

Rollforming

EXCLUSIVELY DEVOTED TO CONSTRUCTION PROFESSIONALS

Magazine

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AUGUST/SEPTEMBER 2022
Vol. 5, No. 4

**MID-YEAR
BUSINESS
OUTLOOK**

**LIGHTNING
PROTECTION:**
PROTECT YOUR SHOP
FROM POWER SURGES

**AVOID
BREAKDOWNS
WITH PREVENTIVE
MAINTENANCE**

**PREVENT WICKING
IN YOUR CONDENSATION CONTROL**

**GEARING UP FOR THE
CONSTRUCTION
ROLLFORMING SHOW**
FAMILY-FRIENDLY FUN IN NEW ORLEANS



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Will you do what it takes?

■ By Gary Reichert

According to the survey we completed business is generally good for most of us, but the world seems sideways.

The preliminary numbers for GDP are out and showing a decline of 2.1%. The official number comes out in about 3 weeks, but it is pretty clear we are “officially” in a recession. Inflation is the highest since 1981. Material costs and supply chain problems are nearly universal. There is a lot of uncertainty about what comes next. I know, for me personally, that uncertainty causes more sleepless nights than any immediate challenges. Immediate challenges can be faced and overcome. Vague future

problems loom like fog in an old horror movie.

One of my favorite quotes from Jordan Petersen is “If you know the why, the how is easy.” The point is there is always a way to succeed. Eventually perseverance, effort, talent or whatever will always win. The question is are you willing to do what it takes to embrace the grind and succeed. There has to be a reason that you (and I) spend sleepless nights staring at the ceiling going over numbers, risk nearly everything you own and take time away from things you enjoy to be in the office weekend mornings.

Call it embracing the grind, the suck or something different. But the discipline

to do what needs to be done every single day is the key to success in a tough or competitive marketplace. Not everyone can. Friends I used to work with were betting I would not last a year at the pace I had in start-up mode. Three years later (on July 2) I am still here, mileage showing but still running forward as fast as I can.

What makes you able to embrace the suck?

Going into a potentially challenging economic period, I would like to know. I think others would too. If you are comfortable sharing your “Why” send it to me and we will run the responses in an upcoming issue of Rollforming. [RF](#)

Editor's Note))

What do you need to know?

■ By Karen Knapstein

When Sharon Thatcher, Rollforming Magazine's previous editor, retired, I knew I had some big shoes to fill. I think you'll agree she did a fantastic job of filling this magazine with relevant information, produced exclusively for construction roll formers. Thankfully, although she's two states away, she continues to write for us. You'll find two of her bylined articles in this edition. The first is the cover story, which is about preventive maintenance; the story begins on page 12.

The second article Sharon wrote for this edition is a business profile about Stillwater Metals of Kenton, Ohio. I've received feedback from many readers saying the business profiles are one of their favorite features because they like

learning about what other guys are doing. Since this is the case, we'll continue including these business profiles in every edition. I truly appreciate the feedback!

Without hearing from you, I have no idea whether or not I'm on the right track with providing the information you need. We are currently working on the editorial schedule for 2023. Since my knowledge of roll forming topics is very limited, I'm reaching out to you — our readers — for help. I would be in your debt if you would contact me and let me know: **What topics and types of articles would you like to see covered in 2023?**

Would you like to see more technical articles or business profiles? More show coverage, news, and new products? Or would you like to see less of one thing or another? I'm very approachable ... You

can call me at 715-513-6767 (I promise to answer if I'm in the office), send me a letter or postcard at the postal address on page 5, or send an email to karen@shield-wallmedia.com. (Be warned: I'll be calling some subscribers soon to pick your brains for article ideas.)

I'll close with a brief note about the Construction Rollforming Show. Consider this issue the pre-preview edition for the show, which will be held Oct. 26-27 in New Orleans. (Please note: The show is on Wednesday-Thursday this time, rather than Thursday-Friday as in previous years.) We've included some tourist information that you'll enjoy if you're bringing your family to the show in October. And you'll find the educational schedule on page 28 (subject to change).

I hope to hear from you soon! [RF](#)

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Which should you use?



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Roll forming machine assembly at Metal Rollforming Systems. *Photo courtesy of Metal Rollforming Systems.*

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Publisher, Shield Wall Media

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Industry Partners



STEEL DYNAMICS PLANS TO ACQUIRE MEXICAN METALS RECYCLING COMPANY

Steel Dynamics, Inc., has announced that as part of its North American raw material procurement strategy, the company has entered into a definitive agreement to acquire the equity interest of ROCA ACERO S.A. de C.V. ("ROCA") to be funded with available cash. ROCA is headquartered in Monterrey, Mexico and operates a ferrous and nonferrous scrap metals recycling business. ROCA's primary operations are comprised of four scrap processing facilities, strategically positioned near high-volume industrial scrap sources located throughout Central and Northern Mexico. These combined facilities currently ship approximately 575,000 gross tons of scrap annually and have an estimated annual processing capability of approximately 850,000 gross tons.

"We look forward to adding ROCA to the Steel Dynamics family to further solidify our Southwest U.S. and Mexico growth strategy," said Mark D. Millett, Chairman, President and Chief Executive Officer. "Combined with our existing North American metals recycling facilities, the addition

of ROCA significantly strengthens our raw material procurement strategy in the region. After closing the ROCA transaction and fully integrating our Mexican metals recycling operations, we believe our Mexican scrap facilities will provide an even more meaningful competitive advantage to our U.S. electric-arc-furnace steel operations, while also providing a high-quality, customer centered option for our outside scrap customers. We are very excited to welcome and learn from the entire ROCA team."

This transaction is subject to customary closing conditions and receipt of required regulatory approvals.

ENGLERT INCREASES FINISH WARRANTY TO 40 YEARS

Englert Inc., a manufacturer of standing seam metal roofing, single-skin wall panel systems, seamless gutters and downspouts, and LeafGuard gutter systems, has increased its 35-year finish warranty on Englert ULTRA-Cool Low-Gloss coatings to 40-years.

A 40-year finish warranty means a building or homeowner will have a longer period of confidence in the performance of their metal roofing or metal

siding purchase.

Englert's metal roofing, wall panel, and accessories are painted with its Low-Gloss/ULTRA-Cool paint finish. The 40-year limited warranty is against chipping, cracking, and peeling. Also, the Low-Gloss/ULTRA-Cool finish helps minimize "oil-canning" while being environmentally friendly.

An in-house continuous paint line offers low minimum quantities, and its dried-in-place pretreatment system allows the company to eliminate harmful chromates to offer an environmentally friendly coating process. They can apply various coatings, including Energy Star® compliant Kynars®, silicone polyesters, polyesters, plastisols, and acrylics to aluminum, Galvalume®, galvanized, or cold-rolled steel.

CDH CUSTOM ROLL FORM RECEIVES ISO CERTIFICATION

CDH Custom Roll Form (CDH) has received ISO 9001:2015 certification for its quality management system in its Warren, Ohio, facility. The certification has a scope of the manufacture and supply of cold roll-formed sections to customer requirements for, but not limited to, custom profiles, construction

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CDH manufactures component and custom products to meet the needs of a variety of customers in the North American steel roll-form products market. CDH's Warren facility offers state-of-the-art roll-forming technology, as well as stamping and slitting capabilities.

Jack Pacalo, CDH Custom Roll Form President, said, "This is a natural progression for the Company as we move forward with our plans for aggressive growth. It enables us to work with an even broader group of customers that require ISO certification from its manufacturers and suppliers."

AKZONOBEL LAUNCHES CAMPAIGN TO SUPPORT PVDF PARTNERS

In the face of ongoing uncertainty in global PVDF (or polyvinylidene difluoride) supply chains, coatings and paint manufacturer AkzoNobel has launched a campaign to help its partners navigate the changing PVDF landscape.

Changes in global market dynamics, including increased demand from

markets such as electric vehicle batteries and solar panels, have led to interruptions in the supply of PVDF resin commonly used in coil coatings. This, in turn, has affected the availability of some PVDF-containing products.

AkzoNobel has produced a suite of tools and information to help its partners and end-users respond to these challenges. The aim is to help partners gain a full understanding of the PVDF situation and enable them to make more informed decisions about the best solutions for their specific circumstances.

"The robust versatility of PVDF means it is in high demand. This has squeezed supplies to the metal coatings industry, as well as pushed up prices. We want to support our customers in responding to these challenges by helping them understand the context and, where necessary, find new solutions," explains Bo Matzner, Global Product Marketing Director, Coil and Extrusion Coatings at AkzoNobel.

In many cases, Matzner says, AkzoNobel offers a non-PVDF equivalent or similar product delivering the same quality required. At the same time, its research and development team is working to develop new offerings.

MAJESTIC STEEL USA ACQUIRES MERCURY TRANSPORT, QUICKEN STEEL

Majestic Steel USA, Inc. ("Majestic"), a steel service center and processor of flat-rolled steel products across North America, has completed two strategic acquisitions in manufacturing and logistics.

Quicken Steel LLC, a manufacturer of steel buildings and components headquartered in Claxton, Georgia, and Mercury Transport Inc., a transportation company headquartered in Pittsburg, California will become wholly owned divisions of Majestic Steel USA, Inc.

Quicken Steel will continue to operate independently while using Majestic resources to create synergies. With a niche in providing short lead-times and the quick installation of steel buildings, it's a downstream opportunity that aligns with Majestic's approach to growth and innovation.

The acquisition of Mercury Transport will allow the company to better serve its customers as an integrated logistics provider with local market expertise. **RF**



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Moisture Membrane Glazing

Heat treating DR!PSTOP edges to prevent mildew and wicking

You've likely heard of DR!PSTOP, a popular condensation control membrane that is applied to metal roofing panels as it is roll formed. But did you know the manufacturer recommends heat treating, or glazing, portions of the membrane while installing the roof?

According to DR!PSTOP, "We recommend heat treating the edges, eaves, and end laps for a couple of reasons. By itself, DR!PSTOP is resistant to mold and mildew. But as dirty rainwater runs down a roof, organic material can get trapped in the air pockets in the membrane. These organics provide food for mold and mildew to feed off of and grow from. Besides hurting the appearance, this mold and mildew can spread once it takes hold. This can accelerate the second problem, which is wicking moisture into the building.

"Glazing prevents the wicking of moisture back up (which can slow the evaporation process). On end laps (panels lapped over each other from ridge to eave, typically found in wider buildings where a single panel length is not possible), heat treating keeps the water from wicking in as it runs down the roof during rain or snowfall. Holding water on a panel like this can void manufacturers' warranties."

See this step-by-step guide to glazing the necessary portions of the moisture membrane:

1. Since the material is polyester, it melts when heated by either a heat gun or open flame. The key is to melt the material completely until it looks like dots. We recommend using a heat gun for safety purposes. End laps are typically done before the panels are on the roof, either on the lift or on sawhorses set up for this purpose.

