

SECTION 07 41 13

METAL ROOF PANELS

05/11

PART 1 GENERAL

1.1 REFERENCES

The publications listed below form a part of this specification to the extent referenced. The publications are referred to within the text by the basic designation only.

ALUMINUM ASSOCIATION (AA)

AA ADM (2020) Aluminum Design Manual

AMERICAN INSTITUTE OF STEEL CONSTRUCTION (AISC)

AISC 341 (2016) Seismic Provisions for Structural Steel Buildings

AMERICAN IRON AND STEEL INSTITUTE (AISI)

AISI S100 (2012) North American Specification for the Design of Cold-Formed Steel Structural Members

AISI SG03-3 (2002; Suppl 2001-2004; R 2008) Cold-Formed Steel Design Manual Set

AMERICAN SOCIETY OF CIVIL ENGINEERS (ASCE)

ASCE 7-16 (2017; Errata 2018; Supp 1 2018) Minimum Design Loads and Associated Criteria for Buildings and Other Structures

AMERICAN WELDING SOCIETY (AWS)

AWS A5.1/A5.1M (2012) Specification for Carbon Steel Electrodes for Shielded Metal Arc Welding

AWS D1.1/D1.1M (2020) Structural Welding Code - Steel

AWS D1.2/D1.2M (2014; Errata 1 2014; Errata 2 2020) Structural Welding Code - Aluminum

ASTM INTERNATIONAL (ASTM)

ASTM A36/A36M (2019) Standard Specification for Carbon Structural Steel

ASTM A123/A123M (2017) Standard Specification for Zinc (Hot-Dip Galvanized) Coatings on Iron and Steel Products

ASTM A424/A424M	(2009a; R 2016) Standard Specification for Steel Sheet for Porcelain Enameling
ASTM A463/A463M	(2015; R 2020; E 2020) Standard Specification for Steel Sheet, Aluminum-Coated, by the Hot-Dip Process
ASTM A653/A653M	(2020) Standard Specification for Steel Sheet, Zinc-Coated (Galvanized) or Zinc-Iron Alloy-Coated (Galvannealed) by the Hot-Dip Process
ASTM A755/A755M	(2018) Standard Specification for Steel Sheet, Metallic Coated by the Hot-Dip Process and Prepainted by the Coil-Coating Process for Exterior Exposed Building Products
ASTM A792/A792M	(2010; R 2015) Standard Specification for Steel Sheet, 55% Aluminum-Zinc Alloy-Coated by the Hot-Dip Process
ASTM A924/A924M	(2019) Standard Specification for General Requirements for Steel Sheet, Metallic-Coated by the Hot-Dip Process
ASTM A1008/A1008M	(2018) Standard Specification for Steel, Sheet, Cold-Rolled, Carbon, Structural, High-Strength Low-Alloy, High-Strength Low-Alloy with Improved Formability, Solution Hardened, and Bake Hardenable
ASTM B117	(2019) Standard Practice for Operating Salt Spray (Fog) Apparatus
ASTM B209	(2014) Standard Specification for Aluminum and Aluminum-Alloy Sheet and Plate
ASTM B209M	(2014) Standard Specification for Aluminum and Aluminum-Alloy Sheet and Plate (Metric)
ASTM C286	(1999; R 2017) Standard Terminology Relating to Porcelain Enamel and Ceramic-Metal Systems
ASTM C552	(2017; E 2018) Standard Specification for Cellular Glass Thermal Insulation
ASTM C553	(2013; R 2019) Standard Specification for Mineral Fiber Blanket Thermal Insulation for Commercial and Industrial Applications
ASTM C792	(2015; R 2020) Effects of Heat Aging on Weight Loss, Cracking, and Chalking of Elastomeric Sealants
ASTM C920	(2018) Standard Specification for

Elastomeric Joint Sealants

ASTM D226/D226M	(2017) Standard Specification for Asphalt-Saturated Organic Felt Used in Roofing and Waterproofing
ASTM D522/D522M	(2017) Mandrel Bend Test of Attached Organic Coatings
ASTM D523	(2014; R 2018) Standard Test Method for Specular Gloss
ASTM D610	(2008; R 2019) Standard Practice for Evaluating Degree of Rusting on Painted Steel Surfaces
ASTM D714	(2002; R 2017) Standard Test Method for Evaluating Degree of Blistering of Paints
ASTM D822	(2013; R 2018) Filtered Open-Flame Carbon-Arc Exposures of Paint and Related Coatings
ASTM D968	(2017) Standard Test Methods for Abrasion Resistance of Organic Coatings by Falling Abrasive
ASTM D1056	(2014) Standard Specification for Flexible Cellular Materials - Sponge or Expanded Rubber
ASTM D1308	(2002; R 2013) Effect of Household Chemicals on Clear and Pigmented Organic Finishes
ASTM D1654	(2008; R 2016; E 2017) Standard Test Method for Evaluation of Painted or Coated Specimens Subjected to Corrosive Environments
ASTM D1667	(2017) Standard Specification for Flexible Cellular Materials - Poly (Vinyl Chloride) Foam (Closed-Cell)
ASTM D1970/D1970M	(2019) Standard Specification for Self-Adhering Polymer Modified Bituminous Sheet Materials Used as Steep Roofing Underlayment for Ice Dam Protection
ASTM D2244	(2016) Standard Practice for Calculation of Color Tolerances and Color Differences from Instrumentally Measured Color Coordinates
ASTM D2247	(2015) Testing Water Resistance of Coatings in 100% Relative Humidity

