

APRIL/MAY 2024
Vol. 7, No. 2

Rollforming Magazine

EXCLUSIVE CONTENT FOR ROLLFORMING PROFESSIONALS

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**TEAM RUBICON:
DRIVEN
TO SERVE**

**CARBON
& STEEL
WHY IT
MATTERS**

**ROLL FORMER
CLEANING & PREVENTIVE
MAINTENANCE**

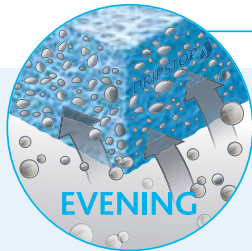
**ROLL TOOLING
& DIE DESIGN**

**DON'T MISS THE
POST-FRAME
BUILDER'S SHOW**





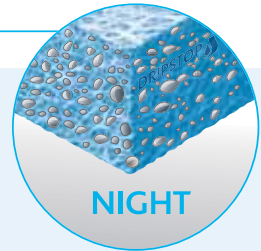
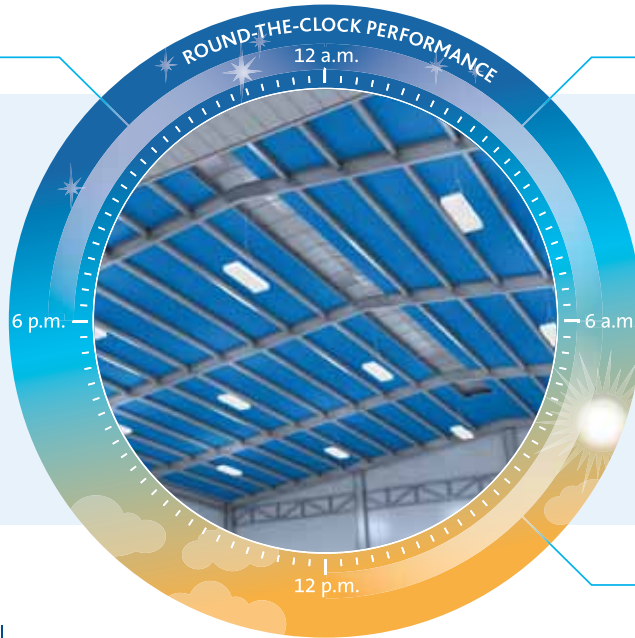
CONDENSATION CONTROL WHICH INCREASES PROFITS NOT LABOR COSTS



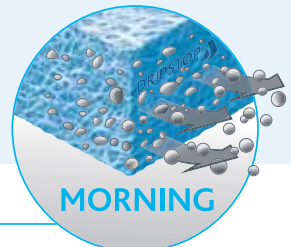
Wet air rises up to the cold metal roof with Dripstop®



Effective condensation control requires good building ventilation



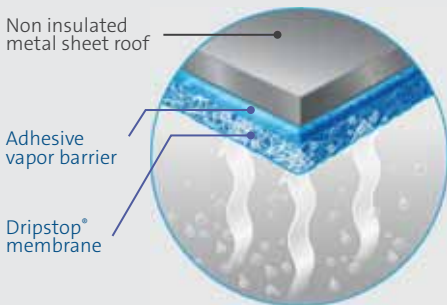
Moisture is trapped in the air pockets of the membrane



Water evaporates and is vented out through the roof

A Necessity for Any Metal Roofed Building That is Not Climate Controlled.

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Take Care Of What You Have

■ By Karen Knapstein

If you've ever chatted up the roll forming manufacturer reps at the Construction Rollforming Show or other trade shows, you know they really know their stuff. This edition's cover story addresses a very important topic: Caring for your roll forming equipment.

Your metal-forming equipment is probably one of the largest capital investments you will make, so it stands to reason that taking care of it will help you maximize that investment. We sourced information from three different manufacturers for this hearty feature:

Metal Rollforming Systems, Acu-Form Equipment, and The Bradbury Company. The feature begins on page 18.

Did you know that as of January 1 of this year, many companies in the U.S. are required to report information about their beneficial owners (the individuals who ultimately own or control the company) to the Financial Crimes Enforcement Network, a bureau of the U.S. Department of the Treasury? If you are not aware of BOI reporting, you won't want to miss the rundown from CliftonLarsonAllen that begins on page 14. It's a short article (just 2 pages), and

well worth the investment of your time. To wrap up, I'd like to invite you to the Post-Frame Builder's Show in June. If you've been to any of Shield Wall Media's shows, you know that we treat exhibitors and attendees with equal care. We're always glad to see you and learn about what's going on in your neck of the woods and hear your opinions about what we should be covering in our magazines.

Until next time — be well.



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Contents))



18

- 8:** Carbon & Steel
Why carbon matters
- 12:** Can't Miss Show
Post-Frame Builder Show
- 14:** BOI Reporting
Does the new federal reporting requirement affect you?
- 18:** Clean & Maintain
to maximize your equipment investment
- 26:** Business Profile
Star-1 Products
- 28:** Material Handling
Choose equipment that moves material efficiently
- 33:** Roll Former Tooling
Considerations for metal forming
- 36:** Meet Team Rubicon
Volunteer organization is driven to serve
- 41:** The Way We Roll
Meet Legacy Metals
- 51:** Construction Survey Insights

Departments))

- 3 Editor's Note
- 6 Steel Market Update
- 27 Events Calendar
- 42 Business Connections
- 45 News
- 49 New Products
- 50 Products & Services



On The Cover:

There are multiple locations where it is important to maintain the lubrication levels on your roll

former. PHOTO COURTESY OF THE BRADBURY GROUP

INDEX OF ADVERTISERS

Company	Page #
AceClamp	39
Acu-Form	20, 44
Anthem Built	42
ASC Machine Tools Inc	23, 44
Aztec Washer Company	44
Beck Automation	45
Bradbury Group	25
Comblift	29
Direct Metals Inc	20, 42
Drexel Metals	11
Dripstop®	IFC
Dynamic Fastener	BC
Englert Inc	13
Everlast Metals	43
Golden Rule Fasteners	42
Hixwood	39
I Beam Sliding Doors	43
Kevmar Manufacturing	43
Levi's Building Components	3
Little Harveys	7
Marion Manufacturing	42
Metal Rollforming Systems	21
Mid South Aluminum	17
New Tech Machinery	35
Perma-Column LLC	44
Pine Hill Trailers	42
Planet Saver Industries / GreenPost	43
Red Dot Products, LLC	43
RetroFitClip	43
rFOIL Reflective Insulation	37, 42
Roll Former LLC	45
Samco Machinery	43
SmartBuild Systems	47
Snap Z	37
Snow Stoppers LLC	42
Star 1 Products	27
SteelGrip SAMM, Inc	43
SWI Machinery	19
United Steel Supply	9, 42

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Gary Reichert,
Publisher, Shield Wall Media

Rollforming Magazine

Managing Editor:

Karen Knapstein
karen@shieldwallmedia.com
715-513-6767

Editorial Staff:

Dan Brownell, Linda Schmid

Circulation/Subscriptions:

Barb Prill
barb@shieldwallmedia.com
920-471-4846

Publisher/CEO:

Gary Reichert
gary@shieldwallmedia.com
715-252-6360

Director of Events:

Missy Beyer
missy@shieldwallmedia.com
920-216-3007

Executive/Advertising Assistant:

Kathy Budsberg
kathy@shieldwallmedia.com

Advertising/Show Assistant:

Cari Ullom
cari@shieldwallmedia.com

Graphic Designers:

Tom Nelsen, Kevin Ulrich

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Next Issue: • Metal Under Stress
• Structural Roll Forming



Steel Market Update

■ Courtesy of Majestic Steel USA

Each week, Majestic Steel USA [majesticsteel.com], a steel service center that distributes prime, flat-rolled galvanized steel sheets and coils to industries across the United States, compiles the Core Report. The Report is “an in-depth look at key indicators and trends driving the steel market. Market volatility demands your attention about what’s driving prices, when and why.”