2. Move the heat gun over the target



Using a heat gun, melt the membrane until it looks like dots. Photos courtesy of DR!PSTOP.

area. When using a heat gun, place it approximately 1" to 2" from the material and move the gun constantly over the material until it melts. The material will have a Braille-like or raised dot appearance as it melts.

3. The goal is to treat all of the exposed edge and eave material to prevent wick-

ing of the runoff moisture (approximately 2"). After glazing, the material will feel coarse to the touch. While some builders have successfully used other methods, we recommend the heat gun.

There is also a how-to video on the DripStop website at www.dripstop.com.
RF



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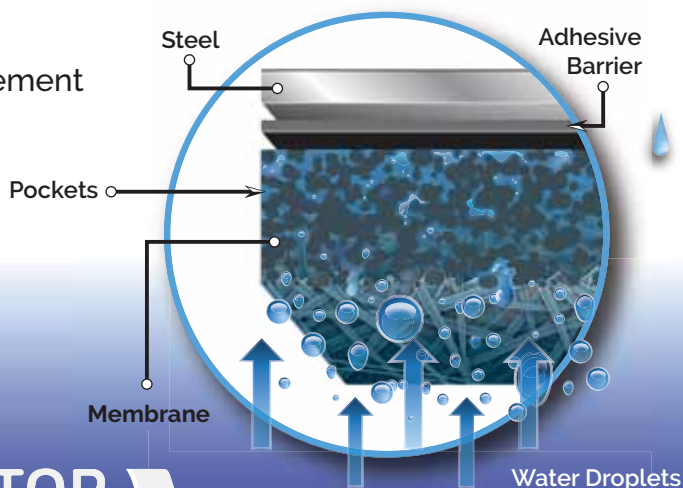
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How to Avoid Breakdowns

The care and maintenance of roll-forming equipment

■ By Sharon Thatcher

Long delays for back-ordered parts needed to fix a broken machine can be costly for a company's bottom line and reputation. The commonly provided answer for how to avoid that problem lies in taking precautionary care of your equipment to avoid unexpected breakdowns.

Roll-forming machine manufacturers provide specific guidance for their machines. That guidance typically depends on how much you use it, and what types of metal you run through it. The first rule of thumb is to read through the machine manual and follow the recommendations. Even if you do rely on your supplier's service team to conduct routine maintenance, a cursory knowledge of what needs to be done and why can prove critical to breakdown-avoidance.

Here are the areas all roll-former operators should take into consideration, as well as a general timeline for ongoing maintenance.

COOLANT SYSTEM

An accurate cooling mixture of water and oil is critical for proper and smooth operation. Too much water can cause rollers to stick, altering the machine's performance and product quality. The proper ratio is prescribed by the supplier. Use a refractometer daily to measure for correct concentration.

To avoid limescale build-up in machine piping, use softened water.

If you use pressure filters, periodically



Vibration from normal use can loosen bolts. Inspect machines before and during operation so little things like this don't turn into big headaches. PHOTO COURTESY OF METAL ROLLFORMING SYSTEMS

check and change them as needed.

LUBRICANTS

All power transmission parts (bearings, dies, pillow blocks, slide blocks, and chain gears) should be kept lubricated with a thin film of lubricant to avoid premature wearing of parts that can ultimately damage a panel. This applies even to high-quality roll forming dies that are chrome-plated to help overcome the surface speed difference inherent in tooling.

How often lubrication is needed depends on production volume. For high-volume operations (daily two-shift

operations) shear dies should be lubricated daily, roll former shaft bearings monthly and pillow blocks and slide blocks yearly.

Lubricant serves as a magnet for dust and dirt so always wipe off excess from surfaces.

HYDRAULICS

Because hydraulic oils are sensitive to contaminants (both dust and moisture), regular maintenance can significantly increase the life of hydraulic systems and components. Oil levels should be checked daily.

Maintenance Too Often Overlooked

Chris Cox, the Southeast Regional Sales Manager for ASC Machine Tools, sees problems arising more often from oversights in three areas of maintenance. Heed these and you will avoid most problems.

Lubrication: “Roll formers have multiple moving parts that need to be lubricated according to the manufacturer’s specifications. Failure to do so can result in damage to the equipment and shortening the equipment’s production lifespan.”

Tooling Cleaning: “Dust and other debris can build up on a roll former’s tooling which may lead to scratched paint and excessive wear on the tooling. The tooling should be cleaned at least once each month or more often depending on the manufacturing environment.”

Visual Inspection: “Operators should perform a visual inspection of the equipment prior to operating it to ensure there are no obstructions, fluid leaks, or other potential problems. Operators should also perform a visual inspection while the equipment is operating to check for potential problems, i.e. loose bolts and fluid leaks.”

Hydraulic oil usually requires changing twice a year for high-volume operations, but operators should check oil levels daily. Microscopic testing of the oil, provided by an oil service firm, offers the best read on when hydraulic oil needs to be changed.

When filling a new machine, or changing oil, a filtered 10 (or more) micron filter is needed to remove impurities.

Hydraulic Filters: In-line hydraulic filters can be checked via a color-coded indicator. Changing oil within the yellow range is the most ideal time. The red range indicates that no filtering is taking place and ongoing use of the machine will lead to degradation and break-down.

Hydraulic Hoses: On a monthly basis, check for abrasions and leakage in hydraulic hoses, paying particular attention to high-pressure lines. Installing hose separator clamps will help to prevent abrasion due to hoses rubbing together over extended time.

Leaking hoses should be replaced immediately. While properly engineered hydraulic hoses provide many hours of care-free operation, hydraulic oil is extremely hot and under great pressure. A failure is a major safety hazard. Operators of hydraulic shears should pay special attention due to repetitive flexing of the hoses.

Hydraulic Reservoirs: Clean reservoirs with solvent-soaked, lint-free wipes to eliminate accumulated dirt.



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PNEUMATICS

If using compressed air systems, monitor daily for correct PSI levels. Improper levels indicate an air leak and will ultimately lead to malfunction. The best check is when the plant is idle. Turning the air lines on and off when it is completely quiet will let you hear any air leaks. Once pinpointed, the leaks can be repaired.

DRIVE BELT TENSIONING

One of the common oversights in roll former maintenance is not checking chain tension. Slack in the tension can create a jerking motion within the roll former. This can ruin shafts, keyways, and sprockets. Before long, the chain itself is stretched out of shape, climaxing into a major overhaul.

A tensioner mechanism can ensure that the correct tension is set.

TOOLING INSPECTION

Roll tooling can be expected to hold up to years of use, but ongoing vigilance is needed to be sure tooling gaps and clearances are set properly, and various parts of the cutting process are running at top performance. This should be done daily or whenever the gauge is changed. Feeler gauges or an inspection mirror can help detect problems before major damage occurs.

Advisable is keeping replacement punches and dies in stock for quick replacement.

Periodically stop the line and evaluate what is being produced in comparison to engineered roll drawings that show the desired shape. Misshapen profiles will require either a simple adjustment or, worst case, a complete roll replacement.

SAFETY

Although routine maintenance can prevent costly breakdowns, all is for naught if safety is disregarded, and a



The pressure of deadlines can cause operators to skip necessary maintenance but the small cost in time can prevent more costly down time in the future. PHOTO COURTESY OF THE BRADBURY GROUP

BRADBURY

LUBRICATION SCHEDULE

LUBRICATION PRODUCTS BY MOBIL OIL COMPANY

DATE: 03/05/19

MACHINE TYPE: 320DH RAFT ASSYS

WO #:

Pg: 1 of 1

LUBRICANTS		FREQUENCY	
1. MOBILITE EP 2 (NUS 90.200000)	A. DAILY		
2. MOBILITE LIFT (NUS 100.000000)	B. WEEKLY		
3. MOBILITE MEDIUM	C. MONTHLY		
4. MOBILITE HEAVY (NUS 100.000000)	D. 2 MONTH INTERVALS		
5. MOBILITE 24 (NUS 100.000000)	E. 3 MONTH INTERVALS		
6. MOBILITE EXTRA MEDIA SUPER CYCLO	F. 1 YEAR INTERVALS		
7. MOBILITE 24 (NUS 100.000000)	G. TILL TO LEVEL		
8. MOBILITE 24 (NUS 100.000000)	H. PER MFT'S SPEC.		
9. MOBILITE 24 (NUS 100.000000)	I. CHANGE AFTER MFT'S		
10. MOBILITE 24 (NUS 100.000000)	J. 2 MONTH INTERVALS		
11. MOBILITE 24 (NUS 100.000000)	K. KEEP COVERED WITH LUBE		
12. MOBILITE 24 (NUS 100.000000)	L. PRIOR TO INITIAL STARTUP &		
13. MOBILITE 24 (NUS 100.000000)	M. AFTER REPAIR		
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BUBBLE	POINT OF LUBRICATION	QTY	FREQ	TYP	REMARKS
1	ROLLER	6	B	1	
2	DRIVE CHAINS	27	J	12	
3	APPROX BEARINGS	136	B	1	
4	SPUR GEARS	65	J	14	
5	PILLOW BLOCK	4	C	1	

* QTY - NUMBER OF POINTS TO LUBRICATE
** WHEN REPLACING PARTS (INCLUDING BEARINGS) SEE MANUFACTURERS RECOMMENDED SPECIFICATIONS FOR LUBRICATION

Manufacturers provide recommendations for scheduled maintenance of their machines. This example from The Bradbury Company offers frequency guidance for lubrication. The company also provides a list of critical spare parts you should consider keeping on hand for faster repair. PHOTO COURTESY OF THE BRADBURY GROUP

health emergency wipes out the cost savings and brings with it the trauma of injury.

Daily, before operating equipment, walk around the machine to verify that all guards and safety switches are in proper place and condition.

Power off machinery before working on it.

Never bypass emergency stop buttons or disengage safety equipment.

Know where the emergency stop buttons are located and prepare yourself mentally for using them in an emergency.

Always know the proper lock-out and tag-out procedures.

Use proper personal protection equipment (PPE) around machinery: safety glasses, gloves, and hearing protection.

Keep the workspace clean and organized. This includes the roll former and the work area around the machine. A machine that is well kept is a lot easier to operate safely and to maintain. It makes it easier to detect problems like a hydraulic leak or blown seal.

KNOW YOUR MACHINE

New technology with gauges and sensors is helping operators monitor critical parts and functions before things go wrong, yet always important is learning the sights and sounds of a good working machine and heeding your senses — and operator's manual — when something doesn't seem right. With routine inspection, catch problems before they become critical. [RF](#)

Technician Reveals How To Avoid Having To Make an SOS Call for His Services

Bradbury Co. Customer Service Technician John Rogers knows the insides-out of roll formers because he works on them daily. He offers insight into how to prevent an unexpected breakdown that could lead to an expensive visit from a technician like him.