ASTM D2794	(1993; R 2019) Standard Test Method for Resistance of Organic Coatings to the Effects of Rapid Deformation (Impact)
ASTM D3359	(2017) Standard Test Methods for Rating Adhesion by Tape Test
ASTM D3363	(2005; E 2011; R 2011; E 2012) Film Hardness by Pencil Test
ASTM D4214	(2007; R 2015) Standard Test Method for Evaluating the Degree of Chalking of Exterior Paint Films
ASTM D4587	(2011; R 2019; E 2019) Standard Practice for Fluorescent UV-Condensation Exposures of Paint and Related Coatings
ASTM D4637/D4637M	(2015) EPDM Sheet Used in Single-Ply Roof Membrane
ASTM D4869/D4869M	(2016a) Standard Specification for Asphalt-Saturated Organic Felt Underlayment Used in Steep Slope Roofing
ASTM D5894	(2016) Standard Practice for Cyclic Salt Fog/UV Exposure of Painted Metal, (Alternating Exposures in a Fog/Dry Cabinet and a UV/Condensation Cabinet)
ASTM E84	(2020) Standard Test Method for Surface Burning Characteristics of Building Materials
ASTM E1592	(2017) Standard Test Method for Structural Performance of Sheet Metal Roof and Siding Systems by Uniform Static Air Pressure Difference
ASTM E2140	(2001; R 2017) Standard Test Method for Water Penetration of Metal Roof Panel Systems by Static Water Pressure Head
ASTM G152	(2013) Operating Open Flame Carbon Arc Light Apparatus for Exposure of Nonmetallic Materials
ASTM G153	(2013) Operating Enclosed Carbon Arc Light Apparatus for Exposure of Nonmetallic Materials

FM GLOBAL (FM)

FM 4471	(2010) Class I Panel Roofs
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METAL BUILDING MANUFACTURERS ASSOCIATION (MBMA)

MBMA RSDM (2012) Metal Roofing Systems Design Manual

NATIONAL ROOFING CONTRACTORS ASSOCIATION (NRCA)

NRCA 0420 (2010) Architectural Metal Flashing,
Condensation Control and Reroofing

NRCA RoofMan (2020) The NRCA Roofing Manual

PORCELAIN ENAMEL INSTITUTE (PEI)

PEI 1001 (1996) Specification for Architectural
Porcelain Enamel (ALS-100)

PEI CG-3 (2005) Color Guide for Architectural
Porcelain Enamel

SHEET METAL AND AIR CONDITIONING CONTRACTORS' NATIONAL ASSOCIATION
(SMACNA)

SMACNA 1793 (2012) Architectural Sheet Metal Manual,
7th Edition

U.S. DEPARTMENT OF ENERGY (DOE)

Energy Star (1992; R 2006) Energy Star Energy
Efficiency Labeling System (FEMP)

UNDERWRITERS LABORATORIES (UL)

UL 580 (2006; Reprint Mar 2019) UL Standard for
Safety Tests for Uplift Resistance of Roof
Assemblies

UL Bld Mat Dir (updated continuously online) Building
Materials Directory

1.2 DESCRIPTION OF METAL ROOF SYSTEM

1.2.1 Performance Requirements

Steel panels and accessory components must conform to the following
standards:

ASTM A1008/A1008M

ASTM A123/A123M

ASTM A36/A36M

ASTM A424/A424M, ASTM C286, PEI 1001, PEI CG-3 for Porcelain and
Ceramic Enameling

ASTM A463/A463M for aluminum coated steel sheet

ASTM A755/A755M for metallic coated steel sheet for exterior coil
prepainted applications.

ASTM A924/A924M for metallic coated steel sheet

ASTM D522/D522M for applied coatings

UL Bld Mat Dir

1.2.1.1 Hydrostatic Head Resistance

No water penetration when tested according to [ASTM E2140](#). Submit [leakage test report](#) upon completion of installation.

1.2.1.2 Wind Uplift Resistance

Provide metal roof panel system that conform to the requirements of [ASTM E1592](#) and [UL 580](#). Uplift force due to wind action governs the design for panels. Submit [wind uplift test report](#) prior to commencing installation.

Provide roof system and attachments that resist the wind loads as determined by [ASCE 7-16](#), in pounds per square foot. Metal roof panels and component materials must also comply with the requirements in [FM 4471](#) as part of a panel roofing system as listed in Factory Mutual Guide (FMG) "Approval Guide" for class 1 or noncombustible construction, as applicable. Identify all materials with FMG markings.

