



PRODUCT & ENGINEERING MANUAL

NUCOR CFR™ STANDING SEAM ROOF SYSTEM TABLE OF CONTENTS

Nucor CFR™ Standing Seam Roof System Table of Contents	1
Nucor CFR™ Trapezoidal Rib Standing Seam Roof System	2
Nucor CFR™ Property and Span Table	3
Nucor CFR™ Seaming Options.....	4
General.....	4
Nucor Roll Lock™ Seam.....	4
Nucor Vise Lock® Seam.....	5
Nucor Vise Lock 360® Seam.....	5
CF0025PE – Panel Profile	6
CF0010PE – Nucor CFR™ Clip Systems	7
EA6022 – Thermal Block – Tall Clips.....	8
EA6023 – Thermal Block – Tall Clips Without Insulation.....	9
EA6024 – Thermal Block – Short Clips Without Insulation	10
EA6026 – Guidance to Install Single Layer 8” Insulation.....	11
Nucor Composite CFR™ Options:	12
FA6003 – Batt Insulation with Z-Bars.....	12
FA6004 – Rigid Board Insulation with Z-Bars.....	13
FA6005 – Rigid Board Insulation	14



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NUCOR CFR™ TRAPEZOIDAL RIB STANDING SEAM ROOF SYSTEM

The Nucor CFR™ trapezoidal rib standing seam roof system panel is available as a component of one of Nucor Building Systems' Standard Roof Systems.

The Nucor CFR™ Standing Seam Roof System presents the building owner with a high quality, economical alternative to other roofing systems. The system is designed to meet the demanding needs of today's building market

The Nucor CFR™ system is a functional roof specifically designed for low slopes. This roof system has been extensively tested to ensure the highest level of performance for weather tightness and structural integrity. The panels have been tested and approved by Factory Mutual® and Underwriters Laboratories® for wind uplift as well as hail and fire resistance. The flexible options offer a number of cost effective design solutions.

The Nucor CFR™ system is a raised seam metal roof which is designed to "float" to accommodate thermal expansion and contraction. This is accomplished with concealed sliding clips which allow for up to 3" of expansion and contraction. The panel sidelap has factory-applied mastic and can be completely erected without the use of electric seaming machines. Nucor offers a hand-operated crimping tool for the Nucor Roll Lock™ installation option.

Information about the available panel and seaming options, panel properties, performance and testing information, and much more is available at the Nucor Building Systems website at the below link.

[Nucor CFR™ Trapezoidal Rib Standing Seam Roof Panel](#)

The following pages outline the different seaming options and span capacities as well as provide Nucor standard details for this roof system.



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NUCOR CFR™ PROPERTY AND SPAN TABLE

CFR Roof (24 Gage A792 Grade 50, Class 1 with Fy = 50 ksi, Fu = 65 ksi)									
Panel Material Information					Panel Properties per foot of panel width				
								Top in Compression	
Panel Gage	Thickness (in.)	Yield (Ksi)	Tensile (Ksi)	Panel Wt. (Psf)	I _x (Gross) (in ⁴)	S _x (eff.) (in ³)	Ma (Kip-in.)	S _x (eff.) (in ³)	Ma (Kip-in.)
24	0.0222	50	65	1.19	0.3640	0.149	4.4465	0.083	2.4905

Allowable Gravity and Wind Pressure (psf): Panel: (Stress, Deflection, and Web Crippling)

Span (Ft)	Simple Span			2 Equal Spans			3 Equal Spans		
	Stress	Deflection		Stress	Deflection		Stress	Deflection	
		L/60	L/240		L/60	L/240		L/60	L/240
2.0	763	n/c	n/c	763	n/c	n/c	763	n/c	n/c
2.5	489	n/c	n/c	489	n/c	n/c	489	n/c	n/c
3.0	339	n/c	n/c	339	n/c	n/c	339	n/c	n/c
3.5	249	n/c	n/c	249	n/c	n/c	249	n/c	n/c
4.0	191	n/c	n/c	191	n/c	n/c	191	n/c	n/c
4.5	151	n/c	n/c	151	n/c	n/c	151	n/c	n/c
5.0	122	n/c	n/c	122	n/c	n/c	122	n/c	n/c

Allowable Wind Suction (psf): Panel: (Stress and Deflection) - Standard Clip with 2 Fasteners

Span (Ft)	Roll Lock	Vise Lock®	Vise Lock 360®
2.0	60.3	84.5	107.4
2.5	54.9	77.4	98.4
3.0	49.5	70.4	89.3
3.5	44.1	63.3	80.3
4.0	38.7	56.3	71.3
4.5	33.3	49.3	62.2
5.0	27.9	42.2	53.2

Contact the engineering team for capacities with different panel, fastener, or clip configurations. Note: n/c indicates that deflection considerations do not control over stress limits.



NUCOR CFR™ SEAMING OPTIONS

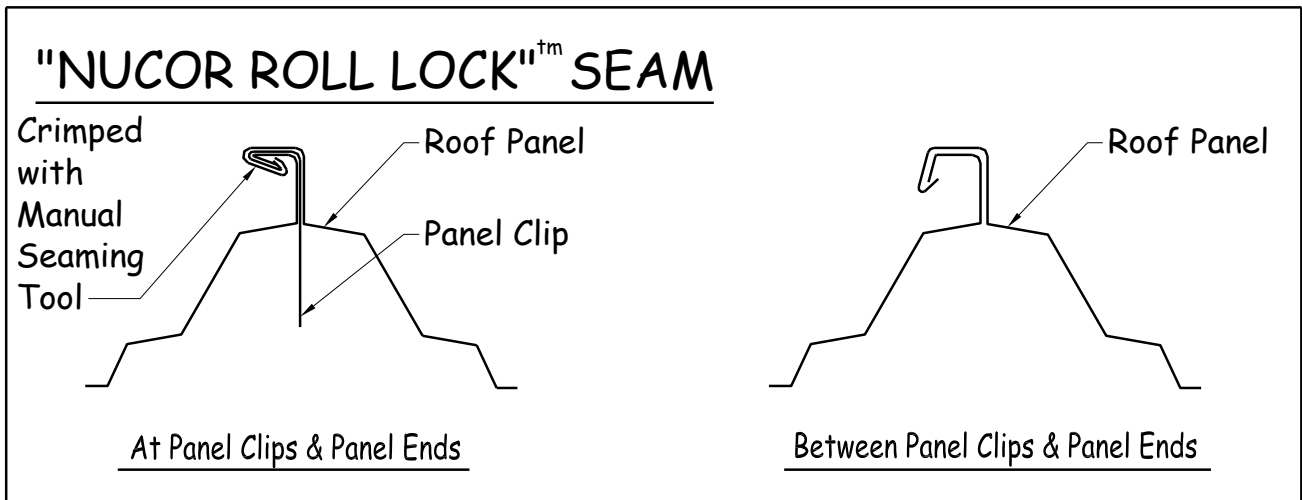
GENERAL

The Nucor CFR™ roof system has three seam type options. The project design and performance requirements govern which seam type is required.

