



PRODUCT & ENGINEERING MANUAL

The following ***Nucor Building Systems Specification Guide*** provides the owner or design professional a detailed description of all standard Nucor Building Systems (NBS) products. This guide is designed to aid the architect or engineer of record in the process of specifying the best building system solution.

These comprehensive specifications cover many aspects of the NBS product line. Since it is possible to apply the various NBS products covered in this manual in many different ways, not all conditions are addressed, and more detailed information is available. For the unique needs of an individual project building design, please contact the NBS engineering team for assistance.

This guide incorporates, by reference, the latest edition of the MBMA Metal Building Systems Manual, published by the Metal Building Manufacturers Association (MBMA), to all Nucor project specifications.

Notice: In keeping with a program of continuous and never ending improvement all information contained herein is subject to change without notice.

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1. General

1.1. Scope

1.1.1. The building shall consist of all primary and secondary structural members, connection bolts, canopies, roof extensions, sheeting, trim, flashing, doors, fasteners, gutters, downspouts, and other miscellaneous items and accessories as specified, shown, or called for on Nucor Building Systems' drawings or order documents. Refer to the Latest Edition of the Metal Building Systems Manual section entitled "Common Industry Practices" for the standards in which this guide will be used. Nucor will not provide items not specifically called for in the Nucor order documents.

1.2. Dimensional Terminology

1.2.1. The building "width" shall be the distance from outside face of sidewall girt to outside face of sidewall girt (steel line to steel line).

1.2.2. The building "length" shall be the distance from outside face of endwall girt to outside face of endwall girt (steel line to steel line).

1.2.3. The building "eave height" shall be the distance from finished floor to top of eave strut or purlin at the steel line. For buildings with curbs or column recesses, eave height shall still be measured from the finished-floor elevation.

1.2.4. The "bay spacing" shall be the distance from center of primary frame to center of primary frame for interior bays. End bays shall be the distance from outside face of endwall girt (steel line) to center of first interior primary frame.

1.2.5. The "module spacing" on RMG-X buildings shall be the distance from outside face of sidewall girt (steel line) to center of first interior column. It is also the distance from center to center of interior columns for interior spans.

1.2.6. The "roof slope" shall be based on an order-specified vertical rise for each 12" horizontal run unless otherwise stated (1/4" in 12" minimum for Nucor CFR™ and VR16 II™; 1/2" in 12" for Nucor Classic™ roofs).



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1.3. Building Types

- 1.3.1. Solid web framing consists of members fabricated from shop-welded, hot-rolled steel sheets or plates and hot-rolled flat bars.
 - 1.3.1.1. Rigid frames (RCG) are clear span buildings with tapered sidewall columns. They are commonly used for spans from 40 feet to over 150 feet.
 - 1.3.1.2. Tapered beams (TCG) are clear span buildings suitable for smaller span buildings from 20 feet to 60 feet wide. TCG buildings utilize straight sidewall columns and horizontal bottom flange rafters.
 - 1.3.1.3. Rigid frames with interior columns (RMG-X) are multi-span buildings with interior columns (number of interior columns is designated by the "X"). They provide an economical advantage on buildings from 80 feet to over 300 feet wide.
 - 1.3.1.4. Single slope clear span (RCS) or multi-span (RMS-X) buildings are available in width ranges similar to RCG and RMG-X as previously listed. All roof drainage is taken to the low sidewall.
 - 1.3.1.5. Lean-to (LCS) or (LMS-X) buildings are similar to the single slope building; however, the high side column has been eliminated. The lean-to rafter is supported by the main building frame, sidewall, or endwall column.
 - 1.3.1.6. TrussFrame buildings incorporate straight or tapered columns in combination with open-web rafters comprised of tee-section chords with double-angle web members. Frames may be either clear span or modular.

2. Design

2.1. Design Criteria

- 2.1.1. All structural steel sections and welded plate members shall be designed in accordance with the latest editions of the AISC Specification for Structural Steel Buildings or CSA Specification for Structural Steel Buildings (S16) and the latest edition of the AWS D1.1 and D1.8 Structural Welding Codes or CSA Welded steel construction (metal arc welding) (W59), based on project location.
- 2.1.2. All light gage cold-formed structural members and exterior covering shall be designed in accordance with the AISI North American Specification for the Design of Cold-Formed Steel Structural Members (AISI S100). All standards for the welding of cold-formed members are based upon the latest edition of AWS D1.3 Structural Welding Code or CSA Welded steel construction (metal arc welding) (W59), based on project location.



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- 2.1.3. The primary and secondary framing and covering shall be designed for all applicable loads and combinations of loads as set forth in the specified governing building code for the order under consideration. This may be any of the standard model building codes currently published, such as: the International Code Council's International Building Code (IBC) or the National Research Council of Canada's National Building Code of Canada (NBC). Additionally, many orders may be within states or municipalities that have their own amendments to the governing model code or that have their own independent code. In this case, loads, deflection criteria, and load combinations will be determined in accordance with this governing local code. Specification of loads and codes and design responsibility shall be as stated in the "Common Industry Practices" section of the latest MBMA Metal Building Systems Manual. These "common industry practices" will apply regardless of the state, local, or model code chosen.
- 2.1.4. The appropriate code shall be specified at the time of the building quotation.

2.2. Engineering Certifications

- 2.2.1. All buildings shall be designed by or under the direct supervision of registered professional engineers in accordance with the information specified to Nucor on the order documentation in compliance with the "Common Industry Practices" section of the latest MBMA Metal Building Systems Manual. Nucor's sealing engineer is not the "Engineer of Record" for the project and cannot be construed as such.
- 2.2.2. Design calculations, certified by a professional engineer, may be purchased with the order, if requested.
- 2.2.3. A letter of certification, certified by a professional engineer, may be supplied with the building quote proposal, if requested. A letter of certification shall be provided with the order at the time the anchor bolt plans are complete.
- 2.2.4. All permit drawings shall be stamped with a professional engineer's seal in the state of the building location. Approval drawings will not be sealed. Erection drawings will be sealed only if specifically requested by the customer.

2.3. Non-Standard Design Loads

- 2.3.1. All building types shall be available with non-standard design loads as required by the local code or governing body provided these loads are specified on the order documents. Special dead, live, or wind loads shall be applied in the same manner as standard design loads for the type of building involved as long as MBMA design requirements are satisfied.



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2.4. Auxiliary Design Loads

- 2.4.1. Crane and impact loads shall be applied in accordance with the latest editions of the AISC Specification for Structural Steel Buildings, the CSA Specification for Structural Steel Buildings (S16), the "Common Industry Practices" section of the latest MBMA Metal Building Systems Manual as applicable, and the appropriate building code specified with the building proposal.
- 2.4.2. Seismic loads, for buildings in areas subject to earthquakes, shall be derived using the procedure set forth by appropriate building codes specified on the Nucor order documents.

2.5. Load Combinations

- 2.5.1. Load combinations shall be per the appropriate building code.

3. Anchor Bolts And Foundations

3.1. Anchor Bolts

- 3.1.1. Anchor bolts and base plates shall be designed to resist all column reactions. Sizes used shall be as those shown on Nucor Building Systems' drawings. The length and embedment anchorage of all anchor bolts shall be the responsibility of the foundation engineer.
- 3.1.2. Anchor bolts shall not be supplied by Nucor Building Systems and are the responsibility of the contractor or erector to furnish.
- 3.1.3. Leveling plates shall not be supplied by Nucor Building Systems unless specifically called for on the Nucor order documents.

3.2. Foundations

- 3.2.1. Foundations shall be designed by a qualified registered professional engineer to accommodate the local soil conditions and meet building reaction requirements in addition to other loads imposed by building use or occupancy. It shall be the responsibility of the Engineer of Record to verify that the loading criteria defined on the Order Documents is adequate for the location of the project in question.
- 3.2.2. Neither the foundation design nor the reinforcing steel shall be supplied by Nucor Building Systems. It shall be the responsibility of the customer, contractor, or erector to obtain these items.

4. Drawings

4.1. General

- 4.1.1. Nucor Building Systems shall supply on all orders three sets of anchor bolt drawings and reactions.
- 4.1.2. Nucor Building Systems shall supply on all orders three sets of final erection drawings.



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- 4.1.3. Upon request, Nucor Building Systems shall supply three sets of permit drawings showing engineering design details, critical clearances, key connection details, material specifications, and lateral load resisting elements such as bracing, diaphragm, and shear wall layouts.
- 4.1.4. Nucor Building Systems shall supply three sets of approval drawings on specified jobs. Approval drawings shall show building layout, critical clearances, critical details, and may include permit drawing information if requested. Final fabrication will not begin until approval drawings have been returned with appropriate release signatures or appropriate instruction has been given to Nucor to release the project using a Change Order.
- 4.1.5. Nucor Building Systems does not supply shop fabrication drawings for review or approval. As-built drawings are not provided by Nucor Building Systems.
- 4.1.6. Unless noted on the Nucor order documents, all drawings are issued on 11" x 17" paper stock. Full-size prints (24" x 36") are available at an additional cost.
- 4.1.7. Nucor does not provide electronic drawing files or as-built drawings.

