

**SECTION 13 34 19**  
**METAL BUILDING SYSTEMS**

**PART 1 - GENERAL**

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

A. Section Includes:

- 1. Structural-steel framing.
- 2. Metal roof panels.
- 3. Metal wall panels.
- 4. Metal soffit panels.
- 5. Thermal insulation.
- 6. Accessories (roof ventilators, and louvers).

B. Related Sections:

- 1. Division 08 Section "Insulated Overhead Coiling Doors."

1.3 DEFINITIONS

- A. Terminology Standard: See MBMA's "Metal Building Systems Manual" for definitions of terms for metal building system construction not otherwise defined in this Section or in referenced standards.

1.4 SUBMITTALS

- A. Product Data: For each type of metal building system component. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes for the following:

- 1. Structural-steel-framing system.
- 2. Metal roof panels.
- 3. Metal wall panels.
- 4. Metal liner panels.
- 5. Insulation and vapor retarder facings.
- 6. Flashing and trim.
- 7. Accessories.

- B. Shop Drawings: For the following metal building system components. Include plans, elevations, sections, details, and attachments to other work. All structural drawings and calculations provided shall be signed and sealed by a registered professional engineer in the state of Alabama.
1. Anchor-Bolt Plans: Submit anchor-bolt plans and templates before foundation work begins. Include a plan view showing the building columns, girt lines, base plate locations, and location, diameter, and projection of anchor bolts required to attach metal building to foundation. Indicate column reactions at each location for each load case as required by ASCE 7 for verification of the foundation design by the Engineer of Record.
  2. Structural-Framing Drawings: Show complete fabrication of primary and secondary framing; include provisions for openings. Indicate welds and bolted connections, distinguishing between shop and field applications. Include transverse cross-sections.
    - a. Show provisions for attaching bridge crane.
    - b. Provide drawings for the cold formed steel framing required for the modifications to the existing building roof slope. A plan view showing the location of the existing purlins to remain, the building frame, and the locations of the new trusses and girt lines. Provide elevations for the filler trusses showing. Provide all connection details of the trusses to the existing frame and for the trusses to the steel deck.
  3. Metal Roof and Wall Panel Layout Drawings: Show layouts of metal panels including methods of support. Include details of edge conditions, joints, panel profiles, corners, anchorages, trim, flashings, closures, and special details. Distinguish between factory- and field-assembled work; show locations of exposed fasteners.
    - a. Show roof-mounted items including roof hatches, equipment supports, pipe supports and penetrations, lighting fixtures, and items mounted on roof curbs.
    - b. Show wall-mounted items including doors, windows, louvers, and lighting fixtures.
  4. Accessory Drawings: Include details of the following items, at a scale of not less than 1-1/2 inches per 12 inches (1:8):
    - a. Flashing and trim.
    - b. Roof ventilators.
    - c. Louvers.
- C. Samples for Initial Selection: For units with factory-applied color finish.
- D. Samples for Verification: For each type of exposed finish required, prepared on Samples of sizes indicated below:
1. Metal Panels: Nominal 12 inches (300 mm) long by actual panel width. Include fasteners, closures, and other exposed panel accessories.

2. Flashing and Trim: Nominal 12 inches (300 mm) long. Include fasteners and other exposed accessories.
  3. Vapor-Retarder Facings: Nominal 6-inch- (150-mm-) square Samples.
  4. Windows: Full-size, nominal 12-inch- (300-mm-) long frame Samples showing typical profile.
  5. Accessories: Nominal 12-inch- (300-mm-) long Samples for each type of accessory.
- E. Door Schedule: For doors and frames. Use same designations indicated on Drawings. Include details of reinforcement.
1. Door Hardware Schedule: Include details of fabrication and assembly of door hardware. Organize schedule into door hardware sets indicating complete designations of every item required for each door or opening.
  2. Keying Schedule: Detail Owner's final keying instructions for locks. Include schematic keying diagram and index each key set to unique door designations.
- F. Delegated-Design Submittal: For metal building systems indicated to comply with performance requirements and design criteria, including analysis data signed and sealed by the qualified professional engineer responsible for their preparation.
- G. Qualification Data: For qualified erector and manufacturer.
- H. Welding certificates.
- I. Metal Building System Certificates: For each type of metal building system, from manufacturer.
1. Letter of Design Certification: Signed and sealed by a qualified professional engineer. Include the following:
    - a. Name and location of Project.
    - b. Order number.
    - c. Name of manufacturer.
    - d. Name of Contractor.
    - e. Building dimensions including width, length, height, and roof slope.
    - f. Indicate compliance with AISC standards for hot-rolled steel and AISI standards for cold-rolled steel, including edition dates of each standard.
    - g. Governing building code and year of edition.
    - h. Design Loads: Include dead load, roof live load, collateral loads, roof snow load, deflection, wind loads/speeds and exposure, seismic design category or effective peak velocity-related acceleration/peak acceleration, and auxiliary loads (cranes).

- i. Load Combinations: Indicate that loads were applied acting simultaneously with concentrated loads, according to governing building code.
  - j. Building-Use Category: Indicate category of building use and its effect on load importance factors.
  - k. AISC Certification for Category MB: Include statement that metal building system and components were designed and produced in an AISC-Certified Facility by an AISC-Certified Manufacturer.
- J. Erector Certificates: For each product, from manufacturer.
- K. Manufacturer Certificates: For each product, from manufacturer.
- L. Material Test Reports: For each of the following products:
  - 1. Structural steel including chemical and physical properties.
  - 2. Bolts, nuts, and washers including mechanical properties and chemical analysis.
  - 3. Tension-control, high-strength, bolt-nut-washer assemblies.
  - 4. Shop primers.
  - 5. Nonshrink grout.
- M. Product Test Reports: Based on evaluation of comprehensive tests performed by manufacturer and witnessed by a qualified testing agency, for insulation and vapor-retarder facings. Include reports for thermal resistance, fire-test-response characteristics, water-vapor transmission, and water absorption.
- N. Source quality-control reports.
- O. Field quality-control reports.
- P. Surveys: Show final elevations and locations of major members. Indicate discrepancies between actual installation and the Contract Documents. Have surveyor who performed surveys certify their accuracy.
- Q. Maintenance Data: For metal panel finishes and door hardware to include in maintenance manuals.
- R. Warranties: Sample of special warranties.

## 1.5 QUALITY ASSURANCE

- A. Manufacturer Qualifications: A qualified manufacturer and member of MBMA.
  - 1. AISC Certification for Category MB: An AISC-Certified Manufacturer that designs and produces metal building systems and components in an AISC-Certified Facility.

2. Engineering Responsibility: Preparation of Shop Drawings and comprehensive engineering analysis by a qualified professional engineer.
- B. Land Surveyor Qualifications: A professional land surveyor who practices in jurisdiction where Project is located and who is experienced in providing surveying services of the kind indicated.
- C. Erector Qualifications: An experienced erector who specializes in erecting and installing work similar in material, design, and extent to that indicated for this Project and who is acceptable to manufacturer.
- D. Testing Agency Qualifications: Qualified according to ASTM E 329 for testing indicated.
- E. Source Limitations: Obtain metal building system components, including primary and secondary framing and metal panel assemblies, from single source from single manufacturer.
- F. Welding Qualifications: Qualify procedures and personnel according to the following:
  1. AWS D1.1/D1.1M, "Structural Welding Code - Steel."
  2. AWS D1.3, "Structural Welding Code - Sheet Steel."
- G. Structural Steel: Comply with AISC 360, "Specification for Structural Steel Buildings," for design requirements and allowable stresses.
- H. Cold-Formed Steel: Comply with AISI's "North American Specification for the Design of Cold-Formed Steel Structural Members" for design requirements and allowable stresses.
- I. Fire-Resistance Ratings: Where indicated, provide metal panel assemblies identical to those of assemblies tested for fire resistance per ASTM E 119 by a qualified testing agency. Identify products with appropriate markings of applicable testing agency.
  1. Indicate design designations from UL's "Fire Resistance Directory" or from the listings of another qualified testing agency.
  2. Combustion Characteristics: ASTM E 136.
- J. Fire-Rated Door Assemblies: Assemblies complying with NFPA 80 that are listed and labeled by a qualified testing agency, for fire-protection ratings indicated, based on testing at positive pressure according to NFPA 252 or UL 10C.
  1. Oversize Fire-Rated Door Assemblies: For units exceeding sizes of tested assemblies, provide certification by a qualified testing agency that doors comply

with standard construction requirements for tested and labeled fire-rated door assemblies except for size.