Different seam types may be required on specific areas of the roof. In all cases, refer to the erection drawings to determine the required seam type and locations.

NUCOR ROLL LOCK™ SEAM

The Nucor Roll Lock™ seam requires the roof panels be seamed with the manual seaming tool only at the panel clips, the eave, the high side of the roof panels and at the end laps.

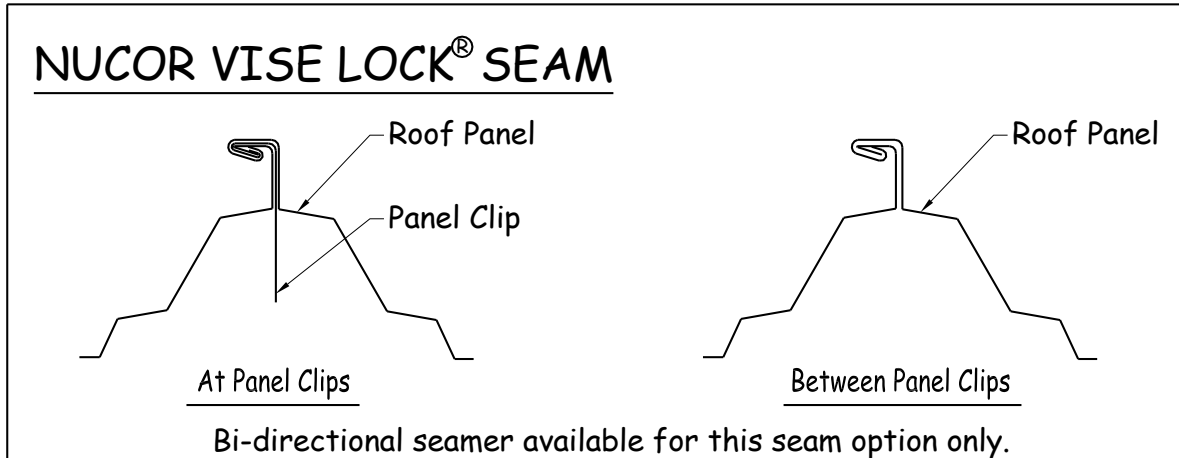




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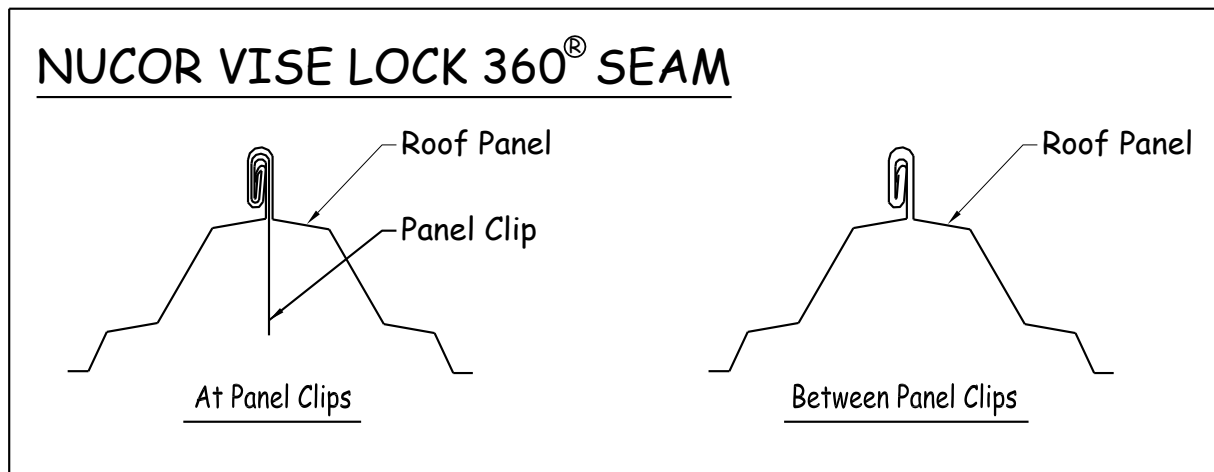
NUCOR VISE LOCK[®] SEAM

The Nucor Vise Lock[®] seam requires seaming the roof panel with the manual seaming tool at the starting eave or ridge end of the panels, and at the end laps. Then seaming the full length of the roof panels with the Motorized Seaming Machine.