1.3 SUBMITTALS

Government approval is required for submittals with a "G" designation; submittals not having a "G" designation are for Contractor Quality Control approval. Submittals with an "S" are for inclusion in the Sustainability eNotebook, in conformance with Section [01 33 29 SUSTAINABILITY REPORTING](#). Submit the following in accordance with Section [01 33 00 SUBMITTAL PROCEDURES](#):

[SD-02 Shop Drawings](#)

[Roofing Panels; G](#)

[Flashing and Accessories; G](#)

[Gutter/Downspout Assembly; G](#)

[SD-03 Product Data](#)

Submit manufacturer's catalog data for the following items:

[Roof Panels; G](#)

[Recycled Content for Aluminum Roof Panels; S](#)

[Recycled Content for Steel Roof Panels; S](#)

[Energy Star Label for Metal Roofing Product; S](#)

[Heat Island Reduction; S](#)

[Factory-Applied Color Finish; G](#)

[Accessories; G](#)

[Fasteners; G](#)

[Pressure Sensitive Tape; G](#)

[Underlayments; G](#)

Gaskets and Sealing/Insulating Compounds; G

Coil Stock; G

Aluminized Steel Repair Paint; G

Enamel Repair Paint; G

Galvanizing Repair Paint; G

SD-04 Samples

Roof Panels; G

Factory-applied Color Finish, Samples, 9 inch lengths, full width;
G

Accessories; G

Fasteners; G

Gaskets and Sealant/Insulating Compounds; G

SD-05 Design Data

Wind Uplift Resistance; G

SD-06 Test Reports

Leakage Test Report; G

Wind Uplift Test Report; G

Fire Rating Test Report; G

Factory Finish and Color Performance Requirements; G

SD-07 Certificates

Roof Panels; G

Coil Stock Compatibility; G

Self-Adhering Modified Bitumen Underlayment; G

Qualification of Manufacturer; G

Qualification of Applicator; G

SD-08 Manufacturer's Instructions

Insulation; G

Installation Manual; G

SD-09 Manufacturer's Field Reports

Manufacturer's Field Inspection Reports; G

SD-11 Closeout Submittals

Warranties; G

Information Card; G

1.4 QUALITY ASSURANCE

1.4.1 Qualification of Manufacturer

Submit documentation verifying metal roof panel manufacturer has been in the business of manufacturing metal roof panels for a period of not less than 5 years.

Manufacturer must also provide engineering services by an authorized engineer, currently licensed in the geographic area of the project, with a minimum of five (5) years experience as an engineer knowledgeable in roof wind design analysis, protocols and procedures for MBMA RSDM, ASCE 7-16, UL 580, and FM 4471. Engineer must provide certified engineering calculations for the project conforming to the stated references.

1.4.1.1 Manufacturer's Technical Representative

The manufacturer's technical representative must be thoroughly familiar with the products to be installed, installation requirements and practices, and with any special considerations in the geographical area of the project. The representative must perform field inspections and attend meetings as specified.

1.4.1.2 Single Source

Provide roofing panels, clips, closures, and other accessories that are standard products of the same manufacturer, and the most recent design of the manufacturer to operate as a complete system for the intended use.

1.4.2 Qualification of Applicator

Metal roof system applicator must be approved, authorized, or licensed in writing by the roof panel manufacturer and have a minimum of three years experience as an approved, authorized, or licensed applicator with that manufacturer, approved at a level capable of providing the specified warranty. Supply the names, locations and client contact information of 5 projects of similar size and scope constructed by applicator using the manufacturer's roofing products submitted for this project within the previous three years.

1.4.3 Field Verification

Prior to the preparation of drawings and fabrication, verify location of roof framing, roof openings and penetrations, and any other special conditions. Indicate all special conditions and measurements on final shop drawings.

1.4.4 Qualifications for Welding Work

Perform welding procedures in conformance to AWS D1.1/D1.1M for steel or AWS D1.2/D1.2M for aluminum.

Operators are permitted to make only those types of weldments for which each is specifically qualified.

1.4.5 Pre-roofing Conference

After approval of submittals and before performing roofing system installation work, hold a pre-roofing conference to review the following:

- a. Drawings, specifications, and submittals related to the roof work. Submit, as a minimum; sample profiles of roofing panels, with factory-applied color finish samples, flashing and accessories, gutter/downspout assembly samples, typical fasteners and pressure sensitive tape, sample gaskets and sealant/insulating compounds. Also include data and 1/2 pint sample of aluminized steel repair paint, and technical data on coil stock and coil stock compatibility, and manufacturer's installation manual.
- b. Roof system components installation;
- c. Procedure for the roof manufacturer's technical representative's onsite inspection and acceptance of the roofing substrate, the name of the manufacturer's technical representatives, the frequency of the onsite visits, distribution of copies of the inspection reports from the manufacturer's technical representative;
- d. Contractor's plan for coordination of the work of the various trades involved in providing the roofing system and other components secured to the roofing; and
- e. Quality control plan for the roof system installation;
- f. Safety requirements.

Coordinate pre-roofing conference scheduling with the Contracting Officer. Attendance is mandatory for the Contractor, the Contracting Officer's designated personnel, personnel directly responsible for the installation of metal roof system, flashing and sheet metal work, mechanical and electrical work, other trades interfacing with the roof work, and representative of the metal roofing manufacturer. Before beginning roofing work, provide a copy of meeting notes and action items to all attending parties. Note action items requiring resolution prior to start of roof work.

1.5 DELIVERY, HANDLING, AND STORAGE

Deliver, store, and handle panel materials, bulk roofing products, accessories, and other manufactured items in a manner to prevent damage and deformation, as recommended by the manufacturer, and as specified.

1.5.1 Delivery

Package and deliver materials to the site in undamaged condition. Provide adequate packaging to protect materials during shipment. Do not uncrate materials until ready for use, except for inspection. Immediately upon

arrival of materials at jobsite, inspect materials for damage, deformation, dampness, and staining. Remove affected materials from the site and immediately replace. Remove moisture from wet materials not otherwise affected, restack and protect from further moisture exposure.

