

## SECTION 133419 - METAL BUILDING SYSTEMS

### PART 1 - GENERAL

#### 1.1 SUMMARY

- A. Section Includes:
1. Structural-steel framing.
  2. Metal roof panels.
  3. Accessories.

#### 1.2 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 standards referenced by this Section.

#### 1.3 COORDINATION

- A. Coordinate sizes and locations of concrete foundations and casting of anchor-rod inserts into foundation walls and footings. Anchor rod installation, concrete, reinforcement, and formwork requirements are specified in 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.

#### 1.4 SUBMITTALS

- A. Product Data: For each type of metal building system component.
1. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes for the following:
    - a. Metal roof panels.
    - b. Metal wall panels.
- B. Shop Drawings: Indicate components by others. Include full building plan, elevations, sections, details and the following:
1. Anchor-Rod Plans: Submit anchor-rod plans and templates before foundation work begins. Include location, diameter, and minimum required projection of anchor rods required to attach metal building to foundation. Indicate column reactions at each location.
  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.

3. Metal Roof Panel Layout Drawings: Show layouts of panels including methods of support. Include details of edge conditions, joints, panel profiles, corners, anchorages, clip spacing, trim, flashings, closures, and special details. Distinguish between factory- and field-assembled work; show locations of exposed fasteners.
  4. Accessory Drawings: Include details of the following items:
    - a. Flashing and trim.
    - b. Gutters.
    - c. Downspouts.
- C. Samples for Verification: For the following products:
1. Roof Panels: Nominal 12 inches long by actual panel width. Include fasteners, closures, and other exposed panel accessories.
  2. Flashing and Trim: Nominal 12 inches long. Include fasteners and other exposed accessories.
- D. Delegated-Design Submittal: For metal building systems.
1. Include analysis data indicating compliance with performance requirements and design data signed and sealed by the qualified professional engineer responsible for their preparation.
- E. Field quality-control reports.
- F. Sample Warranties: For warranties.
- G. Maintenance Data: For metal panel finishes to include in maintenance manuals.
- 1.5 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.
- 1.6 FIELD CONDITIONS
- A. Weather Limitations: Proceed with panel installation only when weather conditions permit metal panels to be installed according to manufacturers' written instructions and warranty requirements.
- 1.7 WARRANTY
- A. Warranty on Metal Panel Finishes: Manufacturer agrees to repair finish or replace metal panels that show evidence of deterioration of factory-applied finishes within specified warranty period.
1. Exposed Roof Panel Finish: Deterioration includes, but is not limited to, the following:
    - a. Color fading more than 5 Hunter units when tested according to ASTM D2244.

- b. Chalking in excess of a No. 8 rating when tested according to ASTM D4214.
  - c. Cracking, checking, peeling, or failure of paint to adhere to bare metal.
2. Finish Warranty Period: Minimum 20 years from date of Substantial Completion.
- B. Weathertightness Warranty for Standing-Seam Metal Roof Panels: 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: Minimum 20 years from date of Substantial Completion.

## PART 2 - PRODUCTS

### 2.1 METAL BUILDING SYSTEM

- A. Manufacturer - Basis of Design: Varco-Pruden Buildings, a division of BlueScope Buildings North America, Inc.
- B. Source Limitations: Obtain metal building system components, including primary and secondary framing and metal panel assemblies, from single source from single manufacturer.

### 2.2 SYSTEM DESCRIPTION

- A. Provide a complete, integrated set of 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.
- B. Primary-Frame Type:
  1. Rigid Clear Span: Solid-member, structural-framing system without interior columns.
  2. Rigid Modular: Solid-member, structural-framing system with interior columns.
  3. Truss-Frame Clear Span: Truss-member, structural-framing system without interior columns.
  4. Truss-Frame Modular: Truss-member, structural-framing system with interior columns.
  5. Lean-to: Solid- or truss-member, structural-framing system, designed to be partially supported by another structure.
- 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**] [**load-bearing end-wall and corner columns and rafters**].
- 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 and exterior-framed (bypass) girts.
- F. Eave Height: Manufacturer's standard height, as indicated by nominal height on Drawings.