Majestic Steel has granted Rollforming Magazine permission to publish information excerpted from the Report for its readers. The information included here is from the Core Report for the week ending March 1, 2024.

DOMESTIC STEEL PRODUCTION

According to the American Iron & Steel Institute, Weekly Domestic Steel Production report dated February 27, 2024, domestic raw steel production increased for the fourth consecutive week.

U.S. mills produced an estimated 1,727k tons at a 77.8% utilization rate; this is up from 1,721k tons and a 77.5% rate previously.

This is the highest weekly tonnage output since the last week of September.

Production increased in three of the five regions with the largest tonnage increase coming from the Northeast region. Production from the Northeast

region rose from 127k tons to 132k tons.

Year-to-date production is now up 4% compared to the same timeframe from last year.

SPOT IRON ORE

The Platts, Spot Iron Ore report ending March 1, 2024, indicates a slight decrease, “slipping for the fourth time in the last five weeks.” Spot iron ore pricing ended the week at \$124.75/mt, down from \$125.75/mt the week before.

It’s the lowest price since late October.

The report also says, “The Chinese market has seen lackluster steel demand and a decline in blast furnace operating rates throughout the Lunar New Year break, reducing iron ore demand and prices.”

CARBON STEEL IMPORTS

According to the U.S. Census Bureau, Carbon Steel Imports report for January 2024: Total carbon steel imports totaled 1.919 million tons in January, which is up 22.7% from December and up 2.8% from January 2023.

The total finished steel imports (excluding semi/slab) totaled 1.482 million tons, down 2.4% from January 2023.

Carbon flat rolled imports increased sharply: Carbon flat rolled imports totaled 602,255 tons, up 26.7% from

December and up 23.3% from January 2023. All three flat rolled products saw increases from December, with coated sheet imports climbing the most (50.3%), boosted by the highest monthly total of “other coated” product imports since July 2017.

Hot rolled and cold rolled sheet imports increased as well, climbing 2.4% and 21.6%, respectively.

ZINC PRICE & INVENTORY

Based on the London Metal Exchange, Weekly Zinc Price and Inventory Report: March 1, 2024 and the Shanghai Futures Exchange, Weekly Zinc Inventory Report: March 1, 2024: Zinc pricing increased for the third consecutive week.

Zinc pricing ended the week at \$2,362/mt (\$1.071/lb), up from \$2,348/mt (\$1.065lb) previously.

The global zinc market has been in a surplus, lifting stocks to the highest level since June 2021.

LME warehouse inventory increased for the fifth consecutive week, climbing from 268,700 metric tons to 276,100 metric tons. This is highest LME warehouse level since June 2021.

Shanghai warehouse inventory climbed from 36,526 metric tons to 39,252 metric tons.

The full library of Core Reports from Majestic Steel USA can be accessed at <https://www.majesticsteel.com/majestic-insights/core-report/>. **RF**

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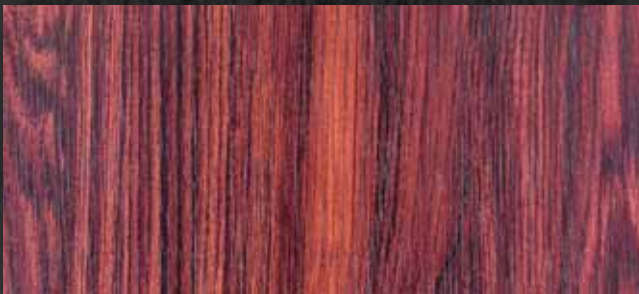
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Carbon Steel

Why Carbon Matters

■ By Karen Knapstein

As its name would imply, low carbon steel, also known as mild steel, is a type of steel that contains a relatively low amount of carbon. It is an alloy of iron and carbon, where the carbon content typically ranges from 0.05% to 2.0%. In the case of low carbon steel, the carbon content usually ranges from 0.04-0.29%.

The low carbon content makes this type of steel more ductile, malleable, and easy to weld, which are desirable attributes for a material used in construction. It's used for various structural applications — in the fabrication of beams, columns, structural panels, and other components — due to its strength, versatility, and cost-effectiveness.

The amount of carbon in steel can significantly impact how the material behaves during the roll-forming process. The malleability of low-carbon steel makes it an ideal material to make into steel coil and for roll-forming trims and panels.

Steel with lower carbon content is generally more ductile and has better formability than steel with higher carbon content. This means that it can be easily shaped and bent without cracking or breaking during the roll-forming process. Low-carbon steel is often preferred for roll forming applications where complex shapes and tight bending radii are required.

Low-carbon steel often exhibits good toughness and resistance to fracture, which makes it suitable for roll forming applications where flexibility and resistance to deformation are important.

Higher carbon content contributes to increased hardness and strength in high-carbon steel. However, this can come at the expense of toughness. High-carbon



Steel with lower carbon content is generally more ductile and has better formability than steel with higher carbon content. PHOTO COURTESY OF MILL STEEL.

steels may be more brittle, and their use in roll forming applications may be limited to situations where high strength is a primary requirement and where careful handling is possible to avoid excessive stress.

Low-carbon steel tends to have less springback, meaning it retains its formed shape more effectively after the roll forming process. Controlling springback is important in order to achieve precise dimensions and consistent profiles.

CARBON & STEEL PRODUCTION

There are growing concerns about the sustainability of steel production. Environmental impact assessments

take into account the entire life cycle of a product, including its production. To address environmental concerns and meet sustainability goals, the steel industry is actively working to lower the carbon intensity of steel. Steel with reduced carbon content is considered more environmentally friendly, as it helps minimize the depletion of natural resources and reduces pollution.

The production of steel using blast furnaces creates significant carbon dioxide emissions. By reducing the carbon content in steel, the industry can lower its overall carbon footprint, contributing to global efforts to mitigate climate change and reduce greenhouse gas emissions. According to the Center for Sustainable



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Closer Look))

Systems at the University of Michigan, “A carbon footprint is the total greenhouse gas (GHG) emissions caused directly and indirectly by an individual, organization, event or product.”

Alternative methods of steel production, such as EAFs and hydrogen-based processes, can be more energy-efficient than blast furnaces, and EAF production can have a huge impact on the amount of carbon in the steel. EAFs primarily use scrap steel as the raw material; when it’s melted in the EAF, the carbon content in the end product is determined by the composition of the scrap, which is often a mix of various sources. The carbon content in EAF-produced steel can be lower compared to steel produced from iron ore in traditional blast furnaces.