1.5.2 Handling

Handle materials in a manner to avoid damage. Select and operate material handling equipment so as not to damage materials or applied roofing.

1.5.3 Storage

Stack materials stored on site on platforms or pallets, and cover with tarpaulins or other weathertight covering which prevents trapping of water or condensation under the covering. Store roof panels so that water which may have accumulated during transit or storage will drain off. Do not store panels in contact with materials that might cause staining. Secure coverings and stored items to protect from wind displacement.

1.6 PROJECT CONDITIONS

Weather Limitations: Proceed with installation only when existing and forecast weather conditions permit metal roof panel work to be performed according to manufacturer's written instructions and warranty requirements, and specified safety requirements.

1.7 FABRICATION

Fabricate and finish metal roof panels and accessories on a factory stationary industrial type rolling mill to the greatest extent possible, per manufacturer's standard procedures and processes, and as necessary to fulfill indicated performance requirements. Comply with indicated profiles, dimensional and structural requirements.

Provide panel profile, including major ribs and intermediate stiffening ribs for full length of panel. Fabricate panel side laps with factory installed captive gaskets providing a weather tight seal and preventing metal-to-metal contact, and minimizing noise from movements within the panel assembly.

1.7.1 Finishes

Finish quality and application processes must conform to the related standards specified within this section. Noticeable variations within the same piece are not acceptable. Variations in appearance of adjoining components are acceptable if they are within the range of approved samples and are assembled or installed to minimize any contrasting variations.

1.7.2 Accessories

Fabricate flashing and trim to comply with recommendations in [SMACNA 1793](#) as applicable to the design, dimensions, metal, and other characteristics of the item indicated.

- a. Form exposed sheet metal accessories which are free from excessive oil canning, buckling, and tool marks, and are true to line and levels indicated, with exposed edges folded back to form hems.

- b. End Seams: Fabricate nonmoving seams with flat-lock seams. Form seams and seal with epoxy seam sealer. Rivet joints for additional strength.
- c. Sealed Joints: Form non-expansion, but movable joints in metal to accommodate elastomeric sealant to comply with [SMACNA 1793](#).
- d. Conceal fasteners and expansion provisions where possible. Exposed fasteners are not allowed on faces of accessories exposed to view.
- e. Fabricate cleats and attachments devices of size and metal thickness recommended by SMACNA or by metal roof panel manufacturer for application, but not less than the thickness of the metal being secured.

1.8 [WARRANTIES](#)

Provide metal roof system material and workmanship warranties meeting specified requirements. Provide revision or amendment to manufacturer's standard warranty as required to comply with the specified requirements.

1.8.1 Metal Roof Panel Manufacturer Warranty

Furnish the metal roof panel manufacturer's 20-year no dollar limit roof system materials and installation workmanship warranty, including flashing, insulation, components, trim, and accessories necessary for a watertight roof system construction. Make warranty directly to the Government, commencing at time of Government's acceptance of the roof work. The warranty must state that:

- a. If within the warranty period, the metal roof system, as installed for its intended use in the normal climatic and environmental conditions of the facility, becomes non-watertight, shows evidence of moisture intrusion within the assembly, displaces, corrodes, perforates, separates at the seams, or shows evidence of excessive weathering due to defective materials or installation workmanship, the repair or replacement of the defective and damaged materials of the metal roof system and correction of defective workmanship is the responsibility of the metal roof panel manufacturer. All costs associated with the repair or replacement work are the responsibility of the metal roof panel manufacturer.
- b. If the manufacturer or his approved applicator fail to perform the repairs within 24 hours of notification, emergency temporary repairs performed by others does not void the warranty.

1.8.2 Manufacturer's Finish Warranty

Provide a manufacturer's no-dollar-limit 20 year warranty for the roofing system. Issue the warranty directly to the Government at the date of Government acceptance, warranting that the factory color finish, under normal atmospheric conditions at the site, will not crack, peel, or delaminate; chalk in excess of a numerical rating of 8 when measured in accordance with [ASTM D4214](#); or fade or change colors in excess of 5 NBS units as measured in accordance with [ASTM D2244](#).

1.8.3 Continuance of Warranty

Repair or replacement work that becomes necessary within the warranty period must be approved, as required, and accomplished in a manner so as to restore the integrity of the roof system assembly and validity of the metal roof system manufacturer warranty for the remainder of the manufacturer warranty period.

1.9 CONFORMANCE AND COMPATIBILITY

Provide the entire metal roofing and flashing system in accordance with specified and indicated requirements, including wind resistance and seismic requirements. Perform work not specifically addressed and any deviation from specified requirements in general accordance with recommendations of the MBMA RSDM, NRCA RoofMan, the metal panel manufacturer's published recommendations and details, and compatible with surrounding components and construction. Submit any deviation from specified or indicated requirements to the Contracting Officer for approval prior to installation.

PART 2 PRODUCTS

2.1 ROOF PANELS

2.1.1 Aluminum Sheet Panels

Roll-form aluminum roof panels to the specified profile, with $f_y = 30 \text{ ksi}$, .0401 inch thickness and depth as indicated.