ON ALIGNMENT

"Alignment is king in the roll-forming world. Having material flow through the shear to the lead-in and through the tooling smoothly will eliminate most defects in your product. Verify that the dials match the tooling gap; make sure

no one has gotten the dial off a round [during changeovers].

"If your panel doesn't look right, did something get adjusted incorrectly, is it pinching somewhere, is the tooling running together, am I about to cost myself a lot of money? Spending a little time inspecting alignment and tooling gap can save costly repairs.

"Check the lead-in/entry guides as well as both horizontal and vertical tooling areas. Don't assume that the coil is to blame. The inclination may be to come down harder on the panel, but if you run that tooling together very long, you're going to be buying new roll



Worn tooling typically occurs gradually over time and is not always recognized immediately by the daily machine operator. PHOTO COURTESY OF THE BRADBURY GROUP.

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Maintaining proper lubrication is essential for the longevity of your roll former. This includes inspection of bearings, bushings, gear boxes, chains, sprockets, and spur gears. PHOTO COURTESY OF THE BRADBURY GROUP.

tooling ... Looking for a pinch point on roll tooling is one of the most important things you can do.”

ON LUBRICATION

“The amount of times I go into someone’s facility and ... I ask Bob the

Operator, ‘hey, grab me your grease gun,’ if it takes Bob the Operator more than 10 minutes to find me a grease gun, I know he doesn’t use it every day; he doesn’t use it once a week. On a Bradbury roll former there are 136 grease zerks on the arbor stands, on the

16 pass [double high roll former]. If you can’t find the grease gun and you’re having to grease those 136 zerks every week, you’re not doing it. Take care of that machine and it will take care of you.”

ON CHAIN CHATTER

“If you let those chains get super loose and worn because they haven’t broke, that doesn’t help you because you’re going to wear your spur gears out faster. If you have chatter in the chain, you get chatter in the spur gear, that transfers to chatter in the roll tooling. You’re going to start seeing shiny marks on your roll tooling, you’re going to see a [staggered] radius on your panel — you can see it; it’s not super defined, but it wears out your roll tooling faster. So make sure, per your schedule, to lubricate your gear boxes, chains, sprockets, spur gears.”

The Value of Manufacturer Service Teams for PM

Roll-forming companies are increasingly recognizing the value of their manufacturer’s service teams to provide preventative maintenance and direction. Bill Griffin, President of Metal Rollforming Systems (MRS), said, “We’ve seen an increase in requests for factory service techs as people recognize the value and importance of uptime. They’ve been willing to invest in the preventative maintenance side of things, especially with the industry as a whole being so busy right now; every minute is valuable, and you want to get the maximum out of that machine and avoid downtime as much as possible.”

Typical for MRS are requests for annual inspections on a scheduled basis. “We travel to a customer’s facility and focus on issues or items that may need to be inspected or replaced to reduce future downtime issues,” Griffin said, “and a lot of the times we are able

to catch things before they become an issue.”

An annual checkup includes inspec-



More equipment owners are relying on technicians from roll former manufacturers to conduct annual maintenance, with operators conducting daily, weekly, and monthly maintenance. PHOTO COURTESY OF METAL ROLLFORMING SYSTEMS

tion of wear parts, verification of calibration, and optimizing production speeds and settings. “Often times our technicians will flip and adjust shear blades, inspect drive rollers, and chain tension, adjust tooling gap for optimal panel coverage and angles. If you can get ahead of the problem, you can really minimize the issues,” Bill said.

A single visit from an MRS technician costs an average of \$2,000 to \$4,000; a small cost to pay in comparison to a major breakdown.

Good used roll formers are hard to come by, so most machines sold today are new, making breakdowns less likely. In addition to annual inspections, manufacturers offer their customers advice on routine tasks for daily, weekly, and monthly schedules to keep those machines running smoothly well into the future. Buyers are advised to take advantage of and follow the PM schedule to maximize the longevity of their equipment. [RF](#)

ON SPARE PARTS

"Spare parts on your shelf limit your down time. If [we determine] your machine isn't working because the low-air compressor switch on the back of your brake is faulty, and the lead time on that switch is two weeks and the part costs \$70, do you want to be down two weeks because of a \$70 part? Have some of the critical parts on hand. Limiting down time is part of maintenance. Be prepared."

ON SETTING AND KEEPING A MAINTENANCE SCHEDULE

"Lube those chains, lube the spur gears, take a look at your gear boxes as per your lubrication schedule and prolong the life of your roll tooling, your bearings, and the quality of your panel. ...[New] roll tooling is far more expensive than the lubrication on your chain.



Problems can arise at lead-in or entry guides showing up as inconsistent width entry and exit. When caught early, small adjustments can avoid damage to panel and machine. PHOTO COURTESY OF THE BRADBURY GROUP.

Take the five minutes. Take the time to keep your lubrication schedule up.

"Simplify the issues. Find the root problem. It might take a little to get there but don't fix symptoms. Don't put a band aid on a band aid. Keeping the line in good working condition will

keep you from major repairs, and major downtime!" RF

Sharon Thatcher is the former managing editor of Rollforming Magazine. She is now an independent writer living in Ohio.

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From Their Perspective...

We asked suppliers and manufacturers about their take on the current construction business climate. Here's what a few of them had to say:

“Finding and retaining employees is key to success in any climate, especially now. We here at Levi's Building Components believe company culture matters, and it is proving to be a valuable part of our formula for success. We are living our core values of Integrity, Quality, Service, Collaboration, and Growth. To our employees and customers, it's known as the Levi's Experience.”

**Mike O'Hara, National Sales Manager
Levi's Building Components**

“S-5! distributor orders are up significantly over 2021. However, shipments are flat due to backlogs caused by supply chain issues and raw material availability. Our advantage is our distribution model. S-5! products are on shelves nationwide—always. Labor shortage is rarely a problem. We have a reputation in the industry for doing things The Right Way™. We are a privately held company with a comfortable working environment, and values that attract great talent and retention.”

**Rob Haddock,
Founder and CEO, S-5!**

“The construction industry appears to be holding strong despite rising interest rates. New construction starts and remodels continue to dominate the market. Overall the largest challenge many of our customers face is a tight and competitive labor market. To that end many have invested and continue to invest in additional equipment and automation process to offset labor demands.”

**Bill Griffin, President
Metal Rollforming Systems**

“The current business climate, at the moment, appears strong in this industry. Most manufacturers have a strong backlog of orders. Equipment manufacturers are anywhere between 6 months and 18 months of lead time in deliveries. From a controls standpoint, we have a strong backlog but, as many manufacturers, are having issues with getting components used in our systems. Lead times have been extended from weeks to months, which ultimately affects delivery of our product to our customers. We do our best to navigate the issues, but sometimes we have no choice but to push out our lead times also. We hope the industry sees improvement in this over the next year.”

**Jeff Fitterling,
Director of Sales & Marketing
AMS Controls Inc.**

“Supply issues have plagued the residential roofing market across the board recently – regardless of roofing type. Many MRA members have experienced some delay in material supply but are reporting these issues are typically short-lived.”

**Renee Ramey,
Executive Director
Metal Roofing Alliance**

“We've lost a lot of loyalty in our workforce; there's no 30-year worker anymore. We need to use tools and technology to help make up for the labor shortage. For example, we developed the Ridgeline Safety System, the Badger Post Hole Cleaner, and the Rapid Framing System to take the physicality out of jobs, which helps new workers coming in that have no experience be effective and productive from day one.”

**Todd Meinhold
Ridgeline Safety System**

“Demand is very good, and with supply chain issues steadily improving much easier to manage customer expectations.”

**Paul Zimmerman
Hixwood**

“The construction industry has slowed down some. However, with lumber, steel and gas prices starting to drop we are seeing it start to pick up again. Overall it is still very good!”

**Wayne Troyer
Acu-Form**

Construction Business Climate

Shield Wall Media recently closed its mid-year Construction Business Climate Survey. Despite all the doom and gloom we hear from news outlets, the results are surprisingly good.

We divided respondents into three categories: Building Contractors, Roofing Contractors, and Building Material Dealers or Manufacturers.

We believe you'll find the results of interest.

HOW DOES YOUR YEAR OVER YEAR GROSS SALES, INCLUDING BACKLOG (Q1) COMPARE TO 2021?

81% of Building Material Dealers/Manufacturers report results that are up compared to Q1 2021.

67% of respondents are up across all business types.

HOW WILL YOUR Q2 YEAR OVER YEAR GROSS SALES, INCLUDING BACKLOG, COMPARE TO 2021? (BEST GUESS)

88% of Building Material Dealers/Manufacturers estimate Q2 sales will be the same or better than 2021.

81% across all sectors report gross sales will be the same or better.

HOW DOES YOUR UNITS SOLD YEAR OVER YEAR, INCLUDING BACKLOG (Q1) COMPARE TO 2021?

75% of Dealers/Manufacturers report unit sales being the same or better than Q1 of last year.

76% are the same or better across all business types, while 24% are down slightly across all business types.

2022 GENERAL OUTLOOK

56% of Dealers/Manufacturers estimate 2022 will close better than 2021.

54% of respondents across all categories believe 2022 will be better than 2021.

WHAT CHALLENGE IS EXERTING THE GREATEST IMPACT ON YOUR BUSINESS?

#1 Challenge: Shortage of workers is the #1 challenge for Building Contractors and Dealers/Distributors/Manufacturers.

The #1 challenge for Roofing Contractors: It was a tie between material shortages and material costs.

HOW DOES YOUR OVERALL Q1 PROFITABILITY COMPARE TO 2021?

75% of Dealers and Manufacturers report profitability to be the same or better when compared to Q1 2021.

86% across all business types report profitability to be the same or better. (2021 was a record year for many!)

HOW WILL YOUR OVERALL PROFITABILITY IN Q2 COMPARE TO 2021? (BEST GUESS)

75% of Dealers/Manufacturers estimate profitability will be the same or better.

90% of respondents (across all categories) are the same or more profitable than they were in Q2 2021.

+ Comparing the numbers for Q1, Q2 and 2022 as a whole (best guess) sentiment drops slightly for Q2 and slightly more for the year as a whole.

Sentiment seems to be declining, but is still generally positive.

Stillwater Metals Builds Big in the Buckeye State

State-of-the-art shop designed with room to grow

■ Photos and Story By Sharon Thatcher

A large maroon and white metal building stands on the southwestern edge of Kenton, Ohio. It was built in 2018 by Stillwater Metals and equipped with all state-of-the-art roll forming machinery. At 35,000 square feet in size, it was built with room to grow, giving the anticipation that one day the company would expand to completely fill its big shoe-print.