5. Structural Framing

5.1 General

- 5.1.1. The term "primary structural" members or framing shall refer to any built-up, hot-rolled, or cold-form columns or framing systems which transfer their loads directly to the structure's foundation.
- 5.1.2. The term "secondary structural" members or framing shall refer to any cold-form, hot-rolled, or built-up purlins, girts, struts, bracing, or beams which transfer their loads from the cladding to the primary structural member or framing to which they attach.
- 5.1.3. Unless otherwise specified, the minimum standard design thickness of structural framing members shall be as follows:
 - Webs of welded built-up members → 0.125"
 - Flanges of welded built-up members → 0.188"
 - Cold-formed secondary framing members → 0.060"
 - Cable bracing → 0.250" / Rod bracing → 0.625"
 - Angle bracing → 0.1875"
- 5.1.4. All hot-rolled sheet, plate, and strip steel used in webs from 0.125" to 0.225" thick shall conform to the provisions of ASTM A-1011 SS or HSLAS Grade 55 (55,000 psi minimum yield strength). All thicknesses greater than 0.230" (to 0.500" inclusive) shall conform to ASTM A-572 Grade 55 (55,000 ksi minimum yield).
- 5.1.5. All hot-rolled flat bars used in flanges shall conform to the provisions of ASTM A-572 or A-529 Grade 55, with minimum yield of 55,000 psi.
- 5.1.6. All wide-flange, channel, and "S" shapes shall conform to the provisions of ASTM A-36, ASTM A-572 or ASTM A-992 ("W" shape only). All tube and pipe shapes



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shall conform to ASTM A-500, Grade B. All hot-rolled or cold-rolled sheet and strip steel less than 0.150" thick used in fabrication of cold-formed structural members shall be of ASTM A-1011, Grade 55 (55,000 psi minimum yield stress).

- 5.1.7. Cable used for diagonal bracing shall conform to ASTM A-475; coating Class A, Grade- Extra High Strength 7 wire. Threaded rod shall meet ASTM A-529 or A-572, Grade 50 requirements. Angle sections shall meet minimum A-36, A-572 or A-529 Grade 50 requirements.
- 5.1.8. Structural steel members shall be sheared, formed, punched, welded, and painted by the manufacturer. All shop connections shall be welded in conformance with standards based upon the current edition of AWS D1.1, D1.8 or CSA W59 referenced previously in this guide in Paragraph 2.1.1. Welders and welding operators are qualified as provided in these same codes.
- 5.1.9. All field connections of primary structural members shall be bolted with high strength bolts and nuts (ASTM A-325 or A490) and shall be snug tightened unless otherwise specified. Secondary structural members shall be field bolted with ASTM A-307 or A-325 bolt assemblies as called for in design.
- 5.1.10. Light gage cold-formed sections shall be manufactured by roll or brake-forming. All dimensions shall be fabricated to MBMA tolerances.
- 5.1.11. All structural-framing members that are not galvanized shall be given one shop coat of a red primer. Gray primer is available at an additional cost but must be requested under special requirements of the order document and applied to a nominal thickness of 0.8 mil. All surfaces are in accordance to systems industry standards as cleaned of loose rust, loose mill scale, and other foreign matter by using, as a minimum, the hand tool cleaning method SSPC-SP2 prior to painting. All painted surfaces are to be reasonably free of excessive drips, runs, sags, and cracking. Reference MBMA¹ and AISC² for intended primer protection, proper care, erection, and function of shop prime coat.
- 5.1.12. All framing members shall have identifying marks to aid the erector in the erection of the building.

5.2. Primary Structural Members

- 5.2.1. Rigid frame, sidewall columns, rafter beams, and canopy beams shall be shop-welded, built-up "I" shapes. Members shall be of constant depth or tapered, having base plates, necessary clips, and splice plates for completely field-bolted assembly and attachment of secondary members.
- 5.2.2. Rafter beams and endwall columns shall be either built-up "I" shapes, "WF" shapes, or roll-formed "C" sections as required to satisfy load and span

¹ Chapter IV, Section 4 of the latest MBMA Metal Building Systems Manual (Structural Framing Shop Primer).

² Section 6.5 of the "Code of Standard Practice for Steel Buildings and Bridges", AISC, Latest Edition.



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requirements. Interior columns shall be round pipe sections. Built-up "I" shapes or hot-rolled "WF" or tube sections shall be provided as required to satisfy certain load or order requirements.

5.3. Secondary Structural Members

- 5.3.1. Purlins and girts shall be roll-formed "Z" or "C" sections of adequate size and thickness as determined by the design criteria. Purlins and girts shall be either simple-span or continuous members.
- 5.3.2. Purlins for "long-bay" building layouts shall typically consist of bar joists designed under Steel Joist Institute specifications for the prescribed loads. Field welding of joist bridging and seats is the standard method for connection of joists to supporting primary structural members.
- 5.3.3. Eave struts shall be roll-formed or brake-formed "C" sections.
- 5.3.4. Wind bracing shall consist of diagonal cable, rod, or angle bracing. Adjustment to cable braces shall be made by an eyebolt assembly. Adjustment to rod bracing may be by threaded assembly. Angle bracing is not adjustable and may require final field welding.
- 5.3.5. Flange bracing shall consist of angle bracing connected to the web of the purlin or girt and to the compression flange of the primary structural member. Flange braces shall be attached to bar joists via field welding.
- 5.3.6. Base support for wall panels shall consist of a continuous base angle, base angle flash, or base girt which shall be securely attached to concrete by the contractor using powder actuated drive pins/nails, expansion anchors, or other similar anchorage.

6. Roof Covering Nucor Classic Roof™ Panel

6.1. General

- 6.1.1. Minimum recommended roof slope for Nucor Classic Roof™ panel is 1/2" in 12".
- 6.1.2. Maximum recommended building width is 240' (gable) or 120' (single slope) for "Z" purlin roofs. Nucor Classic Roof™ profile shall be used in conjunction with zee or cee purlins as supports. Joists or roof beams are not acceptable support members unless specifically agreed to by Nucor's Engineering Manager.
- 6.1.3. Nucor Classic Roof™ (26 ga.) panel qualifies for a UL 580 Class 90® uplift rating (Construction #161) when attached to roof purlins, when spaced at 5'-0" on center or less.
- 6.1.4. Nucor Classic Roof™ (26 ga.) panel qualifies for a FM1-120 uplift rating when attached to roof purlins, spaced at 5'-0" on center or less.



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6.2. Panel Material

- 6.2.1. Nucor Classic Roof™ panel profile shall be precision roll-formed from 26-gage steel sheeting.
- 6.2.2. Galvanized steel sheeting shall be processed in accordance with ASTM A-653. Consult your specific plant for minimum yield strength and grade of material. The galvanized coating shall be .90 oz per square foot (Class G90) in accordance with ASTM A-653. The spangle for galvanized panel is bright flat spangle in accordance with ASTM A-653.
- 6.2.3. Galvalume® steel sheeting shall be aluminum-zinc alloy coated steel sheet in accordance with ASTM A-792. Consult your specific plant for minimum yield strength and grade of material. It has a coating thickness of .55 oz per square foot.
- 6.2.4. Roof panels provided by Nucor Building Systems for exterior use are precision roll-formed from pre-painted G90 galvanized or Galvalume® coils. Coils to receive finish paints are subjected to a strenuous cleaning process prior to coating. Next, the coils are primer coated and oven cured. The finish coat is then applied and monitored for proper oven-cure temperature and color uniformity. Finished material is subjected to stringent quality control tests including: physical bend and impact resistance, film thickness, hardness, gloss, and color. This process is time tested and uses the industry proven modified Siliconized Polyester paint system. A 70% PVDF finish is available at an additional cost upon request.

6.3. Panel Configuration

- 6.3.1. “Nucor Classic Roof™ panel provides a 36” net coverage and consists of major ribs 1-1/4” deep spaced at 12” on center with an extended purlin bearing sidelap to allow for additional sidelap support. Two minor ribs are evenly spaced in the flat area between major ribs. Fasteners
- 6.3.2. Roof panel to secondary structural fastener shall be a No. 12 self-drilling carbon steel screw, hex washer head with sealing washer, 1-1/4” long. Fastener shall have a 20-year corrosion resistant coating. Fastener shall have a painted head to match panel and/or trim color when used with painted material.
- 6.3.3. Panel to panel, flash to flash, (stitch) fastener for roof shall be a No. 12 self-drilling carbon steel screw, hex washer head with sealing washer, 7/8” long. Fastener shall have a 20-year corrosion resistant coating. Fastener shall have a painted head to match panel and/or trim color when used with painted materials.

6.4. Trim and Flashing

- 6.4.1. Color-coated trim and flashing shall be 26 gage. Trim shall be provided at eave, ridge, rake, and wherever necessary to ensure a properly constructed building, as defined on the Nucor order documents.



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- 6.4.2. Neither counter-flashing for parapet conditions nor tie-in flashing to existing buildings shall be provided by Nucor Building Systems.
- 6.4.3. All exposed trim and flashing material shall be manufactured from galvanized or Galvalume® steel strip.
- 6.4.4. Exterior gutters and gable flash shall be manufactured in 20' lengths wherever possible.

6.5. Sealants

- 6.5.1. Mastic for sidelaps, endlaps, and flashing shall be an isobutylene tripolymer rubber pressure sensitive tape mastic.
- 6.5.2. Tape mastic for sidelaps shall be 3/32" thick X 1/2" wide and mastic for endlaps shall be 3/16" thick X 3/4" wide.
- 6.5.3. Tube sealants shall be of the non-hardening elastomeric type. This sealant is to be used at all trim and flashing endlaps.

6.6. Closures

- 6.6.1. Closures shall be closed cell polyethylene foam to match the panel configuration.
- 6.6.2. Closures shall be provided at the eave of roof panels.

6.7. Installation of Panels

- 6.7.1. Storage and installation of the roofing system shall be in accordance with Nucor's printed instructions.
- 6.7.2. All endlaps and sidelaps on roof panels shall be sealed with a continuous row of tape mastic to prevent air and water from infiltrating the building.
- 6.7.3. Standard maximum panel length shall be 30'. If required, lengths of up to 45' may be provided.
- 6.7.4. The use of cutting tools that damage the panel finish shall not be allowed.
- 6.7.5. Panels shall not be marked with any graphite or lead markers.

6.8. Clean-Up

- 6.8.1. Roof surface should be cleaned daily during construction of all filings, cuttings, screws, pencil markings, and debris to prevent damage due to oxidation of foreign materials.
- 6.8.2. Contractor shall thoroughly clean all panels, trim, and gutters of all foreign material upon completion of construction.