Because of their ability to add alloying elements and control the input materials, steel makers have greater flexibility in controlling the chemical composition of the steel. This is beneficial when making specialty steels with precise carbon content for specific applications, as described above. Some steel producers using EAFs are also integrating renewable energy sources into their operations. By using renewable electricity to power EAFs, the overall environmental impact can be reduced even more, contributing to the production of low-carbon or carbon-free steel and furthering environmental sustainability efforts.

The government is a powerful influence on carbon reduction efforts. Through agencies like the Department of Energy, it has been providing funding for research and development projects aimed at advancing technologies that reduce carbon emissions in steel production, including support for processes like hydrogen-based steelmaking. Government tax credits and incentives encourage steel producers to invest in low-carbon technologies.

Strict emission standards and government-imposed regulations are aimed at addressing climate change and air quality concerns. Steelmakers face increasing pressure to comply with these regula-



tions, and reducing carbon emissions is a key component of meeting environmental requirements and avoiding penalties. Lowering emissions then aligns with regulatory compliance and helps manage operational costs.

THE PATH TO NET ZERO

There is a growing awareness among consumers and businesses regarding the environmental impact of products, including steel. More customers and end-users are looking for products with lower carbon footprints. As a result, steel producers are responding to the market demands for more sustainable and environmentally friendly steel products. Not to mention reducing carbon emissions with the intention of mitigating climate change and complying with government mandates. The Net-Zero Steel Initiative aims to put the global steel sector on a path to reach net-zero emissions by 2050. Steel makers Steel Dynamics, Nucor and United States Steel all aim to hit the net-zero greenhouse gas target by that year.

Many steel manufacturers are issuing official Environmental Policy Statements declaring how they will do it. In part, the Steel Dynamics Environmental Policy Statement says: “We are committed to continuing to operate our business in an environmentally sustainable manner. We recognize the importance of being good stewards of our environment and the communities where we work and live. We continually evaluate opportunities to improve our processes, equipment and technology to reduce our physical impact on the environment. To us, it’s more than simply meeting the requirements, but going beyond with a commitment to higher environmental standards.”

CONCLUSION

Steel companies aim to develop and adopt environmentally responsible business and production practices that align with the expectations to reduce carbon emissions, while still producing the high-quality, malleable steel necessary for the construction roll-forming industry. **RF**



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New Building Show

Shield Wall Media Launching Post-Frame Builder Show

■ By Rollforming Magazine Staff

If your company offers post-frame buildings, or you are considering expanding into post-frame buildings, you need to plan to attend the Post-Frame Builder Show in Branson, Missouri, June 18-19.

Produced by Shield Wall Media, the Post-Frame Builder Show offers educational sessions, a robust expo hall filled with post-frame material and service providers, and opportunities to meet one-on-one with construction industry insiders. This family-friendly event is the company's third construction-focused trade show as it joins the Construction Rollforming Show and the Garage, Shed & Carport Builder Show.

The Post Frame Builder Show, like the other Shield Wall Media shows is a business-to-business event. Exhibitors can expect attendees to be decision makers for their companies and attendees can expect that exhibitors are dedicated to spending the time needed to help them make their buying decisions. While all industry professionals are welcome, Shield Wall events focus on connecting those that ultimately make business happen on the show floor.

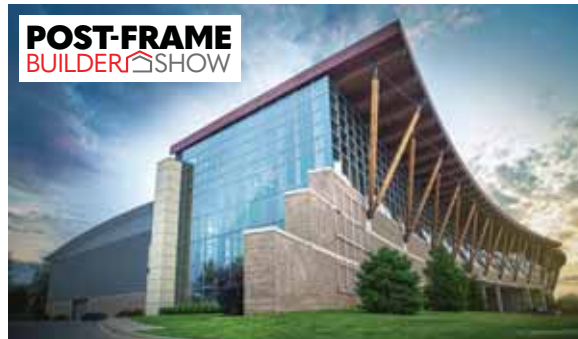
The Post-Frame Builder Show educational programming emphasizes topics you, as a decision-maker, want to see. Programming focuses on how you can make your business more successful by providing you with the assets you can use to do that. Those assets include connecting you with product and service providers, offering insights on best business practices and building efficiencies, how you can save money, and how you can

increase your profit margins.

General admission is \$50. If you have relationships with exhibitors, contact them; they have an unlimited number of FREE guest passes and will gladly provide

simple and business-oriented. If you are looking for a supplier, it doesn't take three days. Exhibit hall hours are Wednesday and Thursday so you can get in, do business, and still spend the weekend with your family whether that be heading home to them or bringing them with. Shield Wall Media is proud to be a family focused company. The Post Frame Builder Show welcomes families and has dedicated areas for those with children to take time to rest, re-group and maybe build a block tower or have a snack.

If you are looking for new products, business opportunities, or different sources for products you already use, you can't afford to miss the Post-Frame Builders Show June 18-19 at the Branson Convention Center in Branson, Missouri. If you have any questions about the Show or would like to exhibit, contact Shield Wall Media Director of Events Missy Beyer at 920-216-3007 or missy@shieldwallmedia.com. **RF**



Branson Convention Center in Branson, Missouri.

you with free admission. These passes include the educational programming and are good for manufacturers, contractors, support staff, or anyone else. (As of March 1, exhibitors scheduled to appear on the expo floor are shown in the inset.)