Sam Hostetler, co-owner of Stillwater Metals, offers a tour of the plant floor, where the Bradbury name is prominent: a Bradbury high-speed double-high roll former, Bradbury slitter, and Bradbury double uncoiler. Added together with a Thalmann long folder, Roll Former perforator, Star-One Felt Applicator, Ameripak Shrink Wrap system, two 10-ton overhead cranes, and two tractor trailer rigs with boom lifts, this is not a cheap operation.

Kenton is a small rural community, with a population of less than 8,400 people. So, what is the secret to Stillwater's success? Sam attributes it to great service, experience, and, yes, location.

LOCATION

Although Kenton is relatively small, within 60 miles there are larger communities from which to draw additional customers: Lima, Marion, Bellefontaine, and Findlay. Their reach extends to Dayton and many mid-sized communities in between. Metal is widely popular in Ohio and is only expected to grow in the coming years.

EXPERIENCE

Sam grew up within 10 miles of the Stillwater Metals property and started working in construction for his brothers.

A relative in Michigan started roll

forming around 2005, exposing Sam and family members to the potential. "You see all these products and you have no idea of how things are made," he said. "We saw his operation and we saw what



A more recent addition to Stillwater's roll forming line is a Star-1 Felt Applicator

we could do.”

Sam’s father opened a roll-forming shop in 2007-08. With the Great Recession looming, it was a rough time to start. “That’s what everybody told us,” Sam chuckled. “It probably wasn’t the smartest, but it was actually pretty good. We went through a little bit of a slowdown, but by just word of mouth it continued to grow.”

Sam’s father was Old Order Amish so the machines he used were mechanically powered, devoid of electronics. Sam set himself down a different path when he left the church in 2012. First, he started his own construction business focused on metal roofing, then after his father sold his roll-forming shop, Sam returned to the industry he enjoyed most, opening his own metal shop in October 2018 with the help of a business partner.

Sam looked at options before deciding



The Bradbury double-high roll former is equipped with Beck Automation controls.

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A Bradbury double uncoiler keeps metal running through the double-high roll former.

on a building and the equipment. Knowing firsthand that there was a market for the products and services he offered, he opted for big and new all the way down the line, rationalizing that the service and warranties of new equipment would cancel out the extra cost.

Overall, he is happy with his decisions. "There's always some things where you say, yeh, going back, I would have done it different, but then again, we wouldn't have learned the lesson in the first place," he said.

The contrast is like night and day between the roll formers of his past and his present. While he has nothing bad to say about those early machines, of

the Bradburys he said, "It's a whole different ballgame. There is just so much adjustability, so many options to keep that panel perfect coming out. It's just a Cadillac. It's a machine that will sit here for many years doing its job," Sam said, adding: "And the customer service [from Bradbury] is just unbelievable."

SERVICE

Stillwater understands what has made the regional roll-forming industry flourish as it has: the importance of getting panel orders to its customers as fast as possible. In the past, many of the local contractors depended on lumberyard inventories for orders, which in turn

depended on a handful of national metal suppliers. Lead times could be a week or more. Stillwater cut the lead time to 24 hours in most cases.

Stillwater's primary customer is the metal contractor. "I like to work with the end user because you can control that customer service better," he said.

He also sells to a couple of lumberyards but concedes that providing a wholesale product to a lumberyard and a retail product to a contractor poses challenges. "It's a delicate, fine line to tread," he said. "It's a little bit tougher when you're trying to do a mixture of wholesale and retail. It's a fine line because you're really competing for customers."

POPULAR PROFILES

Stillwater runs two panel profiles that are most popular in his service area: a 3/4" rib on 9" center ag panel for residential and an R-panel for commercial.

He offers a board and batten panel as well, currently formed on the folder. He may purchase a dedicated machine if the popularity continues to rise as it seems it will.



A Thalmann Long Folder from Cidan is used for metal siding orders that includes a board and batten profile.

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His reliable coil providers include Progressive for smooth-finish metal and United Steel for textured-finish metal.

Popular colors remain black and white for residential, a trend he has seen for the past two or three years.

Stillwater is striving to be a one-stop shop for contractors, offering accessories and packages. Trim is a big part of business, with brother Benny filling orders. Sam relies on Graber Post for post-frame packages. Randy Chaffee of One Source Marketing is his go-to guy for ST Fastening and MWI Components. Levi's Building Components is also a valued supplier.

THE BUBBLE

There is little argument that the bubble for residential demand will one day pop, resulting in a less frenzied market. "Last year it was just crazy. You really didn't have to sell anything last year. If you had anything, it was gone. We got close to triple in sales over the year before. It was almost too fast to control," Sam said.

In addition to a strong residential market, farmers in his area had a good year, resulting in demand for ag construction,



Sam Hostetler, co-owner of Stillwater Metals pictured beside the Bradbury double-high roll former.

currently about a 50-50 mix.

He is starting to see a little bit of slow-down in residential demand, but he doesn't see much of an ill effect in the near term. "Our contractors are booked way out," he said. If those bookings aren't canceled, Sam expects to remain busy for some time to come.

Even if residential slows, there are usually other areas of construction demand waiting in the wings. Going back to when his father started his shop in the midst of the Great Recession, a strong ag market

carried them through. As well, commercial tends to pick up following a weak residential market.

"Construction gets really busy and it slows down, but it never dies; especially your better contractors, they always have work. People are always building something," he said.

Sam plans to be there to fill the orders. "I really enjoy this," he said. "Sometimes I don't know why, but I do. I've met a lot of really good people. It's not like a job if you enjoy what you're doing." RF



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STANDING SEAM

Events Calendar))

Before making travel arrangements, check with the show producer to confirm there have been no changes to event dates, venue, or show hours. To have events included here, contact Karen Knapstein, 715-513-6767, karen@shieldwallmedia.com; mail to: Shield Wall Media Events Calendar, PO Box 255, Iola, WI 54945.

AUGUST

Aug. 16-20

National Association of Women in Construction's (NAWIC) Annual Meeting and Educational Conference; www.nawic.org

SEPTEMBER

Sep. 24-26

Western Roofing Expo (WSRCA), Paris, Las Vegas, Nevada; westernroofingexpo.com

Sep. 27-29

RCAT / MRCA Roofing Conference, Fort Worth Convention Center, Fort Worth, Texas; www.roofingcontractors-texas.com

OCTOBER

Oct. 12-14

METALCON, Indiana Convention Center, Indianapolis, Indiana; www.metalcon.com

Oct. 26-27

Construction Rollforming Show, Ernest N. Morial Convention Center, New Orleans, Louisiana; www.constructionrollformingshow.com

NOVEMBER

Nov. 6-8

RoofCON Roofing & Solar Conference, Orange County Convention Center, Orlando, Florida; roofcon.com

Nov. 8-10

FABTECH, Georgia World Congress Center, Atlanta; www.fabtechexpo.com

2023

JANUARY

Jan. 18-19

Garage, Shed & Carport Builder Show, Greenville Convention Center, Greenville, South Carolina. garageshed-carportbuilder.com/show-registration/

Jan. 23-25

MCA Winter Meeting, Hyatt Regency in Clearwater Beach Resort & Spa, Clearwater, Fla.; metalconstruction.org

MARCH

March 7-9

International Roofing Expo, Kay Bailey Hutchison Convention Center, Dallas, Texas; www.theroofingexpo.com RF

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Defect Or Not?

Ability to Adjust Machines Key To Preventing Some Defects

■ By Karen Knapstein

Everyone has to deal with defects at one point or another. There are four different types of defects found in metal building components: coating defects, substrate defects, defects caused during manufacturing, and defects caused during installation. Metal formers can avoid making defective components and even lessen defects caused during installation.

DEFECTS VS. VARIANCES

As a roll former, you can't control defects in the substrate or coating; however, those defects account for only a tiny percentage of complaints received. Conrad Farley, National Sales Manager at coil distributor United Steel Supply [<https://unitedsteelsupply.com>], says they have very, very few claims about defective coil. Although a lot can go wrong in the coil production process, he estimates there are issues with a minuscule amount (less than 1/10 of 1%) of all the material they distribute. "Controls, inspections, and checkpoints maintain quality all along the way," he explains. "It's very rare for defective material to get out.

"The finished product is only as good as the substrate," he continues. "That's always the case. If the surface to be painted isn't prepared correctly before it's coated, any defects you paint over will stand out. The Galvalume itself carries a 25½-year warranty from US Steel and Steel Dynamics (SDI). And a 40-year warranty

on paint."

Although coil steel is of very high quality, width, thickness, and coatings will still vary. Cole Wolford, Coil Division, Graber Post Buildings, Inc. [www.graberpost.com], explains there can be a variance in the coil thickness and width, which may affect how well the components are formed. As long as the variances fall within the mill specs that were provided with the warranty, it's not a defect.

"A lot of guys don't realize that there's a variance until there's a problem," says Wolford. Depending on the mill, the width of the coil may vary up to 1/8". "Some mills never vary, but it can happen." The thickness of steel throughout the width of the coil can vary, as well. "That's not something that happens often, but it does. There's always going to be some variance; the question is if it's enough to show up in the panel. If the center part of the coil is slightly thicker than the edges, or vice versa, you could come up with shape issues, or maybe a wavy edge on the finished product."

There is also an allowable variance in the paint. "There's an allowable variance that's still within warranty spec. It doesn't mean the paint company missed the mark. They may have had to switch up an ingredient or pigment. The paint is still within spec, but if you take a sample from the high end and one from the low end of the spectrum and put them together, you'll see the difference."



Get the most product out of your steel coil. To prevent unnecessary waste in the production process, keep close watch and catch quality problems as they arise.

PHOTO COURTESY OF GRABER POST BUILDINGS, INC.

MANUFACTURING DEFECTS

John Moore, Production Manager with Graber Post Buildings, explains a few of the defects that can crop up during the metal forming process. For example, during the slitting process, if the guide width isn't set right, it can cause problems. "When you're running through the slit line and recoiling, you have two to three different sets of guides," he explains. "You have to allow a little bit of variance so the coil isn't rubbing the guide. If the guide is too tight to the edge of the steel, it will cause a burr on the edge." It's important to know how to set the guides and to train new, inexperienced operators to set the guides to the correct spacing.



Trained workers and operators are critical in today's market. Photo courtesy of Graber Post Buildings.



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There's not a lot that will go wrong with slitting as long the variables are set correctly. "You gotta be rewinding and decoiling at the right speed," Moore explains. "Each slitter will be a little different. But the end goal is the same: You need to get as close to your target size as you can. Use a digital caliper to be as precise as you can to make the slit width the correct size; 1/8" can make or break a trim component. If you're trying to make a trim and the coil is too narrow, you can't make a good hem on that component so you've got to reject that coil. Or if you need an exact width of fascia, 1/8" can be enough for some customers to reject your fascia trim. If we cut too narrow when we're trying to train someone or run a line, we've had to trim it down to the next size of stock coil widths for a smaller trim component to salvage the majority of that slit coil."

