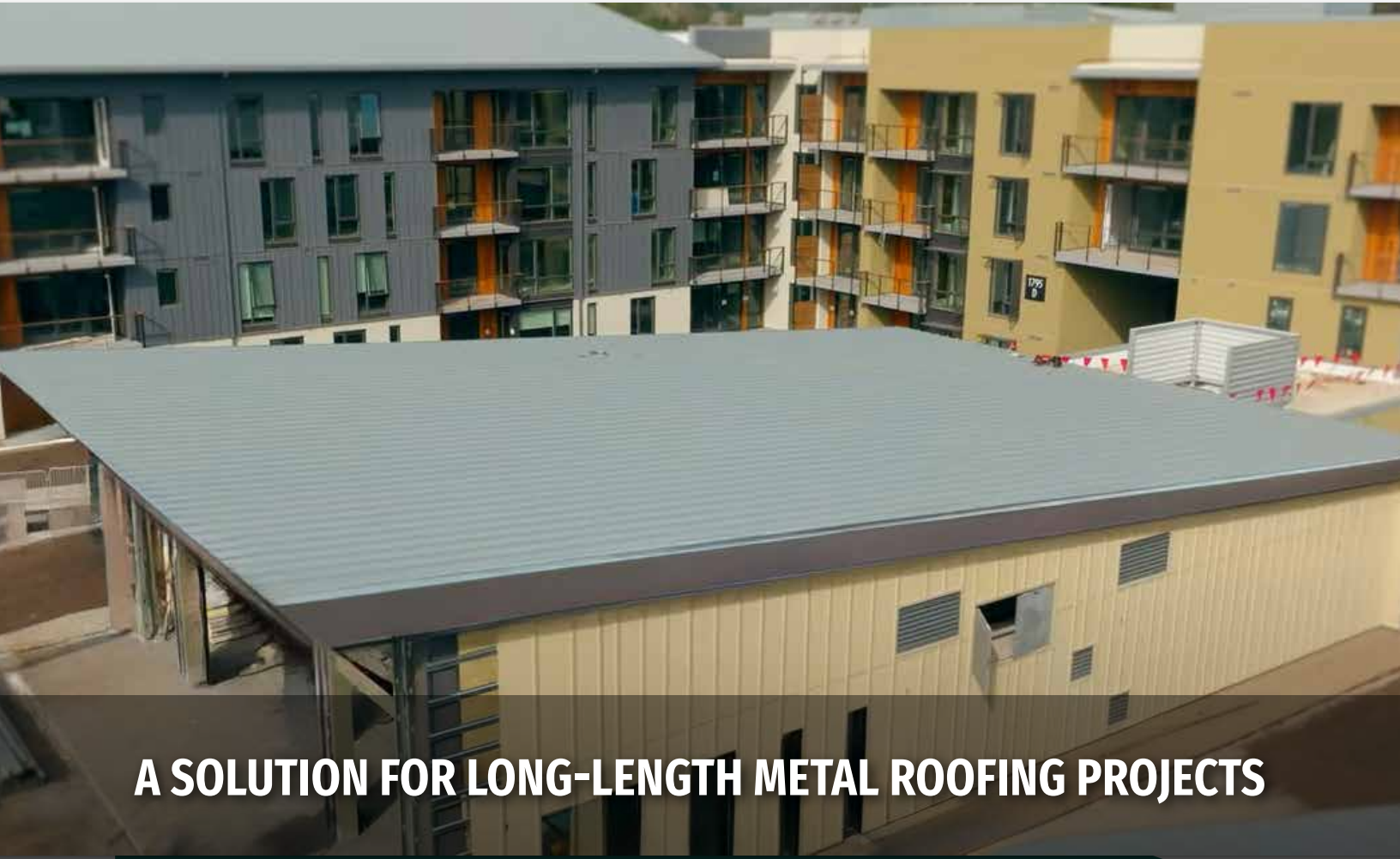




## ON-SITE ROLL FORMING CAPABILITIES & REQUIREMENTS



### A SOLUTION FOR LONG-LENGTH METAL ROOFING PROJECTS



AEP Span offers an on-site roll former solution for long-length Span-Lok™ *hp* metal roofing projects. On-site roll forming is an ideal solution for metal roofing projects designed with continuous long-lengths with no lapping of panels.

As your reliable partner, AEP Span's expert team can provide technical and logistical solutions to meet your project needs and guarantee a quality Span-Lok *hp* metal roof product produced on-site.