- K. Preinstallation Conference: Conduct conference at Project site .
1. Review methods and procedures related to metal building systems including, but not limited to, the following:
    - a. Condition of foundations and other preparatory work performed by other trades.
    - b. Structural load limitations.
    - c. Construction schedule. Verify availability of materials and erector's personnel, equipment, and facilities needed to make progress and avoid delays.
    - d. Required tests, inspections, and certifications.
    - e. Unfavorable weather and forecasted weather conditions.
  2. Review methods and procedures related to metal roof panel assemblies including, but not limited to, the following:
    - a. Compliance with requirements for purlin and rafter conditions, including flatness and attachment to structural members.
    - b. Structural limitations of purlins and rafters during and after roofing.
    - c. Flashings, special roof details, roof drainage, roof penetrations, equipment curbs, and condition of other construction that will affect metal roof panels.
    - d. Temporary protection requirements for metal roof panel assembly during and after installation.
    - e. Roof observation and repair after metal roof panel installation.
  3. Review methods and procedures related to metal wall panel assemblies including, but not limited to, the following:
    - a. Compliance with requirements for support conditions, including alignment between and attachment to structural members.
    - b. Structural limitations of girts and columns during and after wall panel installation.
    - c. Flashings, special siding details, wall penetrations, openings, and condition of other construction that will affect metal wall panels.
    - d. Temporary protection requirements for metal wall panel assembly during and after installation.
    - e. Wall observation and repair after metal wall panel installation.

## 1.6 DELIVERY, STORAGE, AND HANDLING

- A. Deliver components, sheets, panels, and other manufactured items so as not to be damaged or deformed. Package metal panels for protection during transportation and handling.
- B. Unload, store, and erect metal panels in a manner to prevent bending, warping, twisting, and surface damage.

- C. Stack metal panels horizontally on platforms or pallets, covered with suitable weathertight and ventilated covering. Store metal panels to ensure dryness, with positive slope for drainage of water. Do not store metal panels in contact with other materials that might cause staining, denting, or other surface damage.
- D. Protect foam-plastic insulation as follows:
  - 1. Do not expose to sunlight, except to extent necessary for period of installation and concealment.
  - 2. Protect against ignition at all times. Do not deliver foam-plastic insulation materials to Project site before installation time.
  - 3. Complete installation and concealment of foam-plastic materials as rapidly as possible in each area of construction.

## 1.7 PROJECT CONDITIONS

- A. Weather Limitations: Proceed with installation only when weather conditions permit metal panels to be installed according to manufacturers' written instructions and warranty requirements.
- B. Field Measurements:
  - 1. Established Dimensions for Foundations: Comply with established dimensions on approved anchor-bolt plans, establishing foundation dimensions and proceeding with fabricating structural framing without field measurements. Coordinate anchor-bolt installation to ensure that actual anchorage dimensions correspond to established dimensions.
  - 2. Established Dimensions for Metal Panels: Where field measurements cannot be made without delaying the Work, either establish framing and opening dimensions and proceed with fabricating metal panels without field measurements, or allow for field trimming metal panels. Coordinate construction to ensure that actual building dimensions, locations of structural members, and openings correspond to established dimensions.
  - 3. Established Dimensions for Existing Building: Field measure the existing building for all dimensions needed for wall panels, roof support members, and roof replacement limits.

## 1.8 COORDINATION

- A. Coordinate sizes and locations of concrete foundations and casting of anchor-bolt inserts into foundation walls and footings. Concrete, reinforcement, and formwork requirements are specified in Division 03 Section "Cast-in-Place Concrete."
- B. Coordinate metal panel assemblies with rain drainage work, flashing, trim, and construction of supports and other adjoining work to provide a leakproof, secure, and noncorrosive installation.

## 1.9 WARRANTY

- A. Special Warranty on Metal Panel Finishes: Manufacturer's standard form in which manufacturer agrees to repair finish or replace metal panels that show evidence of deterioration of factory-applied finishes within specified warranty period.
  - 1. Exposed Panel Finish: Deterioration includes, but is not limited to, the following:
    - a. Color fading more than 5 Hunter units when tested according to ASTM D 2244.
    - b. Chalking in excess of a No. 8 rating when tested according to ASTM D 4214.
    - c. Cracking, checking, peeling, or failure of paint to adhere to bare metal.
  - 2. Finish Warranty Period: 20 years from date of Substantial Completion.
- B. Special Weathertightness Warranty for Standing-Seam Metal Roof Panels: Manufacturer's standard form in which manufacturer agrees to repair or replace standing-seam metal roof panel assemblies that leak or otherwise fail to remain weathertight within specified warranty period.
  - 1. Warranty Period: 20 years from date of Substantial Completion.

## PART 2 - PRODUCTS

### 2.1 MANUFACTURERS

- A. Manufacturers: Subject to compliance with requirements, available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
  - 1. A&S Building Systems, Inc.; Division of NCI Building Systems, L.P.
  - 2. Alliance Steel, Inc.
  - 3. American Buildings Company; Division of Magnatrx Corp.
  - 4. American Steel Building Co., Inc.
  - 5. BC Steel Buildings, Inc.
  - 6. Behlen Mfg. Co.
  - 7. Bigbee Steel Buildings, Inc.
  - 8. Butler Manufacturing Company; a BlueScope Steel company.
  - 9. CBC Steel Buildings; Division of Magnatrx Corp.
  - 10. Ceco Building Systems; Division of NCI Building Systems, L.P.
  - 11. Chief Buildings; Division of Chief Industries, Inc.
  - 12. Elite Structures, Inc.
  - 13. Garco Building Systems; Division of NCI Building Systems, L.P.
  - 14. Gulf States Manufacturers, Inc.; Division of Magnatrx Corp.

15. Inland Buildings; Subsidiary of Behlen Mfg. Co.
16. Kirby Building Systems; Division of Magnatrax Corp.
17. Mesco Building Solutions; Division of NCI Building Systems, L.P.
18. Metallic Building Company; Division of NCI Building Systems, L.P.
19. Metco Metal Supply.
20. Mid-West Steel Building Company; Division of NCI Building Systems, L.P.
21. Nucor Building Systems.
22. Oakland Metal Buildings, Inc.
23. Olympia Steel Building Systems.
24. Package Industries, Inc.
25. Pinnacle Structures, Inc.
26. Robertson Building Systems; an NCI company.
27. Ruffin Building Systems, Inc.
28. Schulte Building Systems, LLP.
29. Spirco Manufacturing.
30. Star Building Systems; an NCI company.
31. Tyler Building Systems, L.P.
32. USA, Inc.
33. VP Buildings; a United Dominion company.
34. Vulcan Steel Structures, Inc.
35. Whirlwind Building Systems.

## 2.2 METAL BUILDING SYSTEMS

- A. Description: Provide a complete, integrated set of metal building system manufacturer's standard mutually dependent components and assemblies that form a metal building system capable of withstanding structural and other loads, thermally induced movement, and exposure to weather without failure or infiltration of water into building interior.
  1. Provide metal building system of size and with bay spacings, roof slopes, and spans indicated.
- B. Primary-Frame Type:
  1. Rigid Clear Span: Solid-member, structural-framing system without interior columns.
- C. End-Wall Framing: Manufacturer's standard, for buildings not required to be expandable, consisting of primary frame, capable of supporting one-half of a bay design load, and end-wall columns.
- D. End-Wall Framing: Engineer end walls to be expandable. Provide primary frame, capable of supporting full-bay design loads, and end-wall columns.

- E. Secondary-Frame Type: Manufacturer's standard purlins and joists and flush-framed girts.
- F. Eave Height: Manufacturer's standard height, as indicated by nominal height on Drawings .
- G. Bay Spacing: As shown on the plans.
- H. Roof Slope: 1 inch per 12 inches (1:12).
- I. Roof System: Manufacturer's standard vertical-rib, standing-seam metal roof panels.
- J. Exterior Wall System: Manufacturer's standard tapered-rib, exposed-fastener metal wall panels with field-installed insulation.