6.9. Field-Cutting Of Panels

- 6.9.1. When field-cutting or mitering Nucor Classic Roof™ panels, non-abrasive cutting tools such as nibblers or tin-snips shall be used. Abrasive cutting tools such as mechanical grinders, saws, shears, or scissors can damage the Galvalume® or painted finish and create excess metal shavings that can corrode the panels. The use of non-approved cutting devices may void your manufacturer's warranty.

7. Roof Covering Nucor CFR™ Standing Seam Roof System

7.1. General

- 7.1.1. Specifically included are panels, panel clips, flashing, panel splices, ridge material, and all necessary fasteners.
- 7.1.2. Minimum roof slope is 1/4" in 12".
- 7.1.3. Panels are rated for UL90® uplift rating UL580 when installed to roof support members spaced as listed in UL Construction Listing #552, supported at a maximum of 5'0 on center by either joists or purlins.
- 7.1.4. Panels have an FM1-120 uplift rating when installed to roof support members spaced at a maximum of 5'0 on center by either joists or purlins
- 7.1.5. Reference "Optional Insulation Pan" under 9.5.2.

7.2. Panel Material

- 7.2.1. Nucor CFR™ profile shall be precision roll-formed from 24 gage steel. Galvalume® steel sheeting is aluminum-zinc coated steel alloy coated steel sheet with a minimum yield strength of 50 ksi in accordance with ASTM A-792, Grade 50. It has a coating thickness of .55 oz. per square foot.
- 7.2.2. Roof panels provided by Nucor Building Systems for exterior use are precision roll-formed from pre-painted Galvalume® coils. Coils to receive finish paints are subjected to a strenuous cleaning process prior to coating. Next, the coils are prime coated and oven cured. The finish coat is then applied and monitored for proper oven-cure temperature and color uniformity. Finished material is subjected to stringent quality control tests including: physical bend and impact resistance, film thickness, hardness, gloss, and color. This process is time tested and uses the industry proven modified Siliconized Polyester paint system. A 70% PVDF finish is available at an additional cost upon request. CFR roof accessories (end dams, cinch straps, gutter brackets) are provided as unpainted.
- 7.2.3. Panel shall be factory-dimpled and notched at ridge, high side, and lap locations.
- 7.2.4. Panel sidelaps shall have factory-applied non-skinning Butyl mastic.



7.3. Panel Configuration

7.3.1. Panels shall have 3" deep trapezoidal ribs spaced 24" on center. Three minor ribs are spaced in the flat of the panel between the major ribs.

7.4. Panel Clip & Fasteners

7.4.1. Fixed panel clips shall only be used with panel runs of less than 120'. Floating panel clips shall be used up to a 250' panel run and shall be self-centering and allow for up to 1-1/2" expansion and/or contraction of total movement from the centered position. The clip design shall insure that movement does not occur between the panel and clip.

7.4.2. The panel clips shall have factory-applied mastic to insure a weather-tight installation.

7.4.3. Each clip shall be attached to the joist or purlin with a minimum of two fasteners. In certain instances, three fasteners may be required. Size and type of clip and fastener quantity will be recommended by Nucor Building Systems for the specific application. Clip fasteners for retrofit applications are not by Nucor and must be specified by the owner or his agent.

7.4.4. Panel endlap fasteners shall be a No. 12 self-drilling carbon steel screw, hex washer head, 1-1/4" long. Fastener shall have a 20-year corrosion resistant coating.

7.5. Trim and Flashing

7.5.1. Color-coated trim and flashing shall be 26 gage. Trim shall be provided at eave, ridge, rake, and where necessary to ensure a properly constructed building.

7.5.2. High eave flashing and flashing parallel to the roof panels shall accommodate the thermal expansion and contraction of the roof without damage to the roof panels or flashing. Counter-flashing for parapet conditions and flash to existing buildings are not provided by Nucor Building Systems.

7.5.3. All exposed trim and flashing material shall be manufactured from galvanized or Galvalume® steel strip.

7.5.4. Exterior gutters and gable flash shall typically be manufactured in 20' lengths wherever possible.

7.6. Installation

7.6.1. Storage and installation of the roofing system shall be in accordance with Nucor's printed instructions.

7.6.2. The Nucor CFR™ roof hand crimper is specially designed for use with Nucor CFR™ roof. Under no circumstances shall the Nucor crimper be used on any



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other manufacturer's roof system. In addition, under no circumstances is another manufacturer's crimper to be used on the Nucor CFR™ roof (even if they appear to be the same). Permanent damage to the seam and/or the panel finish may occur if the Nucor crimping tool is not used and shall void all warranties.

- 7.6.3. The panel splice shall have a 0.060" galvanized steel back-up plate.
- 7.6.4. The back-up plate shall have alignment tabs to ensure proper fit.
- 7.6.5. Panel splice shall be sealed with precut tape mastic.
- 7.6.6. Standard maximum panel length varies per plant (50'-0" to 55'-0"). Check your local plant for their specific max panel lengths.
- 7.6.7. The use of cutting tools that damage the panel finish shall not be allowed.
- 7.6.8. Panels shall not be marked with any graphite or lead markers.

7.7. Clean-Up

- 7.7.1. Roof surface should be cleaned daily during construction of all filings, cuttings, screws, pencil markings, and debris to prevent damage due to oxidation of foreign materials.
- 7.7.2. Contractor shall thoroughly clean all panels, trim, and gutters of all foreign material upon completion of construction.

7.8. Maintenance

- 7.8.1. The owner shall keep the roof free and clean of debris and corrosive materials at all times.
- 7.8.2. Gutters and downspouts shall be cleaned periodically and kept free-flowing at all times.
- 7.8.3. Flashing and sheeting interfaces shall be inspected yearly to ensure connection and water-tightness.
- 7.8.4. Endlaps, eaves, ridges, curbs, translucent panels, and other interfaces shall be inspected and maintained yearly. Normal adjustments or tightening of fasteners may be required.
- 7.8.5. The use of tar and other topical applied products shall not be permitted unless specified by the manufacturer.
- 7.8.6. Copper, lead flashing, exposed iron, or debris shall not be permitted on the roof.
- 7.8.7. Pipes to and supports for roof-supported units shall be of a non-corrosive or rust-free material. Field painting of pipes and supports may be required to resist corrosion. Condensation from roof-top units shall be piped to interior or exterior locations. Damage due to condensate water is not covered under manufacturer's warranty.



7.9. Erection Sequence

- 7.9.1. The Nucor CFR™ Roof System is designed to be erected starting from either end of the building. In rare cases, due to the building layout, it may be required to start erection from a specified end. In those cases, it will be noted as such on the erection drawings.
- 7.9.2. Sequencing of steel shall be clearly marked on the order documents at the time of order entry.

7.10. Coordination with Other Trades

- 7.10.1. Supports for the Nucor CFR™ Roof System shall be provided and are required as shown in the drawings and as noted in these specifications. All necessary clearance dimensions for proper elevations relative to the roof panels have been shown. The customer shall be responsible for coordinating these dimensional requirements with other trades associated with the building roof system.

7.11. Erection Care

- 7.11.1. The erector must be skilled in the erection of metal building systems and is responsible for complying with all applicable local, federal, and state construction and safety regulations. This includes OSHA regulations as well as any applicable requirements of local, national, or international union rules or practices. The Erector remains solely responsible for the safety and appropriateness of all techniques and methods utilized by its crews in the erection of the metal building system and/or the CFR roof system. The Erector is also responsible for supplying any safety devices such as scaffolds, runways, nets, etc., which may be required by the governing codes to safely erect the metal building system and/or CFR roof system.
- 7.11.2. Anchorage for safety devices may be added at an additional cost provided specific connections are designed and clearly noted on the order documents. All anchorage points must be noted with exact location, magnitude, and direction of force for a fully-braced structure.
- 7.11.3. The erector of the Nucor CFR™ erection drawings shall exercise great care and attention to the details as shown on the erection drawings and in the Nucor CFR™ erection manual to insure a secure and proper fit of all components. Nucor Building Systems shall not be responsible for supervising and/or coordinating the erection of the CFR Roof System with other trades. Erection drawings take precedence when a situation differs from that shown in the erection manual.
- 7.11.4. Due consideration must be given by the erector to the effects of thermal expansion and contraction when erecting a roof tie-in to an existing structure to insure a safe, secure, weather-tight condition. Flashing for tie-ins to existing buildings is typically not included as part of the material provided by Nucor Building Systems. Refer to the sections and details for specific materials provided by Nucor Building Systems.



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7.11.5. The erector acknowledges that all details for all conditions can be noted on the plans and that due care and judgment are required to make a safe and watertight condition. Sealants and caulks may be required based upon actual conditions encountered.

7.12. Field-Cutting of Panels

7.12.1. When field-cutting or mitering Nucor CFR™ roof panels, non-abrasive cutting tools such as nibblers or tin-snips shall be used. Abrasive cutting tools such as mechanical grinders, saws, shears, or scissors can damage the Galvalume® or painted finish and create excess metal shavings that can corrode the panels. The use of non-approved cutting devices may void your manufacturer's warranty.

7.13. Roof-Top Units and Curb Supports

7.13.1. The Nucor CFR™ Roof Curb Framing System is level with roof secondary structural members. The outer roof curb in a double curb system, will have channels attached to accommodate the clip off set of 1/2" for short clips and 1 1/2" for tall clips. Refer to the details for proper dimensions.

7.13.2. The Nucor CFR™ Roof System is designed as a floating system. Curb framing and flashing must be designed accordingly to allow the curb system to float with the CFR roof during thermal expansion and contraction.

7.13.3. Roof curbs should be laid out maintaining a "3-purlin-space" rule. This rule is that a roof curb should always be located a distance of at least the equivalent of three purlin spaces from the ridge or eave of a building and from any adjacent roof openings or curbs.

8. Roof Covering Nucor VR16 II™ Standing Seam Roof System

8.1. General

8.1.1. Specifically included are panels, panel clips, flashing, panel splices, ridge material, and all necessary fasteners.