[www.aepspan.com](http://www.aepspan.com)

### Why Select the Span-Lok™ *hp* On-Site Roll Former?

Due to its weather-tight design and aesthetic appeal, the Span-Lok *hp* profile is a top metal roof product for architects and metal roofing contractors. Ideal for commercial, mixed-use, retail, or multi-use projects.

The on-site roll forming of Span-Lok *hp* enables the production of longer-length panels at the job site. Right off the on-site mill, the roofing contractor can begin the installation of the continuous panel lengths with no end lapping to achieve a roofing panel length that exceeds 45 feet.

### Guaranteed Excellence:

AEP Span's factory-certified team guarantees excellent quality control and effective on-site material management. The on-site roll former features an enclosed mill design, reducing exposure to job site conditions and weather variability, maximizing product consistency and job site uptime.

Effective quality control and having the right team in place can save you time, money, and materials.

## Span-Lok™ *hp* Metal Roofing

The mechanically seamed 2" high rib, provides aesthetic appeal and weathertightness that can be used in a wide variety of new construction or retrofit applications.



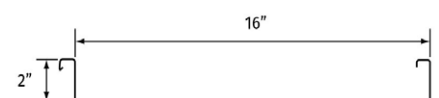
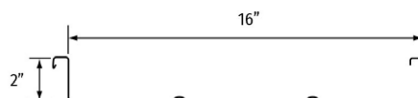
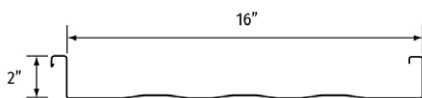
*Span-Lok™ hp Striated*



*Span-Lok™ hp 2 Pencil Ribs*



*Span-Lok™ hp Flat*



Also available in SpanSeam™ for narrow applications. Inquire with your AEP Span sales representative for details.



Available in Striated, 2 Pencil Ribs, & Flat

Coverage: 16" | Gauge: 24, 22

Colors: All standard PVDF options

Slope: 1/4" : 12"

Panel assemblies are Class A Fire Rated when installed on noncombustible deck or framing per IBC or IRC. Panel assemblies are also Class A Fire Rated per UL790 when installed in accordance to UL listings.

Panel evaluated by accredited third party. All structural performance data is contained within an IBC/IRC 2018 code compliance report #ER-0309.

\* Notching and swaging are not available with the on-site roll former.



# ON-SITE ROLL FORMING REQUIREMENTS

## AEP SPAN WILL:

1. Ensure that sufficient coil arrives at the jobsite on time.
2. Ensure that arrival of the roll forming equipment at the proper time.
3. Maintain production schedules and product quality.
4. Provide (1) operator to run the on-site machine.
5. Confirm jobsite conditions, including layout and safety requirements. This must be done prior to starting work.

**SAFETY:** AEP Span's top priority is safety. AEP Span has joint responsibility with the customer (buyer) for the safe operation of the on-site equipment and the work that will be performed. The AEP Span operator and individuals involved in on-site operations will comply with all safety requirements. A daily safety meeting will be held prior to work starting. All PPE must be worn in accordance with jobsite requirements. Customer (buyer) must notify AEP Span in advance of any jobsite safety requirements and provide specialized equipment if needed.

**PERMITS:** If applicable, customer is responsible for securing all necessary permits for the operation of the on-site machine and fabrication of the panels at the jobsite. AEP Span will provide whatever assistance and information required to secure a permit.

