which is typically 15% to 33% smaller than the outside thread diameter of the fastener. Fasteners for masonry or concrete substrates may have a variety of methods of attachment. A threaded fastener with a hi-lo thread pattern in ⅜" or ¼" diameters are two of the most common used for roofing panel attachment, however split-drive nails in anchors and bent-rod anchors have also proven effective in roofing attachment applications.

Fasteners for Different Panel Systems

Exposed fastener panels use fasteners with rubber sealing washers to weatherproof the installation penetrations. There is a wide range of these types of fasteners, with many manufacturers offering up to six choices in corrosion resistance. Upgrades



to traditional coated or galvanized carbon steel fasteners include zinc alloy capped or zamac molded heads, stainless steel capped or SCAMP fasteners, or full stainless steel varieties. These exposed panel roofing fasteners can be found from #9 diameters up to #21 diameters for replacement applications.

Concealed fastener panels use fasteners designed with internal drive and a low profile head designed to avoid contact with the underside of the roofing panel. Pancake head style fasteners are designed for panel clip attachment, while extra low profile (XLP) styles are designed for nail-strip or nail-fin clipless standing seam metal panels. Upgrades to traditional zinc-plated fasteners include long-life coated and stainless steel choices in 410, 302, 304, and 316 stainless steel. Most roofing applications require these fasteners in #10, #12, or #14 diameters ranging in length from ¾" up to 16".

Metal Compatibilities and Coatings

It is important to understand the differences between metal alloys and how bare dissimilar metals in certain environmental conditions can have serious reactions that promote premature corrosion and degradation. When working with copper or aluminum panels, it is particularly important to understand the exposure to agitating factors such as proximity to saltwater fallout, moisture, and air movement. An example would be when working with copper panels to only use copper rivets for exposed fastening points, or in the case of exposed fastener aluminum panels, to use an all-aluminum fastener (such as the DMI ATEAM fastener) to avoid dissimilar metal reactions. If aluminum fasteners cannot be found for the application, a best practice approach of predrilling a pilot hole slightly larger than the fastener diameter and then sealing all edges of the hole with a barrier coating or sealant prior to fastener installation can lessen the chances of a reaction.

With metal roofing panels, you also have the option of wet paint or powder-coated paint systems. East Coast Fasteners



shared that wet paint is considered more forgiving and malleable when driving the fasteners and powder-coated paint can be more “brittle” with a risk of fracturing if fasteners are driven with too much force. East Coast also reminds contractors to consider the fastener coating versus the panel coating. Many metal panels have a 40-year or longer warranty, so you want a fastener with a coating warranty that matches.

Fasteners for Repairs

According to Stephen G. Redmann, National Account Manager with Leland Industries, when a mechanically fastened roof requires a repair, how to fix it is strictly up to the roll former/distributor that supplied the steel. Parts are often developed for a specific repair on a particular job, which allows the facility owner future protection under warranty from the manufacturer. Consider stitch and goof screws, larger diameter parts with larger washers, or screw bolts with diameters up to #24, to name a few.

Building Code Compliance

Building codes promote the use of higher quality materials expected to increase the structural rigidity and extend the life of the building. These standards are quickly being specified, adopted, or mandated by many coastal cities, counties, and insurance bodies to encourage responsible building practices.

Examples of code requirements and recommendations include the 2014, 2017, and upcoming 2020 code version of the Florida Building Code, which requires corrosion-resistant fasteners for roof assemblies. FEMA has written recommendations that coastal construction and high wind areas only use

stainless steel fasteners for roofing within 3,000 linear feet of a body of salt water. The Miami-Dade County Code compliance office has also implemented a fastener listing program that outlines additional corrosion-resistance and shear-strength standards required for metal roofing fasteners, both concealed and exposed. If you are in building code regulated zones, it is suggested that you determine if the fasteners in your system have certification listing numbers or meet building code guidelines.