8.1.2. Minimum roof slope is 1/4" in 12".

8.1.3. Panels are rated for UL90® uplift rating UL580 when installed to roof support members spaced as listed in UL Construction Listing #332, supported at a maximum of 5'0 on center by either joists or purlins.

8.2. Panel Material

8.2.1. Nucor VR16 II™ profile shall be precision roll-formed from 24 gage Galvalume® AZ50 or AZ55 aluminum-zinc alloy-coated steel sheet with a minimum yield strength of 50 ksi in accordance with ASTM A-792, Grade 50, Class 2. It has a coating thickness of .50 oz. to .55 oz per square foot.



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- 8.2.2. Roof panels provided by Nucor Building Systems for exterior use are precision roll-formed from pre-painted Galvalume® aluminum-zinc alloy-coated steel coils. Coils to receive finish paints are subjected to a strenuous cleaning process prior to coating. Next, the coils are prime coated and oven cured. The finish coat is then applied and monitored for proper oven-cure temperature and color uniformity. Finished material is subjected to stringent quality control tests including: physical bend and impact resistance, film thickness, hardness, gloss, and color. This process is time tested and uses the industry proven modified Siliconized Polyester paint system. A 70% PVDF finish is available at an additional cost upon request. VR16 II gutter brackets are provided as the same color as the roof. VR16 II ridge closure zees are provided unpainted but, a roof colored cover flash is provided.
- 8.2.3. Panels are not factory punched or notched.
- 8.2.4. The upper panels on buildings with endlaps will be factory swaged.
- 8.2.5. Panel sidelaps shall have factory-applied non-skinning Butyl mastic.

8.3. Panel Configuration

- 8.3.1. Panels shall have 2" deep vertical ribs spaced 16" on center. Striated or Pencil Rib pans are available. Buildings with Pencil Rib panels cannot be supplied on buildings *with* endlaps. The upper panels on buildings with endlaps need to be swaged. Swaging on Pencil Ribbed panels are not available.

8.4. Panel Clip & Fasteners

- 8.4.1. Floating panel clips shall be used and shall be self-centering and allow for up to 1" expansion and/or contraction of total movement from the centered position. The clip design shall insure that movement does not occur between the panel and clip.
- 8.4.2. The panel clips shall have factory-punched holes in the top of the clip to allow the sidelap sealant to flow when installed. This is to insure a continuous weather-tight seal along the panel seam.
- 8.4.3. Each clip shall be attached to the joist or purlin with two fasteners. Size and type will be recommended by Nucor Building Systems for the specific application. Clip fasteners for retrofit applications are not by Nucor and must be specified by the owner or his agent.
- 8.4.4. Panel endlap fasteners shall be a ¼-14 self-drilling carbon steel screw, hex washer head, 1-1/4" long. Fastener shall have a 20-year corrosion resistant coating.

8.5. Trim and Flashing

- 8.5.1. Color-coated trim and flashing shall be 26 gage. Trim shall be provided at eave, ridge, rake, and where necessary to ensure a properly constructed building.



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- 8.5.2. High eave flashing and flashing parallel to the roof panels shall accommodate the thermal expansion and contraction of the roof without damage to the roof panels or flashing. Counter-flashing for parapet conditions and flash to existing buildings are not provided by Nucor Building Systems.
- 8.5.3. All exposed trim and flashing material shall be manufactured from galvanized or Galvalume® steel strip.
- 8.5.4. Exterior gutters and gable flash shall typically be manufactured in 20' lengths wherever possible.

8.6. Installation

- 8.6.1. Storage and installation of the roofing system shall be in accordance with Nucor's printed instructions.
- 8.6.2. The Nucor VR16 II™ roof hand crimper is specially designed for use with Nucor VR16 II™ roof. Under no circumstances shall the Nucor crimper be used on any other manufacturer's roof system. In addition, under no circumstances is another manufacturer's crimper to be used on the Nucor VR16 II™ roof (even if they appear to be the same). Permanent damage to the seam and/or the panel finish may occur if the Nucor crimping tool is not used and shall void all warranties.
- 8.6.3. The panel splice shall have a 0.060" prime painted steel back-up plate.
- 8.6.4. Panel splice shall be sealed with precut tape mastic and butyl tube caulk.
- 8.6.5. Standard maximum panel length shall be 50'-0".
- 8.6.6. The use of cutting tools that damage the panel finish shall not be allowed.
- 8.6.7. Panels shall not be marked with any graphite or lead markers.

8.7. Clean-Up

- 8.7.1. Roof surface should be cleaned daily during construction of all filings, cuttings, screws, pencil markings, and debris to prevent damage due to oxidation of foreign materials.
- 8.7.2. Contractor shall thoroughly clean all panels, trim, and gutters of all foreign material upon completion of construction.

8.8. Maintenance

- 8.8.1. The owner shall keep the roof free and clean of debris and corrosive materials at all times.
- 8.8.2. Gutters and downspouts shall be cleaned periodically and kept free-flowing at all times.
- 8.8.3. Flashing and sheeting interfaces shall be inspected yearly to ensure connection and water-tightness.



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- 8.8.4. Endlaps, eaves, ridges, curbs, translucent panels, and other interfaces shall be inspected and maintained yearly. Normal adjustments or tightening of fasteners may be required.
- 8.8.5. The use of tar and other topical applied products shall not be permitted unless specified by the manufacturer.
- 8.8.6. Copper, lead flashing, exposed iron, or debris shall not be permitted on the roof.
- 8.8.7. Pipes to and supports for roof-supported units shall be of a non-corrosive or rust-free material. Field painting of pipes and supports may be required to resist corrosion. Condensation from roof-top units shall be piped to interior or exterior locations. Damage due to condensate water is not covered under manufacturer's warranty.

8.9. Erection Sequence

- 8.9.1. Buildings with the Nucor VR16 II™ Roof System *without* an endlap are designed to be erected starting from either end of the building. Buildings that have an endlap will have swaged panels and will need to be erected right to left. In those cases, it will be noted as such on the erection drawings.
- 8.9.2. Sequencing of steel shall be clearly marked on the order documents at the time of order entry.

8.10. Coordination with Other Trades

- 8.10.1. Supports for the Nucor VR16 II™ Roof System shall be provided and are required as shown in the drawings and as noted in these specifications. All necessary clearance dimensions for proper elevations relative to the roof panels have been shown. The customer shall be responsible for coordinating these dimensional requirements with other trades associated with the building roof system.

8.11. Erection Care

- 8.11.1. The erector must be skilled in the erection of metal building systems and is responsible for complying with all applicable local, federal, and state construction and safety regulations. This includes OSHA regulations as well as any applicable requirements of local, national, or international union rules or practices. The Erector remains solely responsible for the safety and appropriateness of all techniques and methods utilized by its crews in the erection of the metal building system and/or the VR16 II roof system. The Erector is also responsible for supplying any safety devices such as scaffolds, runways, nets, etc., which may be required by the governing codes to safely erect the metal building system and/or VR16 II roof system.
- 8.11.2. Anchorage for safety devices may be added at an additional cost provided specific connections are designed and clearly noted on the order documents. All



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anchorage points must be noted with exact location, magnitude, and direction of force for a fully-braced structure.

- 8.11.3. The erector of the Nucor VR16 II™ erection drawings shall exercise great care and attention to the details as shown on the erection drawings and in the Nucor VR16 II™ erection manual to insure a secure and proper fit of all components. Nucor Building Systems shall not be responsible for supervising and/or coordinating the erection of the VR16 II Roof System with other trades. Erection drawings take precedence when a situation differs from that shown in the erection manual.
- 8.11.4. Due consideration must be given by the erector to the effects of thermal expansion and contraction when erecting a roof tie-in to an existing structure to insure a safe, secure, weather-tight condition. Flashing for tie-ins to existing buildings is typically not included as part of the material provided by Nucor Building Systems. Refer to the sections and details for specific materials provided by Nucor Building Systems.
- 8.11.5. The erector acknowledges that all details for all conditions can be noted on the plans and that due care and judgment are required to make a safe and watertight condition. Sealants and caulks may be required based upon actual conditions encountered.

8.12. Field-Cutting of Panels

- 8.12.1. When field-cutting or mitering Nucor VR16 II™ roof panels, non-abrasive cutting tools such as nibblers or tin-snips shall be used. Abrasive cutting tools such as mechanical grinders, saws, shears, or scissors can damage the Galvalume® or painted finish and create excess metal shavings that can corrode the panels. The use of non-approved cutting devices may void your manufacturer's warranty.

8.13. Roof-Top Units and Curb Supports

- 8.13.1. The Nucor VR16 II™ Roof Curb Framing System is level with roof secondary structural members. The outer roof curb in a double curb system, will have channels attached to accommodate the clip off set of ½" for short clips and 1 ½" for tall clips. Refer to the details for proper dimensions.
- 8.13.2. The Nucor VR16 II™ Roof System is designed as a floating system. Curb framing and flashing must be designed accordingly to allow the curb system to float with the VR16 II roof during thermal expansion and contraction.
- 8.13.3. Roof curbs should be laid out maintaining a "3-purlin-space" rule. This rule is that a roof curb should always be located a distance of at least the equivalent of three purlin spaces from the ridge or eave of a building and from any adjacent roof openings or curbs.