Provide aluminum panels with a minimum recycled content of 30 percent. Provide data indicating percentage of recycled content for aluminum roof panels.

Material must be plumb and true, and within the tolerances listed:

- a. Aluminum sheet conforming to ASTM B209, and AA ADM
- b. Individual panels to have continuous length sufficient to cover the entire length of any unbroken roof slope with no joints or seams and formed without warping, waviness, or ripples that are not a part of the panel profile and free from damage to the finish coating system.
- c. Provide panels with thermal expansion and contraction consistent with the type of system specified, and the following profile:

(9) profile to be a 1-3/4 inch high standing seam, 24 inch coverage with mechanical crimping or snap-together seams with concealed

- 2.2 (10) profile to be smooth, flatsurface.

FACTORY FINISH AND COLOR PERFORMANCE REQUIREMENTS

All panels are to receive a factory applied Kynar 500/Hylar 5000 finish consisting of a baked topcoat with a manufacturer's recommended prime coat conforming to the following:

- a. Metal Preparation: All metal is to have the surfaces carefully prepared for painting on a continuous process coil coating line by alkali cleaning, hot water rinsing, application of chemical conversion

coating, cold water rinsing, sealing with an acid rinse, and thorough drying.

- b. Prime Coating: A base coat of epoxy paint, specifically formulated to interact with the top-coat, is to be applied to the prepared surfaces by roll coating to a dry film thickness of 0.20 plus 0.05 mils. Oven cure the prime coat prior to application of the finish coat.
- c. Exterior Finish Coating: Apply the exterior finish coating over the primer by roll coating to a dry film thickness of 0.80 plus 0.05 mils (3.80 plus 0.05 mils for Vinyl Plastisol) for a total dry film thickness of 1.00 plus 0.10 mils (4.00 plus 0.10 mils for Vinyl Plastisol). Oven cure this exterior finish coat.
- d. Interior finish coating: Apply a wash coat on the reverse side over primer by roll coating to a dry film thickness of 0.30 plus 0.05 mils for a total dry film thickness of 0.50 plus 0.10 mils. Oven cure the wash coat.
- e. Color: The exterior finish chosen from the manufacturer's standard color chart.
- f. Physical Properties: Coating must conform to the industry and manufacturer's standard performance criteria as listed by the following certified test reports:

General:	ASTM D5894 and ASTM D4587
Abrasion:	ASTM D968
Adhesion:	ASTM D3359
Chalking:	ASTM D4214
Chemical Pollution:	ASTM D1308
Color Change and Conformity:	ASTM D2244
Creepage:	ASTM D1654
Cyclic Corrosion Test:	ASTM D5894
Flame Spread:	ASTM E84
Flexibility:	ASTM D522/D522M
Formability:	ASTM D522/D522M
Gloss at 60 and 85 degrees:	ASTM D523
Humidity:	ASTM D2247 and ASTM D714

Oxidation:	ASTM D610
Pencil Hardness:	ASTM D3363
Reverse Impact:	ASTM D2794
Salt Spray:	ASTM B117
Weatherometer:	ASTM G152, ASTM G153 and ASTM D822

2.2.1 Specular Gloss

Finished roof surfaces to have a specular gloss value of 30 plus or minus 5 at an angle of 60 degrees when measured in accordance with ASTM D523.

2.2.2 Energy and Cool Roof Performance

Provide a product that is Energy Star labeled and is produced and compatible with the requirements of this specification. Provide data identifying Energy Star label for metal roofing product.

2.3 MISCELLANEOUS METAL FRAMING

2.3.1 General

Provide cold formed metallic-coated steel sheet conforming to ASTM A653/A653M, AISI S100, and as specified in 05 40 00 COLD-FORMED METAL FRAMING unless otherwise indicated.

2.3.2 Fasteners and Miscellaneous Metal Framing

Provide compatible type, corrosion resistant, of sufficient size and length to penetrate the supporting element a minimum of one inch with other required properties to fasten miscellaneous metal framing members to substrates in accordance with the roof panel manufacturer's and ASCE 7-16 requirements.

2.3.2.1 Exposed Fasteners

Provide corrosion resistant coated steefasteners for roof panels, compatible with the sheet panel or flashing material and of the type and size recommended by the manufacturer to meet the performance requirements and design loads. Provide fasteners for accessories that are the manufacturer's standard. Provide an integral metal washer, matching the color of attached material with compressible sealing EPDM gasket approximately 3/32 inch thick for exposed fasteners.

2.3.2.2 Screws

Provide corrosion resistant screws, coated steel of the type and size recommended by the manufacturer to meet the performance requirements.

2.3.2.3 Rivets

Provide closed-end type rivets, corrosion resistant coated steel where watertight connections are required.

2.3.2.4 Attachment Clips

Provide hot-dip galvanized, conforming to [ASTM A653/A653M](#), clips. Size, shape, thickness and capacity must meet the thickness and design load criteria specified.

2.3.3 Electrodes for Manual, Shielded Metal Arc Welding

Utilize electrodes for manual, shielded metal arc welding meeting the requirements of [AWS D1.1/D1.1M](#), that are covered, mild-steel electrodes conforming to [AWS A5.1/A5.1M](#).