### 2.3 METAL BUILDING SYSTEM PERFORMANCE

- A. Delegated Design: Design metal building system, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.
- B. Structural Performance: Metal building systems shall withstand the effects of gravity loads and the following loads and stresses within limits and under conditions indicated according to procedures in MBMA's "Metal Building Systems Manual."
  - 1. Design Loads: As indicated on Drawings.
  - 2. Deflection Limits: Design metal building system assemblies to withstand design loads with deflections no greater than the following:
    - a. Purlins and Rafters: Vertical deflection of 1/240 of the span.
    - b. Girts: Horizontal deflection of 1/180 of the span.
    - c. Metal Roof Panels: Vertical deflection of 1/180 of the span.
    - d. Metal Wall Panels: Horizontal deflection of 1/180 of the span.
    - e. Design secondary-framing system to accommodate deflection of primary framing and construction tolerances, and to maintain clearances at openings.
  - 3. Drift Limits: Engineer building structure to withstand design loads with drift limits no greater than the following:
    - a. Lateral Drift: Maximum of 1/200 of the building height.
  - 4. Metal panel assemblies shall withstand the effects of gravity loads and loads and stresses within limits and under conditions indicated according to ASTM E 1592.
- C. Seismic Performance: Metal building systems shall withstand the effects of earthquake motions determined according to ASCE/SEI 7.

- D. Thermal Movements: Allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures by preventing buckling, opening of joints, overstressing of components, failure of joint sealants, failure of connections, and other detrimental effects. Base engineering calculations on surface temperatures of materials due to both solar heat gain and nighttime-sky heat loss.
  - 1. Temperature Change (Range): 120 deg F (67 deg C), ambient; 180 deg F (100 deg C), material surfaces.
- E. Air Infiltration for Metal Roof Panels: Air leakage through assembly of not more than 0.06 cfm/sq. ft. (0.3 L/s per sq. m) of roof area when tested according to ASTM E 1680 at negative test-pressure difference of 1.57 lbf/sq. ft. (75 Pa) .
- F. Air Infiltration for Metal Wall Panels: Air leakage through assembly of not more than 0.06 cfm/sq. ft. (0.3 L/s per sq. m) of wall area when tested according to ASTM E 283 at static-air-pressure difference of 1.57 lbf/sq. ft. (75 Pa) .
- G. Water Penetration for Metal Roof Panels: No water penetration when tested according to ASTM E 1646 at test-pressure difference of 2.86 lbf/sq. ft. (137 Pa) .
- H. Water Penetration for Metal Wall Panels: No water penetration when tested according to ASTM E 331 at a wind-load design pressure of not less than 2.86 lbf/sq. ft. (137 Pa) .
- I. Wind-Uplift Resistance: Provide metal roof panel assemblies that comply with UL 580 for Class 60 .
- J. Energy Performance: Provide roof panels with Solar Reflectance Index not less than 29 when calculated according to ASTM E 1980 based on testing identical products by a qualified testing agency.
- K. Energy Performance: Provide roof panels that are listed on the DOE's ENERGY STAR Roof Products Qualified Product List for low -slope roof products.

## 2.4 STRUCTURAL-STEEL FRAMING

- A. Primary Framing: Manufacturer's standard primary-framing system, designed to withstand required loads and specified requirements. Primary framing includes transverse and lean-to frames; rafter, rake, and canopy beams; sidewall, intermediate, end-wall, and corner columns; and wind bracing.
  - 1. General: Provide frames with attachment plates, bearing plates, and splice members. Factory drill for field-bolted assembly. Provide frame span and spacing indicated.
    - a. Slight variations in span and spacing may be acceptable if necessary to comply with manufacturer's standard, as approved by Architect.

2. Frame Configuration: Single gable.
  3. Exterior Column Type: Tapered.
  4. Rafter Type: Uniform depth.
- B. End-Wall Framing: Manufacturer's standard primary end-wall framing fabricated for field-bolted assembly to comply with the following:
1. End-Wall and Corner Columns: I-shaped sections fabricated from structural-steel shapes; shop-welded, built-up steel plates; or C-shaped, cold-formed, structural-steel sheet.
  2. End-Wall Rafters: C-shaped, cold-formed, structural-steel sheet; or I-shaped sections fabricated from shop-welded, built-up steel plates or structural-steel shapes.
- C. Secondary Framing: Manufacturer's standard secondary framing, including purlins, girts, eave struts, flange bracing, base members, gable angles, clips, headers, jambs, and other miscellaneous structural members. Unless otherwise indicated, fabricate framing from either cold-formed, structural-steel sheet or roll-formed, metallic-coated steel sheet, prepainted with coil coating, to comply with the following:
1. Purlins: C- or Z-shaped sections; fabricated from built-up steel plates, steel sheet, or structural-steel shapes; minimum 2-1/2-inch- (64-mm-) wide flanges.
    - a. Depth: As needed to comply with system performance requirements.
  2. Girts: C- or Z-shaped sections; fabricated from built-up steel plates, steel sheet, or structural-steel shapes. Form ends of Z-sections with stiffening lips angled 40 to 50 degrees from flange, with minimum 2-1/2-inch- (64-mm-) wide flanges.
    - a. Depth: 8"
  3. Eave Struts: Unequal-flange, C-shaped sections; fabricated from built-up steel plates, steel sheet, or structural-steel shapes; to provide adequate backup for metal panels.
  4. Flange Bracing: Minimum 2-by-2-by-1/8-inch (51-by-51-by-3-mm) structural-steel angles or 1-inch (- (25-mm-) diameter, cold-formed structural tubing to stiffen primary-frame flanges.
  5. Sag Bracing: Minimum 1-by-1-by-1/8-inch (25-by-25-by-3-mm) structural-steel angles.
  6. Base or Sill Angles: Minimum 3-by-2-inch (76-by-51-mm) zinc-coated (galvanized) steel sheet.
  7. Purlin and Girt Clips: Manufacturer's standard clips fabricated from steel sheet. Provide galvanized clips where clips are connected to galvanized framing members.
  8. Secondary End-Wall Framing: Manufacturer's standard sections fabricated from structural-steel sheet.

9. Framing for Openings: Channel shapes; fabricated from cold-formed, structural-steel sheet or structural-steel shapes. Frame head and jamb of door openings and head, jamb, and sill of other openings.
10. Miscellaneous Structural Members: Manufacturer's standard sections fabricated from cold-formed, structural-steel sheet; built-up steel plates; or zinc-coated (galvanized) steel sheet; designed to withstand required loads.

D. Bracing: Provide adjustable wind bracing as follows:

1. Rods: ASTM A 36/A 36M; ASTM A 572/A 572M, Grade 50 (345); or ASTM A 529/A 529M, Grade 50 (345); minimum 1/2-inch- (13-mm-) diameter steel; threaded full length or threaded a minimum of 6 inches (152 mm) at each end.
2. Cable: ASTM A 475, 1/4-inch- (6-mm-) diameter, extra-high-strength grade, Class B, zinc-coated, seven-strand steel; with threaded end anchors.
3. Angles: Fabricated from structural-steel shapes to match primary framing, of size required to withstand design loads.
4. Rigid Portal Frames: Fabricated from shop-welded, built-up steel plates or structural-steel shapes to match primary framing; of size required to withstand design loads.
5. Fixed-Base Columns: Fabricated from shop-welded, built-up steel plates or structural-steel shapes to match primary framing; of size required to withstand design loads.
6. Diaphragm Action of Metal Panels: Design metal building to resist wind forces through diaphragm action of metal panels.
7. Bracing: Provide wind bracing using any method specified above, at manufacturer's option.

E. Bolts: Provide plain-finish bolts for structural-framing components that are primed or finish painted. Provide hot-dip galvanized bolts for structural-framing components that are galvanized.