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9. Roof Covering “HR3” Hi Rib Insulated Roof System (Exposed Fastener)

9.1. General

- 9.1.1. Specifically included are panels, panel clips, flashing, panel splices, ridge material, and all necessary fasteners.
- 9.1.2. Minimum roof slope is ½:12, 1:12 is recommended.
- 9.1.3. Available in 3 ½”, 4”, 5”, & 6” thicknesses
- 9.1.4. Through fasteners

9.2. Panel Material

- 9.2.1. “HR3” profile shall be two layers of precision roll-formed from 26 gage material that sandwich a layer of polyisocyanurate foam board insulation.
- 9.2.2. Roof panels provided by AWIP for exterior use are precision roll-formed from pre-painted Galvalume® aluminum-zinc alloy-coated steel coils. Coils to receive finish paints are subjected to a strenuous cleaning process prior to coating. Next, the coils are prime coated and oven cured. The finish coat is then applied and monitored for proper oven-cure temperature and color uniformity.
- 9.2.3. Panels are not factory punched or notched. The low eave panel has a factory saw cut on the bottom metal panel. The piece is left in place for transport. This area will need to be removed during erection.
- 9.2.4. The upper panels on buildings with endlaps will be have the factory saw cut on the bottom metal skin as well.

9.3. Panel Configuration

- 9.3.1. “HR3” panel provides a 40” net coverage and consists of major ribs 1-3/8” deep spaced at 20” on center with an extended leg at the bottom that extends into the next panel for added weather-tightness. Three minor ribs are evenly spaced in the flat area between major ribs.

9.4. Panel Exposed Fasteners

- 9.4.1. Roof panel to secondary structural fastener shall be a No. 14 self-drilling screw, hex washer head with saddle washer sitting on top of the panel rib. Fastener shall have a painted head to match panel and/or trim color when used with painted material.
- 9.4.2. Panel to panel, flash to flash, (stitch) fastener for roof shall be a No. 12 sharp-point carbon steel screw, hex washer head with sealing washer, 3/4” long. Fastener shall have a 20-year corrosion resistant coating. Fastener shall have a painted head to match panel and/or trim color when used with painted materials.



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9.4.3. Panel endlap fasteners shall be a No. 12 self-drilling carbon steel screw, hex washer head with sealing washer, 7/8" long. Fastener shall have a 20-year corrosion resistant coating.

9.5. Trim and Flashing

9.5.1. Color-coated trim and flashing shall be 26 gage. Trim shall be provided at eave, ridge, rake, and where necessary to ensure a properly constructed building.

9.5.2. High eave flashing and flashing parallel to the roof panels shall accommodate the thermal expansion and contraction of the roof without damage to the roof panels or flashing. Counter-flashing for parapet conditions and flash to existing buildings are not provided by Nucor Building Systems.

9.5.3. All exposed trim and flashing material shall be manufactured from galvanized or Galvalume® steel strip.

9.5.4. Exterior gutters and gable flash shall typically be manufactured in 20' lengths wherever possible.

9.6. Installation

9.6.1. Storage and installation of the roofing system shall be in accordance with Nucor's printed instructions.

9.6.2. Panels will be installed from left to right.

9.6.3. Removal of foam will be required at the downslope side of the panel at low eaves and endlaps.

9.6.4. The panel splice shall have a 0.060" prime painted steel back-up angle attached to the purlin at 12" on center.

9.6.5. Panel splice shall be sealed with precut tape mastic and butyl tube caulk.

9.6.6. Standard maximum panel length shall be 56'-0".

9.6.7. The use of cutting tools that damage the panel finish shall not be allowed.

9.6.8. Panels shall not be marked with any graphite or lead markers.

9.7. Clean-Up and Maintenance

9.7.1. Roof surface should be cleaned daily during construction of all filings, cuttings, screws, pencil markings, and debris to prevent damage due to oxidation of foreign materials.

9.7.2. Contractor shall thoroughly clean all panels, trim, and gutters of all foreign material upon completion of construction.

9.7.3. Proper installation and maintenance are extremely important to obtain the best performance and appearance from the insulated panel. Dirt, oil grease,



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fingerprints or any other kind of containment must be completely removed when the installation is finish to maximize coatings performance.

- 9.7.4. The building will require periodic maintenance according to conditions at the site: U. V., dirt, smoke, corrosive atmosphere, etc. If further assistance is required, please consult the technical department of AWIP.
- 9.7.5. To remove oxidation and tough stains, it is recommended to use a household cleaner recommended for use of porcelain sinks and bath tubs. This should be followed with a thorough rinsing. Wire brushing or any abrasive material may damage the painted surface and should not be used.
- 9.7.6. If "touch up" paint is required, contact AWIP to obtain and air-dry urethane color match for your project.
- 9.7.7. Dirt pickup may cause apparent discoloration of the paint when it has been exposed to dirt-laden atmospheres for long periods of time. Slight chalking may cause some change in appearance in areas of strong sunlight. A good cleaning will often restore the appearance of these buildings. In many cases simply washing the building with plain water using pressure sprays will be adequate. In areas of heavy dirt deposits, a solution of water and detergent may be used. Use a rag or sponge, to clean. A clear water rinse should follow.

9.8. Erection Sequence

- 9.8.1. Buildings with the "HR3" Roof System are designed to be erected from left to right since these panels are not symmetrical.

9.9. Coordination with Other Trades

- 9.9.1. Supports for the "HR3" Roof System shall be provided and are required as shown in the drawings and as noted in these specifications. All necessary clearance dimensions for proper elevations relative to the roof panels have been shown. The customer shall be responsible for coordinating these dimensional requirements with other trades associated with the building roof system.

9.10. Field-Cutting of Panels

- 9.10.1. When field-cutting or mitering "HR3" roof panels, non-abrasive cutting tools such as nibblers or tin-snips shall be used. Abrasive cutting tools such as mechanical grinders, saws, shears, or scissors can damage the Galvalume® or painted finish and create excess metal shavings that can corrode the panels. The use of non-approved cutting devices may void your manufacturer's warranty.



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9.11. Erection Care

- 9.11.1. The erector must be skilled in the erection of metal building systems and is responsible for complying with all applicable local, federal, and state construction and safety regulations. This includes OSHA regulations as well as any applicable requirements of local, national, or international union rules or practices. The Erector remains solely responsible for the safety and appropriateness of all techniques and methods utilized by its crews in the erection of the metal building system and/or the HR3 roof system. The Erector is also responsible for supplying any safety devices such as scaffolds, runways, nets, etc., which may be required by the governing codes to safely erect the metal building system and/or HR3 roof system.
- 9.11.2. Anchorage for safety devices may be added at an additional cost provided specific connections are designed and clearly noted on the order documents. All anchorage points must be noted with exact location, magnitude, and direction of force for a fully-braced structure.
- 9.11.3. The erector of the "HR3" erection drawings shall exercise great care and attention to the details as shown on the erection drawings and in the "HR3" erection manual to insure a secure and proper fit of all components. Nucor Building Systems shall not be responsible for supervising and/or coordinating the erection of the HR3 Roof System with other trades. Erection drawings take precedence when a situation differs from that shown in the erection manual.
- 9.11.4. Due consideration must be given by the erector to the effects of thermal expansion and contraction when erecting a roof tie-in to an existing structure to insure a safe, secure, weather-tight condition. Flashing for tie-ins to existing buildings is typically not included as part of the material provided by Nucor Building Systems. Refer to the sections and details for specific materials provided by Nucor Building Systems.
- 9.11.5. The erector acknowledges that all details for all conditions can be noted on the plans and that due care and judgment are required to make a safe and watertight condition. Sealants and caulks may be required based upon actual conditions encountered.

10. Roof Covering "SR2" Insulated Standing Seam Roof System

10.1. General

- 10.1.1. Specifically included are panels, panel clips, flashing, panel splices, ridge material, and all necessary fasteners.
- 10.1.2. Minimum roof slope is 1/2" in 12".
- 10.1.3. Panel endlaps will always be staggered.
- 10.1.4. Panels have an FM 1-90 uplift rating when installed to roof support members spaced at a maximum of 5'-0" on center purlins



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10.2. Panel Material

- 10.2.1. "SR2" profile shall be two layers of precision roll-formed from 26 gage material that sandwich a layer of polyisocyanurate foam board insulation.
- 10.2.2. Roof panels provided by AWIP for exterior use are precision roll-formed from pre-painted Galvalume® aluminum-zinc alloy-coated steel coils. Coils to receive finish paints are subjected to a strenuous cleaning process prior to coating. Next, the coils are prime coated and oven cured. The finish coat is then applied and monitored for proper oven-cure temperature and color uniformity.
- 10.2.3. Panel are not factory punched or notched. The low eave panel has a factory saw cut on the bottom metal panel. The piece is left in place for transport. This area will need to be removed during erection.

10.3. Panel Configuration

- 10.3.1. Panels shall have 2" deep trapezoidal ribs spaced 40" on center. Seven minor ribs are spaced in the flat of the panel between the major ribs.

10.4. Panel Clip & Fasteners

- 10.4.1. Fixed panel clips only.
- 10.4.2. The panel clips shall have field-applied mastic to insure a weather-tight installation.
- 10.4.3. Each clip shall be attached to the joist or purlin with two/three No. 14 fasteners. .
- 10.4.4. Panel endlap fasteners shall be a No. 12 self-drilling carbon steel screw, hex washer head, 7/8" long. Fastener shall have a 20-year corrosion resistant coating.

10.5. Trim and Flashing

- 10.5.1. Color-coated trim and flashing shall be 26 gage. Trim shall be provided at eave, ridge, rake, and where necessary to ensure a properly constructed building.
- 10.5.2. High eave flashing and flashing parallel to the roof panels shall accommodate the thermal expansion and contraction of the roof without damage to the roof panels or flashing. Counter-flashing for parapet conditions and flash to existing buildings are not provided by Nucor Building Systems.
- 10.5.3. All exposed trim and flashing material shall be manufactured from galvanized or Galvalume® steel strip.
- 10.5.4. Exterior gutters and gable flash shall typically be manufactured in 20' lengths wherever possible.



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10.6. Installation

- 10.6.1. Storage and installation of the roofing system shall be in accordance with Nucor's printed instructions.
- 10.6.2. Removal of foam will be required at the downslope side of the panel at low eaves and endlaps.
- 10.6.3. Panels will be installed from left to right since they are not symmetrical.
- 10.6.4. The staggered panel splices shall have a 0.060" prime painted steel back-up angle attached to the purlin at 12" on center.
- 10.6.5. Panel splice shall be sealed with precut tape mastic and butyl tube caulk.
- 10.6.6. Standard maximum panel length shall be 56'-0".
- 10.6.7. The use of cutting tools that damage the panel finish shall not be allowed.
- 10.6.8. Panels shall not be marked with any graphite or lead markers.