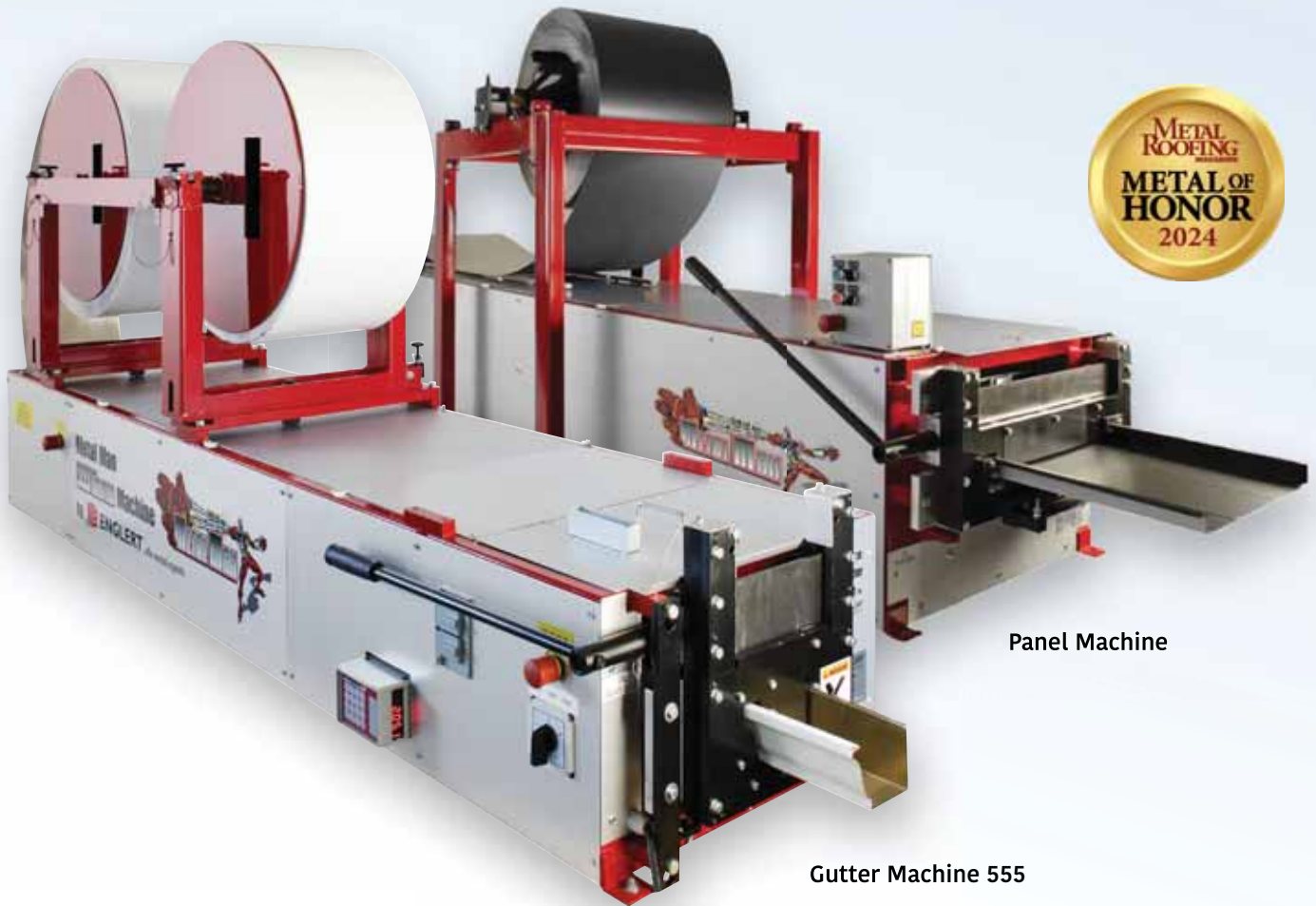
Shield Wall Media keeps its shows

2024 Post-Frame Builder Show Exhibitors

- Acu-Form Equipment
- AJ Manufacturing
- AmeriLux International
- Anthem Built
- The Bradbury Group
- Burrow's Post-Frame Supply
- Capital Forest Products
- Cold Spring Enterprises
- Delden Garage Doors
- Dutch Tech Inc.
- Everlast Roofing
- Footing Pad
- Forest Products Supply
- Frontier Metal
- Graber Post Buildings
- Hitz Halter
- Hixwood
- J-Money, LLC
- Levi's Building Components
- Little Harvey's
- Made Right Metal Buildings
- Malco Tools
- Marco Industries
- Martin Metal
- Midco Building Products
- MWI Components
- Perma Column
- Plyco Corporation
- Post Protector
- Red Dot Products
- Richland Laminated Columns
- Rigid Built Laminated / Yoder Precast
- Signature Steel
- Silvercraft
- SmartBuild
- SpeedLap
- ST Fastening Systems
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Be Aware of BOI

5 Fast Facts About Beneficial Ownership Information Reporting

■ By CliftonLarsonAllen

Key Insights

The Corporate Transparency Tax Act is designed to help the U.S. government collect information to prevent use of the U.S. financial system for illicit activities.

All domestic entities and any foreign entity registered to

do business in the United States must report beneficial ownership information.

The reporting is complex and there are penalties for non-compliance. Be aware of your BOI reporting requirements.

Many businesses must soon report new beneficial ownership information (BOI) to the U.S. government. Our earlier article [<https://blogs.claconnect.com/realestate/beneficial-ownership-information-reporting/>] covered a high-level overview of BOI reporting requirements, and now we're sharing important updates to help you clarify your responsibilities. Read on for five fast facts.

BACKGROUND

In 2021, Congress enacted the Corporate Transparency Tax Act (CTA), which establishes uniform BOI reporting requirements for certain types of corporations, limited liability companies, and other similar entities created in or registered to do business in the United States.

The CTA is designed to help the U.S. government collect information necessary to prevent bad actors from using the U.S. financial system to facilitate money laundering, tax evasion, human and drug trafficking, and other illicit activities.

The CTA authorizes the Financial Crimes Enforcement Network (FinCEN), a bureau of the U.S. Treasury, to collect and disclose BOI information

to authorized government authorities and financial institutions. Since CTA's enactment, FinCEN has issued implementing regulations — the basics of which are discussed briefly below.

CliftonLarsonAllen will not advise on or assist with BOI reporting preparation. We recommend that you reach out to your attorney for assistance in complying with these filings.

Reporting companies created or registered to do business before January 1, 2024, must file initial BOI reports with FinCEN on or before January 1, 2025.

5 FAST BOI REPORTING FAQs

1. What companies will be required to report BOI to FinCEN?

All domestic entities and any foreign entity registered to do business in the United States. Entities subject to BOI reporting include a corporation, limited liability company, or any other entity

created by the filing of a document with the secretary of state or similar office in the United States.

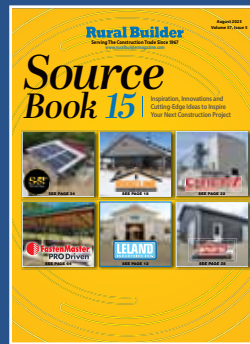
2. Are there exemptions from BOI reporting?

Yes, FinCEN notes 23 BOI reporting exemptions.

Perhaps the most common exception to BOI reporting is the large operating company exemption. Generally, a company meets this exemption if it has at least 20 full-time employees, more than \$5 million in gross receipts or sales, and an operating presence at a physical office within the United States. For purposes of the \$5 million threshold, the threshold is measured as gross receipts or sales net of allowances on Forms 1120, 1120-S, 1065,



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or other equivalent tax return. It should be noted, however, that the 20-employee threshold is not applied on a consolidated basis. As a result, a parent company filer of a consolidated C corporation tax return must itself have 20 or more full-time employees to meet the large operating company exception.

Other exemptions apply to Section 501(c)(3) tax-exempt entities and certain types of regulated financial companies.

3. When does BOI reporting start?

Reporting companies created or registered to do business before January 1, 2024, must file initial BOI reports with FinCEN on or before January 1, 2025. Reporting companies created or registered to do business on or after January 1, 2024, will have 90 days from creation or registration to file their initial BOI reports. Any changes to previously reported BOI must be reported to FinCEN within 30 days.

4. What information does a reporting company disclose to FinCEN?

A reporting company must report:

- Legal name
- Any trade, doing business as, or trading as names
- The current street address of its U.S. place of business, jurisdiction of formation or registration
- IRS taxpayer identification number
- Type of BOI filing (i.e., initial report, a correction of a prior report, or an update to a prior report).