NUCOR VISE LOCK 360[®] SEAM

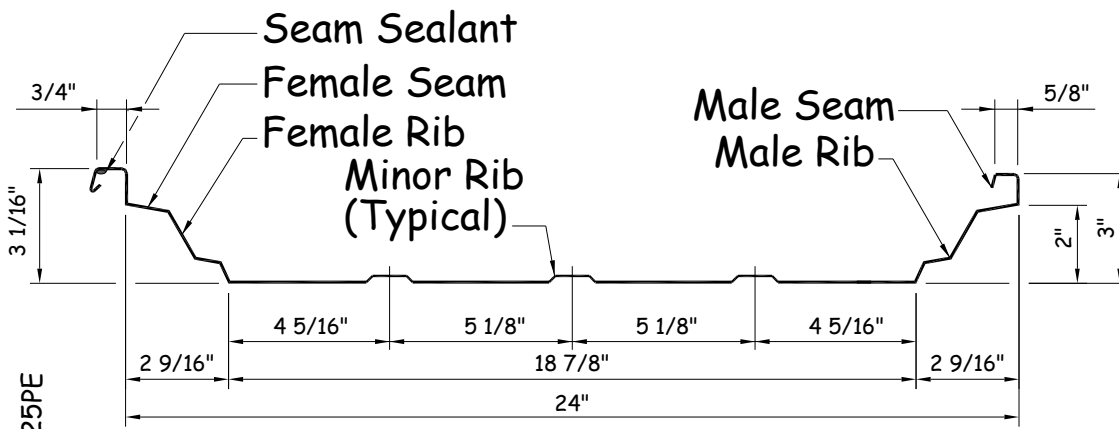
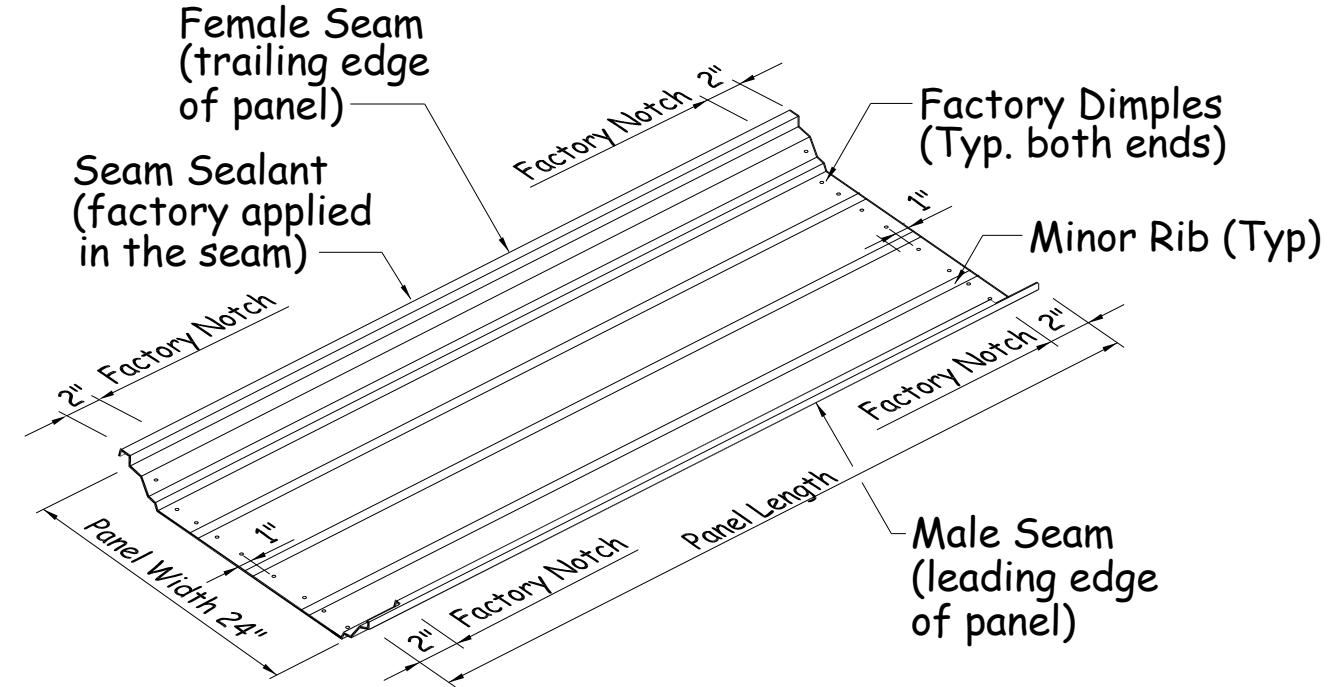
The Nucor Vise Lock 360[®] seam can be formed with a one pass VL 360 seamer OR two separate seamers, one set-up with Vise Lock tooling and the other set-up with Vise Lock 360 tooling. The Nucor Vise Lock 360[®] seam requires manual seaming at the low eave so that you can start the Motorized Seaming Machine onto the panels.





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CF0025PE – PANEL PROFILE



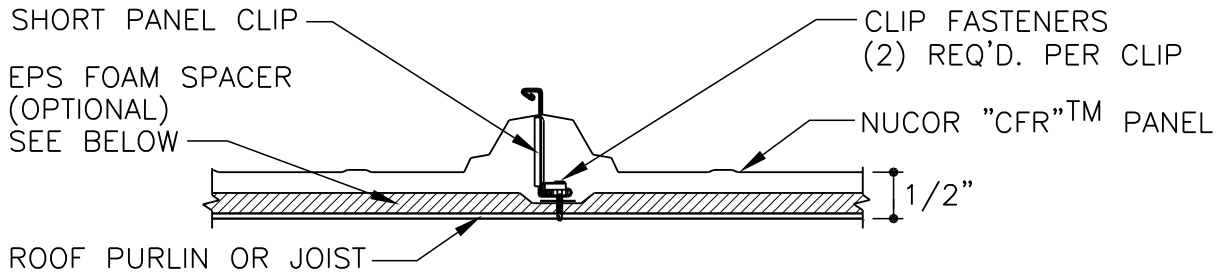
PANEL SECTION



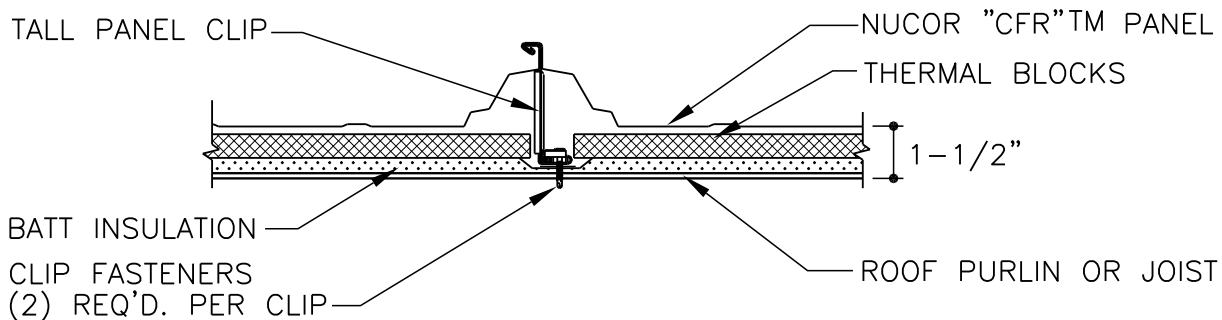
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CF0010PE – NUCOR CFR™ CLIP SYSTEMS

NUCOR "CFR"™ PANEL W/SHORT CLIP & EPS FOAM SPACER



NUCOR "CFR"™ PANEL W/TALL CLIP & THERMAL BLOCK



CLIP AND INSULATION APPLICATIONS:

- Nucor Building Systems recommends that insulation be used in all CFR roof applications to avoid problems with condensation formation. Insulation also provides a buffer between the purlins and the CFR roof to reduce noise and possible damage due to metal-to-metal contact. Insulation requirements are as follows:
 - Short Clips: 2" to 4" of insulation compressing to 1/2" over roof purlins. EPS foam spacers are available for limited use in un-insulated areas.
 - Tall Clips: 4" to 6" of insulation compressing to 3/4" thickness under thermal block at roof purlin locations. Thermal blocks are required when tall clips are used. 1 1/2" thermal blocks with adhesive are available for limited use in un-insulated roof areas.
 - Tall Clips: Maximum of 8" of single layer batt insulation is allowed, which requires special attention to maintain panel modularity and thermal performance.