F. Materials:

1. W-Shapes: ASTM A 992/A 992M; ASTM A 572/A 572M, Grade 50 or 55 (345 or 380); or ASTM A 529/A 529M, Grade 50 or 55 (345 or 380).
2. Channels, Angles, M-Shapes, and S-Shapes: ASTM A 36/A 36M; ASTM A 572/A 572M, Grade 50 or 55 (345 or 380); or ASTM A 529/A 529M, Grade 50 or 55 (345 or 380).
3. Plate and Bar: ASTM A 36/A 36M; ASTM A 572/A 572M, Grade 50 or 55 (345 or 380); or ASTM A 529/A 529M, Grade 50 or 55 (345 or 380).
4. Steel Pipe: ASTM A 53/A 53M, Type E or S, Grade B.
5. Cold-Formed Hollow Structural Sections: ASTM A 500, Grade B or C, structural tubing.
6. Structural-Steel Sheet: Hot-rolled, ASTM A 1011/A 1011M, Structural Steel (SS), Grades 30 through 55 (205 through 380), or High-Strength Low-Alloy Steel (HSLAS), Grades 45 through 70 (310 through 480); or cold-

- rolled, ASTM A 1008/A 1008M, Structural Steel (SS), Grades 25 through 80 (170 through 550), or High-Strength Low-Alloy Steel (HSLAS), Grades 45 through 70 (310 through 480).
7. Metallic-Coated Steel Sheet: ASTM A 653/A 653M, Structural Steel (SS), Grades 33 through 80 (230 through 550), or High-Strength Low-Alloy Steel (HSLAS), Grades 50 through 80 (340 through 550); with G60 (Z180) coating designation; mill phosphatized.
  8. Metallic-Coated Steel Sheet Prepainted with Coil Coating: Steel sheet, metallic coated by the hot-dip process and prepainted by the coil-coating process to comply with ASTM A 755/A 755M.
    - a. Zinc-Coated (Galvanized) Steel Sheet: ASTM A 653/A 653M, Structural Steel (SS), Grades 33 through 80 (230 through 550), or High-Strength Low-Alloy Steel (HSLAS), Grades 50 through 80 (340 through 550); with G90 (Z275) coating designation.
    - b. Aluminum-Zinc Alloy-Coated Steel Sheet: ASTM A 792/A 792M, Structural Steel (SS), Grade 50 or 80 (340 or 550); with Class AZ50 (AZM150) coating.
  9. High-Strength Bolts, Nuts, and Washers: ASTM A 325 (ASTM A 325M), Type 1, heavy-hex steel structural bolts; ASTM A 563 (ASTM A 563M) heavy-hex carbon-steel nuts; and ASTM F 436 (ASTM F 436M) hardened carbon-steel washers.
    - a. Finish: Hot-dip zinc coating, ASTM A 153/A 153M, Class C.
  10. Headed Anchor Rods: ASTM F 1554, Grade 36.
    - a. Configuration: Straight.
    - b. Nuts: ASTM A 563 (ASTM A 563M) heavy-hex carbon steel.
    - c. Plate Washers: ASTM A 36/A 36M carbon steel.
    - d. Washers: ASTM F 436 (ASTM F 436M) hardened carbon steel.
    - e. Finish: Hot-dip zinc coating, ASTM A 153/A 153M, Class C.
  11. Threaded Rods: ASTM A 193/A 193M.
    - a. Nuts: ASTM A 563 (ASTM A 563M) heavy-hex carbon steel.
    - b. Washers: ASTM F 436 (ASTM F 436M) hardened carbon steel.
    - c. Finish: Plain.
- G. Finish: Factory primed. Apply specified primer immediately after cleaning and pretreating.
1. Apply primer to primary and secondary framing to a minimum dry film thickness of 1 mil (0.025 mm).
    - a. Prime secondary framing formed from uncoated steel sheet to a minimum dry film thickness of 0.5 mil (0.013 mm) on each side.
  2. Prime galvanized members with specified primer after phosphoric acid pretreatment.
  3. Primer: SSPC-Paint 15, Type I, red oxide.

## 2.5 METAL ROOF PANELS

A. Vertical-Rib, Standing-Seam Metal Roof Panels : Formed with vertical ribs at panel edges and intermediate stiffening ribs symmetrically spaced between ribs; designed for sequential installation by mechanically attaching panels to supports using concealed clips located under one side of panels and engaging opposite edge of adjacent panels.

1. Material: Zinc-coated (galvanized) steel sheet, 0.022-inch (0.56-mm) nominal thickness.
  - a. Exterior Finish: Fluoropolymer .
  - b. Color: As selected by Architect from manufacturer's full range to match adjacent buildings.
2. Clips: Manufacturer's standard, floating type to accommodate thermal movement; fabricated from zinc-coated (galvanized) steel sheet.
3. Joint Type: Panels snapped together.
4. Joint Type: Mechanically seamed, folded according to manufacturer's standard.
5. Panel Coverage: 16 inches (406 mm) .
6. Panel Height: 2 inches (51 mm) .
7. Uplift Rating: UL 60 .

B. Materials:

1. Metallic-Coated Steel Sheet: Restricted-flatness steel sheet, metallic coated by the hot-dip process and prepainted by the coil-coating process to comply with ASTM A 755/A 755M.
  - a. Zinc-Coated (Galvanized) Steel Sheet: ASTM A 653/A 653M, G90 (Z275) coating designation; structural quality.
  - b. Aluminum-Zinc Alloy-Coated Steel Sheet: ASTM A 792/A 792M, Class AZ50 coating designation, Grade 40 (Class AZM150 coating designation, Grade 275); structural quality.
  - c. Surface: Smooth, flat finish.

C. Finishes:

1. Exposed Coil-Coated Finish:
  - a. Two-Coat Fluoropolymer: AAMA 621. Fluoropolymer finish containing not less than 70 percent PVDF resin by weight in color coat. Prepare, pretreat, and apply coating to exposed metal surfaces to comply with coating and resin manufacturers' written instructions.
  - b. Three-Coat Fluoropolymer: AAMA 621. Fluoropolymer finish containing not less than 70 percent PVDF resin by weight in both color coat and clear topcoat. Prepare, pretreat, and apply coating to exposed metal surfaces to comply with coating and resin manufacturers' written instructions.

- c. Siliconized Polyester: Epoxy primer and silicone-modified, polyester-enamel topcoat; with a dry film thickness of not less than 0.2 mil (0.005 mm) for primer and 0.8 mil (0.02 mm) for topcoat.
- 2. Concealed Finish: Apply pretreatment and manufacturer's standard white or light-colored acrylic or polyester backer finish, consisting of prime coat and wash coat with a minimum total dry film thickness of 0.5 mil (0.013 mm).

## 2.6 METAL WALL PANELS

A. Tapered-Rib-Profile, Exposed-Fastener Metal Wall Panels : Formed with raised, trapezoidal major ribs and intermediate stiffening ribs symmetrically spaced between major ribs; designed to be installed by lapping side edges of adjacent panels and mechanically attaching panels to supports using exposed fasteners in side laps.

- 1. Material: Zinc-coated (galvanized) steel sheet, 0.022-inch (0.56-mm) nominal thickness.
  - a. Exterior Finish: Fluoropolymer .
  - b. Color: As selected by Architect from manufacturer's full range match adjacent buildings.
- 2. Major-Rib Spacing: 12 inches (305 mm) o.c.
- 3. Panel Coverage: 36 inches (914 mm) .
- 4. Panel Height: 1.25 inches (32 mm) .

B. Flush-Profile, Metal Liner Panels : Solid panels formed with vertical panel edges and flat pan between panel edges; with flush joint between panels; designed for interior side of metal wall panel assemblies and installed by lapping and interconnecting side edges of adjacent panels and mechanically attaching through panel to supports using concealed fasteners and factory-applied sealant in side laps.

- 1. Material: Zinc-coated (galvanized) steel sheet, 0.028-inch (0.71-mm) nominal thickness.
  - a. Exterior Finish: Siliconized polyester .
  - b. Color: As selected by Architect from manufacturer's full range .
- 2. Panel Coverage: 12 inches (305 mm) .
- 3. Panel Height: 1.5 inches (38 mm) .

C. Materials:

- 1. Metallic-Coated Steel Sheet: Restricted-flatness steel sheet, metallic coated by the hot-dip process and prepainted by the coil-coating process to comply with ASTM A 755/A 755M.
  - a. Zinc-Coated (Galvanized) Steel Sheet: ASTM A 653/A 653M, G90 (Z275) coating designation; structural quality.