Moore continues: "Another big problem can occur if you're slitting coil for another manufacturer that's going to roll form it." The slitter needs to know which side will be the underlap side. You don't want to slit the side that will overlap because, over time, a rust stain will develop. It's a cosmetic issue but can be mistaken as a defect. "If we're slitting for somebody, we like to know which side is going to be the underlap side on the panel so the slit edge isn't exposed to the elements. Because from a contractor or manufacturer standpoint, it could be viewed as a coil issue, but it's not."



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On the back end of the roll forming line, close attention needs to be paid to the shear. If the shear is getting dull, it can create a burr during cutting. As it comes out of the machine, the panel goes past the stack and comes back. If you let the panel ride the stack, it will make a scratch on the panel underneath. You can keep extra shear blades on hand, but the stacker needs to closely watch what's coming off the machine. If a burr develops and you can't switch the blade right away, put two people on stacking. "You've got to get it to the jobsite without scratching the material," he says.

"The main thing is you really need to know how to adjust your machine and have operators who are paying attention," says Moore. "In today's market, trained operators and workers are what you need. If you have a bunch of turnover and new guys coming in, you'll have more issues. And those issues will show up a lot more on the roof than when it's coming off the line because the lighting is different." Something not obvious under LED lighting may be much more obvious on a roof in bright daylight.

INSTALLATION DEFECTS

Most metal defects are caused during installation. From the perspective of America's largest distributor of painted coil, Farley explains that the great majority of reported defects are caused by poor installation. "So many people take shortcuts or

are just new and learning how to put metal on correctly. Metal just doesn't get applied as well as it should be," he says.

This industry has grown so fast, there are a lot of people who are new to it. He recommends roll forming companies train the contractors they do business with; it's a great way to avoid installation mistakes. For example, presenting installation classes at an open house event, perhaps on a portable building, will discourage poor installation practices and encourage good ones. He says it's critical to teach people the right way to do things, "otherwise people are out there trying to figure it out on their own."

For example, contractors cut panels on the jobsite, which creates metal shavings that are hot. "The shavings attach themselves to that panel. If they don't brush them off, you'll start seeing rust lines. Those are the types of things that are seen as defects on the backend" but that are contractor and installation issues.

In summary, while you can't do anything about substrate and coating defects, you can minimize manufacturing flaws and lessen defects caused during installation. Even cosmetic flaws can have a negative impact on the reputation of metal as a building material. If the metal building market is to continue to grow with a sound reputation, metal roofs and buildings need to look and perform at their best. **RF**



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Educational Schedule Announced

If you roll form or use benders or brakes to form panels, channel, studding, soffits, gutters, carport or other metal construction components, the Construction Rollforming Show is a must-attend event. The educational programming and exhibitors are tailored specifically to companies that roll form or metal form for the construction industry.

The Third Annual Construction Rollforming Show will be held at the Ernest N. Morial Convention Center in New Orleans, October 26-27, 2022. The Show is 100% dedicated to construction roll forming, making it *the* place to learn about

best practices, the equipment and materials that will help make your roll forming business a success.

Unlike previous years, all of this year's show passes are all-access: educational programming and exhibit hall entry are all included with the \$50 pre-registered admission. (Admission is \$75 at the door.) Families are welcome; children under 14 are admitted free with an adult.

More show details will be included in the October/November edition of Rollforming Magazine. Visit www.constructionrollformingshow.com for updates as they develop. RF

As of March 21, 2022, New Orleans has lifted its mandate requiring proof of vaccine or negative COVID test to enter certain businesses. Individuals are not required to wear a mask or face covering with the exception of healthcare facilities and long-term care settings, as specified in Federal guidelines.

Event Venue:

Ernest N. Morial
Convention Center, 900
Convention Center Blvd.,
New Orleans, LA 70130.

Host Hotel:

Omni Riverfront Hotel,
701 Convention Center
Boulevard, New Orleans,
LA 70130. (Group Code
102422CNSTRF)

Wednesday, October 26, 2022*

8:00-8:45	Metal-to-Metal Fasteners	Underlayments
9:00-9:45	Coil Coating Basics	Benefits of Design Software
10:00-10:45	Bending Trim and Flashing	Polycarbonate Panels
11:00-11:45	Condensation Protection	Sales Process
12:00-12:45	Coil Irregularities	Ventilation and Ridge Vents
12:30	Exhibit Hall Opens	
1:00-1:45	In Demo Area: Carport Roll Forming Lines	
2:00-2:45	Sealants	Standing Seam Clamps
3:00-3:45	Using Pro Tips On as a Sales Aid	Software to Improve Quality
4:00-4:45	Fasteners Metal to Wood	Coil Gauges and Specifications
5:00	Happy Hour Starts	
5:30	Exhibit Hall Closes	
6:30	Happy Hour Ends	

Thursday, October 27, 2022*

8:30	Exhibit Hall Opens	
9:00-9:45	Snow Retention Types and Applications	Roll Former Maintenance
10:00-10:45	In Demo Area: Portable Roll Formers	
11:00-11:45	Software for Efficiency	Closing a Sale
12:00-12:45	Shearing Contest	
1:30	Exhibit Hall Closes	

*Educational schedule subject to change



#2 "CRS is a nice change of pace when it comes to the metal convention. It's exciting to be at a show where a large percentage of the attendees are involved in or looking to get involved with rollforming specifically."

- Zach Beck,
Beck Automation

#4 "I have attended every Rollforming Show to date and will continue."

Anyone involved in metal buildings is or should be there, and the attendees have always been the exact customers I am looking to connect with."

- Buddy Pullen,
Onduline North America

#1 "The Construction Rollforming Show is designed for roll formers. Not small contractors. If you need to learn about metal forming or speak directly with manufacturers who sell in pallet, container or truck load lots, this show is for you."

- Gary Reichert, Shield Wall Media

#3 "We've attended since the first show in 2019 and make plans to do so each year. Truly a valuable event!"

- Keith Deitzen,
Smart Build Systems

#5 "Metal roofing continues to grow stronger as an industry and the CONSTRUCTION ROLLFORMING SHOW helps you stay up to date on the latest innovations and new products."

- Dave Quehl,
Direct Metals Inc.



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FUN ACTIVITIES

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<https://audubonnatureinstitute.org/aquarium>
504-212-5157

One of the top aquariums in America, this state-of-the-art facility is home to 15,000 sea life creatures. The Caribbean Reef Tunnel allows views usually reserved for sea divers. Enjoy the Sea Horse Gallery, white alligators, and touch baby sharks.

Audubon Zoo

6500 Magazine Street
New Orleans

<https://audubonnature-institute.org/zoo>



This zoo is one of the top-ranked in the country, featuring naturalized habitats such as the Jaguar Jungle and the Louisiana Swamp. Take in the daily animal shows, endangered whooping cranes, Amur leopards, and orangutans, white alligators, and much more.

Getting Around: Streetcars

The streetcars are a fun, charming, and economical way to get around and see the town. Four distinct streetcar lines, each originating Downtown, will take you through the French Quarter and beyond to places you might not otherwise get to see. Streetcar fare is \$1.25 (each way) and must be paid with exact change when you board. One-day unlimited "Jazzy Passes" are available for \$3; three-day unlimited ride "Jazzy Passes" are available for \$9.

Storyland in City Park

5 Victory Avenue

<https://neworleanscitypark.com/>
504-483-9402

Life-size sculptures of kids' fairy tale favorites include Old Mother Hubbard in her shoe, Cinderella's pumpkin carriage, and Captain Hook's pirate ship. A playground kids can climb on adds to the fun.

The Botanical Garden in City Park

1 Palm Drive,
New Orleans

<https://neworleanscitypark.com/>
504-483-9402

October is a magical time in the Botanical Garden as the butterfly populations have peaked and you should see a lot of butterflies feeding in the butterfly garden.

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411 Bourbon Street
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www.mambosnola.com
504-407-3717



From Po'Boys to Gumbos, Mambo's has the authentic Cajun and Creole dishes you don't want to miss out on. Children will be happy with the kid's menu complete with chicken strips, burgers, and french fries.

The Milk Bar

710 S. Carrollton Avenue
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www.themilkbarneworleans.com/
504-309-3310

Gourmet Po'Boys and salads, fresh to order and fast! For the kids, order cheese, ham and cheese, or turkey and cheese croissants. Old fashioned milk shakes and malts, smoothies, fresh lemonade, and coffees complete the menu.

Barracuda

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The Camellia Grill

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www.nationalww2museum.org
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Bradbury Group A Global Leader

Roll-forming equipment manufacturer showcases diverse offerings

■ By Anthony Brass

The Bradbury Group wasn't always a "group." The company started out as a custom roll-forming business in 1959 in Kansas. Floyd Bradbury and Jack Lacy manufactured awnings and other products, and roller die tooling for customers. They had humble beginnings, setting up shop in an egg room of a creamery. Early on, the company catered to the aviation industry, roll-forming parts for aircraft in Wichita, in addition to the Ag and transportation industries. One of the more notable orders in Bradbury history was supplying roll formed curved rings for the Saturn V rocket.

They designed more roll tooling and machines on their own, and opened up additional lines of industries, including metal buildings, which was crucial to their growth, says Senior Manager of Sales and Marketing, Matt Werner.

"That [metal buildings] is our largest industry every year," says Werner, who has 18 years under his belt with Bradbury. Werner came on board in sales. He was in another industry, but Moundridge is a small town, and he heard from others the company was looking for help.

Today, Floyd's son David is involved in the decision making along with his son-in-law, David Cox, who is CEO. They are all close-knit, and always think big in expanding the company.

The family business is a leading global roll-forming and coil processing equipment manufacturer. They are innovative, holding over 28 active US patents and 60 international patents for equipment. They produce machines for metal buildings, garage doors, HVAC, grain storage, steel framing, transportation,



Bradbury in 1960s, running their purlin roll former.
PHOTO COURTESY OF THE BRADBURY GROUP.

automotive and more. The Group has equipment running in 89 countries. They continue as stalwart leaders in original equipment manufacturing of metal forming, parts production, coil processing, and polyurethane equipment along with automation and shop floor integration software.

GARAGE GROUP

Over 20 years ago, the company built its first fully automated garage door roll-forming line. Some components of that line were supplied by other manufacturers. Werner says over the years, through expansion and acquisitions, The Group was able to become a single-source provider of complex roll-forming lines. Currently, The Bradbury Group of companies can supply a turn-key solution for customers needing custom-built production lines. Embossers for garage door lines are now supplied by Alliance Machine and Engraving, a member of the Group. They're perfect partners to join the company with their metal, plastic, and film embossing machines for products like composite decking and siding. The addition of Bradbury Group Pu.Ma. gives them the ability to manufacture continuous, foam-filled panel production lines for the garage door industry and numerous others.