2.4 ACCESSORIES

Provide accessories compatible with the metal roof panels. Sheet metal flashing, trim, metal closure strips, caps, and similar metal accessories must be not less than the minimum thicknesses specified for roof panels. Provide exposed metal accessories to match the panels furnished, except as otherwise indicated. Provide molded foam rib, ridge and other closure strips that are closed-cell or solid-cell synthetic rubber or neoprene premolded to match configuration of the panels and not absorb or retain water.

2.4.1 Pre-manufactured Accessories

Provide pre-manufactured accessories that are manufacturer's standard for intended purpose, , compatible with the metal roof system and approved for use by the metal roof panel manufacturer. Construct curbs to match roof slope.

2.4.2 Metal Closure Strips

Provide factory fabricated closure strips of the same , color, finish and profile as the specified roof panel.

2.4.3 Rubber Closure Strips

Provide closed-cell, expanded cellular rubber closure strips conforming to [ASTM D1056](#) and [ASTM D1667](#), extruded or molded to the configuration of the specified roof panel profile and in lengths supplied by roof panel manufacturer.

2.5 JOINT SEALANTS

2.5.1 Sealants

Sealants are to be an approved gun type for use in hand or air pressure caulking guns at temperatures above [40 degrees F](#) (or frost-free application at temperatures above [10 degrees F](#)) with a minimum solid content of 85 percent of the total volume. Ensure sealant dries with a tough, durable surface skin which permits it to remain soft and pliable underneath, providing a weather tight joint. No migratory staining, in conformance with to [ASTM C792](#), is permitted on painted or unpainted metal, stone, glass, vinyl or wood.

Prime all joints to receive sealants with a compatible one-component or two-component primer as recommended by the roof panel manufacturer.

2.5.1.1 Shop Applied Sealants

Provide sealant for shop-applied caulking that is an approved gun grade, non-sag one-component polysulfide or silicone conforming to [ASTM C792](#) and [ASTM C920](#), Type II, with a curing time which ensures the sealants plasticity at the time of field erection. Color to match panel color.

2.5.1.2 Field Applied Sealants

Provide sealants for field-applied caulking that is an approved gun grade, non-sag one-component polysulfide or two component polyurethane with an initial maximum Shore A durometer hardness of 25, conforming to [ASTM C920](#), Type II. Color to match panel color.

2.5.1.3 Tape Sealants

Provide pressure sensitive, 100 percent solid tape sealant with a release paper backing; permanently elastic, non-sagging, non-toxic and non-staining as approved by the roof panel manufacturer.

2.5.2 Sheet Metal Flashing and Trim

2.5.2.1 Fabrication, General

Custom fabricate sheet metal flashing and trim to comply with recommendations within the SMACNA 1793 that apply to design, dimensions, metal type, and other characteristics of design indicated. Shop fabricate items to the greatest extent possible. Obtain and verify field measurements for accurate fit prior to shop fabrication. Fabricate flashing and trim without excessive oil canning, buckling, and tool marks, true to line and levels indicated, with exposed edges folded back to form hems.

2.5.2.2 Roof Drainage Sheet Metal Fabrications

Gutters: Fabricate to cross section indicated, with riveted and soldered joints, complete with end pieces, outlet tubes, and other special accessories as required. Fabricate in minimum [96 inch](#) long sections. Fabricate expansion joints and accessories from the same metal as gutters, unless otherwise indicated.

Downspouts: Fabricate rectangular downspouts complete with mitered elbows. Furnish with metal hangers of same material as downspouts and anchors.

2.6 [INSULATION](#)

Provide insulation, facer material and attachment compatible with metal roof system specified, as approved by the roof panel manufacturer, and conform to [ASTM C552](#) (cellular glass) or [ASTM C553](#) (fiber blankets).

2.6.1 Fire Rated Roof Panel Assembly

Provide metal facing as indicated and fabricated of enamel-coated hot-dip

galvanized steel conforming to [ASTM A653/A653M](#), Grade A. Coating in conformance with [ASTM A653/A653M](#) and [ASTM A924/A924M](#). Provide Class A fire hazard classification finish. Flame spread, fuel contributed, or smoke developed cannot exceed a value of 25.

Submit [fire rating test report](#) to contracting officer for review and approval. Secure written approval prior to commencement of installation.

2.7 UNDERLAYMENTS

2.7.1 Self-Adhering Modified Bitumen Underlayment

Provide self-adhering modified bitumen membrane underlayment material in compliance with [ASTM D1970/D1970M](#), suitable for use as underlayment for metal roofing. Use membrane resistant to cyclical elevated temperatures for extended period of time in high heat service conditions. Provide membrane with integral non-tacking top surface of polyethylene film or other surface material to serve as separator between bituminous material and metal products to be applied above.

2.8 GASKETS AND SEALING/INSULATING COMPOUNDS

Provide gaskets and sealing/insulating compounds that are nonabsorptive and suitable for insulating contact points of incompatible materials. Utilize sealing/insulating compounds that are non-running after drying.

2.9 FINISH REPAIR MATERIAL

Only use repair and touch-up paint supplied by the roof panel manufacturer and is compatible with the specified system.

PART 3 EXECUTION

3.1 EXAMINATION

Examine substrates, areas, and conditions, with installer present, for compliance with requirements for installation tolerances, metal roof panel supports, and other conditions affecting performance of the work. Ensure surfaces are suitable, dry and free of defects and projections which might affect the installation.