- Fixed or floating clips may be used as determined by the following:

Roof Structural Type
Purlins
Joists

Panel Run <= 80'-0"
Fixed Clips
Floating Clips

Panel Run > 80'-0"
Floating Clips
Floating Clips

LAST REVISION
DATE: 05/18/16
BY: KMC CHK: EGB

DETAIL NAME IF APPLICABLE
CF0010PE.DWG

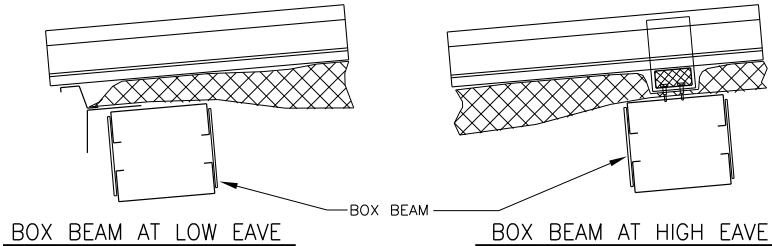
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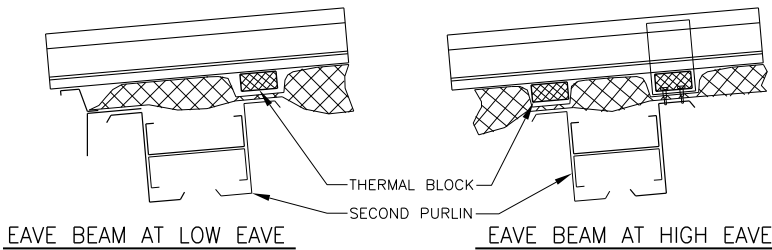
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EA6022 – THERMAL BLOCK – TALL CLIPS

SPECIAL CONDITION AT A BOX BEAM

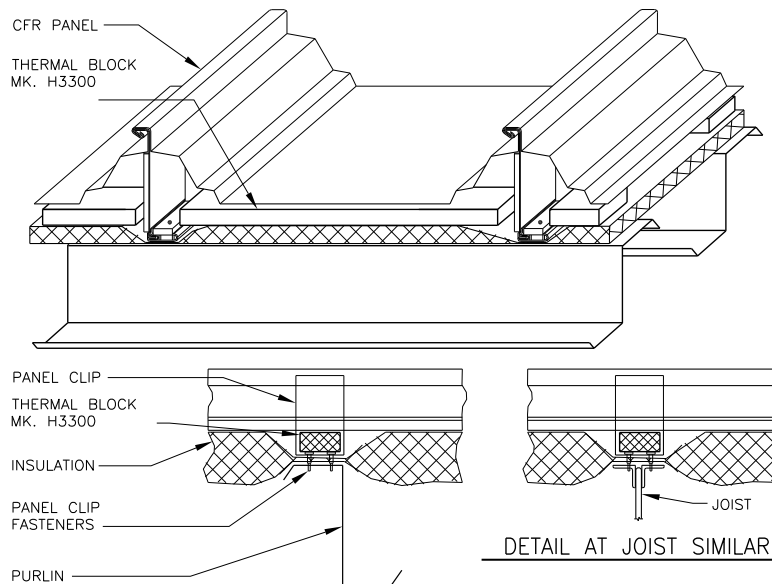


SPECIAL CONDITION AT AN EAVE BEAM



IF THIS PROJECT HAS AN EAVE BEAM WITH (2) PURLINS, AS SHOWN, **DO NOT** ATTACH ROOF CLIPS TO THE "SECOND" PURLIN. HOWEVER, THERMAL BLOCKS ARE PROVIDED FOR INSTALLATION AT THE SECOND PURLIN.

INSULATION TIE-OFF AT THE EAVES VARIES BASED ON THE EAVE CONDITION. REFER TO THE ROOF PANEL ERECTION MANUAL FOR DETAILS.



THERMAL BLOCK DETAIL AT TALL CFR CLIPS

CFR ROOF WITH BATT INSULATION

EA6022

LAST REVISION
 DATE: 02/16/15
 BY: AK CHK: EGB

DETAIL NAME IF APPLICABLE

EA6022.DWG

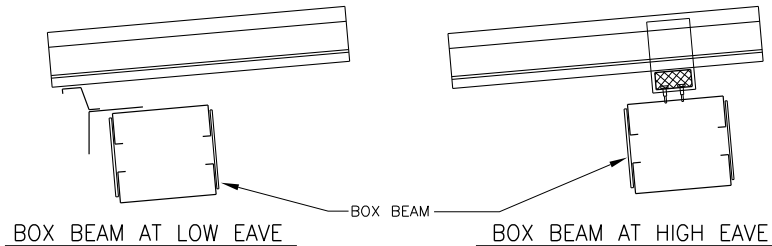
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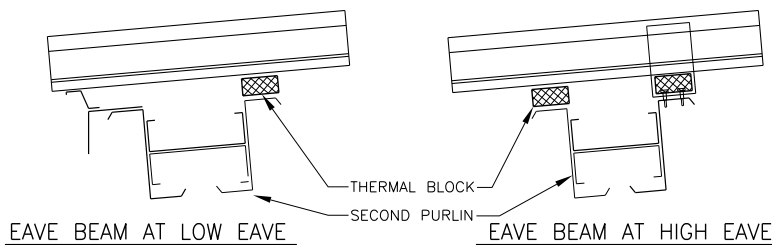
PRODUCT & ENGINEERING MANUAL