- b. Aluminum-Zinc Alloy-Coated Steel Sheet: ASTM A 792/A 792M, Class AZ50 coating designation, Grade 40 (Class AZM150 coating designation, Grade 275); structural quality.
- c. Surface: Smooth, flat finish.

D. Finishes:

- 1. Exposed Coil-Coated Finish:
  - a. Two-Coat Fluoropolymer: AAMA 621. Fluoropolymer finish containing not less than 70 percent PVDF resin by weight in color coat. Prepare, pretreat, and apply coating to exposed metal surfaces to comply with coating and resin manufacturers' written instructions.
  - b. Three-Coat Fluoropolymer: AAMA 621. Fluoropolymer finish containing not less than 70 percent PVDF resin by weight in both color coat and clear topcoat. Prepare, pretreat, and apply coating to exposed metal surfaces to comply with coating and resin manufacturers' written instructions.
  - c. Siliconized Polyester: Epoxy primer and silicone-modified, polyester-enamel topcoat; with a dry film thickness of not less than 0.2 mil (0.005 mm) for primer and 0.8 mil (0.02 mm) for topcoat.
- 2. Concealed Finish: Apply pretreatment and manufacturer's standard white or light-colored acrylic or polyester backer finish, consisting of prime coat and wash coat with a minimum total dry film thickness of 0.5 mil (0.013 mm).

## 2.7 METAL SOFFIT PANELS

- A. General: Provide factory-formed metal soffit panels designed to be installed by lapping and interconnecting side edges of adjacent panels and mechanically attaching through panel to supports using concealed fasteners and factory-applied sealant in side laps. Include accessories required for weathertight installation.
- B. Metal Soffit Panels: Match profile and material of metal wall panels.
  - 1. Finish: Match finish and color of metal wall panels .

## 2.8 THERMAL INSULATION

- A. Faced Metal Building Insulation: ASTM C 991, Type II, glass-fiber-blanket insulation; 0.5-lb/cu. ft. (8-kg/cu. m) density; 2-inch- (51-mm-) wide, continuous, vapor-tight edge tabs; with a flame-spread index of 25 or less.

## 2.9 ACCESSORIES

- A. General: Provide accessories as standard with metal building system manufacturer and as specified. Fabricate and finish accessories at the factory to greatest extent possible, by manufacturer's standard procedures and processes. Comply with indicated profiles and with dimensional and structural requirements.
1. Form exposed sheet metal accessories that are without excessive oil-canning, buckling, and tool marks and that are true to line and levels indicated, with exposed edges folded back to form hems.
- B. Roof Panel Accessories: Provide components required for a complete metal roof panel assembly including copings, fasciae, corner units, ridge closures, clips, sealants, gaskets, fillers, closure strips, and similar items. Match material and finish of metal roof panels unless otherwise indicated.
1. Closures: Provide closures at eaves and ridges, fabricated of same material as metal roof panels.
  2. Clips: Manufacturer's standard, formed from steel sheet, designed to withstand negative-load requirements.
  3. Cleats: Manufacturer's standard, mechanically seamed cleats formed from steel sheet.
  4. Backing Plates: Provide metal backing plates at panel end splices, fabricated from material recommended by manufacturer.
  5. Closure Strips: Closed-cell, expanded, cellular, rubber or crosslinked, polyolefin-foam or closed-cell laminated polyethylene; minimum 1-inch-(25-mm-) thick, flexible closure strips; cut or premolded to match metal roof panel profile. Provide closure strips where indicated or necessary to ensure weathertight construction.
  6. Thermal Spacer Blocks: Where metal panels attach directly to purlins, provide thermal spacer blocks of thickness required to provide 1-inch (25-mm) standoff; fabricated from extruded polystyrene.
- C. Wall Panel Accessories: Provide components required for a complete metal wall panel assembly including copings, fasciae, mullions, sills, corner units, clips, sealants, gaskets, fillers, closure strips, and similar items. Match material and finish of metal wall panels unless otherwise indicated.
1. Closures: Provide closures at eaves and rakes, fabricated of same material as metal wall panels.
  2. Backing Plates: Provide metal backing plates at panel end splices, fabricated from material recommended by manufacturer.
  3. Closure Strips: Closed-cell, expanded, cellular, rubber or crosslinked, polyolefin-foam or closed-cell laminated polyethylene; minimum 1-inch-(25-mm-) thick, flexible closure strips; cut or premolded to match metal wall panel profile. Provide closure strips where indicated or necessary to ensure weathertight construction.

- D. Flashing and Trim: Formed from 0.022-inch (0.56-mm) nominal-thickness, metallic-coated steel sheet or aluminum-zinc alloy-coated steel sheet prepainted with coil coating; finished to match adjacent metal panels.
1. Provide flashing and trim as required to seal against weather and to provide finished appearance. Locations include, but are not limited to, eaves, rakes, corners, bases, framed openings, ridges, fasciae, and fillers.
  2. Opening Trim: Formed from 0.022-inch (0.56-mm) nominal-thickness, metallic-coated steel sheet or aluminum-zinc alloy-coated steel sheet prepainted with coil coating. Trim head and jamb of door openings, and head, jamb, and sill of other openings.
- E. Roof Ventilators: Gravity type, complete with hardware, flashing, closures, and fittings.
1. Circular-Revolving Type: Minimum 20-inch- (508-mm-) diameter throat opening; fabricated from 0.028-inch (0.71-mm) nominal-thickness, metallic-coated steel sheet or aluminum-zinc alloy-coated steel sheet prepainted with coil coating; finished to match metal roof panels; with matching base and rain cap.
    - a. Type: Directional revolving.
    - b. Bird Screening: Galvanized steel, 1/2-inch- (13-mm-) square mesh, 0.041-inch (1.04-mm) wire; or aluminum, 1/2-inch- (13-mm-) square mesh, 0.063-inch (1.6-mm) wire.
    - c. Dampers: Spring-loaded, butterfly type; pull-chain operation; with pull chain of length required to reach within 36 inches (914 mm) of floor.
    - d. Reinforce and brace units, with joints properly formed and edges beaded to be watertight under normal positive-pressure conditions.
    - e. Mount ventilators on square-to-round bases for ridge or on-slope mounting, designed to match roof pitch and roll formed to match metal roof panel profile.
  2. Continuous or Sectional-Ridge Type: Factory-engineered and -fabricated, continuous unit; fabricated from 0.022-inch (0.56-mm) nominal-thickness, metallic-coated steel sheet or aluminum-zinc alloy-coated steel sheet prepainted with coil coating; finished to match metal roof panels. Fabricated in minimum 10-foot- (3-m-) long sections. Provide throat size and total length indicated, complete with side baffles, ventilator assembly, end caps, splice plates, and reinforcing diaphragms.
    - a. Bird Screening: Galvanized steel, 1/2-inch- (13-mm-) square mesh, 0.041-inch (1.04-mm) wire; or aluminum, 1/2-inch- (13-mm-) square mesh, 0.063-inch (1.6-mm) wire.
    - b. Dampers: Manually operated, spring-loaded, vertically rising type; chain and worm gear operator; with pull chain of length required to reach within 36 inches (914 mm) of floor.