Cost Concerns

When choosing a fastener, you are often presented with the choice between an entry-level economy fastener and a long-life fastener that may cost twice as much. It is important to put the extra cost into perspective within the roofing system's total cost. Upgrading from an entry-level, non-warranted fastener to a lifetime-warranted, long-life fastener can be as little as 1.5% the cost of the roofing system. To determine the best value proposition, it is important to understand the performance expectations of the client. An example:

- 30 square metal roof at \$400/square contract cost
- Entry-level fastener: 3,000 pieces at \$0.06 each = \$180
- Premium fastener: 3,000 pieces at \$0.12 each = \$360
- Difference of \$180 or 1.5% of the \$12,000 roofing system

Choosing the correct fastener for the job will not only increase the lifespan of the roof, but lessen the contractor's liability and likelihood of callbacks due to fastener issues. Choosing the right fastener will also avoid job site delays and additional labor costs. Ask your roofing distributor about the cost and benefits of offering premium fasteners, understanding the proper fastener for your application will keep you one step ahead. **MR**

Common Fastener Mistakes to Avoid

Atlas Building Products shared their troubleshooting guide for dealing with fastener-related issues:

PROBLEM	POSSIBLE CAUSES	SOLUTIONS
Fasteners drilling but not tapping home 	Tool in poor condition. Worn components cause insufficient torque levels to tap fasteners home.	Check condition of vital components (switch, clutch, and brushes) and clean and lubricate or replace as necessary.
	Amperage level of tool insufficient.	Use tool with a minimum amperage rating of 4.
	Cable length and gauge improper or insufficient, causing a voltage drop.	Use minimum of 18-gauge cable for 25' to 100' per tool. Use minimum of 14-gauge cable for 100' to 200' per tool. <i>Note:</i> Several tools run off the same cable will require heavier gauge cable for the above lengths.
	Improper fastener for application. Incorrect thread form. Threads too coarse for steel thickness, causing too high tapping torque. Incorrect drill point results in drilling too small a hole for threads to tap into.	Check thread form of fastener. Spaced threads should generally be used in 1/8" thickness or less. Machine threads in 1/8" or greater steel. <i>Note:</i> Spaced threads generally will work in lapped 12-gauge steel.
Threads stripping or heads shearing 	Improper fastener for application. Incorrect thread form for thickness of steel. Incorrect drill point.	Check thread form of fastener. Spaced threads should generally be used in 1/8" thickness or less. Machine threads in 1/8" or greater steel. Check drill capacity of fastener.
Roof is leaking 	Improper fastener has caused top sheet to strip out.	Check flute length and pilot point of fastener to make certain entire material buildup is drilled through before threads engage in top sheet. When this occurs, the top sheet "jacks" and strips out and proper damping and sealing of washer doesn't exist.
	Fasteners are over- or under-sealed.	
Damaged paint on screw head 	Poor socket condition.	Check internal hex, if worn, replace with new socket. Check for chip buildup in socket. Remove chips with sealing tape. Check magnet depth and condition. Using a screw as a punch, set magnet deep enough so screw heads will not be chipped or marred.
	Drill chips in magnetic socket.	
	Improper driving tool being used is causing ratcheting of fastener.	

Tools of the Trade

Use electric screwdriving guns and not impact tools in the installation of roofing fasteners, and be wary of tools with speeds above 2500 RPM such as drywall screw guns. A wave of popular impact-style tools have hit the market and continue to increase in popularity. These tools are light and use long-lasting 18V or 20V batteries, but have damaging effects on entry-level galvanized and coated fasteners. In particular, the impact drivers are cracking protective finishes on fastener heads and bonded sealing washers, leading to premature corrosion. These impact-style guns have also had adverse effects on the drilling performance of traditional metal-to-metal self-drilling fasteners.

Metal roofing has a reputation of being among the most durable, economical, and visually appealing roofing choices. When the wrong tools are used however, the integrity of a metal roof can be seriously compromised. Below is a breakdown of the most common tools found on a metal roofing job site, courtesy of Levi's Building Components:

Screw Gun: Metal roofs require hundreds, if not thousands of fasteners, and the best tool for getting the job done right is a variable speed screw gun. The max speed recommended when using a screw gun to install metal panels is 2,500 RPM. The speed recommendations vary based on panel type and thickness. In metal-to-metal applications, the recommendations on carbon steel or 410 stainless steel are as follows: Less than ¼" panel—2,500 RPM; ¼" to ½"—2,000 RPM. Recommendations for 304 stainless steel are: all thicknesses—2,000 RPM if using self-drilling fasteners; all thicknesses—1,000 RPM if using self-tapping fasteners. For metal-to-wood applications, a screw gun with up to 2,500 RPM is recommended.