- G. Bay Spacing: As indicated on Drawings.
- H. Roof System: Manufacturer's standard standing-seam, vertical-rib, metal roof panels.

### 2.3 PERFORMANCE REQUIREMENTS

- A. Delegated Design: Engage a qualified professional engineer, as defined in Section 014000 "Quality Requirements," to design metal building system.
- 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**] <Insert applicable code requirement>.
  - 2. Deflection and Drift Limits: Design metal building system assemblies to withstand serviceability design loads without exceeding deflections and drift limits recommended in AISC Steel Design Guide No. 3 "Serviceability Design Considerations for Steel Buildings."
  - 3. Deflection and Drift Limits: No greater than the following:
    - a. Purlins and Rafters: Vertical deflection of [**1/150**] [**1/240**] [**1/360**] <Insert limit> of the span.
    - b. Girts: Horizontal deflection of [**1/120**] [**1/180**] [**1/240**] <Insert limit> of the span.
    - c. Design secondary-framing system to accommodate deflection of primary framing and construction tolerances, and to maintain clearances at openings.
    - d. Lateral Drift: Maximum of [**1/60**] [**1/100**] [**1/200**] [**1/400**] <Insert limit> of the building height.
- C. Seismic Performance: Metal building system shall withstand the effects of earthquake motions determined according to [**ASCE/SEI 7**] <Insert requirement>.
- D. Thermal Movements: Allow for thermal movements from ambient and surface temperature changes by preventing buckling, opening of joints, overstressing of components, failure of joint sealants, failure of connections, and other detrimental effects. Base calculations on surface temperatures of materials due to both solar heat gain and nighttime-sky heat loss.
  - 1. Temperature Change: Local ambient, material surfaces.
- E. Structural Performance for Metal Roof Panels: Provide metal panel systems capable of withstanding the effects of the following loads, based on testing according to ASTM E1592:
  - 1. Wind Loads: As indicated on Drawings.
- F. Air Infiltration for Metal Roof Panels: Air leakage of not more than 0.06 cfm/sq. ft. when tested according to ASTM E1680[ **or ASTM E283**] at the following test-pressure difference:
  - 1. Test-Pressure Difference: [**1.57 lbf/sq. ft.**] [**6.24 lbf/sq. ft.**].
- G. Water Penetration for Metal Roof Panels: No water penetration when tested according to ASTM E1646[ **or ASTM E331**] at the following test-pressure difference:

1. Test-Pressure Difference: [2.86 lbf/sq. ft.] [6.24 lbf/sq. ft.].
- H. Thermal Performance for Opaque Elements: Provide the following maximum U-factors and minimum R-values when tested according to ASTM C1363 or ASTM C518:
  1. Roof:
    - a. U-Factor: <Insert value>.
    - b. R-Value: <Insert value>.

#### 2.4 STRUCTURAL-STEEL FRAMING

- A. Structural Steel: Comply with AISC 360, "Specification for Structural Steel Buildings."
- B. Bolted Connections: Comply with RCSC's "Specification for Structural Joints Using High-Strength Bolts."
- C. 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.
- D. Primary Framing: Manufacturer's standard primary-framing system, designed to withstand required loads and specified requirements. Primary framing includes transverse and lean-to frames; rafters, 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. Rigid Clear-Span Frames: I-shaped frame sections fabricated from shop-welded, built-up steel plates or structural-steel shapes. Interior columns are not permitted.
  3. Rigid Modular Frames: I-shaped frame sections fabricated from shop-welded, built-up steel plates or structural-steel shapes. Provide interior columns fabricated from round steel pipes or tubes, or shop-welded, built-up steel plates.
  4. Truss-Frame, Clear-Span Frames: Rafter frames fabricated from joist girders, and I-shaped column sections fabricated from shop-welded, built-up steel plates or structural-steel shapes. Interior columns are not permitted.
  5. Truss-Frame Modular Frames: Rafter frames fabricated from joist girders, and I-shaped column sections fabricated from shop-welded, built-up steel plates or structural-steel shapes. Provide interior columns fabricated from round steel pipes or tubes, or shop-welded, built-up steel plates.
  6. Long-Bay Frames: I-shaped frame sections fabricated from shop-welded, built-up steel plates or structural-steel shapes. Provide interior columns fabricated from round steel pipes or tubes, or shop-welded, built-up steel plates.
  7. Frame Configuration: Multiple gable.
  8. Exterior Column: Uniform depth.
  9. Rafter: Tapered.