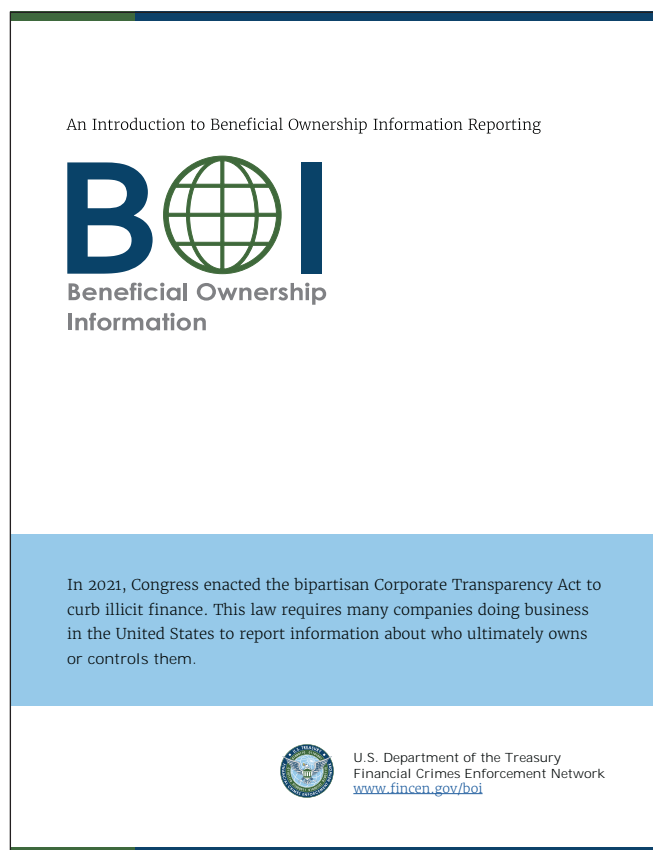
In addition, for each individual who is a beneficial owner or company applicant, the reporting company must report:

- Individual's name
- Date of birth
- Address
- Unique identifying number from an acceptable identification document (e.g., driver's license, passport, etc.)
- Name of the state or jurisdiction that issued the identification document.

A beneficial owner is an individual who either directly or indirectly (1) exercises substantial control over the reporting company (e.g., a senior officer or key decision-maker), or (2) owns or controls at least 25% of the reporting company's ownership interests. A corporate entity owner is "looked through" to its ultimate owners for purposes of determining the

The information contained herein is general in nature and is not intended, and should not be construed, as legal, accounting, investment, or tax advice or opinion provided by CliftonLarsonAllen LLP (CLA) to the reader. For more information, visit CLAconnect.com.

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The Financial Crimes Enforcement Network has published the brochure "An Introduction to Beneficial Ownership Information Reporting," which can be downloaded at <http://tinyurl.com/3und37eh>.

25% ownership test.

Although not required, many filers are encouraged to obtain FinCEN identifiers to help facilitate filing this information.

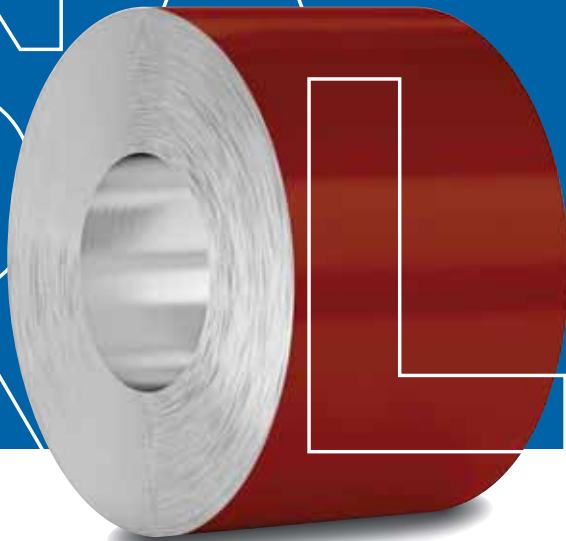
There is no fee to file BOI reports with FinCEN.

5. Are there penalties for failing to file BOI reports with FinCEN?

Yes, be aware of BOI filing penalties. A person who willfully fails to comply with BOI reporting may be subject to civil penalties of \$500 per day and criminal penalties including a \$10,000 fine and/or up to two years of imprisonment. **RF**

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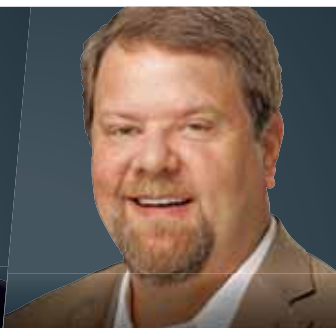
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Preventive Maintenance

Take Care Of Equipment and It Will Take Care Of Business

■ By Karen Knapstein

Roll forming equipment represents one of the largest capital investments — if not THE largest investment — of a metal-forming shop. To maximize the return on that investment, and keep it running smoothly and effectively, regular and thorough cleaning are on the list of best practices.

During the roll forming process, materials like oils, dirt, dust, metal shavings, and adhesives can accumulate on machine components. Cleaning helps prevent the buildup of contaminants that could compromise the quality of the formed products and lead to operational issues. Within this article are a few tips for cleaning and basic preventive maintenance, but by no stretch of the imagination is it a comprehensive guide.

TOP PRIORITY: TOOLING

Clean tooling and forming surfaces play a part in consistent product quality; keeping equipment clear of waste materials such as excess lubricants, metal filings, and other debris can affect the precision of the machine and the quality of the finished product. “Regardless of what brand of machine you have, or whether it’s mechanical, hydraulic, or electric,” says Wayne Troyer of Acu-Form Equipment, “if you want to put out a good quality product, you have to keep your machines clean. Number one is keeping all the dies clean.” The dies are in direct contact with the coil as it runs through the machine, so if they are not in top condition they can cause condition



Always follow manufacturer guidelines when servicing equipment. PHOTO COURTESY OF ACU-FORM.

problems with the panels and premature parts wear on the machine. “There are corners and small grooves that dirt can get into. People clean the dies but often forget to clean the small detailed areas,” he continues.

“Tooling is priority #1,” emphasizes Frank Schiene, Metal Rollforming Systems. “You need to keep your tooling as clean as possible because it creates the product going out the door for the customer. “If you don’t check your tooling you could have things that come

loose and shift, resulting in crashing dies that will ruin the panels,” cautions Frank. “If tooling isn’t checked or cleaned, it affects the overall quality of your panels.”

Non-flammable, solvent-based cleaners may be effective for removing grease, oil, adhesive build-up, and debris, but always make sure cleaners are approved by the machine manufacturer and compatible with the machine’s components. Wayne says Scotch Brite pads are a popular choice to clean the dies; they’re abrasive enough to remove

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Tooling must be kept clean because it creates the product that heads out the door to the customer. PHOTO COURTESY OF METAL ROLLFORMING SYSTEMS.

grime but not hard enough to cause damage. Use soft brushes and cloth to clean intricate parts of the tooling and mild detergents or cleaners for general cleaning, always making sure the cleaners are compatible for the specific materials and finishes of the machine components. After cleaning, reapply the lubricants following manufacturer recommendations for lubricant types and application.

The frequency that cleaning is needed will depend on factors like machine usage, environmental conditions, and the types of materials used during the forming process. “Materials like Dripstop and CondenStop are very good products,” says Wayne. “But people need to pay attention when they’re putting the product onto the panel. It sticks to the panel but can also stick to the dies. And the longer you leave that on, the harder it is to get off. If built up on the dies, it creates friction and overbends where it’s not supposed to. It can be very inconvenient for the metal shop in the long run if they don’t take the time to clean it off after they’re done with the run.