Examine primary and secondary roof framing to verify that rafters, purlins, angels, channels, and other structural support members for panels and anchorages have been installed within alignment tolerances required by metal roof panel manufacturer, UL, ASTM, and [ASCE 7-16](#) and applicable seismic requirements.

Examine solid roof sheathing to verify that sheathing joints are supported by framing or blocking; and that installation is within flatness tolerances required by metal roof panel manufacturer.

Examine rough-in for components and systems penetrating metal roof panels to verify actual locations of penetrations relative to seam locations of panels prior to installation.

Submit a written report to the Contracting Officer, endorsed by the installer, listing conditions detrimental to the performance of the work.

Proceed with installation only after defects have been corrected.

Do not install items that show visual evidence of biological growth.

3.2 INSTALLATION

Perform installation meeting specified requirements and in accordance with the manufacturer's installation instructions and approved shop drawings. Do not install damaged materials. Insulate dissimilar materials which are not compatible when contacting each other by means of gaskets or sealing/insulating compounds. Keep all exposed surfaces and edges clean and free from sealant, metal cuttings, hazardous burrs, and other foreign material. Remove stained, discolored, or damaged materials from the site.

3.2.1 Preparation

Clean all substrate substances which may be harmful to insulation, and roof panels including removing projections capable of interfering with insulation, and roof panel attachment.

Install sub-purlins, eave angles, furring, and other miscellaneous roof panel support members and anchorage according to metal roof panel manufacturer's written instructions.

3.2.2 Underlayment

Install underlayment according to roof panel manufacturer's written recommendations and recommendation in NRCA "The NRCA Roofing and Waterproofing Manual".

3.3 INSULATION INSTALLATION

Install insulation concurrently with metal roof panel installation, in thickness indicated, to cover entire roof, according to manufacturer's written instructions.

3.4 PROTECTION OF APPLIED MATERIALS

Do not permit storing, walking, wheeling, and trucking directly on applied roofing/insulation materials. Provide temporary walkways, runways, and platforms of smooth clean boards or planks as necessary to avoid damage to applied roofing/insulation materials, and to distribute weight to conform to indicated live load limits of roof construction.

3.5 FASTENER INSTALLATION

Anchor metal roof panels and other components of the Work securely in place, using approved fasteners according to manufacturer's written instructions.

3.5.1 Welding

Perform procedures for manual, shielded metal-arc welding, the inspection and testing of welds made, and the methods used in correcting welding work in accordance with [AWS D1.1/D1.1M](#).

3.6 FLASHING, TRIM, AND CLOSURE INSTALLATION

3.6.1 General Requirements

Comply with performance requirements, manufacturer's written installation instructions, and [SMACNA 1793](#). Provide concealed fasteners where possible. Set units true to line and level as indicated. Install work with laps, joints, and seams that will be permanently water tight and weather resistant. Work is to be accomplished to form weather tight construction without waves, warps, buckles, fastening stresses or distortion, and to allow for expansion and contraction. Perform cutting, fitting, drilling, and other operations in connection with sheet metal required to accomplish the work in conformance with the manufacturers written instructions.

3.6.2 Metal Flashing

Install exposed metal flashing at building corners, rakes, eaves, junctions between metal siding and roofing, valleys and changes off slope or direction in metal roofing, building expansion joints and gutters.

Utilize exposed metal flashing that is the same material, color, and finish as the specified metal roofing panels. Furnish flashing in minimum [8 foot](#) lengths. Exposed flashing must have 1 inch locked and blind soldered end joints, with expansion joints at intervals of no greater than [16 feet](#).

Fasten flashing at not more than 8 inches on center for roofs, except where flashing is held in place by the same screws used to secure panels. Bed exposed flashing and flashing subject to rain penetration in specified joint sealant. Isolate flashing which is in contact with dissimilar metals by means of the specified asphalt mastic material to prevent electrolytic deterioration.

Form drips to the profile indicated, with the edge folded back [1/2 inch](#) to form a reinforced drip edge.

3.7 ROOF PANEL INSTALLATION

Provide metal roof panels of full length from eave to ridge or eave to wall as indicated, unless otherwise indicated or restricted by shipping limitations. Anchor metal roof panels or other components of the Work securely in place, with provisions for thermal and structural movement in accordance with [NRCA 0420](#).

Aluminum Roof Panels: Use aluminum or stainless steel fasteners for surfaces exposed to the exterior and aluminum or galvanized steel fasteners for unexposed surfaces.

Anchor Clips: Anchor metal roof panels and other components of the Work securely in place, using approved fasteners according to manufacturer's written instructions. Provide all blocking and nailers as required.

Metal Protection: Where dissimilar metals contact each other or possibly corrosive substrates, protect against galvanic action by permanent separation as recommended by the metal roof panel manufacturer.

Joint Sealers: Install gaskets, joint fillers, and sealants where indicated and required for weatherproof performance of metal roof panel

system. Provide types of gaskets, fillers, and sealants indicated or, if not indicated, types recommended by metal roof panel manufacturer.

3.7.1 Handling and Erection

Erect roofing system in accordance with the approved erection drawings, printed instructions and safety precautions of the manufacturer.

Do not subject panels to overloading, abuse, or undue impact. Do not apply bent, chipped, or defective panels. Replace and remove from the site any damaged panels at the Contractor's expense. Erect panels true, plumb, and in exact alignment with the horizontal and vertical edges of the building, securely anchored, and with indicated rake, eave, and curb overhang. Allow for thermal movement of the roofing, movement of the building structure, and provide permanent freedom from noise due to wind pressure.