- E. 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.
- F. 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-wide flanges.
    - a. Depth: As needed to comply with system performance requirements.
  2. Purlins: Steel joists of depths indicated on Drawings.
  3. 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-wide flanges.
    - a. Depth: As required to comply with system performance requirements.
  4. 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.
  5. Flange Bracing: Minimum 2-by-2-by-1/8-inch structural-steel angles or 1-inch-diameter, cold-formed structural tubing to stiffen primary-frame flanges.
  6. Sag Bracing: Minimum 1-by-1-by-1/8-inch structural-steel angles.
  7. Base or Sill Angles: Manufacturer's standard base angle, minimum 3-by-2-inch, fabricated from zinc-coated (galvanized) steel sheet.
  8. Purlin and Girt Clips: Manufacturer's standard clips fabricated from steel sheet. Provide galvanized clips where clips are connected to galvanized framing members.
  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.
- G. Canopy Framing: Manufacturer's standard structural-framing system, designed to withstand required loads; fabricated from shop-welded, built-up steel plates or structural-steel shapes. Provide frames with attachment plates and splice members, factory drilled for field-bolted assembly.
1. Type: **[Straight-beam, eave type] [Purlin-extension type] [Tapered-beam, below-eave type] [As indicated].**

- H. Bracing: Provide adjustable wind bracing [**using any method**] as follows:
1. Rods: ASTM A36/A36M; ASTM A572/A572M, Grade 50; or ASTM A529/A529M, Grade 50; minimum 1/2-inch-diameter steel; threaded full length or threaded a minimum of 6 inches at each end.
  2. Cable: ASTM A475, minimum 1/4-inch-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.
- I. Anchor Rods: Headed anchor rods as indicated in Anchor Rod Plan for attachment of metal building to foundation.
- J. Materials:
1. W-Shapes: ASTM A992/A992M; ASTM A572/A572M, Grade 50 or 55; or ASTM A529/A529M, Grade 50 or 55.
  2. Channels, Angles, M-Shapes, and S-Shapes: ASTM A36/A36M; ASTM A572/A572M, Grade 50 or 55; or ASTM A529/A529M, Grade 50 or 55.
  3. Plate and Bar: ASTM A36/A36M; ASTM A572/A572M, Grade 50 or 55; or ASTM A529/A529M, Grade 50 or 55.
  4. Steel Pipe: ASTM A53/A53M, Type E or S, Grade B.
  5. Cold-Formed Hollow Structural Sections: ASTM A500, Grade B or C, structural tubing.
  6. Structural-Steel Sheet: Hot-rolled, ASTM A1011/A1011M, Structural Steel (SS), Grades 30 through 55, or High-Strength Low-Alloy Steel (HSLAS) or High-Strength Low-Alloy Steel with Improved Formability (HSLAS-F), Grades 45 through 70; or cold-rolled, ASTM A1008/A1008M, Structural Steel (SS), Grades 25 through 80, or HSLAS, Grades 45 through 70.
  7. Metallic-Coated Steel Sheet: ASTM A653/A653M, SS, Grades 33 through 80, or HSLAS or HSLAS-F, Grades 50 through 80; with G60 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 A755/A755M.
    - a. Zinc-Coated (Galvanized) Steel Sheet: ASTM A653/A653M, SS, Grades 33 through 80, or HSLAS or HSLAS-F, Grades 50 through 80; with G90 coating designation.
    - b. Aluminum-Zinc Alloy-Coated Steel Sheet: ASTM A792/A792M, SS, Grade 50 or 80; with Class AZ50 coating.
  9. Joist Girders: Manufactured according to "Standard Specifications for Joist Girders," in SJI's "Standard Specifications and Load Tables for Steel Joists and Joist Girders"; with steel-angle, top- and bottom-chord members, and end- and top-chord arrangements as indicated on Drawings and required for primary framing.