“Any place your finished product touches should be clean,” he continues. “Make sure the surfaces are clean where you put your finished product. Wipe down everything. The frequency depends a lot on the shop. There are shops where every evening

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they'll clean up. As far as wiping down machines and dies, it depends on your volume. It depends how your shop is situated and where it's located. If the drives are blacktop or concrete, there's very little dust. If the shop has gravel drives, especially in the summertime when doors are open, there's a lot of dust coming into the shop. If that's the case, then you might have to do it daily. Or you might have to do it once a week."

Another factor that affects the frequency that cleaning is needed is whether the shop is insulated and if the environment is controlled. "If it's not insulated and it gets cold and warm and you get a lot of condensation, then dust and anything like that is more likely to stick to everything than if it's insulated and heated."

There are additional benefits to maintaining a clean shop. "Everyone likes to work in a clean environment. And if everything's clean, the customers are going to be more impressed with a clean, well-kept shop than with one that's not — and they may be more likely to buy from the well-kept shop," he surmises.

PREVENTIVE MAINTENANCE BASICS

Regular cleaning is an opportunity for a visual inspection of the machine's moving parts. This allows early detection of signs



Clean tooling and forming surfaces are important for producing consistent product quality. PHOTO COURTESY OF ACU-FORM.



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Improperly tensioned chains have the potential of causing a lot of premature wear and damage. PHOTO COURTESY OF METAL ROLLFORMING SYSTEMS.

of wear, damage, or other issues that could require attention. Identifying problems early can prevent more extensive damage and unplanned downtime.

Chains are constantly moving. If not maintained properly, they can cause a lot of damage. “Chain tension can be a key element,” Frank explains. If not properly tensioned they can “hurt a lot of parts. Proper tension prevents premature wear on an extended list of parts. If it’s too tight, it causes undue stress. Most important with chains, though, people let them get too loose; chains slapping keyways and sprockets can tear up ends of shafts and things like that. It can cause premature sprocket wear, keyway wear, shaft wear. Parts will need to be replaced prematurely, and that may not be needed if proper chain tension was established and maintained.”

Almost everyone uses hydraulics. There are a couple guidelines that users should follow to keep them running trouble-free. “A lot of people use different kinds of fluid and some may not work as well. Follow the manufacturer specifications and

change the fluid based on manufacturer specifications, too. On MRS machines, it’s usually once a year, but that may not be the case depending on how much you run.”

A Metal Construction Association (MCA) whitepaper advises, “A well-maintained machine can last decades and extending the machine life may be as simple as ensuring that the hydraulic oil and/or the motor gearbox oil is clean and within the specified lifespan for the oil. This is probably the most common maintenance issue, because ‘out of sight is far too often out of mind.’ The typical hydraulic oil temperature range is in the area of 120°F. Always check the OEM manual for a specific recommendation for the active temperature range. When the oil temperature is out of range it is important to stop operation and determine the cause for this elevated temperature that could at the very least have an impact on the material being produced and at worst damage the metal-forming equipment.”¹¹

Each machine is different and needs to have a separate preventive maintenance checklist/schedule, but Frank suggests the following, with the caveat that “based on the manufacturer, there may be additional preventive maintenance to do daily”:

Daily: Check tooling

Weekly: Check chain tension

Monthly: Check bearings

Annually: Fluid changes (hydraulics and gear box oil).

“If you follow those,” he advises, “usually things will last longer.”

There’s enough demand for preventive maintenance service that Acu-Form has developed service routes; customers can pay for the manufacturer to come out and do annual PMs. “The service routes involve cleaning dies for people. Changing blades, checking oil and gear boxes and checking to make sure everything is running properly,” explains Wayne. “Customers may want us to do it once a year.”

DON'T FORGET THE SHEARS

Machines that have post-cut shears need to be kept properly lubricated to ensure clean cuts and maintain the life expectancy of the shear blades. If not properly lubricated, shear blade life will be shortened and cuts will be more jagged.

SAFETY ALWAYS!

“If you’re doing maintenance you should never be in a hurry,” cautions Frank, who is an integral part of the safety efforts at Metal Rollforming Systems. “Hurry gets you in trouble. You cut corners and do things wrong when you get in a hurry.” Before starting the cleaning process on any metal-forming machine, make sure it’s powered off and isolated; disconnect the power sources and follow lockout/tagout procedures to prevent accidental activation.

“When you clean the machine, always make sure it is locked out,” cautions Wayne. “Never put your hand in the machine to try to clean it while it’s running.” Without exception, proper

lockout/tagout procedures prevent accidents. Frank says that while he sees accidents involving new guys, “it’s usually the guy that gets complacent. New guys are a little bit more nervous. If you get complacent, then it’s literally a matter of time before it becomes a bad day and someone has a career-changing or life-altering accident.” Devastating injuries can happen when cleaning dies with the machine running (and folders claim a lot of fingers).

“A lot of the accidents I’ve seen, most of them were avoidable. Do the things that give you a chance of staying safe,” he warns. “Poor choices usually cause more accidents.”

CONCLUSION

Cleaning equipment is an important step in preventive maintenance; it will help ensure its longevity and performance. There are benefits to establishing a cleaning and preventive maintenance schedule. According to the MCA, “A study conducted by RWC Production Support Services Inc. came to the conclusion that, ‘Many studies suggest that consistent PM can result in a 5 to 10 percent productivity improvement, which can reduce costs by up to 20 percent.’”(ibid.)

And the operator is your first line of defense. “No one spends more time in front of the machine than the operator who can see, or sometimes even sense, minor operational changes in the equipment. Many times, issues slowly arise, and an observant operator can help catch an issue when it still is an easy fix rather than requiring a major overhaul. Operators should be trained to pay attention and document gradual changes such as hydraulic oil color over time.” (ibid.)

Maintaining records of cleaning and preventive maintenance activities can also help identify patterns or recurring issues. “With proper training, maintenance can become a routine, very easy way to keep machines up,” Frank recommends. Regular and thorough cleaning, in addition to proper lubrication and maintenance, contributes to the overall performance and reliability of metal forming machines. **RF**

¹ “Best Practices – General Maintenance on Factory Metal Forming Equipment,” Metal Construction Association, www.metalconstruction.org, March 2022.



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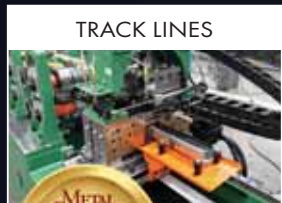
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How To Prevent Roll Former Breakdowns

■ By Ron Dies, Field Service Manager, The Bradbury Group

Your roll former only makes money when it's up and running. Therefore, it's critical to keep it operating properly and producing efficiently. Regular roll former maintenance will prevent long-term breakdown and expensive repair.

DEVELOP A PREVENTATIVE MAINTENANCE SCHEDULE

The way to ensure regular maintenance is to schedule it. Every roll former will come with a manual that outlines required maintenance. Review and understand the maintenance instructions provided in the equipment manual thoroughly. It's vital to adhere to the recommended schedules for routine checks, inspections, and servicing outlined by the equipment manufacturer or supplier.

LUBRICATION ROUTINE/SCHEDULE

Identify critical components that require regular lubrication,



If your roll former is not producing consistent product, the problem can be remedied by adjusting the roll tooling.
PHOTO COURTESY OF THE BRADBURY GROUP

including rollers, bearings, and chains. Details for maintaining a proper lubing schedule should be supplied or available from the manufacturer.