10.7. Clean-Up & Maintenance

- 10.7.1. Roof surface should be cleaned daily during construction of all filings, cuttings, screws, pencil markings, and debris to prevent damage due to oxidation of foreign materials.
- 10.7.2. Contractor shall thoroughly clean all panels, trim, and gutters of all foreign material upon completion of construction.
- 10.7.3. Proper installation and maintenance are extremely important to obtain the best performance and appearance from the insulated panel. Dirt, oil grease, fingerprints or any other kind of contamination must be completely removed when the installation is finish to maximize coatings performance.
- 10.7.4. The building will require periodic maintenance according to conditions at the site: U. V., dirt, smoke, corrosive atmosphere, etc. If further assistance is required, please consult the technical department of AWIP.
- 10.7.5. To remove oxidation and tough stains, it is recommended to use a household cleaner recommended for use of porcelain sinks and bath tubs. This should be followed with a thorough rinsing. Wire brushing or any abrasive material may damage the painted surface and should not be used.
- 10.7.6. If "touch up" paint is required, contact AWIP to obtain and air-dry urethane color match for your project.
- 10.7.7. Dirt pickup may cause apparent discoloration of the paint when it has been exposed to dirt-laden atmospheres for long periods of time. Slight chalking may cause some change in appearance in areas of strong sunlight. A good cleaning will often restore the appearance of these buildings. In many cases simply washing the building with plain water using pressure sprays will be adequate. In



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areas of heavy dirt deposits, a solution of water and detergent may be used. Use a rag or sponge, to clean. A clear water rinse should follow.

- 10.7.8. Endlaps, eaves, ridges, curbs, and other interfaces shall be inspected and maintained yearly. Normal adjustments or tightening of fasteners may be required.
- 10.7.9. The use of tar and other topical applied products shall not be permitted unless specified by the manufacturer.
- 10.7.10. Copper, lead flashing, exposed iron, or debris shall not be permitted on the roof.
- 10.7.11. Pipes to and supports for roof-supported units shall be of a non-corrosive or rust-free material. Field painting of pipes and supports may be required to resist corrosion. Condensation from roof-top units shall be piped to interior or exterior locations. Damage due to condensate water is not covered under manufacturer's warranty.

10.8. Erection Sequence

- 10.8.1. Buildings with the "SR2" Roof System are designed to be erected from left to right since these panels are not symmetrical.

10.9. Coordination with Other Trades

- 10.9.1. Supports for the SR2 Roof System shall be provided and are required as shown in the drawings and as noted in these specifications. All necessary clearance dimensions for proper elevations relative to the roof panels have been shown. The customer shall be responsible for coordinating these dimensional requirements with other trades associated with the building roof system.

10.10. Erection Care

- 10.10.1. The erector must be skilled in the erection of metal building systems and is responsible for complying with all applicable local, federal, and state construction and safety regulations. This includes OSHA regulations as well as any applicable requirements of local, national, or international union rules or practices. The Erector remains solely responsible for the safety and appropriateness of all techniques and methods utilized by its crews in the erection of the metal building system and/or the SR2 roof system. The Erector is also responsible for supplying any safety devices such as scaffolds, runways, nets, etc., which may be required by the governing codes to safely erect the metal building system and/or SR2 roof system.
- 10.10.2. Anchorage for safety devices may be added at an additional cost provided specific connections are designed and clearly noted on the order documents. All anchorage points must be noted with exact location, magnitude, and direction of force for a fully-braced structure.
- 10.10.3. The erector of the Nucor CFR™ erection drawings shall exercise great care and attention to the details as shown on the erection drawings and in the Nucor



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CFR™ erection manual to insure a secure and proper fit of all components. Nucor Building Systems shall not be responsible for supervising and/or coordinating the erection of the CFR Roof System with other trades. Erection drawings take precedence when a situation differs from that shown in the erection manual.

10.10.4. Due consideration must be given by the erector to the effects of thermal expansion and contraction when erecting a roof tie-in to an existing structure to insure a safe, secure, weather-tight condition. Flashing for tie-ins to existing buildings is typically not included as part of the material provided by Nucor Building Systems. Refer to the sections and details for specific materials provided by Nucor Building Systems.

10.10.5. The erector acknowledges that all details for all conditions can be noted on the plans and that due care and judgment are required to make a safe and watertight condition. Sealants and caulks may be required based upon actual conditions encountered

10.11. Field-Cutting of Panels

10.11.1. When field-cutting or mitering SR2 roof panels, non-abrasive cutting tools such as nibblers or tin-snips shall be used. Abrasive cutting tools such as mechanical grinders, saws, shears, or scissors can damage the Galvalume® or painted finish and create excess metal shavings that can corrode the panels. The use of non-approved cutting devices may void your manufacturer's warranty.

11. Wall Covering

11.1. General

11.1.1. Wall covering shall be Nucor Classic Wall™, Nucor Reverse Classic Wall™, or Nucor Accent Wall™ panel profile, precision roll-formed from 26 gage steel.

11.1.2. ASTM E283 is an air infiltration test standard - **See Ratings Manual for specifics.**

11.1.3. ASTM E331 is a water penetration test standard - **See Ratings Manual for specifics.**

11.1.4. All NBS wall panel configurations have been tested per the ASTM E283 & E331 standards: **See Ratings Manual for specifics.**

11.2. Panel Material

11.2.1. Galvanized steel sheeting shall be processed in accordance with ASTM A-653. Consult your specific plant for minimum yield strength and grade of material. The galvanized coating shall be .90 oz per square foot (Class G90) in accordance with ASTM A-653. The spangle for galvanized panel is bright flat spangle in accordance with ASTM A-653.



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- 11.2.2. Galvalume® steel sheeting shall be aluminum-zinc alloy coated steel sheet in accordance with ASTM A-792. Consult your specific plant for minimum yield strength and grade of material. It has a coating thickness of .55 oz per square foot.
- 11.2.3. Wall panels provided by Nucor Building Systems for exterior use are precision roll-formed from pre-painted G90 galvanized or Galvalume® coils. Coils to receive finish paints are subjected to a strenuous cleaning process prior to coating. Next, the coils are prime coated and oven cured. The finish coat is then applied and monitored for proper oven-cure temperature and color uniformity. Finished material is subjected to stringent quality control tests including: physical bend and impact resistance, film thickness, hardness, gloss, and color. This process is time tested and uses the industry proven Modified Siliconized Polyester paint system. A 70% PVDF finish is available at an additional cost upon request.

11.3. Panel Configuration

- 11.3.1. Nucor Classic Wall™ panel provides a 36" net coverage and consists of major ribs 1-1/4" deep spaced at 12" on center with an extended purlin bearing sidelap to allow for additional sidelap support. Two minor ribs are evenly spaced in the flat area between the major ribs. The classic panel is designed for blanket insulation up to 4" thick. (6" is possible with special care)
- 11.3.2. Nucor Reverse Classic Wall™ panel provides a 36" net coverage and consists of major ribs 1-1/4" deep spaced at 12" on center with an extended purlin bearing sidelap to allow for additional sidelap support. Two minor ribs are evenly spaced in the flat area between the major ribs. The Nucor Reverse Classic Wall™ panel is designed for blanket insulation up to 6" thick.
- 11.3.3. Nucor Accent Wall™ panel is an architectural recessed fastener panel. It provides a 36" net coverage and consists of 1-1/4" deep major ribs spaced at 12" on center with an extended purlin bearing sidelap to allow for additional sidelap support. A sculptured valley is between the major ribs. The Nucor Accent Wall™ panel is designed for blanket insulation up to 6" thick.

11.4. Trim And Flashing

- 11.4.1. Color-coated trim and flashing shall be supplied in 26 gage. Trim shall be provided at eave, base, corners, framed openings, and where necessary to insure a properly constructed building.
- 11.4.2. All exposed trim and flashing material shall be manufactured from Galvalume®, galvanized, or painted steel strip.

11.5. Fasteners

- 11.5.1. Panel to structural fastener for all wall panels shall be a No. 12 self-drilling carbon steel screw, hex head x 1-1/4" long. Fastener shall have a painted head to match panel and/or trim color.



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- 11.5.2. Panel to panel, stitch fastener for all wall panels shall be a No. 12 self-drilling carbon steel screw, hex head, 7/8" long. Fastener shall have a painted head to match panel and/or trim color.
- 11.5.3. Fasteners required for securing trim to masonry or concrete are not supplied by Nucor Building Systems.

11.6. Sealants

- 11.6.1. Tube sealants shall be used at all trim endlaps, and shall be a polyurethane sealant.
- 11.6.2. Sealants not provided by Nucor shall not be used without specific approval from Nucor.

11.7. Closures

- 11.7.1. Closures shall be manufactured of closed-cell polyethylene foam to match the panel configuration.
- 11.7.2. Beveled Closures are available for all NBS panel types, Left & Right, Inside & Outside, at roof slopes from > 1 ½:12 to 9 1/2:12.
- 11.7.3. Straight and/or Beveled Closures shall be supplied as ordered to provide a closed wall panel profile at all panel to wall trim conditions. Standard closure offering; at base, low eave, rake, rake parapet, high eave parapet & framed openings. Customer will have the option to remove closures from base trim.

11.8. Installation of Panels

- 11.8.1. All sidelaps shall be lapped a minimum of one full rib. Panel endlaps shall be a minimum of 4" long on wall panels.
- 11.8.2. All wall panels shall be fabricated in one piece providing the length does not exceed practical limits for shipment or construction.
- 11.8.3. Storage and installation of the wall system shall be in accordance with Nucor's printed instructions.
- 11.8.4. Standard maximum panel length shall be 30'. If required, lengths of up to 45' may be provided.