10. Steel Joists: Manufactured according to "Standard Specifications for Open Web Steel Joists, K-Series," in SJI's "Standard Specifications and Load Tables for Steel Joists and Joist Girders"; with steel-angle, top- and bottom-chord members, and end- and top-chord arrangements as indicated on Drawings and required for secondary framing.
11. Non-High-Strength Bolts, Nuts, and Washers: ASTM A307, Grade A, carbon-steel, hex-head bolts; ASTM A563 carbon-steel hex nuts; and ASTM F844 plain (flat) steel washers.
  - a. Finish: **[Plain] [Hot-dip zinc coating, ASTM F2329, Class C] [Mechanically deposited zinc coating, ASTM B695, Class 50].**
12. High-Strength Bolts, Nuts, and Washers: ASTM F3125/F3125M, Grade A325, Type 1, heavy-hex steel structural bolts; ASTM A563, Grade DH, heavy-hex carbon-steel nuts; and ASTM F436/F436M, Type 1, hardened carbon-steel washers.
  - a. Finish: **[Plain] [Hot-dip zinc coating, ASTM F2329, Class C] [Mechanically deposited zinc coating, ASTM B695, Class 50].**
13. High-Strength Bolts, Nuts, and Washers: ASTM F3125/F3125M, Grade A490, Type 1, heavy-hex steel structural bolts **[or Grade F2280 tension-control, bolt-nut-washer assemblies with splined ends]**; ASTM A563, Grade DH, heavy-hex carbon-steel nuts; and ASTM F436/F436M, Type 1, hardened carbon-steel washers; all with plain finish.
14. Tension-Control, High-Strength Bolt-Nut-Washer Assemblies: ASTM F3125/F3125M, Grade F1852, Type 1, **[heavy-hex] [round]** head assemblies consisting of steel structural bolts with splined ends; ASTM A563, Grade DH, heavy-hex carbon-steel nuts; and ASTM F436/F436M, Type 1 hardened carbon-steel washers.
  - a. Finish: **[Plain] [Mechanically deposited zinc coating, ASTM B695, Class 50] [Mechanically deposited zinc coating, ASTM B695, Class 50, baked-epoxy coated].**
15. Unheaded Anchor Rods: **[ASTM F1554, Grade 36] [ASTM A572/A572M, Grade 50] [ASTM A36/A36M] [ASTM A307, Grade A].**
  - a. Configuration: Straight.
  - b. Nuts: ASTM A563 **[heavy-]**hex carbon steel.
  - c. Plate Washers: ASTM A36/A36M carbon steel.
  - d. Washers: ASTM F436 hardened carbon steel.
  - e. Finish: **[Plain] [Hot-dip zinc coating, ASTM F2329, Class C] [Mechanically deposited zinc coating, ASTM B695, Class 50].**
16. Headed Anchor Rods: **[ASTM F1554, Grade 36] [ASTM A307, Grade A].**
  - a. Configuration: Straight.
  - b. Nuts: ASTM A563 **[heavy-]**hex carbon steel.
  - c. Plate Washers: ASTM A36/A36M carbon steel.
  - d. Washers: ASTM F436 hardened carbon steel.
  - e. Finish: **[Plain] [Hot-dip zinc coating, ASTM F2329, Class C] [Mechanically deposited zinc coating, ASTM B695, Class 50].**