It's important to use the specified lubricants and follow the recommended intervals for application. Like any and all maintenance, it's a good idea to keep a log of your lubrication schedule.

INSPECT AND REPLACE TOOLING

Regularly inspect the tooling for signs of wear or damage — either could cause your roll former to produce pieces that are not consistent or meet the standards required by your customers. Replace worn-out tooling promptly to maintain the precision and quality of the forming process for the products being roll formed.



Any regular maintenance on your roll former should include the alignment of critical components. PHOTO COURTESY OF THE BRADBURY GROUP

ALIGN CRITICAL COMPONENTS

It's imperative to perform alignment checks on tooling, tooling gap and other critical components according to the manufacturer's specifications. You can utilize precision measuring tools to ensure accurate alignment. If and when you detect any misalignments, address them promptly to prevent issues like uneven profiles or production inconsistencies.

Keep Equipment Clean

Dirt and dust build up everywhere. Periodically, wipe down the stands and equipment to keep excessive debris from accumulating. This will aid in identifying issues with the equipment before a component fails and leads to a breakdown.

Safety and Training

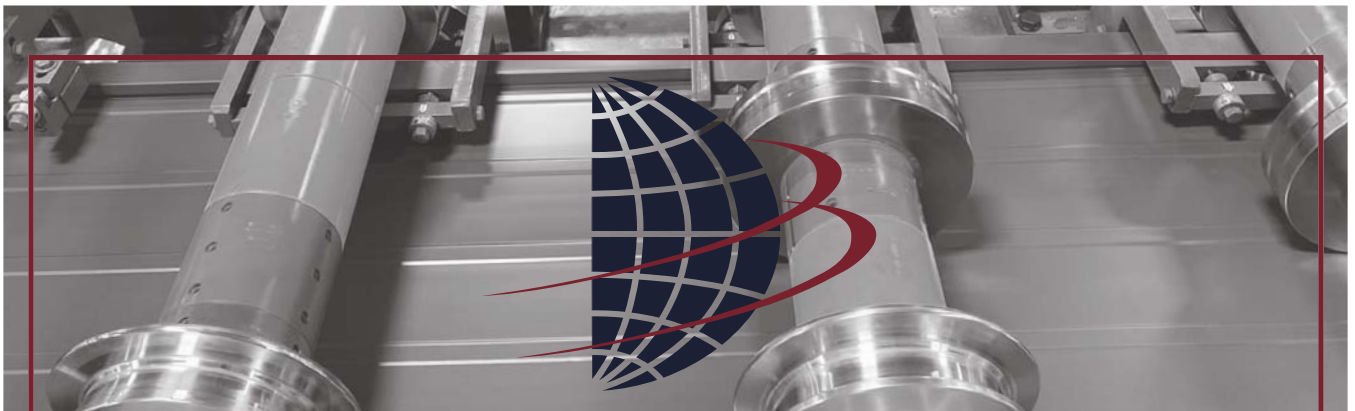
You should provide comprehensive training to operators on safe equipment operation as well as maintenance procedures. You owe it to your operators to emphasize safety! Follow your schedule for regular safety checks, ensuring emergency stops, guards, and other safety features are functional. Always maintain detailed records of operator training and safety inspections.

The best way to get a return on your investment in a roll former is to keep it running consistently and safely. Follow your maintenance schedule and keep track of all maintenance. **RF**



You want your roll former to produce consistent product, so it's important to inspect and calibrate the machine's tooling.

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Looking Toward a Bright Future

Innovation and Open Communication Are the Keys at Star 1

■ By Rollforming Staff

In 2018, Robert Miller worked in a roll-forming shop owned by Ray Wagler. Ray, as an innovator started rolling ideas around in his mind for a better felt application process, more consistent placement on metal, ease of use, and less waste. Ray and Robert worked together on building a design that fit those goals.

After some prototypes and testing, they had what they were looking for and it worked well in Ray's facility.

Then Robert realized that other facilities were struggling with the same issues that Ray's shop was facing. That's when Robert took the initiative to build more felt applicators to provide a solution for other roll-forming facilities. Robert's brother Nelson joined in to further research, develop, and bring this Felt Applicator to the market.

STAR 1 TODAY

Star 1 Products' first focus was the Felt Applicator, in 2019, with a vision to provide more innovative products for the roll-forming industry. Star 1 Products, located in McBain, Michigan, is now serving roll-formers in the United States, Canada, and New Zealand.

INNOVATION

While the Felt Applicator is still the company's primary product, Star 1 has added other products by listening to the needs and innovating solutions for the problems in the industry. Other products that are now available include Adjustable Wide Forks to handle 30-40 foot metal panels, and Coil Storage Systems.

It also has new products coming for 2024, including a new and updated Felt Applicator, a Coil Handling System, and a non-computerized 21' Trim Folder operated by pneumatics and hydraulics only, specifically for those who choose to operate without computers.

CHALLENGES AND LOOKING FORWARD TO THE FUTURE

As a manufacture the past few years have been difficult, with shortages in product availability, shipping issues, and long lead times. Honest and open communication with the customers are the key to getting through.

Nelson says the steel roofing and building market seems to be strong and growing. There are lots of smaller, local roll-forming facilities popping up across the country. He says they



plan to continue innovation and problem solving with new products. The future looks bright for the metal roofing and siding industry. RF

Events Calendar))

April

April 16-17

Roofing Day in D.C., Washington, D.C.
www.nrca.net

April 24-26

Metal Building Contractors & Erectors Association (MBCEA) Annual Conference, Rancho Bernardo Inn, San Diego, California. mbcea.org

June

June 5-7

Florida Roofing & Sheet Metal Expo, Gaylord Palms Convention Center, Kissimmee, Florida.
www.floridarooft.com

June 5-8

AIA Conference on Architecture 2024, Walter E. Washington Convention

Center, Washington, D.C.
conferenceonarchitecture.com

June 11-12

Metal Construction Association (MCA) Summer Meeting, Hilton Rosemont/Chicago. metalconstruction.org

June 19-20

Pacific Coast Builders Conference (PCBC), Anaheim Convention Center, Anaheim, California. pcbc.com

June 19-20

Post-Frame Builder Show, Branson Convention Center, Branson, Missouri.
framebuildingnews.com/postframe-builder-show-registration/

September

Sept 18-19

Construction Rollforming Show, DeVos

Place, Grand Rapids, Michigan.
constructionrollformingshow.com

Sept 29-Oct 1

Western Roofing Expo Convention & Trade Show (WRE), Paris Las Vegas Hotel & Casino, Las Vegas, Nevada.
www.westernroofingexpo.com

October

Oct 21-23

Midwest Roofing Contractors Association Conference & Expo, Saint Paul RiverCentre, St. Paul, Minnesota.
www.mrca.org

Oct 30-Nov 1

METALCON, Atlanta Convention Center, Atlanta, Georgia.
www.metalcon.com

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Material Handling

Handling coils and finished metal components doesn't have to be hard

■ By L. Townsend, Combilift

It always pays to take a critical look at the equipment that you use for moving loads in and around production facilities and in storage areas. Safety is paramount, followed closely by the need for effective and productive handling. Other issues

to consider are financial outlay and sustainability. As technology advances, you may find that you have been somewhat left behind if you have relied on the “same old” trucks or machinery for a long time. So it pays to check in on market developments every so often to

see what's new out there.