When the demand for advanced controls and automation increased, Bradbury formed Beck Automation to bring the most up-to-date controls to the industry, Werner says.



The Bradbury B.O.S.S. panel line. PHOTO COURTESY OF THE BRADBURY GROUP.



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These and subsequent moves echo the company's vision of earning the title as, "the most trusted and preferred supplier in the global markets" they serve. Their growth is truly international and expands their base.

TRAINING DAY

The dynamic lineup of productivity-enhancing roll-forming equipment is designed to cover many applications. This makes for a diverse customer base ready to do business with the Group. They generate sales through word of mouth and reputation. Many potential clients come to their Moundridge headquarters to collaborate with the Bradbury engineers and roll-forming experts and observe the machines in action. "In the end we will configure a line that fits their production needs," Werner says. "Once a machine is designed and assembled, we will operate the entire production line at Bradbury to ensure it meets the customer's expectations." Their clients are encouraged to come in for both training and the buy-off process of that line.

"For a new piece of equipment, that time frame will vary based on the complexity of the machine from a few days to a few weeks," Werner adds once the line is approved and bought-off, they disassemble and ship the equipment to the client's facility. Installation and startup of the line is performed by Bradbury's team of Field Service Technicians followed by operator training.

One of Bradbury's most popular offerings includes their state-of-the-art, high-speed, closed-loop flying B.O.S.S.™ shear line for feeding panel roll formers. These are much sought-after with their ability to increase productivity of a new or existing roll-forming line. Their Cee and Zee purlin roll forming lines are also in high demand, driven by a strong building market and the need for highly productive lines that can be operated by a minimal number of operators.

AUTOMATION NATION

"Labor shortages in our customers' industries are driving the integration of robotics and higher levels of automation," Werner says. "It [automation] fits right into the equipment that we build."

The company has delivered lines with integrated robots that can feed product to the rollformers and stack finished parts at the exit of the line, reducing the number of needed operators.

Bradbury rolls on as a leader in pro-



Hayes Dual-Level, Post-Cut panel line. PHOTO COURTESY OF THE BRADBURY GROUP.

viding innovative equipment and opportunities to clients. They grow with partners and help businesses large and small with their equipment solutions. The Bradbury Group is not unlike their machines they build — strong and consistent with results to grow. They've come a long way since running those purlin roll formers in that egg room in Moundridge. **RF**

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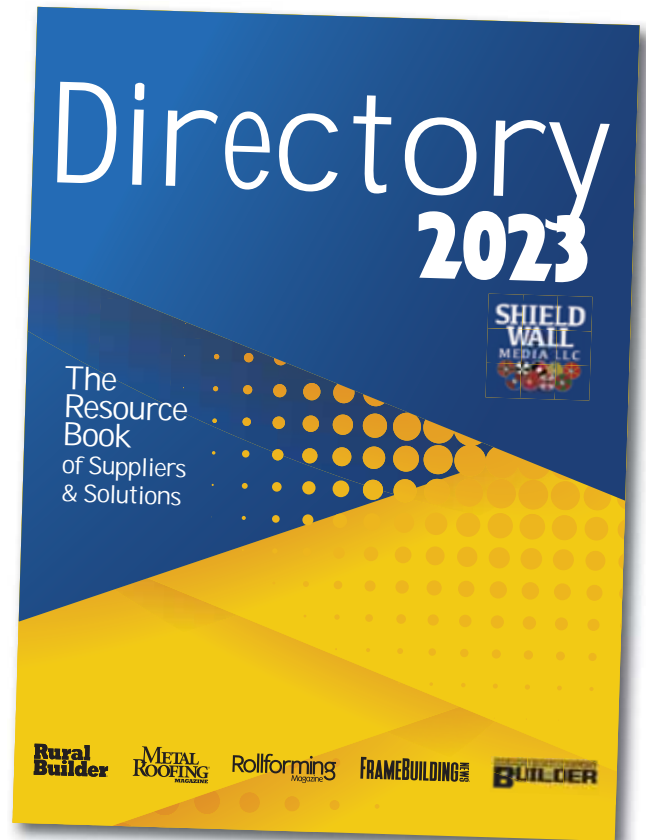


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Sealants and Metal Roofing

Solutions to Adhesive Challenges

■ By Anthony Brass

Metal panels with hidden fastener systems don't require sealants directly underneath. However, sealants for other parts of a metal roof, including hips, rakes, ridges, skylights, boots over vents or other protrusions with exposed fasteners, is necessary to form a barrier against moisture and to seal surfaces. You use the versatile and durable butyl tape as a sealant, as well as caulks. Challenges differ between sealant types.

UNDER THE ELEMENTS

Most builders we spoke to mentioned caulk sealants drying or cracking some time after application. These are inexpensive options and water-based or highly plasticized. Over time, temperatures generated on a metal roof and UV rays affect the composition and structure of these types of sealants and they dry out, shrink, become brittle and crack. When applying sealants to areas on the metal roof, you want a product with long-lasting properties.

Manufacturers recommend using a curing elastomeric product. These superior caulks accept moisture from the air, or are mixed with a curing agent, which causes it to solidify into a stretchy solid. These have a wider range of flexibility that lasts for years.

Use sealants with solvent-based materials that cure by evaporation. Solvent-based products are very forgiving in weather. Apply sealants that are a hybrid: a combo of polyurethane and silicone. Quality caulk doesn't crack. But, if too little sealant is applied to the joint, and the adhesion characteristics are strong, the sealant will stick to the sides and crack down the middle. If the sealant is pulling away from the sides of the substrate, the characteristics of the adhesive bond are less potent than the cohesive properties.

Latex sealants are less expensive but crack. These are found in retail stores and aren't effective for metal roofs. Instead, use

a high-grade, modified silicone caulk. These provide elongation properties and are clear.

When working in very hot conditions, sealants can run out of the tube or fall on areas outside of your target. This causes a mess on a roof or workspace that's difficult to clean up. Thicker sealants aren't always better. Use a caulk that stays "in solution," even in higher temperatures. These formulas are developed and based on rheology tests that study the deformation and flow of fluids in different conditions. You'll have to dig a little to find specific results on your sealant.

You want a clean release of the sealant from the gun end to the metal. Use a caulk gun where the plunger doesn't push out, but pulls back when triggered. These allow a cleaner, balanced flow. Don't store sealants outside in hot conditions when not use. Storage location of product is important. It's not advised to leave these in the back of a hot truck or out in humid conditions overnight. All sealants "gun" differently; this varies according to temperatures.

Some sealants become hard and are difficult to extrude in cold winter months, even moments after released from a tube. Use caulk that stays softer for longer periods after it's applied, in any season. These stay softer right out of the tube for easier application in frigid conditions. Use sealants in plastic, not paper tubes, and those formulated for cold weather.



ADHESION, DISCOLORATION, & DIRT

The long-term adhesion of caulk to metal is another pain point. The adherence to metal is slowly lost over time, which leads to leaks. Use sealants with advanced polymers. Products with these in their formulas provide consistent adhesion to metal. Choose caulk with the properties of both a silicone and urethane product. These possess the elasticity and stability of a liquid adhesive, as well as high water resistance and strong adherence to metal as urethane. Always apply sealants to a clean, dry surface.

Polyether-based sealants provide effective adhesion to metals. These are formulated with polymers that allow adherence to many surfaces.

There are different sealant classes for determining how much movement the caulk will take. Many are “Class 35,” designed for moving up 35% of the joint width in each direction. Use a Class 50 sealant in metal applications.

White-colored caulk suffers discoloration and may yellow. These use impure raw materials. Find sealants with pure materials to prevent color change. Polyurethanes promote discoloration in sealants; don’t use these types. Instead, use products with UV inhibitors to prevent discoloration. Manufacturers are developing both clear and colored sealants to match any

color metal, with properties to prevent loss or change in color.

Some sealants remain tacky, even well after drying. These collect dirt and dust easily. Use a caulk that loses its tackiness after drying, 24-48 hours later. A sealant needs to optimize its cure cycle to prevent dirt accumulation. Use products with faster setting times.

COPPER AND OTHER METALS

Certain metals like copper don’t work well with caulk. When copper is milled an oil residue is produced. This residue doesn’t allow products to bond effectively with the metal. In addition, patina grows under copper. When caulk is used with copper, this grows under the sealant, too, and the application and copper become separated. Use a neutral-cure silicone sealant, as this maintains its adhesiveness to copper longer.

Another challenge is sealants pulling away from galvanized metal. Though rarely practiced, some find it’s sometimes necessary to prevent separation using abrading, etching into the metal surface to get a mechanical purchase of the sealant to the product. If this is done it takes away the protective paint coating and galvanizing properties from the metal.

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Some sealants are specifically made to work better with certain pre-applied panel coatings. Manufacturers produce sealants specifically made for panels coated with Kynar, a superior coating that lessens the effects of UV. Know what your panels are coated with ahead of time and which products are best for adhering to that metal's paint system.

BUTYL TAPE

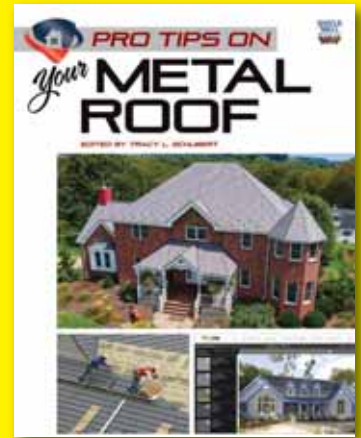
Butyl tape possesses superior adhesive strength, is easy to apply, and is very effective when sliding two pieces of metal together, lapping them over each other (overlaps) and non-exposed joints, and for protecting and sealing seams and vents. Many prefer butyl tape because it is a solid rubberized material that adheres to many surfaces, doesn't dry out, retains its tackiness and

provides years of protection against the elements. This component is popular on commercial buildings or systems with mechanical seams.

Butyl tape isn't ideal as a sealant when sliding a boot over plumbing ventilation or other similar type of roof protrusion. In this scenario, use caulk, as it provides a tighter fit for the inside wall of the boot that stays right up against the object. Plus, caulk isn't exposed to the sun so it keeps its adhesiveness.