Cordless Drills/Drivers: While a cordless drill/driver can be used for installing metal roofing, the Metal Construction Association (MCA) has specifically recommended against using impact drills when installing metal panels. The use of impact drills can result in overdriving the fasteners, which can damage the metal panels. The force of impact drills has also resulted in damaging paint and coatings, and even breaking the heads off of screws while they are being installed. While impact drivers are commonly used among contractors, it is important to note the high risk of damaging screws and metal panels with these tools, which can result in early corrosion of both the fasteners and metal panels.

Shears: Shears for cutting metal panels are a must-have for many metal roofing contractors. Shears allow for on-site cutting of metal panels in order to fit the size and shape of each roof. Companies such as Swenson Shear have created a great product with a variety of blades to make the cutting of panels incredibly easy.



Nibblers: Nibblers are a great tool for quick hand-cutting of metal panels. Nibbler attachments can be found for drills, enabling low-cost clean cutting of panels that is easy to do on the go.

Seaming Tool: For panels that require machine folding of panel seams in order to lock the panels together, a seaming tool is needed. A seaming tool crimps the panels at the locking points. Some panels are double-locked, requiring two different types of crimping. Hand seamers can be used, but are typically reserved for smaller jobs or hard to reach areas. Electric seaming tools fit over the seam and have motorized wheels, allowing them to go up and down the seam.

Tools Not Recommended for Cutting Metal Panels: When shears or nibblers are not used for cutting metal panels, some resort to using a circular saw or a grinding tool. While these tools *can* cut panels, they damage the panels in ways that can void warranties and expose the edges of the panels to rusting. Circular saws and grinding tools leave rough and jagged edges and often chip away at the protective coatings on the panel, decreasing the life of the roof.

Other Tools: Other tools not discussed here include a rivet gun, various size driver bits and nut setters, a caulk gun, and a spray foam gun.

While virtually everyone has at times thought of ways to do a job without having the necessary tools, the best way to get any job done is to have the right tools to do it. Following manufacturer recommendations and best practices is always important for warranties and ensuring a functional, long-lasting, and attractive metal roof. While Levi's Building Components does not sell all of the tools mentioned, they are able to provide recommendations on tool specifications, but not on particular product brands. Swenson Shear, driver bits, spray foam guns, and rivet guns are available through Levi's Building Components and their suppliers. **MR**

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www.acuformequipment.com

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www.ascmt.com

Atlas Building Products



AccuDRYve System Technology includes a screw gun and fastener that automatically stops driving the fastener when properly seated for a leak-proof seal. The fastener washer is engineered to deflect with proper force to disengage the clutch and stop driving the fastener. Dual-thread design prevents metal from panel extruding up, cutting the washer, and ensuring that the metal panel is flush to the substrate before seating.

www.atlasfasteners.com

The Bradbury Group



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www.directmetalsinc.com

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www.dripstop.com

East Coast Fasteners



East Coast Fasteners produces durable fasteners for all combinations of building materials. The Ply-Lo Extreme line of fasteners is designed for extreme environments. The Ply-Lo Driller is the latest addition to the company's fastener line, designed to save time and money. The Ply-Lo Driller features a patent-pending design intended to be more forgiving. This means the tip is designed to reduce the likelihood of "walking" when driven at a slight angle. Less walking means quicker/easier installation and a reduction in damage and waste. The Ply-Lo Driller is available in colors to match virtually any panel as a #10 fastener in lengths of 1", 1½", 2", 2½", and 3".