Do not permit storage, walking, wheeling or trucking directly on applied roofing materials. Provide temporary walkways, runways, and platforms of smooth clean boards or planks as necessary to avoid damage to the installed roofing materials, and to distribute weight to conform to the indicated live load limits of the roof construction.

Lay roof panels with corrugations in the direction of the roof slope. Lap ends of exterior roofing not less than 8 inches; lap sides of standard exterior corrugated panels not less than 2-1/2 corrugations.

Field cutting of metal roof panels by torch is not permitted. Field cut only as recommended by manufacturer's written instructions.

3.7.2 Closure Strips

Install metal closure strips at open ends of metal ridge rolls; open ends of corrugated or ribbed pattern roofs, and at intersection of wall and roof, unless open ends are concealed with formed eave flashing; rake of metal roof unless open end has a formed flashing member; and in other required areas.

Install closure strips at intersection of the wall with metal roofing; top and bottom of metal siding; heads of wall openings; and in other required locations.

3.7.3 Workmanship

Make lines, arises, and angles sharp and true. Free exposed surfaces from any visible wave, warp, buckle and tool marks. Fold back exposed edges neatly to form a 1/2 inch hem on the concealed side. Make sheet metal exposed to the weather watertight with provisions for expansion and contraction.

Make surfaces to receive sheet metal plumb and true, clean, even, smooth, dry, and free of defects and projections which might affect the application. For installation of items not shown in detail or not covered by specifications conform to the applicable requirements of SMACNA 1793. Provide sheet metal flashing in the angles formed where roof decks abut walls, curbs, ventilators, pipes, or other vertical surfaces and wherever indicated and as necessary to make the work watertight.

3.8 ACCEPTANCE PROVISIONS

3.8.1 Erection Tolerances

Erect metal roofing straight and true with plumb vertical lines correctly lapped and secured in accordance with the manufacturer's written instructions. Horizontal lines must not vary more than 1/4 inch in 20 feet or 3/8 inch in 40 feet.

3.8.2 Leakage Tests

Finished application of metal roofing is to be subject to inspection and test for leakage by the Contracting Officer or his designated representative, and Architect/Engineer. Inspection and tests will be conducted without cost to the Government.

Inspection and testing is to be made promptly after erection to permit correction of defects and removal/replacement of defective materials.

3.8.3 Repairs to Finish

Scratches, abrasions, and minor surface defects of finish may be repaired with the specified repair materials and as recommended by the metal roof panel manufacturer. Finished repaired surfaces must be uniform and free from variations of color and surface texture. Repaired metal surfaces that are not acceptable to the project requirements are to be immediately removed and replaced with new material.

3.8.4 Paint Finished Metal Roofing

Paint finished metal roofing will be tested for color stability by the Contracting Officer during the manufacturer's specified guarantee period. Remove and replace panels that indicate color changes, fading, or surface degradation, determined by visual examination with new panels at no expense to the Government. New panels will be subject to the specified tests for an additional year from the date of their installation.

3.9 CLEAN UP AND DISPOSAL

Clean exposed sheet metal work at completion of installation. Remove metal shavings, filings, nails, bolts, and wires from roofs. Remove grease and oil films, excess sealants, handling marks, contamination from steel wool, fittings and drilling debris and scrub the work clean. Exposed metal surfaces must be free of dents, creases, waves, scratch marks, solder or weld marks, and damage to the finish coating. Touch up scratches in panel finish with manufacturer supplied touch-up paint system to match panel finish. Treat exposed cut edges with manufacturer supplied coat.

Collect all scrap/waste materials and place in containers. Promptly dispose of demolished and scrap materials. Do not allow scrap/waste materials to accumulate on-site; transport immediately from the government property and legally dispose of them.

3.10 FIELD QUALITY CONTROL

3.10.1 Manufacturer's Inspection

Manufacturer's technical representative must visit the site a minimum of once per week during the installation for purposes of reviewing materials installation practices and adequacy of work in place. Make inspections during the first 20 squares of roof panel installation, at mid-point of the installation, and at substantial completion, at a minimum. Additional inspections are required for each 100 squares of total roof area with the exception that follow-up inspections of previously noted deficiencies or application errors must be performed as requested by the Contracting Officer. After each inspection, submit a report, signed by the manufacturer's technical representative to the Contracting Officer within 3 working days. Note in the report overall quality of work, deficiencies and any other concerns, and recommended corrective action.

Submit three signed copies of the [manufacturer's field inspection reports](#) to the Contracting Officer within one week of substantial completion.

3.11 [INFORMATION CARD](#)

For each roof, furnish a typewritten information card for facility records and a card laminated in plastic and framed for interior display at roof access point, or a photoengraved [0.032 inch](#) thick aluminum card for exterior display.

Make card [8 1/2 by 11 inches](#) minimum, identifying facility name and number; location; contract number; approximate roof area; detailed roof system description, including deck type, roof panel manufacturer and product name, type underlayment(s), date of completion; installing contractor identification and contact information; manufacturer warranty expiration, warranty reference number, and contact information. Install card at location as directed by the Contracting Officer and provide a paper copy to the Contracting Officer.

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