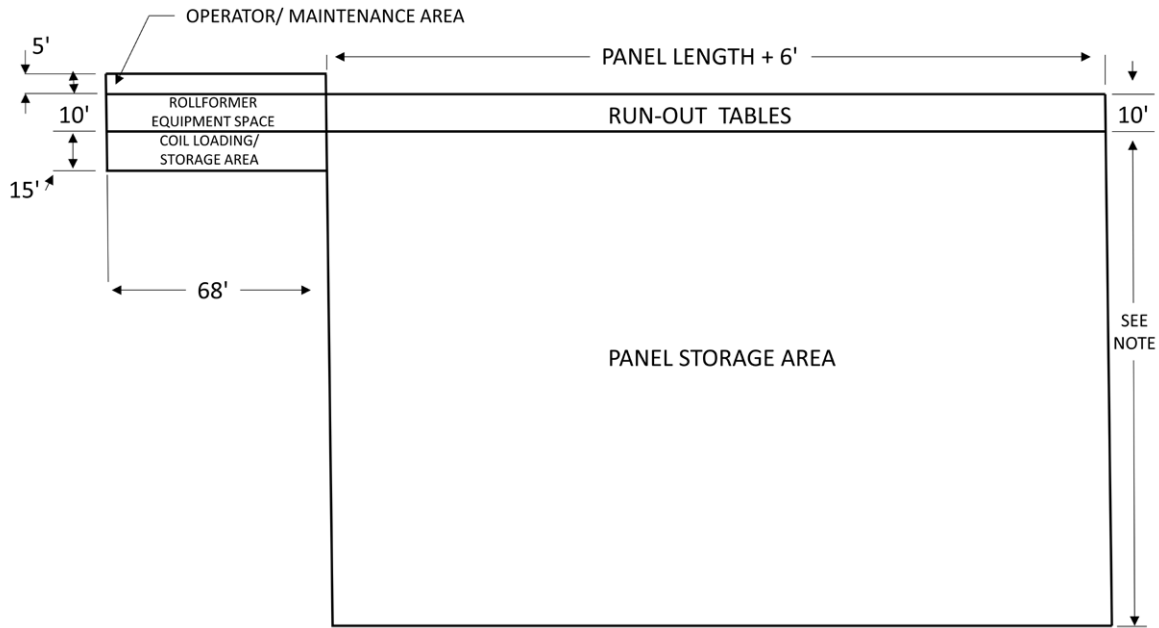


**LABOR:** Customer (buyer) to provide written confirmation of the labor union's approval to allow on-site roll forming at the proposed site at least 60 days prior to completion. Contact the general contractor of the project to determine if a public works project and instruct AEP Span as to prevailing wage requirements.

Customer (buyer) must provide additional labor to assist in the handling of the panels. The AEP Span operator will direct all work instruction as it relates the roll forming operation. *Estimate one person per 15' length, plus one for forming operation.*

**QUOTING:** AEP Span must be informed at time of quote if the project is deemed "Public Works" and prevailing wage is in effect. Customer (buyer) will receive an additional invoice for labor if not specifically outlined at time of quote.

## JOBSITE ROLL FORMING EQUIPMENT REQUIREMENTS:



**NOTE:** PANEL STORAGE AREA DEFINED BY NUMBER OF PANELS TO BE STORED

**Note:** The on-site roll former equipment space provides for coil storage, coil reel, roll former, support equipment, and forklift access for changing coils. The jobsite space should be **a clean, hard surface such as a black top**. All equipment is pre-set and mounted in a 40' closed trailer (approximately 68' total with truck).

**SCHEDULING:** Expected roll forming schedule must be submitted and approved with cut list submitted 8 weeks prior to roll forming. Schedule must be confirmed no later than 4 weeks prior.



**ROLL FORMING EQUIPMENT LOCATION:** Customer (buyer) to ensure the proper work area for the roll forming equipment. The machine is self-contained and requires no on-site electrical connections.

- There must be a solid foundation, as container weighs 16,000 lbs and must be leveled. A solid foundation is also required to maintain maneuverability of the truck and trailer and coil loading and equipment handling.
- There must be adequate storage space to accommodate the finished panels for the entire job.

Any costs incurred to accomplish a. and b. will be paid by the customer (buyer) or General Contractor (GC). Once the machine is set up, any subsequent moves, will be done with equipment furnished by the customer (buyer) and cost an additional \$500 per move.



**FACILITIES:** Customer (buyer) must provide AEP Span on-site employee(s) with access to jobsite facilities, including restroom, parking and access on the same terms as other jobsite laborers.

**PANEL PRODUCTION:** Customer (buyer) is responsible to provide a complete bill of materials prior to start of production. The need for running the order in a particular sequence must be approved prior to the time that the on-site roll former arrives at the job.

On-site roll forming cannot be restricted once it has started. The entire job must be run at one time. Once the panel is sheared and leaves the roller tables, the customer (buyer) is responsible for the movement, storage, safety, and loading of the panels. A spreader bar and crane may be necessary to load panels onto the roof, which is outside the scope of AEP Span's roll-forming contract. The panels will be formed faster than they can be installed and the objective is to run eight hrs/day six days/wk.



**STORAGE AND HANDLING:** Customer (buyer) must provide jobsite security for the roll forming machine and related equipment. Arrange for one 8,000 lb capacity forklift with certified operator to load coils and unload equipment to and from closed trailer. The forklift must be suitable to the terrain at the jobsite. Charges for the forklift will be paid by the contractor-erector.