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www.lelandindustries.com

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www.levisbuildingcomponents.com

Logan Stampings



Logan Stampings and Building Products Development (BPD), Logansport, Indiana, are two of the most well-known names in the metal building and metal roofing market. Products include standing seam roof clips and accessories for a multitude of metal roof systems. While BPD is the ideal source for any contractor roll forming panels at a job site, Logan is the premier source for metal building and roofing manufacturers. Their inventory levels enable them to offer same-day shipping with most stock orders.

www.loganstampings.com

Marco Industries



As North America's leading ventilation manufacturer, Marco Industries offers superior roof ventilation your way, with products tailored to fit your specific performance requirements and budget. Our ventilation products feature an exclusive nonwoven polyester material that delivers extreme durability and breathes to help prevent moisture absorption. All ventilation products offer a 40-year limited warranty, easy one-person installations, and two full beads of M63, Marco's proprietary adhesive, for superior hold.

www.marcoindustries.com

Maze Nails



Maze is the exclusive manufacturer of Stormguard double hot-dipped galvanized nails with a lifetime warranty against rust. Maze offers a full line of specialty nails in bulk for hand driving and in collated sticks and coils for popular pneumatic nailers. Maze also offers painted rubber washer nails for corrugated roofing and siding. Maze post-frame nails meet the all-important ASTM F 1667 specification. In addition, Maze manufactures nails for fiber cement siding products, cedar and redwood sidings, fencing, decking, and roofing.

www.mazenails.com

Metal Plus, LLC



Metal Plus, LLC, continues to create and develop metal roofing tools in order to create a safer and better workplace for our industry. We now offer three brackets that are second to none: The Ultimate Bracket, The Big Boys, and The Roofer's Helper. Installation of standing seam metal roofing has never been so fast, efficient, and comfortable. We've also revolutionized the industry of anchor points with our newest product, the Universal Safety Anchor (USA)!

www.metalplusllc.com

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www.mwicomponents.com

Petersen Aluminum/PAC-CLAD



Petersen's Snap-Clad metal roofing panels feature architectural aesthetics and structural performance. Snap-Clad panels offer a 1¾" leg height and a continuous interlock for improved wind resistance. A concealed-fastener clip system allows for thermal expansion/contraction while providing extraordinary hold-down strength. Snap-Clad panels come in 45 standard colors with a 30-year non-prorated finish warranty. Most colors meet LEED®, ENERGY STAR®, and cool roof certification.

www.pac-clad.com

Raytec Manufacturing



HangTite and HangFast hidden gutter hangers, manufactured by Raytec Manufacturing, are exceptionally strong. Both have proven records of performance, strength, and ease of use in the field. Raytec engineers designed the HangTite to be strong. HangFast hangers, with the integrated screw, add speed to the installation without compromising performance. Both hangers are available in 5" and 6" sizes in aluminum, galvanized, and copper.

www.raytecllc.com

Roof Hugger



Roof Huggers are 10' long, tested, high-strength, structurally correct, 16-gauge, 0.060" min., G-90, 50 KSI, "Z" shaped sub-purlins, specifically notched to let the ribs of any existing metal panel pass through the vertical leg of the "Z." This unique retrofit system allows any new metal roof to be installed over an existing metal roof without its removal, saving time and money and allowing for thermal upgrading of the existing building.

www.roofhugger.com

ST Fastening Systems



ST Fastening Systems supplies steel-frame and post-frame screws for agricultural, commercial, industrial, and residential metal roof applications. Product strengths are drill quality and corrosion resistance, enhanced by the state-of-the-art POWDERFUL powder coat paint. The MAXX Steelbinder and Woodbinder MB with micro-bit drill point eliminates slow-drill or no-drill complaints. The ZXL Steelbinder and Woodbinder is a zinc-aluminum alloy molded head family that carries a 40-year warranty against red rust.

www.stfasteningsystems.com

Triangle Fastener Corporation



The new PANEL-TITE® Metal-to-Wood screws have a patent-pending BURR BUSTER® point, which reduces burrs and chips caused during installation that can lead to leaks and rust stains on the panel. The special low-angle thread helps reduce over-driving—a problem that causes the screw to loosen and leak. Has TRI-SEAL® long-life coating that resists rust better than ordinary wood screws. Carbon steel available in diameters #10, #12, and #14. For warranted panels, stainless cap head, zinc cap head, and 304 stainless steel are available.