EA6023 – THERMAL BLOCK – TALL CLIPS WITHOUT INSULATION

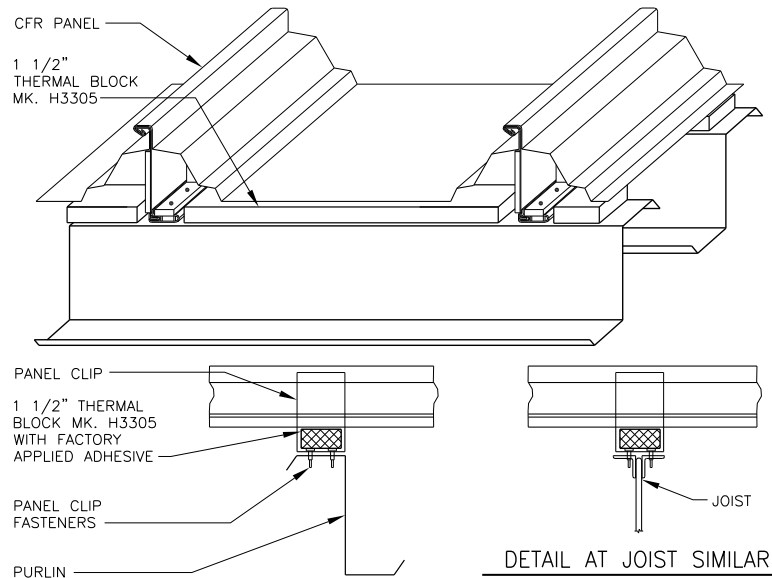
SPECIAL CONDITION AT A BOX BEAM



SPECIAL CONDITION AT AN EAVE BEAM



IF THIS PROJECT HAS AN EAVE BEAM WITH (2) PURLINS, AS SHOWN, **DO NOT** ATTACH ROOF CLIPS TO THE "SECOND" PURLIN. HOWEVER, THERMAL BLOCKS ARE PROVIDED FOR INSTALLATION AT THE SECOND PURLIN.



THERMAL BLOCK DETAIL AT TALL CFR CLIPS

CFR ROOF WITHOUT INSULATION

EA6023

LAST REVISION
 DATE: 02/16/15
 BY: AK CHK: EGB

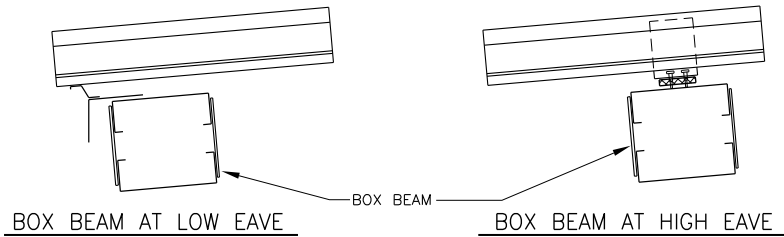
DETAIL NAME IF APPLICABLE
EA6023.DWG



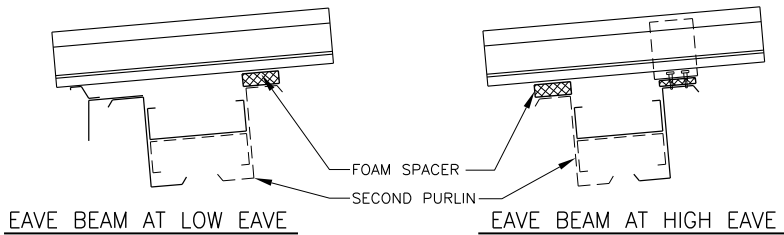
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EA6024 – THERMAL BLOCK – SHORT CLIPS WITHOUT INSULATION

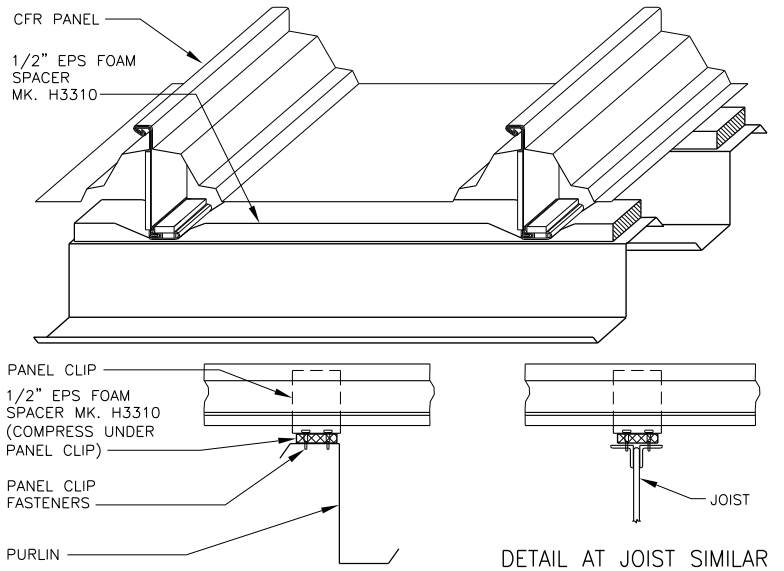
SPECIAL CONDITION AT A BOX BEAM



SPECIAL CONDITION AT AN EAVE BEAM



IF THIS PROJECT HAS AN EAVE BEAM WITH (2) PURLINS, AS SHOWN, **DO NOT** ATTACH ROOF CLIPS TO THE "SECOND" PURLIN. HOWEVER, EPS FOAM SPACER IS PROVIDED FOR INSTALLATION AT THE SECOND PURLIN.



FOAM SPACER DETAIL AT SHORT CLIPS

CFR ROOF WITHOUT INSULATION

EA6024

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 DATE: 02/16/15
 BY: AK CHK: EGB

DETAIL NAME IF APPLICABLE

EA6024.DWG

5.0.10



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EA6026 – GUIDANCE TO INSTALL SINGLE LAYER 8” INSULATION

SEE CFR ERECTION MANUAL FOR PROPER INSTALLATION INSTRUCTIONS

ERECTION MANUAL QUICK REFERENCE:

SECTION(S)	DESCRIPTION
10.6	INSULATION INSTALLATION
13.2	PRE-DRILLING FOR FULL PANEL MODULARITY
13.3	PANEL MODULARITY

THE INSTALLATION OF THE SYSTEM REQUIRES SPECIAL ATTENTION TO MAINTAIN PROPER PANEL MODULARITY AND THERMAL PERFORMANCE AS NOTED BELOW:

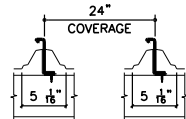
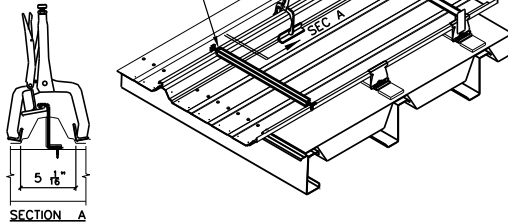
USE MODULARITY CLAMP(S) TO HOLD PANEL TRAPEZOID AT 5-1/16" WIDE ALONG FULL LENGTH OF PANEL SEAM, SEE SECTION A.