CONCLUSION

Make note of the positives and negatives of sealants. All sealants are important in a metal roof component list. Each product provides versatility and different ways of protecting and sealing parts of a roof for years to come. RF



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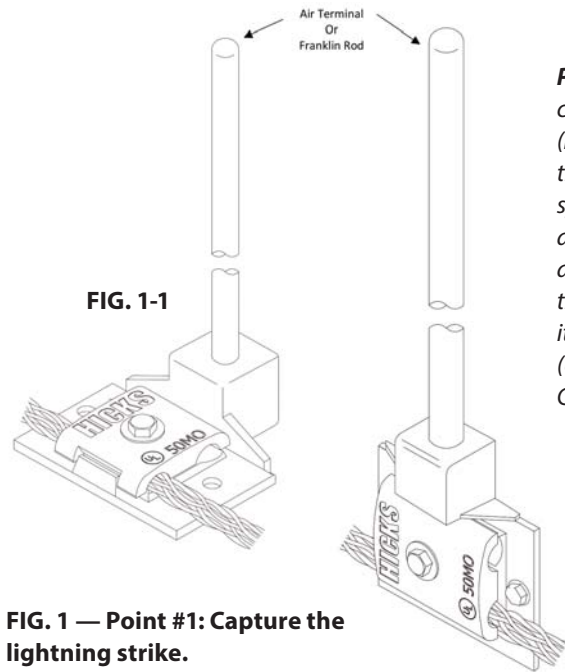
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Lightning Protection

Protect Your Facility From Incoming Surges/Currents

■ By Chuck Cooley, Hicks Lightning Protection; Ponder, Texas



Point #1 – Capture the lightning strike: This is done by having a conventional (Franklin) lightning rod system installed on the building (Fig 1). We want to make sure that the lightning protection system is the preferred point of contact in the event of a lightning strike. This system is to be installed to the national standards of NFPA 780, UL96A, and LPI175. It is also important to note, this system is to be installed by a certified lightning protection contractor, who is a member of UL and the Lightning Protection Institute. After the installation is completed, it is highly recommended the system be inspected by a third party (UL or LPI) and given a UL Master Label or an LPI Master Installation Certificate.

FIG. 1 — Point #1: Capture the lightning strike.

As technology advances and facilities have more and more sensitive electronic equipment, the potential increases dramatically, with the possibility that a structure and/or its electronic equipment will be damaged from an induced surge. There are a few ways a facility can be affected by an induced surge/current i.e. lightning strike. These surges can wreak havoc on electrical components and other electronic devices. The first of these induced surges or currents would be from a direct lightning strike. A typical lightning strike is approximately 30kA and 300 million volts¹. The second way a facility may see an induced surge would be from the transmission lines. These transmission lines would be struck by lightning and the induced current would travel along those lines and potentially travel into the facility, damaging electronic equipment. The third would be from a remote lightning strike, whereas the surge would travel through the Earth, and if there are any underground cables or utility services, the surge/current could travel back into the facility, again damaging electronic equipment and machinery.

The next portion of this article will focus on the various points or areas one needs to apply to help protect their structure and internal electronics from being damage from any stray induced currents.

Point #2 – Safely convey the energy to ground: We want to ensure the energy is given a safe and controlled path to ground. This is done by either using building steel as the control path or multiple downloads of lightning protection conductor (Fig 2). This lightning protection conductor is different than your normal concentric 1/0 AWG or 3/0 AWG. This conductor is wound in a smoothweave or ropelay configuration and has more strands that your conventional concentric cable. With lightning being of high frequency, the energy moves along the surface of each strand and not through the cable. This is called 'skin effect.' The more surface area you have, the less impedance there is for the energy to travel.

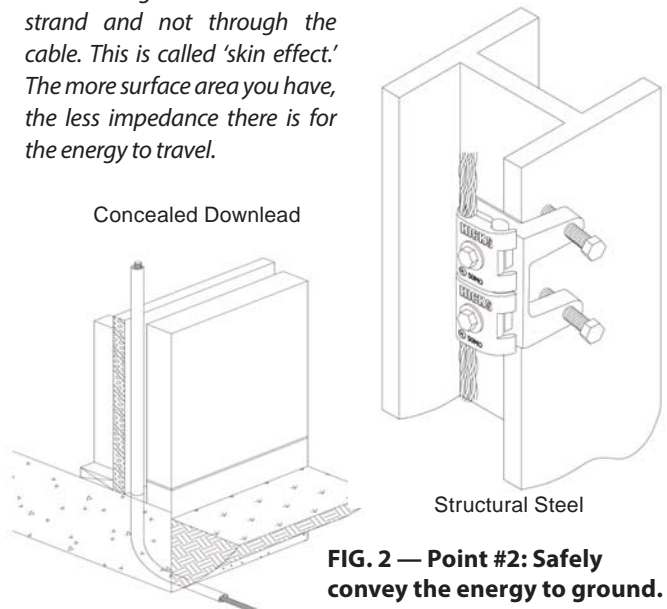


FIG. 2 — Point #2: Safely convey the energy to ground.

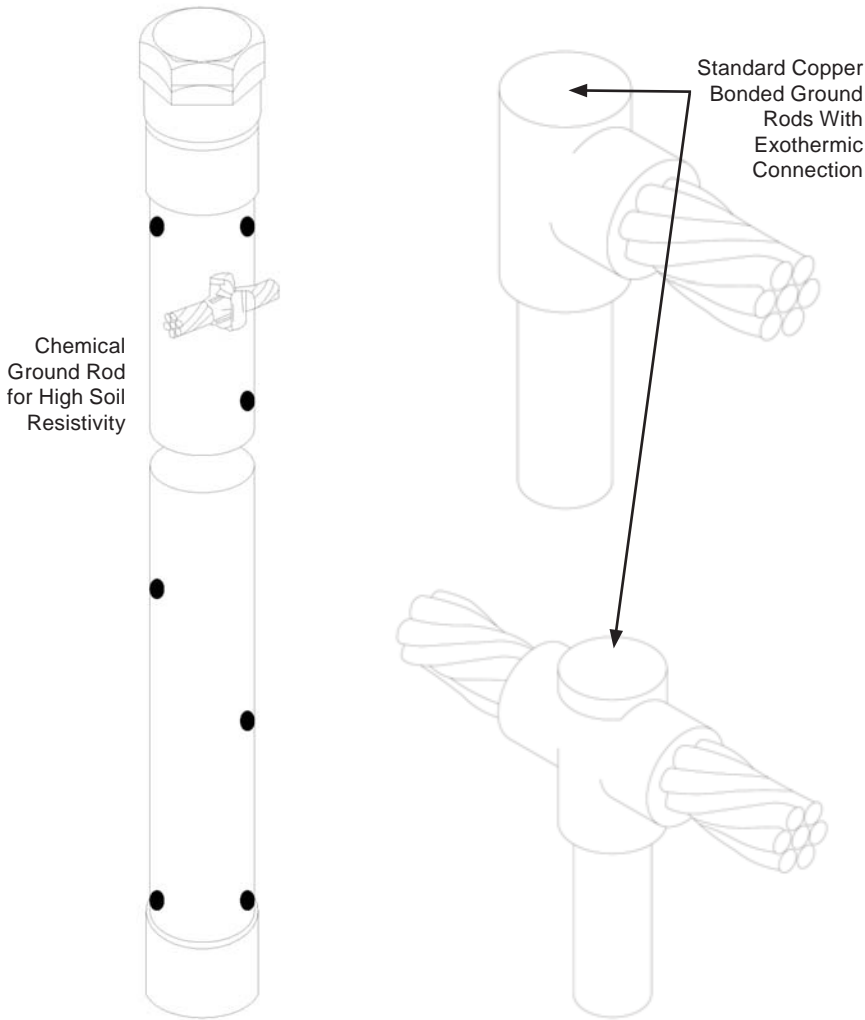


FIG. 3 — Point #3: Dissipate energy into grounding system

Point #3 – Dissipate the energy into a grounding system: We've already captured the lightning strike and we established a controlled path to ground, so where does it go? We need to have a low resistance grounding system. This can be done by using a counterpoise/ground loop. This would consist of bare or tinned concentric cable. Multiple ground rods would be connected to the ground loop as it help "inject" the surge into the ground and also

help with the overall grounding system resistance. If the ground loop and ground rods don't provide a low or an adequate resistance to ground, then the addition of ground enhancement material can be utilized. This ground enhancement material does exactly that; it helps lower the ground system resistance. If there are areas around the building where a ground rod cannot be driven, due to rocky and shallow soil, then the use of ground plates can be used (Fig. 3). It's recommended a ground system resistance of 25 ohms or less be obtained, unless the engineer on the project specifically indicates the required ohm reading.

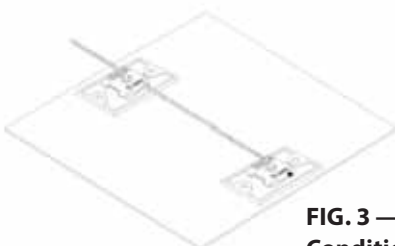
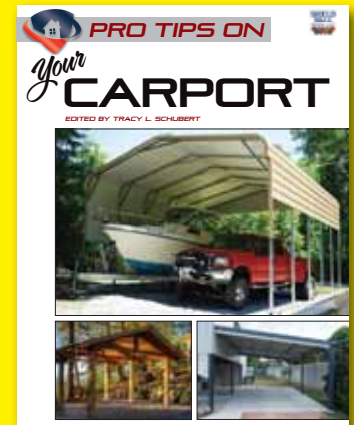


FIG. 3 — Ground Plate for Shallow Soil Conditions



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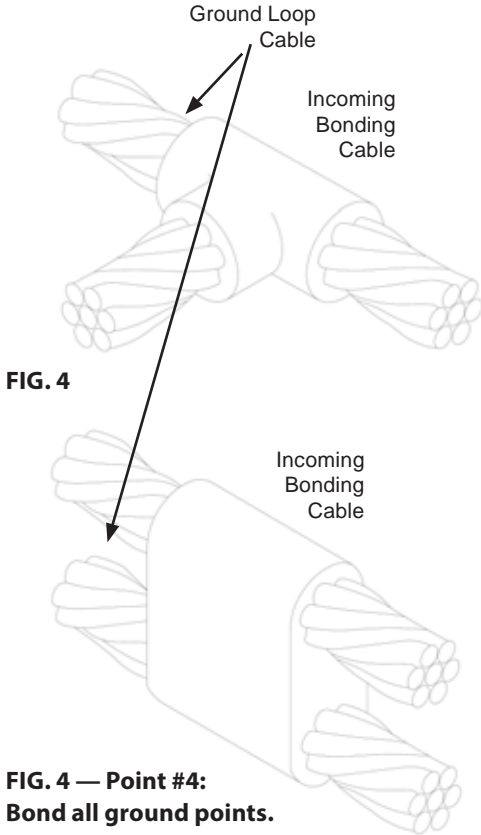
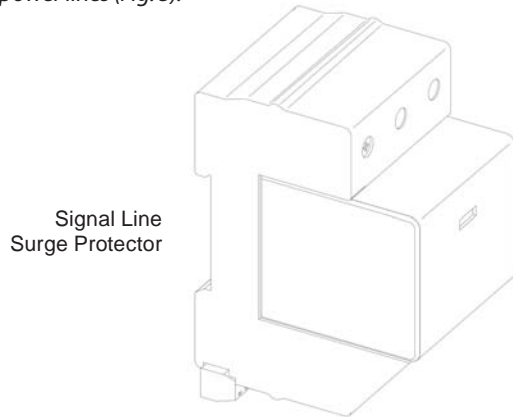


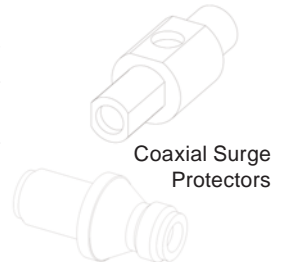
FIG. 4 — Point #4:
Bond all ground points.