www.trianglefastener.com

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NEW PRODUCTS



Large Diameter Screw Now Available

Dynamic Fastener has added a large diameter screw for attaching sheet to sheet, up to .048" thick steel or sheet metal to wood. The 17-10 x 1½" 3/8" Hex Washer Head includes a Type 17 point. This fastener is the perfect solution to plug a hole that was previously occupied by a #14 diameter screw. The screw is available with a 5/8" outside diameter washer or without. Also comes standard with our Dyna-Coat® 1000-hour salt spray premium coating.

www.dynamicfastener.com



Modibond® G FR APP Granulated Cap Sheet

Polyglass, a leading manufacturer of modified bitumen roofing and waterproofing membranes and roof coatings for low and steep-slope applications, announces Modibond® G FR, an APP (plastomeric) granulated cap sheet for low-slope roofs. Featuring fire-retardant additives, Modibond G FR is specially designed for heat-welded applications. It is ideal for new roofing, reroofing, re-cover, and for flashing details. Modibond G FR can be applied directly over an acceptable substrate or as part of a multi-ply system. It is classified as an acceptable option in UL Class A assemblies for a fully adhered cap sheet on a combustible deck.

Modibond G FR incorporates a high-quality polyester mat, providing superior tear strength and puncture resistance. The quality APP compound and durable construction ensures long-term weathering performance. The top surface is granulated while the bottom surface has a factory-applied burn-off film.

With a proprietary blend of APP modified bitumen that allows for superior weathering, Modibond G FR is designed to withstand severe exposure to fire and fortify against increasingly destructive wildfire seasons. In addition to meeting UL Class A assembly standards, Modibond G FR meets ASTM D6222, Type 1, Grade G standards and is FM Approved.

www.polyglass.us/product-type/app-membranes

New Color Introduced by Coated Metals Group

Coated Metals Group is proud to announce the addition of Rustic Rawhide to their already robust offering of standard products. Featuring warm colors and an engaging texture, Rustic Rawhide offers a beautiful natural appearance paired with an industry-leading complete paint warranty.

A Steelscape patented finish, Rustic Rawhide offers both beauty and performance. Having a textured paint finish, it instantly draws attraction by in-



teracting dynamically with light and re-creating the feel of traditional oxidized metal. Rustic Rawhide is an exceptionally versatile finish that was developed to pair well with a variety of different architectural styles.

Rustic Rawhide will be offered on CMG's standard 24-gauge substrate and is backed by a 30-year complete finish warranty. Available at all eight CMG locations, Rustic Rawhide is available for immediate shipment.

www.cmgmetals.com



20V MAX* Brushless Handheld Blower Released by DeWalt

The new 20V MAX* Brushless Handheld Blower by DeWalt provides the ability to clear job site debris with an air volume of up to 450 cubic feet per minute and up to 125 miles per hour with the concentrator nozzle. With a lightweight and ergonomic design, the blower gives users directional control and tackles user fatigue. The variable-speed trigger and speed lock give you full power control.

Features of this new blower include:

- Up to 450 cubic feet per minute of air volume and up to 125 miles per hour with concentrator
- An innovative axial fan design that maximizes on air output and run time
- Low noise during operation (66 dB(A)), ideal for noise-sensitive regions and properties
- High-efficiency brushless motor helps extend run time and motor life
- A lightweight and ergonomic design allowing for easy user control and arm movement
- Variable trigger and speed lock for precise power control

www.dewalt.com **MR**

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The FRSA Educational & Research Foundation is working hard to produce online versions of every CE course that would have been offered at the Convention. 17 hours of codes, business practice, roofing skills and more. **Target launch is July 1.** Visit www.floridarooft.com for updates.



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-Brandon Ingram, Architect, C. Brandon Ingram Design

Tallahassee Residence Installing contractor: Tallahassee Roofing Architect: C. Brandon Ingram Design
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