- c. Throat Size: 9 or 12 inches (229 or 305 mm), as standard with manufacturer, and as required to comply with ventilation requirements.
- F. Louvers: Size and design indicated; self-framing and self-flashing. Fabricate welded frames from minimum 0.052-inch (1.32-mm) nominal-thickness, metallic-coated steel sheet; finished to match metal wall panels. Form blades from 0.040-inch (1.02-mm) nominal-thickness, metallic-coated steel sheet; folded or beaded at edges, set at an angle that excludes driving rains, and secured to frames by riveting or welding. Fabricate louvers with equal blade spacing to produce uniform appearance.
  1. Blades: Fixed.
  2. Blades: Adjustable type, with weather-stripped edges, and manually operated by hand crank or pull chain.
  3. Free Area: Not less than 7.0 sq. ft. (0.65 sq. m) for 48-inch- (1220-mm-) wide by 48-inch- (1220-mm-) high louver.
  4. Bird Screening: Galvanized steel, 1/2-inch- (13-mm-) square mesh, 0.041-inch (1.04-mm) wire; with rewirable frames, removable and secured with clips; fabricated of same kind and form of metal and with same finish as louvers.
    - a. Mounting: Exterior face of louvers.
  5. Vertical Mullions: Provide mullions at spacings recommended by manufacturer, or 72 inches (1830 mm) o.c., whichever is less.
- G. Pipe Flashing: Premolded, EPDM pipe collar with flexible aluminum ring bonded to base.
- H. Materials:
  1. Fasteners: Self-tapping screws, bolts, nuts, self-locking rivets and bolts, end-welded studs, and other suitable fasteners designed to withstand design loads. Provide fasteners with heads matching color of materials being fastened by means of plastic caps or factory-applied coating.
    - a. Fasteners for Metal Roof Panels: Self-drilling or self-tapping, zinc-plated, hex-head carbon-steel screws, with a stainless-steel cap or zinc-aluminum-alloy head and EPDM sealing washer.
    - b. Fasteners for Metal Roof Panels: Self-drilling, Type 410 stainless-steel or self-tapping, Type 304 stainless-steel or zinc-alloy-steel hex washer head, with EPDM washer under heads of fasteners bearing on weather side of metal panels.
    - c. Fasteners for Metal Wall Panels: Self-drilling or self-tapping, zinc-plated, hex-head carbon-steel screws, with EPDM sealing washers bearing on weather side of metal panels.
    - d. Fasteners for Metal Wall Panels: Self-drilling, Type 410 stainless-steel or self-tapping, Type 304 stainless-steel or zinc-alloy-steel

- hex washer head, with EPDM sealing washers bearing on weather side of metal panels.
- e. Fasteners for Flashing and Trim: Blind fasteners or self-drilling screws with hex washer head.
- f. Blind Fasteners: High-strength aluminum or stainless-steel rivets.
- 2. Corrosion-Resistant Coating: Cold-applied asphalt mastic, compounded for 15-mil (0.4-mm) dry film thickness per coat. Provide inert-type noncorrosive compound free of asbestos fibers, sulfur components, and other deleterious impurities.
- 3. Nonmetallic, Shrinkage-Resistant Grout: ASTM C 1107, factory-packaged, nonmetallic aggregate grout, noncorrosive, nonstaining, mixed with water to consistency suitable for application and a 30-minute working time.
- 4. Metal Panel Sealants:
  - a. Sealant Tape: Pressure-sensitive, 100 percent solids, gray polyisobutylene-compound sealant tape with release-paper backing. Provide permanently elastic, nonsag, nontoxic, nonstaining tape of manufacturer's standard size.
  - b. Joint Sealant: ASTM C 920; one-part elastomeric polyurethane or polysulfide; of type, grade, class, and use classifications required to seal joints in metal panels and remain weathertight; and as recommended by metal building system manufacturer.

## 2.10 SOURCE QUALITY CONTROL

- A. Testing Agency: Owner will engage a qualified testing agency to evaluate product.
- B. Special Inspector: Owner will engage a qualified special inspector to perform the following tests and inspections and to submit reports. Special inspector will verify that manufacturer maintains detailed fabrication and quality-control procedures and will review the completeness and adequacy of those procedures to perform the Work.
  - 1. Special inspections will not be required if fabrication is performed by manufacturer registered and approved by authorities having jurisdiction to perform such Work without special inspection.
    - a. After fabrication, submit copy of certificate of compliance to authorities having jurisdiction, certifying that Work was performed according to Contract requirements.
- C. Testing: Test and inspect shop connections for metal buildings according to the following:
  - 1. Bolted Connections: Shop-bolted connections shall be tested and inspected according to RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."

2. Welded Connections: In addition to visual inspection, shop-welded connections shall be tested and inspected according to AWS D1.1/D1.1M and the following inspection procedures, at inspector's option:
  - a. Liquid Penetrant Inspection: ASTM E 165.
  - b. Magnetic Particle Inspection: ASTM E 709; performed on root pass and on finished weld. Cracks or zones of incomplete fusion or penetration will not be accepted.
  - c. Ultrasonic Inspection: ASTM E 164.
  - d. Radiographic Inspection: ASTM E 94.
- D. Product will be considered defective if it does not pass tests and inspections.
- E. Prepare test and inspection reports.

## 2.11 FABRICATION

- A. General: Design components and field connections required for erection to permit easy assembly.
  1. Mark each piece and part of the assembly to correspond with previously prepared erection drawings, diagrams, and instruction manuals.
  2. Fabricate structural framing to produce clean, smooth cuts and bends. Punch holes of proper size, shape, and location. Members shall be free of cracks, tears, and ruptures.
- B. Tolerances: Comply with MBMA's "Metal Building Systems Manual" for fabrication and erection tolerances.
- C. Primary Framing: Shop fabricate framing components to indicated size and section, with baseplates, bearing plates, stiffeners, and other items required for erection welded into place. Cut, form, punch, drill, and weld framing for bolted field assembly.
  1. Make shop connections by welding or by using high-strength bolts.
  2. Join flanges to webs of built-up members by a continuous, submerged arc-welding process.
  3. Brace compression flange of primary framing with steel angles or cold-formed structural tubing between frame web and purlin web or girt web, so flange compressive strength is within allowable limits for any combination of loadings.
  4. Weld clips to frames for attaching secondary framing.
  5. Shop Priming: Prepare surfaces for shop priming according to SSPC-SP 2. Shop prime primary framing with specified primer after fabrication.
- D. Secondary Framing: Shop fabricate framing components to indicated size and section by roll-forming or break-forming, with baseplates, bearing plates, stiffeners, and other plates required for erection welded into place. Cut, form,

punch, drill, and weld secondary framing for bolted field connections to primary framing.

1. Make shop connections by welding or by using non-high-strength bolts.
  2. Shop Priming: Prepare uncoated surfaces for shop priming according to SSPC-SP 2. Shop prime uncoated secondary framing with specified primer after fabrication.
- E. Metal Panels: Fabricate and finish metal panels at the factory to greatest extent possible, by manufacturer's standard procedures and processes, as necessary to fulfill indicated performance requirements. Comply with indicated profiles and with dimensional and structural requirements.
1. Provide panel profile, including major ribs and intermediate stiffening ribs, if any, for full length of metal panel.

### **PART 3 - EXECUTION**

#### **3.1 EXAMINATION**

- A. Examine substrates, areas, and conditions, with erector present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Before erection proceeds, survey elevations and locations of concrete- and masonry-bearing surfaces and locations of anchor rods, bearing plates, and other embedments to receive structural framing, with erector present, for compliance with requirements and metal building system manufacturer's tolerances.
  1. Engage land surveyor to perform surveying.
- C. Proceed with erection only after unsatisfactory conditions have been corrected.

#### **3.2 PREPARATION**

- A. Clean and prepare surfaces to be painted according to manufacturer's written instructions for each particular substrate condition.
- B. Provide temporary shores, guys, braces, and other supports during erection to keep structural framing secure, plumb, and in alignment against temporary construction loads and loads equal in intensity to design loads. Remove temporary supports when permanent structural framing, connections, and bracing are in place unless otherwise indicated.

### 3.3 ERECTION OF STRUCTURAL FRAMING

- A. Erect metal building system according to manufacturer's written erection instructions and erection drawings.
- B. The structural frame shall be braced against horizontal loads if the wall panels are in place prior to the floor slab being poured.
- C. Do not field cut, drill, or alter structural members without written approval from metal building system manufacturer's professional engineer.
- D. Set structural framing accurately in locations and to elevations indicated, according to AISC specifications referenced in this Section. Maintain structural stability of frame during erection.
- E. Base and Bearing Plates: Clean concrete- and masonry-bearing surfaces of bond-reducing materials, and roughen surfaces prior to setting plates. Clean bottom surface of plates.
  - 1. Set plates for structural members on wedges, shims, or setting nuts as required.
  - 2. Tighten anchor rods after supported members have been positioned and plumbed. Do not remove wedges or shims but, if protruding, cut off flush with edge of plate before packing with grout.
  - 3. Promptly pack grout solidly between bearing surfaces and plates so no voids remain. Neatly finish exposed surfaces; protect grout and allow to cure. Comply with manufacturer's written installation instructions for shrinkage-resistant grouts.
- F. Align and adjust structural framing before permanently fastening. Before assembly, clean bearing surfaces and other surfaces that will be in permanent contact with framing. Perform necessary adjustments to compensate for discrepancies in elevations and alignment.
  - 1. Level and plumb individual members of structure.
  - 2. Make allowances for difference between temperature at time of erection and mean temperature when structure will be completed and in service.
- G. Primary Framing and End Walls: Erect framing level, plumb, rigid, secure, and true to line. Level baseplates to a true even plane with full bearing to supporting structures, set with double-nutted anchor bolts. Use grout to obtain uniform bearing and to maintain a level base-line elevation. Moist-cure grout for not less than seven days after placement.
  - 1. Make field connections using high-strength bolts installed according to RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts" for bolt type and joint type specified.