Point #4 – Bond all ground points together: To ensure we have a single grounding plane, and to avoid any differences in touch or step potential, we want to make sure that any other grounding systems that are near our structure are bonded to our structure's grounding system. Equipotential bonding helps ensure that hazardous potential differences do not occur between different incoming systems such as water lines, power and telecommunication systems and the local ground (Fig 4).

Point #5 – Protect incoming AC power feeders: By protecting the incoming power panel(s), this helps prevent equipment damage and costly production down time, from transients coming in from the power lines (Fig. 5).



Point #6 – Protect low voltage data and communication circuits. This helps prevent damage to any incoming telecommunication and signal lines which can result in equipment damage and costly downtime (Fig. 6).



**FIG. 5 & 6 — Point #5 & #6: Protect AC power feeder
and low voltage and communication circuits**

By incorporating these six points, the chances of any stray induced currents will be greatly reduced. Proper grounding and bonding is the backbone of any electrical protection system and having a low resistance grounding system is key. These steps are not only beneficial for the structure and its electrical components, but it's also beneficial for personnel safety.

To learn more about facility lightning protection and safety, or to find a lightning protection contractor in your area, contact the Lightning Protection Institute or visit www.lightning.org. [RF](#)

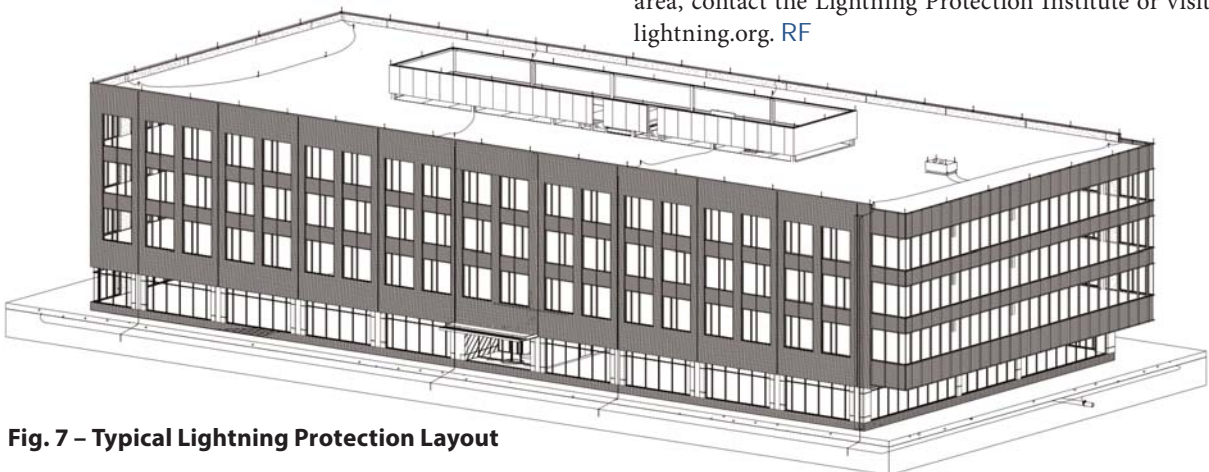


Fig. 7 – Typical Lightning Protection Layout

ISOLATE ROLL FORMER CONTROLS TO PREVENT DAMAGE



"Over the contiguous 48 states, an average of 20,000,000 cloud-to-ground flashes have been detected every year since the lightning detection network (NLDN) covered all of the continental US in 1989. In addition, about half of all flashes have more than one ground strike point, so at least 30 million points on the ground are struck on the average each year in the US."

— NOAA National Severe Storms Laboratory

■ By Karen Knapstein

According to the NOAA National Severe Storms Laboratory, a single lightning bolt can have 100 million to 1 billion volts, and contains billions of watts. As you can imagine, that much voltage will damage electronics and circuitry on its way to ground. Isolating the controls may prevent damage.

Jeff Burger, AMS Controls [www.amscontrols.com], said to protect controls from electrical interference, they eliminate electrical noise and use separate power supplies for the CPU and I/O power. The company uses optical isolation to eliminate electrical noise, which is an electrical magnetic force (EMF) that is generated by relays, contacts, motors, drives, and other electrical equipment. EMF interferes with low voltage signals.

"Any wire that's attached to our controller gets converted to a light signal and gets converted back to an electrical signal because electrical noise doesn't travel through light," he explains. "If

you get enough electrical noise, it will generate voltage."

A properly grounded system will send that voltage to the ground. However, to prevent damage from the high voltage caused by a lightning strike, he recommends using a separate DC power supply for the CPUs in a control system.

Burger also points out that roll forming shops can have a large footprint and that, for maximum effectiveness, each machine should be tied into the same grounding system as the building. For instance, if a new machine is put in and an attempt made at grounding with a rod through the floor, that piece of equipment may not be grounded. Dry soil is an insulator; if the soil beneath the building has not seen water for some time, the electricity won't be transferred to the ground and the lightning will cause more damage than if the machine were properly grounded. "The machine has to share the same ground as the building. Otherwise, the lightning will just blast the control. When lightning hits – something will get burnt. We're trying to minimize the damage." RF

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Closure Strips: Simple Products Prevent Big Problems

■ By Karen Knapstein

If you roll form corrugated panels, you may wish to consider offering closure strips. They are a simple — but critical — component used for closing the gaps in a metal roof system.

As you know, corrugations in metal panels give the material its strength and rigidity. The downside of the corrugations is there are gaps at the eaves and the ridge when panels are installed. If these gaps aren't closed, they will allow pests, dirt, debris, rain and snow to find their way into the interior of the building. To close the gaps, it's standard practice to install closure strips during the initial roof installation. Here's a brief and simple rundown of what they are.

Closure strips are a very simple product that prevent major problems from developing in post-frame and metal buildings. They are profiled strips made of foam. Each strip, which is usually 1"-2" wide, has a profile that fits a specific panel profile. (Strips that fit standing seam are also available.) They are manufactured with or without pre-applied adhesive. Universal closures are flat strips of open-cell polyurethane foam are made to work with any profile. The foam compresses and expands as necessary to fill the gaps.

Inside closure strips are installed under the eaves to seal the inside of the panel profile. Outside closure strips are installed at the ridge between the outside of the panel and the ridge cap.

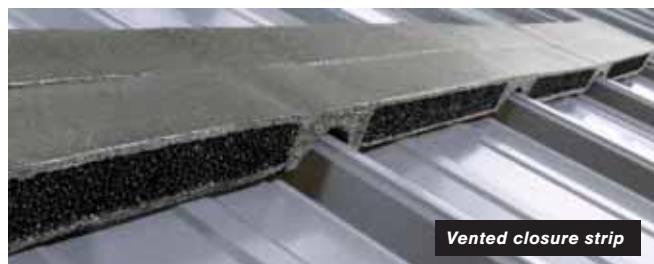
Closure strips come in both open cell and closed-cell configurations. Open cell strips allow air to pass through while keeping out dirt, debris, pests, and precipitation. Closed-cell strips, which are made of a much denser material, effectively seal the openings, allowing nothing to pass through.

The type of building is a determining factor for whether closure strips are needed, and whether open- or closed-cell closure strips should be used; maintaining the functionality of the building is critical. If the building is an open-air building, such as an agricultural shelter, closure strips are not necessary. Enclosed buildings are another story.

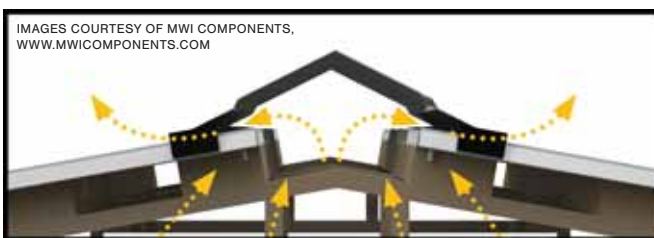
Adequate roof ventilation is critical for the longevity of metal roofs. So, when ventilation is needed, open-cell closure strips are used. Outside open-cell strips are frequently installed at the ridge where hot air accumulates. Hot, moisture-laden air is allowed to escape through the open cells of the foam, but the cell structure doesn't allow dirt, debris, or precipitation to enter.

Open-celled closure strips at the eaves close the gap to prevent wind-driven rain, varmints, and pests from entering, yet they allow fresh air to enter as part of a natural ventilation system. If a building is heated, it will need ventilation.

Traditional closure strips are made 3' long to fit the width of the panel; they're beveled at the ends to fit together. However, rolls of closure strips, which can measure anywhere



MWI Ultra-X vented closure strips' rib profiles form fit to eliminate leak paths at the ridge and wind driven rain issues... Image indicates positioning prior to final glue strip adhesion.



Adequate roof ventilation and uniform airflow are critical for the proper maintenance and longevity of metal roofs.

from 10' to 50' long, are also available. The 50'-long rolls can be a bit unwieldy; it can be difficult to lay it out in a straight line on a windy day.

Closure strips with pre-applied adhesive are easier to install; the adhesive holds the foam in place while the panels or ridge cap are being installed. Most roofers opt for closures with pre-applied adhesive.

Foam degrades quickly when exposed to the weather and UV. Quite often, closures will be placed far enough under the panel that they aren't exposed to direct sunlight. They can also shrink over time and lose their effectiveness; if strips have a good density, they will last as long as possible. Some are made with UV stabilizers and fire retardant additives. Be sure to read the product specs closely to learn about expected life spans.

Closure strips are a necessity for closing a metal building envelope. While there are hundreds of metal panel profiles available, you may wish to consider having on hand universal closure strips or closure strips for the profiles you manufacture. It's a product that builders and roofers need; if you can supply them with it, it will save your customers a trip and drop a little extra money to your bottom line. **RF**

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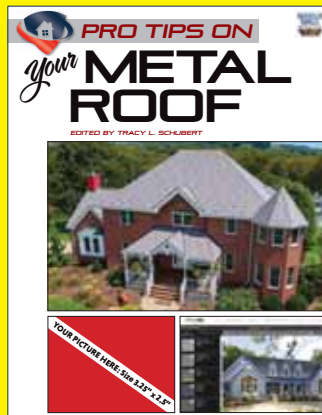
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