17. Threaded Rods: [ASTM A193/A193M] [ASTM A572/A572M, Grade 50] [ASTM A36/A36M] [ASTM A307, Grade A].
  - a. Nuts: ASTM A563 [heavy-]hex carbon steel.
  - b. Washers: [ASTM F436 hardened] [ASTM A36/A36M] carbon steel.
  - c. Finish: [Plain] [Hot-dip zinc coating, ASTM F2329, Class C] [Mechanically deposited zinc coating, ASTM B695, Class 50].

K. Finish: Factory primed. Apply specified primer immediately after cleaning and pretreating.

1. Clean and prepare in accordance with SSPC-SP2.
2. Coat with manufacturer's standard primer. Apply primer to primary and secondary framing to a minimum dry film thickness of 1 mil.
  - a. Prime secondary framing formed from uncoated steel sheet to a minimum dry film thickness of 0.5 mil on each side.

## 2.5 METAL ROOF PANELS

A. 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. Standing-Seam Metal Roof Panels: SSR Standing Seam Roof with Thermodeck Roof System:
  - a. Roof Panel Material: Zinc-coated (galvanized) or aluminum-zinc alloy-coated steel sheet, minimum 24 gauge.
    - 1) Finish: Two-coat fluoropolymer.
    - 2) Color: Cool Metallic Silver
  - b. Clips: Manufacturer's standard for assembly required.
  - c. Joint Type: Manufacturer's standard for assembly required.
  - d. Panel Coverage: As indicated on the Drawings.
  - e. Panel Height: Manufacturer's standard.
2. Thermodeck Roof System: Manufacturer's standard system; provide with Liner Panel and Thermal Spacers.
  - a. Insulation R-Value: As indicated on the Drawings.

B. Finishes:

1. Exterior 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.

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.

## 2.6 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 in side laps. Include accessories required for weathertight installation.
- B. Concealed-Fastener, Flush-Profile, Metal Soffit Panels: Formed with vertical panel edges and flush surface; with flush joint between panels; with 1-inch- (25-mm-) wide flange for attaching interior finish; designed to be installed by lapping and interconnecting side edges of adjacent panels and mechanically attaching through panel to supports using concealed fasteners in side laps.
  1. Material: Zinc-coated (galvanized) or aluminum-zinc alloy-coated steel sheet, minimum 0.024-inch uncoated steel thickness.
    - a. Exterior Finish: Fluoropolymer; paint system to match roof panels.
    - b. Color: White.

## 2.7 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-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 standoff; fabricated from extruded polystyrene.
- C. Flashing and Trim: Zinc-coated (galvanized) or aluminum-zinc alloy-coated steel sheet, 0.018-inch nominal uncoated steel thickness, 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.
- D. Gutters: Zinc-coated (galvanized) or aluminum-zinc alloy-coated steel sheet, 0.018-inch nominal uncoated steel thickness, prepainted with coil coating; finished to match roof fascia and rake trim. Match profile of gable trim, complete with end pieces, outlet tubes, and other special pieces as required. Fabricate in minimum 96-inch-long sections, sized according to SMACNA's "Architectural Sheet Metal Manual."
1. Gutter Supports: Fabricated from same material and finish as gutters.
  2. Strainers: Bronze, copper, or aluminum wire ball type at outlets.
- E. Downspouts: Zinc-coated (galvanized) or aluminum-zinc alloy-coated steel sheet, 0.018-inch nominal uncoated steel thickness, prepainted with coil coating; finished to match metal wall panels. Fabricate in minimum 10-foot-long sections, complete with formed elbows and offsets.
1. Mounting Straps: Fabricated from same material and finish as gutters.
- F. Pipe Flashing: Premolded, EPDM pipe collar with flexible aluminum ring bonded to base.
- G. 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 Flashing and Trim: Blind fasteners or self-drilling screws with hex washer head.
    - c. Blind Fasteners: High-strength aluminum or stainless-steel rivets.