- a. Joint Type: Snug tightened or pretensioned.
- H. Secondary Framing: Erect framing level, plumb, rigid, secure, and true to line. Field bolt secondary framing to clips attached to primary framing.
  - 1. Provide rake or gable purlins with tight-fitting closure channels and fasciae.
  - 2. Locate and space wall girts to suit openings such as doors and windows.
  - 3. Locate canopy framing as indicated.
  - 4. Provide supplemental framing at entire perimeter of openings, including doors, windows, louvers, ventilators, and other penetrations of roof and walls.
- I. Bracing: Install bracing in roof and sidewalls where indicated on erection drawings.
  - 1. Tighten rod and cable bracing to avoid sag.
  - 2. Locate interior end-bay bracing only where indicated.
- J. Framing for Openings: Provide shapes of proper design and size to reinforce openings and to carry loads and vibrations imposed, including equipment furnished under mechanical and electrical work. Securely attach to structural framing.
- K. Erection Tolerances: Maintain erection tolerances of structural framing within AISC 303.

#### 3.4 METAL PANEL INSTALLATION, GENERAL

- A. Examination: Examine primary and secondary framing to verify that structural-panel support members and anchorages have been installed within alignment tolerances required by manufacturer.
  - 1. Examine roughing-in for components and systems penetrating metal panels, to verify actual locations of penetrations relative to seams before metal panel installation.
- B. General: Anchor metal panels and other components of the Work securely in place, with provisions for thermal and structural movement.
  - 1. Field cut metal panels as required for doors, windows, and other openings. Cut openings as small as possible, neatly to size required, and without damage to adjacent metal panel finishes.
    - a. Field cutting of metal panels by torch is not permitted unless approved in writing by manufacturer.
  - 2. Install metal panels perpendicular to structural supports unless otherwise indicated.

3. Flash and seal metal panels with weather closures at perimeter of openings and similar elements. Fasten with self-tapping screws.
  4. Locate and space fastenings in uniform vertical and horizontal alignment.
  5. Locate metal panel splices over, but not attached to, structural supports with end laps in alignment.
  6. Lap metal flashing over metal panels to allow moisture to run over and off the material.
- C. Lap-Seam Metal Panels: Install screw fasteners using power tools with controlled torque adjusted to compress EPDM washers tightly without damage to washers, screw threads, or metal panels. Install screws in predrilled holes.
1. Arrange and nest side-lap joints so prevailing winds blow over, not into, lapped joints. Lap ribbed or fluted sheets one full rib corrugation. Apply metal panels and associated items for neat and weathertight enclosure. Avoid "panel creep" or application not true to line.
- D. Metal Protection: Where dissimilar metals contact each other or corrosive substrates, protect against galvanic action by painting contact surfaces with corrosion-resistant coating, by applying rubberized-asphalt underlayment to each contact surface, or by other permanent separation as recommended by metal roof panel manufacturer.
- E. Joint Sealers: Install gaskets, joint fillers, and sealants where indicated and where required for weatherproof performance of metal panel assemblies. Provide types of gaskets, fillers, and sealants indicated; or, if not indicated, provide types recommended by metal panel manufacturer.
1. Seal metal panel end laps with double beads of tape or sealant the full width of panel. Seal side joints where recommended by metal panel manufacturer.
  2. Prepare joints and apply sealants to comply with requirements in Division 07 Section "Joint Sealants."

### 3.5 METAL ROOF PANEL INSTALLATION

- A. General: Provide metal roof panels of full length from eave to ridge unless otherwise indicated or restricted by shipping limitations.
1. Install ridge and hip caps as metal roof panel work proceeds.
  2. Flash and seal metal roof panels with weather closures at eaves and rakes. Fasten with self-tapping screws.
- B. Standing-Seam Metal Roof Panels: Fasten metal roof panels to supports with concealed clips at each standing-seam joint, at location and spacing and with fasteners recommended by manufacturer.

1. Install clips to supports with self-drilling or self-tapping fasteners.
  2. Install pressure plates at locations indicated in manufacturer's written installation instructions.
  3. Snap Joint: Nest standing seams and fasten together by interlocking and completely engaging factory-applied sealant.
  4. Seamed Joint: Crimp standing seams with manufacturer-approved motorized seamer tool so that clip, metal roof panel, and factory-applied sealant are completely engaged.
  5. Rigidly fasten eave end of metal roof panels and allow ridge end free movement due to thermal expansion and contraction. Pre-drill panels for fasteners.
  6. Provide metal closures at peaks rake edges rake walls and each side of ridge and hip caps.
- C. Lap-Seam Metal Roof Panels: Fasten metal roof panels to supports with exposed fasteners at each lapped joint, at location and spacing recommended by manufacturer.
1. Provide metal-backed sealing washers under heads of exposed fasteners bearing on weather side of metal roof panels.
  2. Provide sealant tape at lapped joints of metal roof panels and between panels and protruding equipment, vents, and accessories.
  3. Apply a continuous ribbon of sealant tape to weather-side surface of fastenings on end laps and on side laps of nesting-type metal panels, on side laps of ribbed or fluted metal panels, and elsewhere as needed to make metal panels weatherproof to driving rains.
4. At metal panel splices, nest panels with minimum 6-inch (152-mm) end lap, sealed with butyl-rubber sealant and fastened together by interlocking clamping plates.
- D. Metal Fascia Panels: Align bottom of metal panels and fasten with blind rivets, bolts, or self-drilling or self-tapping screws. Flash and seal metal panels with weather closures where fasciae meet soffits, along lower panel edges, and at perimeter of all openings.
- E. Metal Roof Panel Installation Tolerances: Shim and align metal roof panels within installed tolerance of 1/4 inch in 20 feet (6 mm in 6 m) on slope and location lines as indicated and within 1/8-inch (3-mm) offset of adjoining faces and of alignment of matching profiles.

### 3.6 METAL WALL PANEL INSTALLATION

- A. General: Install metal wall panels in orientation, sizes, and locations indicated on Drawings. Install panels perpendicular to girts, extending full height of building, unless otherwise indicated. Anchor metal wall panels and other components of the Work securely in place, with provisions for thermal and structural movement.

1. Unless otherwise indicated, begin metal panel installation at corners with center of rib lined up with line of framing.
  2. Shim or otherwise plumb substrates receiving metal wall panels.
  3. When two rows of metal panels are required, lap panels 4 inches (102 mm) minimum.
  4. When building height requires two rows of metal panels at gable ends, align lap of gable panels over metal wall panels at eave height.
  5. Rigidly fasten base end of metal wall panels and allow eave end free movement due to thermal expansion and contraction. Pre-drill panels.
  6. Flash and seal metal wall panels with weather closures at eaves, rakes, and at perimeter of all openings. Fasten with self-tapping screws.
  7. Install screw fasteners in predrilled holes.
  8. Install flashing and trim as metal wall panel work proceeds.
  9. Apply elastomeric sealant continuously between metal base channel (sill angle) and concrete, and elsewhere as indicated; or, if not indicated, as necessary for waterproofing.
  10. Align bottom of metal wall panels and fasten with blind rivets, bolts, or self-drilling or self-tapping screws.
  11. Provide weatherproof escutcheons for pipe and conduit penetrating exterior walls.
- B. Metal Wall Panels: Install metal wall panels on exterior side of girts. Attach metal wall panels to supports with fasteners as recommended by manufacturer.
- C. Installation Tolerances: Shim and align metal wall panels within installed tolerance of 1/4 inch in 20 feet (6 mm in 6 m), nonaccumulative, on level, plumb, and on location lines as indicated, and within 1/8-inch (3-mm) offset of adjoining faces and of alignment of matching profiles.