USE MODULARITY TOOL(S) TO HOLD PANEL CLIPS IN PLACE, PRIOR TO FASTENING, TO MAINTAIN A CONSTANT 24" WIDE PANEL COVERAGE.

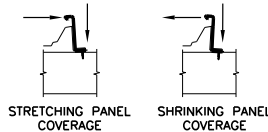
CFR ADJUSTABLE MODULARITY TOOL (BUYOUT) MK. H9510

CFR MODULARITY CLAMP (BUYOUT) MK. H7100

CFR MODULARITY TOOL (SUPPLIED) MK. MTB01



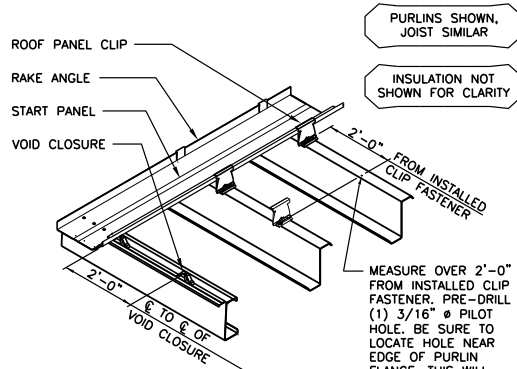
CORRECT PANEL MODULARITY



ADJUSTING PANEL MODULARITY

PRE-DRILL ONE PILOT HOLE FOR ROOF PANEL CLIPS AT MID-SPANS, HIGH SIDE OR RIDGE AND PANEL END LAPS, IF ANY.

INSTALL NEXT VOID CLOSURE AT BUILDING EAVE.

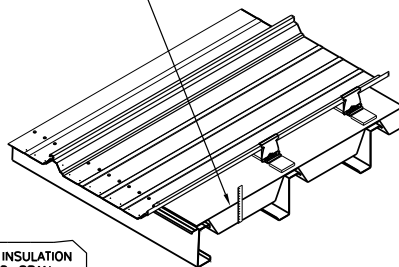


MEASURE OVER 2'-0" FROM CENTER OF INSTALLED VOID CLOSURE AND MARK ON EAVE PLATE TAPE MASTIC. INSTALL NEXT VOID CLOSURE AS SHOWN.

MEASURE OVER 2'-0" FROM INSTALLED CLIP FASTENER. PRE-DRILL (1) 3/16" Ø PILOT HOLE. BE SURE TO LOCATE HOLE NEAR EDGE OF PURLIN FLANGE, THIS WILL ENSURE THAT (3) FASTENERS CAN BE INSTALLED IN CLIP BASE (IF REQ'D BY DESIGN).

ENSURE THE INSULATION IS PERMITTED TO SAG AT MID-SPAN BETWEEN ROOF SECONDARY MEMBERS AND EXPANDED TO THE FULL THICKNESS.

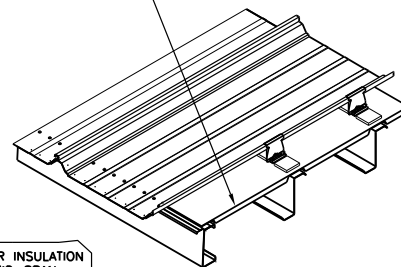
SINGLE LAYER FIBERGLASS BLANKET INSULATION, EXPANDED TO FULL THICKNESS



PROPER INSULATION AT MID-SPAN

DO NOT PULL THE INSULATION TAUT AS THIS WILL SIGNIFICANTLY REDUCE THE THERMAL PERFORMANCE OF THE ROOF SYSTEM.

SINGLE LAYER FIBERGLASS BLANKET INSULATION, PULLED TOO TIGHT



IMPROPER INSULATION AT MID-SPAN

GUIDANCE TO INSTALL SINGLE LAYER OF 8" INSULATION WITH "CFR" ROOF

SPECIAL ATTENTION TO ABOVE STEPS TO MAINTAIN PROPER PANEL MODULARITY AND THERMAL PERFORMANCE IS CRITICAL, FAILURE TO DO SO WILL RESULT IN UNSIGHTLY PANEL APPEARANCE.