11.9. Clean-Up

- 11.9.1. All dirt, oil, grease, fingerprints, or other contaminants shall be removed after installation to insure proper service life of the paint surface.

12. Insulated Wall Covering

12.1. General

- 12.1.1. Insulated Wall covering shall be "Double Mesa", "Striated", "Heavy Embossed", "or "AdobeTexture™" panel profile, precision roll-formed from 26 gage steel. Two layers of metal sandwich foam insulation.
- 12.1.2. ASTM E283 is an air infiltration test standard - **See Ratings Manual for specifics.**



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- 12.1.3. ASTM E331 is a water penetration test standard - **See Rating Manual for specifics.**
- 12.1.4. Insulated wall panel configurations have been tested per the ASTM E283 & E331 standard: **See Ratings Manual for specifics.**

12.2. Panel Material

- 12.2.1. Wall profiles shall be two layers of precision roll-formed from 26 gage material that sandwich a layer of polyisocyanurate foam board insulation.
- 12.2.2. Wall panels provided by AWIP for exterior use are precision roll-formed from pre-painted Galvalume® aluminum-zinc alloy-coated steel coils. Coils to receive finish paints are subjected to a strenuous cleaning process prior to coating. Next, the coils are prime coated and oven cured. The finish coat is then applied and monitored for proper oven-cure temperature and color uniformity.
- 12.2.3. Panels are not factory punched or notched.
- 12.2.4. Panel seams will **not** have factory-applied non-skinning Butyl mastic.

12.3. Panel Configuration

- 12.3.1. Insulated wall panels provide a 40" net coverage and consist of male and female interlocking sides.
- 12.3.2. Four exterior profiles are available.
- 12.3.3. The panel fasteners are concealed within the panel lap.

12.4. Trim And Flashing

- 12.4.1. Color-coated trim and flashing shall be supplied in 26 gauge. Trim shall be provided at eave, base, corners, framed openings, and where necessary to insure a properly constructed building.
- 12.4.2. All exposed trim and flashing material shall be manufactured from Galvalume®, galvanized, or painted steel strip.
- 12.4.3. Trims finish will match wall finish as a standard.

12.5. Fasteners

- 12.5.1. Sidelap panel clips and fasteners are concealed within the lap of the panels
- 12.5.2. Pancake screws will be provided where a through fastener is required, such as corners, base, and eave connections.
- 12.5.3. The panel clips shall have field-applied caulking/mastic to insure a weather-tight installation.



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- 12.5.4. Each clip shall be attached to girts with two No. 14 fasteners. .
- 12.5.5. Panel trim could be attached by 1/8" pop rivets or No. 12 self-drilling carbon steel screw, hex washer head, 7/8" long. Fastener shall have a 20-year corrosion resistant coating.

12.6. Sealants

- 12.6.1. Tube sealants shall be used at all trim endlaps, panel joints, at the perimeter of the wall, and shall be a polyurethane sealant.
- 12.6.2. Sealants are to be provided by NBS when possible.

12.7. Installation of Panels

- 12.7.1. All sidelaps shall be field caulked and engaged fully into the previous panel.
- 12.7.2. All panels shall be secured to the secondary structure with a clip and two fasteners at each support location.
- 12.7.3. All wall panels shall be fabricated in one piece providing the length does not exceed practical limits for shipment or construction.
- 12.7.4. Storage and installation of the wall system shall be in accordance with Nucor's printed instructions.
- 12.7.5. Standard maximum panel length shall be 56'. If required, lengths of up to 62' may be provided (With special permitting, Pre-approval required).

12.8. Clean-Up & Maintenance

- 12.8.1. Surface should be cleaned daily during construction of all filings, cuttings, screws, pencil markings, and debris to prevent damage due to oxidation of foreign materials.
- 12.8.2. Contractor shall thoroughly clean all panels, trim, and gutters of all foreign material upon completion of construction.
- 12.8.3. Proper installation and maintenance are extremely important to obtain the best performance and appearance from the insulated panel. Dirt, oil grease, fingerprints or any other kind of contamination must be completely removed when the installation is finish to maximize coatings performance.
- 12.8.4. The building will require periodic maintenance according to conditions at the site: U. V., dirt, smoke, corrosive atmosphere, etc. If further assistance is required, please consult the technical department of AWIP.
- 12.8.5. To remove oxidation and tough stains, it is recommended to use a household cleaner recommended for use of porcelain sinks and bath tubs. This should be
- 12.8.6. followed with a thorough rinsing. Wire brushing or any abrasive material may damage the painted surface and should not be used.
- 12.8.7. If "touch up" paint is required, contact AWIP to obtain and air-dry urethane color match for your project.



13. Accessories

13.1. Metal Doors & Windows

13.1.1. Standard doors provided by Nucor Building Systems are factory-assembled and include an insulated door leaf consisting of either 20 or 18 gage galvanized steel with a baked enamel finish. All doors are ADA compliant. Door systems can be obtained with the jambs and door frame unassembled from the factory, if so requested on the Nucor order documents.

13.1.2. Windows are available upon request.

13.2. Framed Openings

13.2.1. Framing members for overhead doors shall typically be the same depth as the girts to which they attach. Wall panel edge shall be trimmed and flashed at all openings.

13.2.2. Framing for overhead doors shall be primer-coated or galvanized, as required by the customer.

13.3. Prismatic Skylights

13.3.1. Prismatic Skylights have a minimum of 4,000 tiny prisms per square foot of glazing layer. The prisms refract sunlight into micro light beams, spreading the sun's bright natural light throughout the space, no direct sunlight-therefore no damaging hot spots, no glares and no UV rays to damage interiors/merchandise.

13.3.2. Prismatic Skylights transmit 35% more light, while still providing 100% diffusion, compared to any standard industrial skylight. Catches up to 20% more light even at low sun angles.

13.3.3. Prismatic Skylights are available with double glazing's of ACRYLIT® over ACRYLIT® or Polycarbonate over Polycarbonate.

Prismatic Skylight Sustainable Temperature limits:

Material Type	Max. Temperature (Fahrenheit)
Acrylic	210°
Polycarbonate	270°



13.4. Translucent Light Panels

- 13.4.1. Translucent light panels shall be glass fiber reinforced composite panel of ACRYLIT®, containing 100% Acrylic resin monomers.
- 13.4.2. Panels shall be produced to match the roof/wall panel configuration.
- 13.4.3. Panels shall weigh eight ounces per square foot.
- 13.4.4. Nominal length of panels shall be 5'-0", 10'-0", or 11'-0".
- 13.4.5. Panels shall have "Light Transmission" of 55-60% per ASTM D-1494.
- 13.4.6. Panels shall have a "Burning Rate" of less than 2 1/2" per minute per ASTM D-635.
- 13.4.7. Metal panels above and below the translucent section along the same run shall not be shorter than the length of three purlin spaces. Roof translucent panels shall not be located at the eave or ridge. Translucent panels shall have a minimum of four metal panels between each translucent one.
- 13.4.8. The buyer shall advise all parties and the owner that translucent panels are not designed for foot traffic.
- 13.4.9. Classic Roof Translucent panels have a UL® and Florida approval rating at 5'-0" maximum purlin space.

13.5. Rake/Eave Extensions/Canopies

- 13.5.1. Roof rake/eave extensions shall consist of cantilevered extension beams or roof purlins, 2'-0" or 4'-0" beyond steel line, complete with all trim, closures, and all necessary flashing to provide a weather-tight overhang. Soffit panel is required for rake/eave extensions.
- 13.5.2. Canopies shall consist of roof panels supported by cantilevered beams and purlins, 5'-0" or 10'-0" long, complete with trim, closures, and all necessary flashing to provide a weather-tight overhang. Soffit panel may be requested on the order documents.

13.6. Insulation

- 13.6.1. Recommended insulation thickness (insulation supplied by others) is as follows:
 - 13.6.1.1. Wall or roof blanket insulation over 3" may cause dimpling at support locations.
 - 13.6.1.2. The maximum thickness available for use with the Nucor Classic Roof™ is 6" of blanket insulation. (Please note: the maximum thickness allowed under UL® 30, 60, and 90 shall be 6".)
 - 13.6.1.3. Nucor CFR™ standing seam roof with 3 1/2" short panel clip may be installed over blanket insulation from 2" to 4" thick.



- 13.6.1.4. Nucor CFR™ with 4 1/2" tall panel clip may be installed over blanket insulation from 4" to 6" thick provided a thermal block is placed between clip. Maximum of 8" single layer batt insulation is allowed, which requires special attention to maintain panel modularity and thermal performance
 - 13.6.1.5. Nucor CFR™ with 5 1/2" tall panel clip may be installed over blanket insulation from greater than 8" to 12" thick provided a thermal block is between the clip. Maximum of 12" combined layers of batt insulation is allowed, which requires special attention to maintain panel modularity and thermal performance.
 - 13.6.1.6. It is recommended that insulation be used in all cases to avoid problems with condensation forming on the underside of the sheeting. This also provides a buffer between the purlins and Nucor CFR™ to reduce noise and possible damage due to metal-to-metal contact.
- 13.6.2. An Insulation Pan (Nucor Classic Wall™ liner panel, 28 gage) may be supplied at the ridge for Nucor CFR™ systems, but it must be requested in the order documents.

13.7. Liner Panel

- 13.7.1. Liner panel for a wall or ceiling is produced from a 28 gage material with a white Polyester paint coating. Liner panel is not intended to be exposed to the effects of weather, sunlight, moisture, or corrosive environments.

13.8. Nucor Composite CFR Roof

- 13.8.1. Nucor Composite CFR Roof shall be made up of the previously-defined Nucor CFR™ roof panel specifications, along with either rigid board or fiberglass insulation (not by Nucor), a vapor barrier (not by Nucor), and deck from Vulcraft. Optional z-bars may be used on top of the deck to aid in panel installation as the panel clip fasteners would attach to the z-bar. The deck is manufactured in accordance with Steel Deck Institute specifications. Nucor does not offer any warranties for liner deck.