Customer (buyer)/GC to provide an area sufficient to store completed panels in a manner that prevents damage. See enclosed documentation for proper storage of panels.

**CLEANUP:** Customer (buyer) is responsible for the removal and disposal of all scrap pieces, unused panels and dunnage.

**WEATHER:** Be aware of any unsafe weather or jobsite conditions caused by inclement weather. The decision to roll form or not will be made by the AEP Span equipment operator and the installer/GC based on jobsite conditions at the time. AEP Span will not be responsible for any cost related to project delays due to weather.

**DELAYS:** Delays due to labor, jobsite conditions, or scheduling after the roll forming equipment and operator have arrived are subject to additional charges.

## INTRODUCTION:

Pre-painted building panels and components have been successfully used for many years. In general, properly installed building materials under normal service conditions have excellent corrosion resistance. However, pre-painted and bare building materials are subject to premature corrosion failures prior to installation if they are not handled and stored properly.

Excessive storage periods or poor storage conditions often result in water intrusion. Prolonged exposure to wet conditions can cause paint blistering and substrate corrosion or staining in as little as two weeks.

## ENVIRONMENTAL AND SERVICE CONDITIONS:

Water is a necessary prerequisite for corrosion of stored panels or components. When water or water vapor is available along the sides of a panel bundle or a column/purlin stack, it may penetrate between the panels or parts by capillary action. Ambient humidity and temperature cycles will also promote water intrusion into stored bundles and stacks through condensation. Finally, rain and snow are other potential sources of water that can cause storage corrosion and staining.

Besides water, two other important factors that contribute to the corrosion are temperature and exposure time. Corrosion will accelerate with increased temperature. Given enough time, panel bundles will eventually become wet and storage corrosion and staining may occur. Storage corrosion can be prevented by:

- Reducing site storage time.
- Decreasing water contact.
- Moderating temperature extremes.

## STORAGE:

Prolonged storage will always increase the likelihood of storage corrosion; therefore, the best prevention is to minimize the storage time. Proper storage limits the collection of water from rain, snow and condensation on the panel surfaces. Under roof storage is always preferred. If panel bundles or other components have to be stored outdoors, a number of precautions must be taken to prevent storage corrosion. Material should be stored in a level area out of the way of other activities to minimize the number of movements required. If the material is stored on the ground, i.e. dirt, grass or gravel, a plastic ground cover must be put down to minimize condensation of water from the ground onto the panels or components.

The material must then be raised off the plastic ground cover to avoid contact with water puddles, and allow for air circulation to promote drying of condensed water. The material must be stored on an angle, or slope, to promote drainage of water. Sufficient support must be provided to the raised and angled material to avoid excessive bowing, which may result in low spots that could hold water.

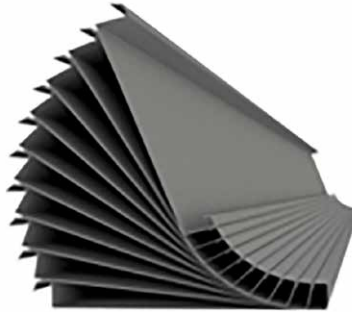
## REMEDIES:

Storage corrosion on pre-painted material cannot be remedied. Once the corrosion process has begun the film integrity of the paint is compromised. Panels displaying any type of corrosion or paint bubbling should not be installed. Light corrosion or staining (white or black in color) on bare material may be cleanable; contact your AEP Span representative for proper cleaning techniques.

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## EXAMPLES OF ON-SITE STORAGE:

Fanning the panels into stacks should only be used for temporary storage and immediate movement to place of panel installation on roof.



For longer term storage and potential panel movement on the ground, the recommended panel cradles illustrated below or some form of a cradle support should be assembled (customer (buyer) discretion), to support the panels along the entire length of the panels. The panels should be supported every 20' feet and on both ends.

Using the illustration below a 6' foot cradle support (3) supports would be required for a 60' foot panel. For movement on the ground and stacking of the bundles the cradles should be closed with a supporting member across the top of the cradle to secure the panels in place. Using this packaging for lifting the bundles to a roof is not recommended without an engineered lifting solution created by the customer (buyer).



## References:

1. National Coil Coating Association, Tool Kit #1 "Preventing Job Site Storage Corrosion of PrePainted Building Materials"



## An On-Site Solution for Long-Length Metal Roofing Projects



[www.aepspan.com](http://www.aepspan.com)



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For most current versions of literature please visit  
[www.aepspan.com](http://www.aepspan.com)

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