EA6026

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BY: KMC CHK: EGB

DETAIL NAME IF APPLICABLE
EA6026.DWG

5.0.11

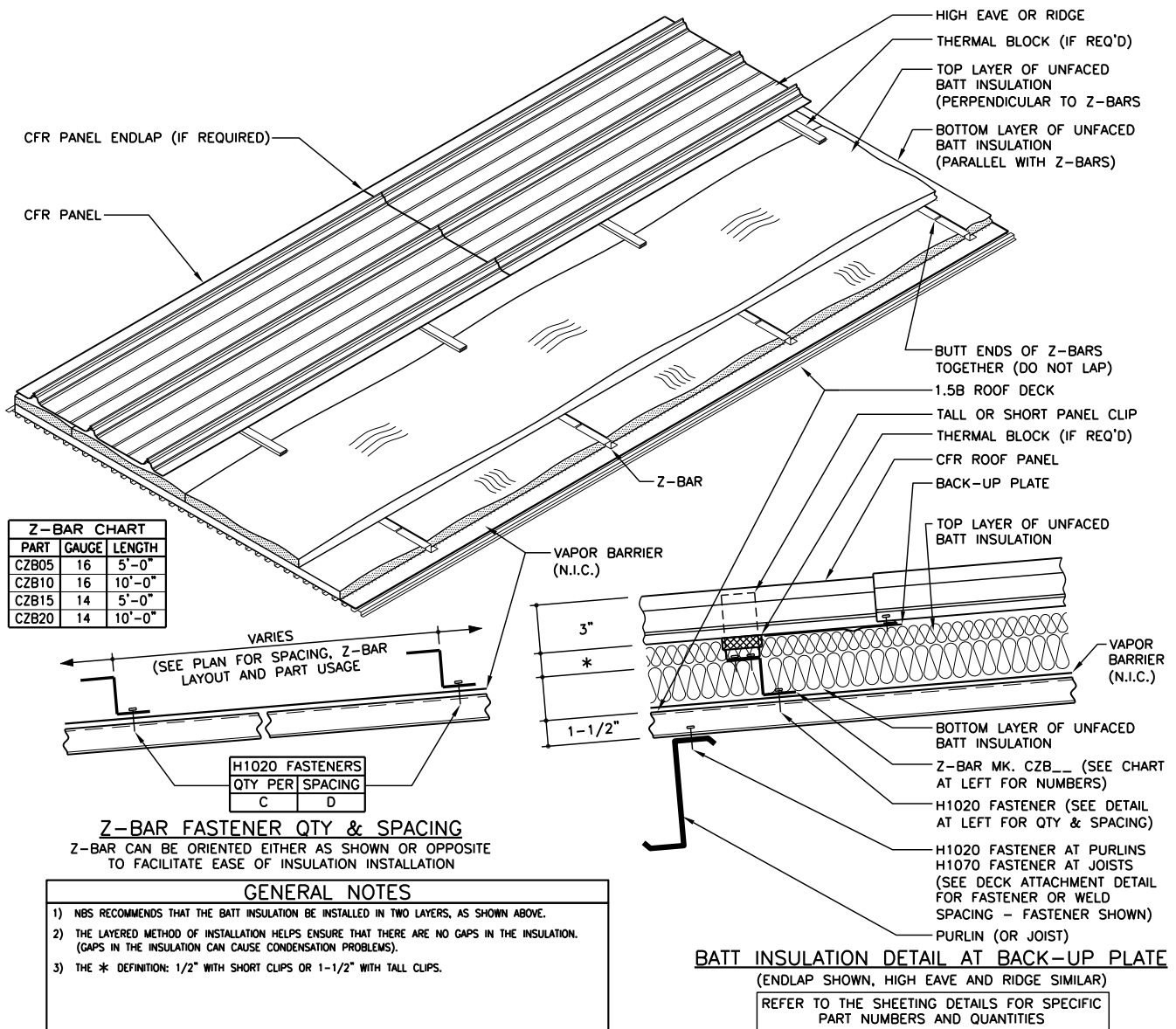


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NUCOR COMPOSITE CFR™ OPTIONS:

FA6003 – BATT INSULATION WITH Z-BARS

- Z-bars are 16 gage material and spaced either 4 or 5 foot apart, depending on insulation width.
- Panel clips attach directly to z-bars with standard self-drilling screws.
- Overall batten insulation thickness allowed: 5" min and 12" max.
- For UL90 requirements, please contact NBS.



COMPOSITE CFR BATT INSULATION INSTALLATION RECOMMENDATION DETAIL Z-BARS AND 1.5B DECK

FA6003

LAST REVISION
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 BY: AK CHK: EGB

DETAIL NAME IF APPLICABLE
FA6003.DWG

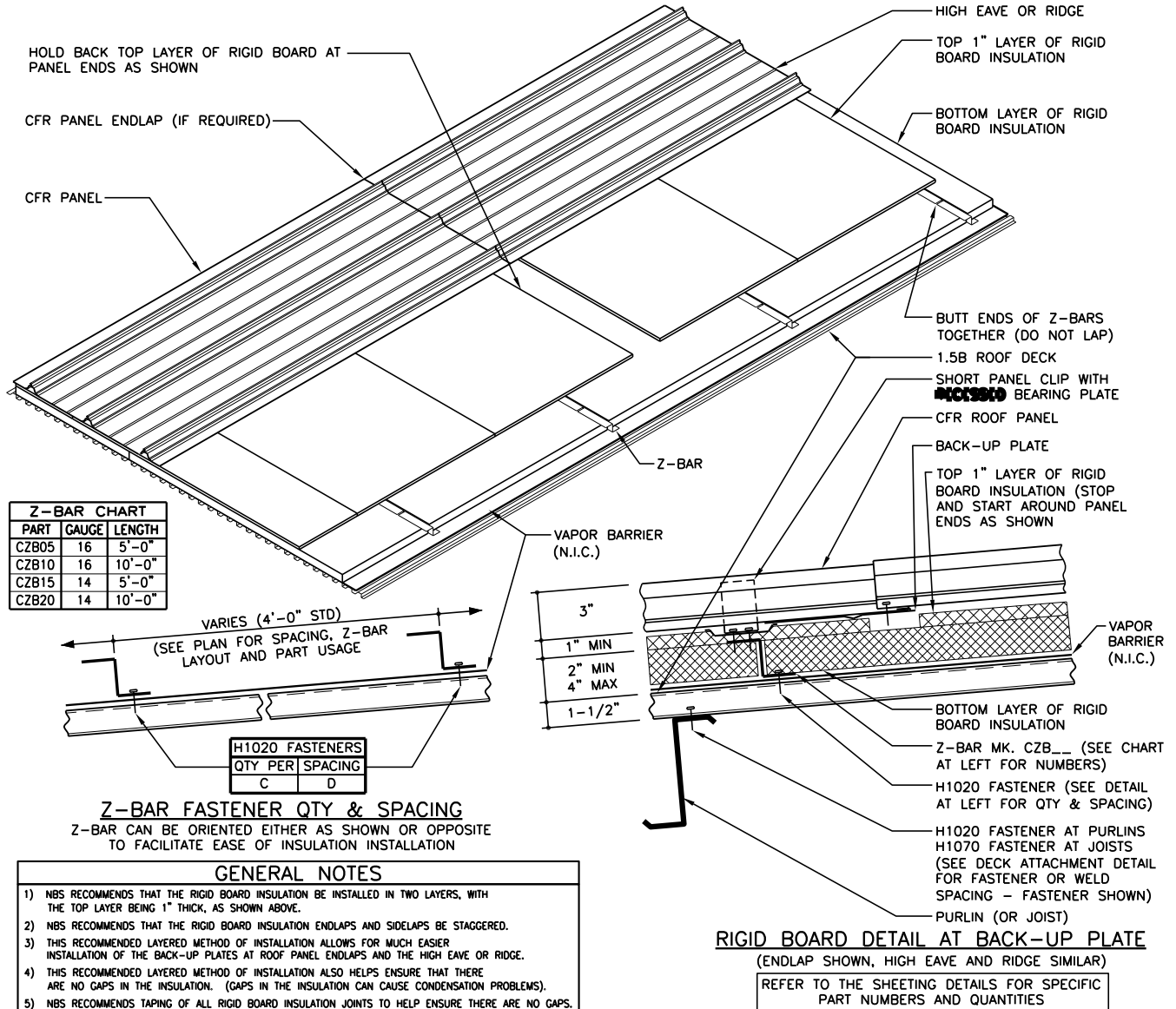
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FA6004 – RIGID BOARD INSULATION WITH Z-BARS

- Z-bars are 16 gage material and typically spaced 4 foot apart.
- Panel clips attach directly to z-bars with self-drilling screws and bearing plates.
- Overall rigid board insulation thickness allowed: 3" min and 10" max.
- For UL90 requirements, please contact NBS.