UL® is a registered trademark of Underwriters Laboratories, Inc.
Galvalume® is a registered trademark of BIEC International.



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14. Standard Serviceability Criteria

The most commonly addressed serviceability criteria in metal building systems are deflections and thermal expansion/contraction. Nucor Building Systems deflection standards are based upon the applicable Building Code and the MBMA serviceability guidelines in the latest MBMA Metal Building Systems Manual. All projects meet or exceed the following criteria unless otherwise specified on the quote or order documents.

<u>Structural Element(s)</u>	<u>Deflection Limit</u>	<u>Loading</u>
Rigid Frames Members:		
Rigid Frame Rafter	Rafter Span / 180 Vertical	Collateral + Roof Live/Snow
	Rafter Span / 120 Vertical	Dead + Collateral + Roof Live/Snow
Rigid Frame Lateral Drift w/ Insulated and Uninsulated Metal Wall Panels	Eave Height / 60 Horizontal	Wind
Pinned-Base Masonry, CMU, or Concrete Panel Walls	Wall Height / 100 Horizontal	Wind
Fixed-Base Masonry or CMU Walls	Wall Height / 200 Horizontal	Wind
Pendant or Radio Operated Top-Running Cranes	Eave Height / 100 Horizontal	Wind
	Top of Rail Elevation / 240	Dead + Crane Lateral
Cab Operated Top-Running Cranes	Eave Height / 240 Horizontal	Wind
	Top of Rail Elevation / 240	Dead + Crane Lateral
Post & Beam Frame Members:		
Post & Beam Rafter	Rafter Span / 180 Vertical	Collateral + Roof Live/Snow
	Rafter Span / 120 Vertical	Dead + Collateral + Roof Live/Snow
Post & Beam, and Sidewall or Endwall Wind Columns	Column Height / 120 Horizontal	Wind
Pinned-Base Masonry, CMU, or Concrete Panel Walls	Wall Height / 200 Horizontal	Wind
Fixed-Base Masonry or CMU Walls	Wall Height / 200 Horizontal	Wind
Roof Secondary Members Supporting:		
Purlins (Roof Slopes \geq 1/4:12) and Roof Joists	Bay / 120 Vertical	Collateral + Roof Live/Snow
	Bay / 150 Vertical	Roof Live/Snow (No Ceiling)
	Bay / 240 Vertical	Roof Live/Snow (Suspended Ceiling)
Wall Secondary Members Supporting:		
Metal Walls	Bay / 90 Horizontal	Wind
Masonry, CMU, Concrete Panel Walls, and Members w/ Brittle Finishes	Bay / 240 Horizontal	Wind



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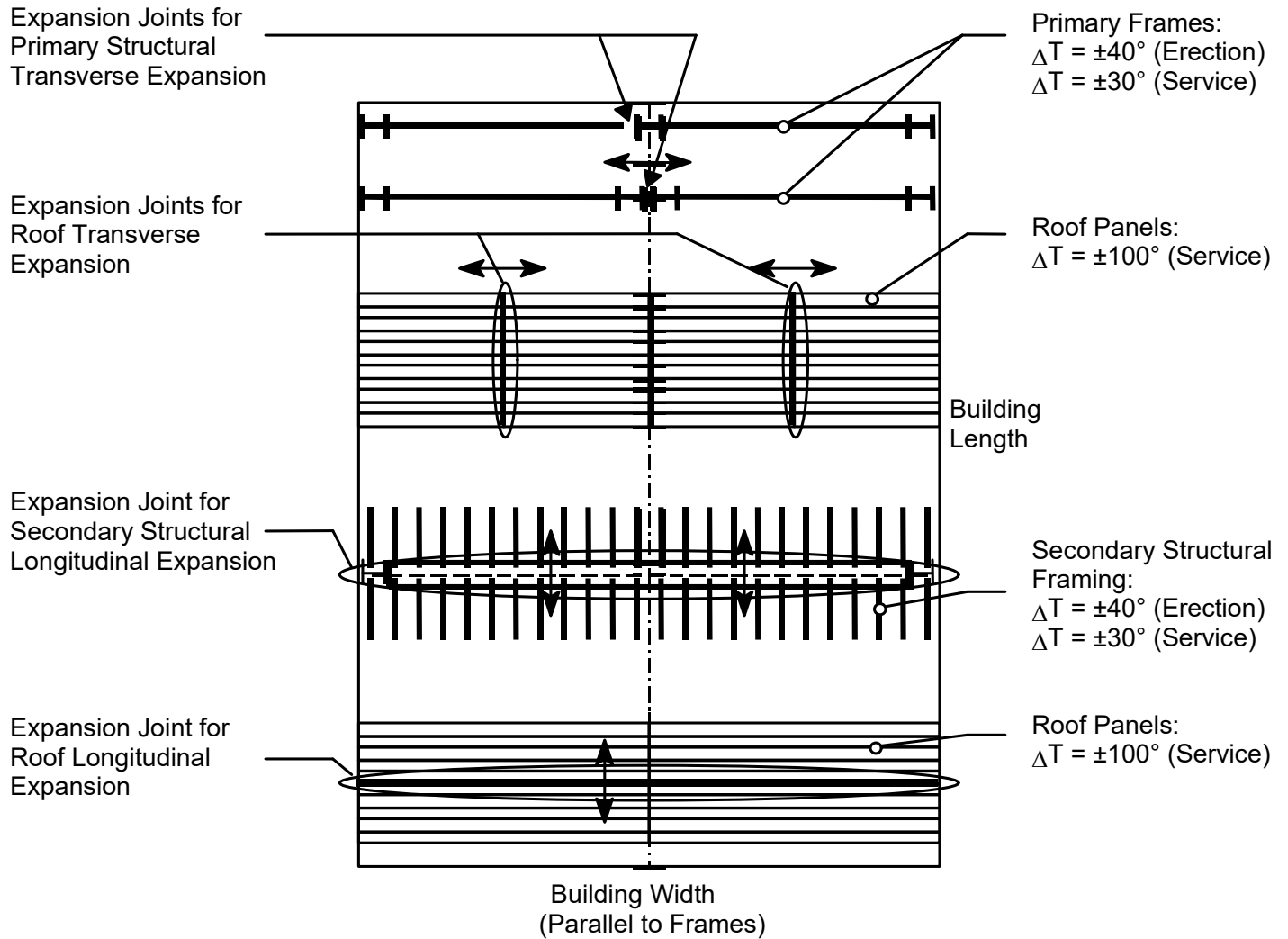
<u>Structural Element(s)</u>	<u>Deflection Limit</u>	<u>Loading</u>
Members with Flexible Finishes	Bay / 240 Horizontal	Wind
Roof Sheeting:		
Uninsulated and Insulated Metal Panel (By Nucor)	Secondary Spacing / 60 Vertical	Collateral + Roof Live/Roof Snow Load or 200# concentrated load at mid-span of 1'-0" wide panel section
Roof Panels By Others and Other Materials	Per Order Documents	Per Order Documents
Wall Sheeting:		
Uninsulated Metal Panel (By Nucor)	Bay/60 Horizontal	Wind
Insulated Metal Panel (By Nucor)	Bay/180 Horizontal	Wind
Wall Panels By Others and Other Materials	Per Order Documents	Per Order Documents
Crane Runway Beams:		
<u>Top Running Crane:</u>		
CMAA Service Classes A through C	Bay Length / 600 Vertical	Crane Vertical Static Load
CMAA Service Class D	Bay Length / 800 Vertical	Crane Vertical Static Load
CMAA Service Classes E and F	Bay Length / 1000 Vertical	Crane Vertical Static Load
CMAA Service Classes A through F	Bay Length / 400 Horizontal	Crane Lateral
<u>Underhung Running Crane:</u>		
CMAA Service Classes A through C	Bay Length / 450 Vertical	Crane Vertical Static Load
	Bay Length / 400 Horizontal	Crane Lateral
Floor Framing:		
Floor Beams and Floor Joists	Beam Length / 360 Vertical	Floor Live Load
	Beam Length / 240 Vertical	Dead + Collateral + Floor Live Load
Vibration:		
<p>Due to the somewhat qualitative nature of vibration effects on a building system, Nucor Building Systems will typically not have any input other than responding to specific order document requests for design criteria. Some areas where the designs are more likely to see impacts from projects specifications include: mezzanine floor designs, buildings with cranes or other similar equipment as part of the end use operation, and large structures supporting HVAC equipment. Nucor will properly address order document specifications but is not in an expert position to give guidance or direction on the matter of vibration</p>		



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15. Standard Expansion Joint Requirement Summary

Standard Expansion Joint Requirement Summary





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Expansion Joint Type (See Diagram Above)	Max. Length w/o Expansion Joint	Net ΔT (\pm °F)	Movement ΔL (\pm in)
Transverse Expansion:			
Primary Structural	Not Provided by NBS Unless Specified on NBS Order Documents.		
Roof Panels:	Required at Primary Structural Expansion Joint.		
Nucor CFR™ Roof Panel	250' Panel Run	$\pm 100^\circ$	1.500" One Direction
Nucor Classic Roof™ Panel	120' Panel Run	$\pm 100^\circ$	0.333" Each Direction
Longitudinal Expansion:			
Cold-Formed Purlins	640' with Metal Walls	$\pm 70^\circ$	1.250" Each Direction
Open-Web Joists	455' with Metal Walls	$\pm 70^\circ$	0.875" Each Direction
Roof Panels:	Required at Primary Structural Expansion Joint.		
Nucor CFR™ Roof Panel	No Additional Limits		
Nucor Classic Roof™ Panel	No Additional Limits		

Notes: Roof panel net ΔT = (Panel ΔT) - (Primary Structural ΔT). When using ΔT other than shown, hold total movement.