## 2.8 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 if applicable, or punch for bolts.
  - 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.

## 2.9 SOURCE QUALITY CONTROL

- A. Special Inspection: Owner will engage a qualified special inspector to perform source quality control inspections and to submit reports.

1. Accredited Manufacturers: Special inspections will not be required if fabrication is performed by an IAS AC472-accredited manufacturer 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.

## 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.
- 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 instructions and drawings.
- B. Do not field cut, drill, or alter structural members without written approval from metal building system manufacturer's professional engineer.
- C. 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.
- D. 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.
- E. 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.
- F. 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 High-Strength Bolts" for bolt type and joint type specified.
    - a. Joint Type: Snug tightened or pretensioned as required by manufacturer.
- G. 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. Provide supplemental framing at entire perimeter of openings, including doors, windows, louvers, ventilators, and other penetrations of roof and walls.
- H. Steel Joists[ **and Joist Girders**]: Install joists[, **girders,**] and accessories plumb, square, and true to line; securely fasten to supporting construction according to SJI's "Standard Specifications and Load Tables for Steel Joists and Joist Girders," joist manufacturer's written instructions, and requirements in this Section.
1. Before installation, splice joists delivered to Project site in more than one piece.
  2. Space, adjust, and align joists accurately in location before permanently fastening.
  3. Install temporary bracing and erection bridging, connections, and anchors to ensure that joists are stabilized during construction.
  4. Joist Installation: Bolt joists to supporting steel framework using carbon-steel bolts unless otherwise indicated.
  5. Joist Installation: Bolt joists to supporting steel framework using high-strength structural bolts unless otherwise indicated. Comply with RCSC's "Specification for Structural Joints Using High-Strength Bolts" for high-strength structural bolt installation and tightening requirements.
  6. Joist Installation: Weld joist seats to supporting steel framework.

7. Install and connect bridging concurrently with joist erection, before construction loads are applied. Anchor ends of bridging lines at top and bottom chords if terminating at walls or beams.
- 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 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 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. Seamed Joint: Crimp standing seams with manufacturer-approved motorized seamer tool so that clip, metal roof panel, and factory-applied sealant are completely engaged.
  4. Rigidly fasten eave end of metal roof panels and allow ridge end free movement for thermal expansion and contraction. Pre-drill panels for fasteners.
  5. Provide metal closures.
- C. Metal Roof Panel Installation Tolerances: Shim and align metal roof panels within installed tolerance of 1/4 inch in 20 feet on slope and location lines and within 1/8-inch offset of adjoining faces and of alignment of matching profiles.

### 3.5 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.

### 3.6 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. 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. 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 with no joints allowed within 24 inches 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 deep, filled with mastic sealant (concealed within joints).
- C. Gutters: Join sections with riveted-and-soldered or lapped-and-sealed joints. Attach gutters to eave with gutter hangers spaced as required for gutter size, but not more than 36 inches o.c. using manufacturer's standard fasteners. Provide end closures and seal watertight with sealant. Provide for thermal expansion.
- D. Downspouts: Join sections with 1-1/2-inch telescoping joints. Provide fasteners designed to hold downspouts securely 1 inch away from walls; locate fasteners at top and bottom and at approximately 60 inches o.c. in between.
- E. Pipe Flashing: Form flashing around pipe penetration and metal roof panels. Fasten and seal to panel as recommended by manufacturer.

### 3.7 FIELD QUALITY CONTROL

- A. Special Inspections: Owner will engage a qualified special inspector to perform field quality control special inspections and to submit reports.
- B. Product will be considered defective if it does not pass tests and inspections.
- C. Prepare test and inspection reports.



3.8 CLEANING AND PROTECTION

- A. Repair damaged galvanized coatings on galvanized items with galvanized repair paint according to ASTM A780/A780M 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.

END OF SECTION 133419