COMPOSITE CFR RIGID BOARD INSTALLATION RECOMMENDATION DETAIL Z-BARS AND 1.5B DECK

FA6004

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BY: AK CHK: EGB

DETAIL NAME IF APPLICABLE
FA6004.DWG

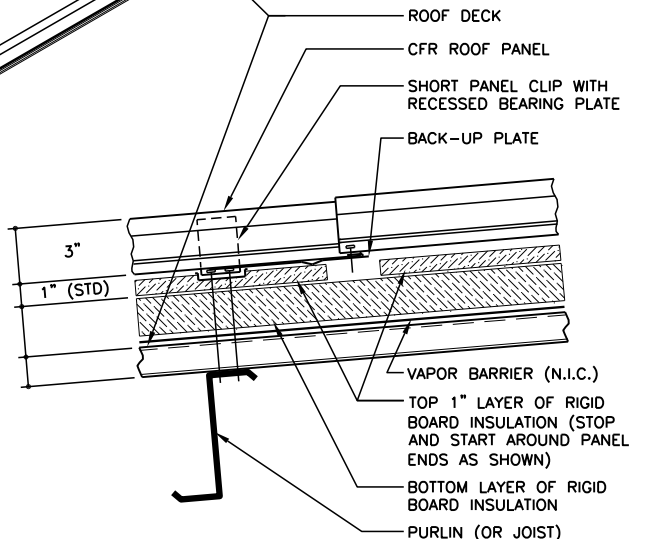
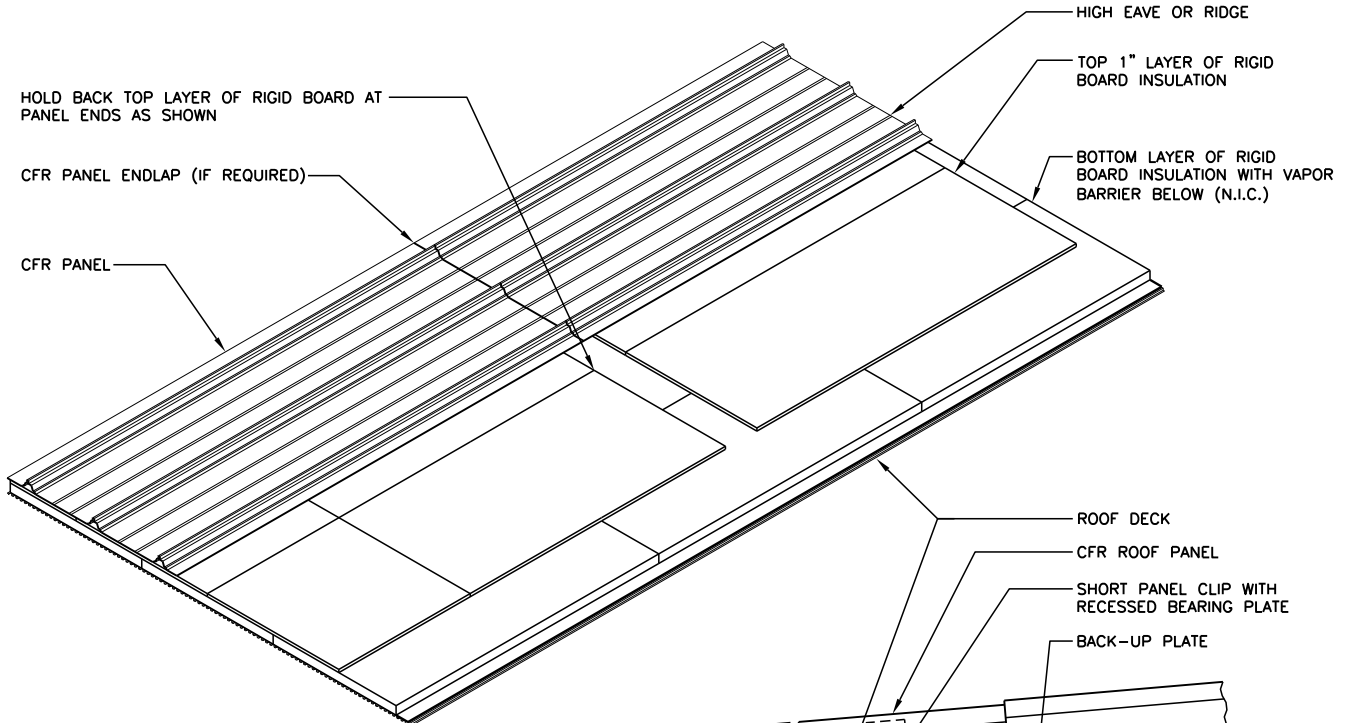
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FA6005 – RIGID BOARD INSULATION

- Panel clips attach directly to secondary member with extra-long self-drilling screws and bearing plates.
- Overall rigid board insulation thickness allowed: 2" min and 5" max.
- UL90 requirements: 5'-0" max purlin spacing, 5'-6" max joist spacing.



GENERAL NOTES	
1)	NUCOR RECOMMENDS THAT THE RIGID BOARD INSULATION BE INSTALLED IN TWO LAYERS, WITH THE TOP LAYER BEING 1" THICK, AS SHOWN ABOVE.
2)	NUCOR RECOMMENDS THAT THE RIGID BOARD INSULATION ENDLAPS AND SIDELAPS BE STAGGERED AS SHOWN ABOVE.
3)	THIS RECOMMENDED LAYERED METHOD OF INSTALLATION ALLOWS FOR MUCH EASIER INSTALLATION OF THE BACK-UP PLATES AT ROOF PANEL ENDLAPS AND THE HIGH EAVE OR RIDGE.
4)	THIS RECOMMENDED LAYERED METHOD OF INSTALLATION ALSO HELPS ENSURE THAT THERE ARE NO GAPS IN THE INSULATION. (GAPS IN THE INSULATION CAN CAUSE CONDENSATION PROBLEMS).
5)	NUCOR RECOMMENDS TAPING OF ALL RIGID BOARD INSULATION JOINTS TO HELP ENSURE THERE ARE NO GAPS IN THE INSULATION.

RIGID BOARD DETAIL AT BACK-UP PLATE
 (ENDLAP SHOWN, HIGH EAVE AND RIDGE SIMILAR)
 REFER TO THE SHEETING DETAILS FOR SPECIFIC PART NUMBERS AND QUANTITIES

COMPOSITE CFR RIGID BOARD INSTALLATION RECOMMENDATION DETAIL

FA6005

LAST REVISION
 DATE: 02/16/15
 BY: AK CHK: EGB

DETAIL NAME IF APPLICABLE
FA6005.DWG

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