### 3.7 METAL SOFFIT PANEL INSTALLATION

- A. Provide metal soffit panels the full width of soffits. Install panels perpendicular to support framing.
- B. Flash and seal metal soffit panels with weather closures where panels meet walls and at perimeter of all openings.

### 3.8 THERMAL INSULATION INSTALLATION

- A. General: Install insulation concurrently with metal panel installation, in thickness indicated to cover entire surface, according to manufacturer's written instructions.
  1. Set vapor-retarder-faced units with vapor retarder toward warm side of construction unless otherwise indicated. Do not obstruct ventilation spaces except for firestopping.
  2. Tape joints and ruptures in vapor retarder, and seal each continuous area of insulation to the surrounding construction to ensure airtight installation.

3. Install factory-laminated, vapor-retarder-faced blankets straight and true in one-piece lengths, with both sets of facing tabs sealed, to provide a complete vapor retarder.
  4. Install blankets straight and true in one-piece lengths. Install vapor retarder over insulation, with both sets of facing tabs sealed, to provide a complete vapor retarder.
- B. Blanket Roof Insulation: Comply with the following installation method:
1. Two-Layers-between-Purlin-with-Spacer-Block Installation: Extend insulation and vapor retarder between purlins. Carry vapor-retarder-facing tabs up and over purlin, overlapping adjoining facing of next insulation course and maintaining continuity of retarder. Install layer of filler insulation over first layer to fill space between purlins formed by thermal spacer blocks. Hold in place with bands and crossbands below insulation.
    - a. Thermal Spacer Blocks: Where metal roof panels attach directly to purlins, install thermal spacer blocks.
- C. Blanket Wall Insulation: Extend insulation and vapor retarder over and perpendicular to top flange of secondary framing. Hold in place by metal wall panels fastened to secondary framing.
1. Retainer Strips: Install retainer strips at each longitudinal insulation joint, straight and taut, nesting with secondary framing to hold insulation in place.

### 3.9 ACCESSORY INSTALLATION

- A. General: Install accessories with positive anchorage to building and weathertight mounting, and provide for thermal expansion. Coordinate installation with flashings and other components.
1. Install components required for a complete metal roof panel assembly, including trim, copings, ridge closures, seam covers, flashings, sealants, gaskets, fillers, closure strips, and similar items.
  2. Install components for a complete metal wall panel assembly, including trim, copings, corners, seam covers, flashings, sealants, gaskets, fillers, closure strips, and similar items.
  3. Where dissimilar metals contact each other or corrosive substrates, protect against galvanic action by painting contact surfaces with corrosion-resistant coating, by applying rubberized-asphalt underlayment to each contact surface, or by other permanent separation as recommended by manufacturer.
- B. Flashing and Trim: Comply with performance requirements, manufacturer's written installation instructions, and SMACNA's "Architectural Sheet Metal Manual." Provide concealed fasteners where possible, and set units true to line

and level as indicated. Install work with laps, joints, and seams that will be permanently watertight and weather resistant.

1. Install exposed flashing and trim that is without excessive oil-canning, buckling, and tool marks and that is true to line and levels indicated, with exposed edges folded back to form hems. Install sheet metal flashing and trim to fit substrates and to result in waterproof and weather-resistant performance.
  2. Expansion Provisions: Provide for thermal expansion of exposed flashing and trim. Space movement joints at a maximum of 10 feet (3 m) with no joints allowed within 24 inches (600 mm) of corner or intersection. Where lapped or bayonet-type expansion provisions cannot be used or would not be sufficiently weather resistant and waterproof, form expansion joints of intermeshing hooked flanges, not less than 1 inch (25 mm) deep, filled with mastic sealant (concealed within joints).
- C. Circular Roof Ventilators: Set ventilators complete with necessary hardware, anchors, dampers, weather guards, rain caps, and equipment supports. Mount ventilators on flat level base. Install preformed filler strips at base to seal ventilator to metal roof panels.
- D. Continuous Roof Ventilators: Set ventilators complete with necessary hardware, anchors, dampers, weather guards, rain caps, and equipment supports. Join sections with splice plates and end-cap skirt assemblies where required to achieve indicated length. Install preformed filler strips at base to seal ventilator to metal roof panels.
- E. Louvers: Locate and place louver units level, plumb, and at indicated alignment with adjacent work.
1. Use concealed anchorages where possible. Provide brass or lead washers fitted to screws where required to protect metal surfaces and to make a weathertight connection.
  2. Provide perimeter reveals and openings of uniform width for sealants and joint fillers.
  3. Protect galvanized- and nonferrous-metal surfaces from corrosion or galvanic action by applying a heavy coating of corrosion-resistant paint on surfaces that will be in contact with concrete, masonry, or dissimilar metals.
  4. Install concealed gaskets, flashings, joint fillers, and insulation as louver installation progresses, where weathertight louver joints are required. Comply with Division 07 Section "Joint Sealants" for sealants applied during louver installation.
- F. Pipe Flashing: Form flashing around pipe penetration and metal roof panels. Fasten and seal to panel as recommended by manufacturer.

### 3.10 FIELD QUALITY CONTROL

- A. Special Inspections: Owner will engage a qualified special inspector to perform the following special inspections:
  - 1. Inspection of fabricators.
  - 2. Steel construction.
- B. Testing Agency: Owner will engage a qualified testing agency to perform tests and inspections.
- C. Tests and Inspections:
  - 1. High-Strength, Field-Bolted Connections: Connections shall be tested and inspected during installation according to RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."
  - 2. Welded Connections: In addition to visual inspection, field-welded connections shall be tested and inspected according to AWS D1.1/D1.1M and the following inspection procedures, at inspector's option:
    - a. Liquid Penetrant Inspection: ASTM E 165.
    - b. Magnetic Particle Inspection: ASTM E 709; performed on root pass and on finished weld. Cracks or zones of incomplete fusion or penetration will not be accepted.
    - c. Ultrasonic Inspection: ASTM E 164.
    - d. Radiographic Inspection: ASTM E 94.
- D. Product will be considered defective if it does not pass tests and inspections.
- E. Prepare test and inspection reports.

### 3.11 ADJUSTING

- A. Doors: After completing installation, test and adjust doors to operate easily, free of warp, twist, or distortion.
- B. Door Hardware: Adjust and check each operating item of door hardware and each door to ensure proper operation and function of every unit. Replace units that cannot be adjusted to operate as intended.
- C. Roof Ventilators and Adjustable Louvers: After completing installation, including work by other trades, lubricate, test, and adjust units to operate easily and be free of warp, twist, or distortion as needed to provide fully functioning units.
  - 1. Adjust louver blades to be weathertight when in closed position.

### 3.12 CLEANING AND PROTECTION

- A. Repair damaged galvanized coatings on galvanized items with galvanized repair paint according to ASTM A 780 and manufacturer's written instructions.
- B. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- C. Touchup Painting: After erection, promptly clean, prepare, and prime or reprime field connections, rust spots, and abraded surfaces of prime-painted structural framing, bearing plates, and accessories.
  - 1. Clean and prepare surfaces by SSPC-SP 2, "Hand Tool Cleaning," or by SSPC-SP 3, "Power Tool Cleaning."
  - 2. Apply a compatible primer of same type as shop primer used on adjacent surfaces.
- D. Touchup Painting: Cleaning and touchup painting are specified in Division 09 painting Sections.
- E. Metal Panels: Remove temporary protective coverings and strippable films, if any, as metal panels are installed. On completion of metal panel installation, clean finished surfaces as recommended by metal panel manufacturer. Maintain in a clean condition during construction.
  - 1. Replace metal panels that have been damaged or have deteriorated beyond successful repair by finish touchup or similar minor repair procedures.
- F. Louvers: Clean exposed surfaces that are not protected by temporary covering, to remove fingerprints and soil during construction period. Do not let soil accumulate until final cleaning.
  - 1. Restore louvers damaged during installation and construction period so no evidence remains of corrective work. If results of restoration are unsuccessful, as determined by Architect, remove damaged units and replace with new units.
    - a. Touch up minor abrasions in finishes with air-dried coating that matches color and gloss of, and is compatible with, factory-applied finish coating.

**END OF SECTION**