Let's look first at safety, and how to avoid pitfalls when it comes to this number one priority. Don't compromise on equipment that is not 100% suitable for the task in hand. The indirect costs of not using the right trucks can be considerable



Combilift C-Series with a coil saddle attachment. PHOTOS COURTESY OF COMBILIFT

in terms of downtime after collisions, product damage or repairs for damaged racking, and administrative costs for accident investigations. Disruptive workflow, delayed deliveries and unhappy customers are further consequences. And this is without counting the much graver human cost of any injuries that may be inflicted. What's required are handling solutions tailored to specific challenges.

Coils and finished metal components are by nature heavy, bulky, and often long, and therefore potentially hazardous when being moved. They need to be stable and secure on any piece of equipment such as a forklift, and ideally transported at a low level rather than being lifted to height on raised forks. So how to maneuver long loads in tight spaces? Juggling a counterbalance truck backwards and forwards until you have eventually squeezed your load through an access doorway is an example of what not to do — as is using a couple of forklifts at either end of a load, which will incur the wrath of health and safety officers.

Multidirectional models such as those in the C-Series range from Combilift have been designed with a very low center of gravity and integrated platform which provide a stable base for resting product on during transportation, eliminating the need for elevated loads, even when negotiating around machinery, obstacles or parked vehicles. An additional benefit of these types of trucks is the ability to quickly change the wheel direction to enable sideways travel in confined spaces. This in turn allows for much better and cost-effective use of all available space which is one of a company's most valuable assets.

Close encounters between forklifts and pedestrians are to be avoided wherever possible, as statistics prove that these are a major cause of accidents and injury to pedestrians. According to statistics, employees in the handling and warehousing industries are at a higher risk of workplace injuries and fatalities. The driver needs to have a clear view of the load, the forks, and the general

surroundings to ensure safety for other personnel who may be in the vicinity. High cab position and generous glazing are features that help the driver's line of sight.

Another option is to look at pedestrian-

operated stacker trucks. These work at speeds inherently lower than those of ride-on trucks, and the operator's awareness of the immediate surroundings is improved as they are physically closer to the load, the machine, and people in



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Closer Look))



Combi-MG equipped with a rotating C-hook for handling coils and operated by remote control.

the vicinity — and they are looking in the direction of travel at all times. These trucks are also not just for lighter loads. For example, the Combi-PPT powered pallet truck comes with lift capacities up to 32,000 lbs. and with power steering, dual rear wheel drive, and AC motor technology it enables one operator to easily maneuver heavy loads.

Sustainability is high on most companies' agendas, and many are looking to switch to emission-free operations. Thanks to ever-improving battery technology, the performance of electric trucks is now on a par with diesel, and lift capacities are continually creeping up. Also, the ability to work in narrow confines even when carrying long loads can create up to 50% more space to maximize available storage capacity. This avoids the need to expand the size of a facility in times of growth, resulting in fewer new builds and lower energy consumption for



The Combilift C-Series can handle long loads of finished metal components

heating and lighting, for a significant reduction in the physical and therefore carbon footprint.

Choosing the handling equipment that is suited to your needs will therefore safeguard your workforce, increase your productivity, cut costs, and improve your contribution to a better environment. [RF](#)



A Combi-CB in operation handling long loads of finished metal components.

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Metal-Forming Insights

A Closer Look At Roll Tooling, Die Design, Maintenance, and Operation

■ By Formtek, www.formtekgroup.com

The continuous rolling operation has a huge cost advantage in terms of production speed and operational efficiencies compared to press brake or similar part-to-part work. That cost advantage does come with some potential disadvantages that may be mitigated just with some basic knowledge and consistent practices. Let's look at the top 5 “real world” issues regarding tooling, die design, maintenance, performance, and operational cost considerations and how to mitigate some common issues.

TOOLING AND DIE DESIGN

This is a great starting place for future tooling and die performance in the field. A good relationship and constructive communication with your design team and a clear direction for concepts can

mitigate most problems before a design has even begun the sketch up phase. Quick hit points such as mill size in relation to the finished part, number of passes required for the bend package, speed requirements, and tonnage for pre/post punch or cut die details should be addressed. Coolants and lubrication packages should be reviewed for appropriate function.

A good design team will work with all the pros and cons of your particular operation and make suggestions on best practices or any beneficial changes that may be incorporated into the process. Considerations towards final product dimensioning and tolerancing, material clarification, and form/fit/function issues should be addressed before a section should be accepted as a candidate for roll forming.

A true “custom” approach is tailored by the engineering team specific to the customer's requirements/needs as dictated. The actual design process is where true knowledge and field experience shines forth, and a viable plan for a well running, profitable, production run is established.

RAW MATERIAL

Tooling and Die engineers are often confronted with situations such as the commercial variation in material strip thickness is often greater than the allowable tolerancing on a finished part. Or an available material is re-rolled to a tighter tolerance thinner strip. We all understand the purchasing aspect of using broader tolerance bands on raw material to obtain cheaper prices, but a tight tolerance, high performance section

Closer Look))

is only as good as the quality of the strip going into the mill. Variations in material thickness have a dramatic effect on cross section dimensional stack up.

Material specifications regarding yield/tensile/elongation parameters impact the formation process in regard to the over form requirements for each bend as well. Consistency in purchased material is a huge key to minimizing scrap costs and setup/tooling adjustments required to make the production run. This presents a huge divergence from a press brake operation in that angles are programmed and adjusted as needed, as opposed to physically fixed angles or profiles on roll tooling. Subsequently, you are trading more specific material characteristics for increased roll forming speed and efficiency.

Multiple production material types on a single tool set are an extreme scenario. Roll tooling engineers often use the example that stainless steel certainly has different requirements than a carbon steel and, in all honesty, a different material should have a dedicated tool set or die assembly. From a financial aspect, the scrap cost, production costs, and tedious setup changes utilizing a single set of rolls would certainly pay for a properly designed additional toolset for the second material type. A clear understanding and balance between the raw material specifics and costs with the performance and function of the part needs to be maintained.

TOOLING MATERIALS AND COATINGS

Good material choices with appropriate heat treatment requirements will vastly improve tooling performance and also reduce section or die punch/cut distortion from the process. A fan favorite D-2 tool steel for rolls is a great option, but there are different materials such as carbide that have benefits on speeds and surface finishes.

Some CPM (Powdered Metals) may be used for toughness and wear resistance. H-13 material is a great choice where temperature is an issue such as forge rolls

or weld rolls. Variations of aluminum bronze are great for areas that are sensitive to wiping and swirl marks. Roll tooling and die engineers have also worked extensively on the coatings and different applications on base materials for specific requirements. Just like drills and end mills can be coated in Titanium Nitride, Titanium Carbo Nitride, or Titanium Aluminum Nitride, rolls and die parts can also be coated for specific performance.



Talk to your design team and ask about options. Even if it's an existing tool set – sometimes there is marking on a specific problem roll or a wonky punch that may work flawlessly with just a coating application.

PREVENTATIVE MAINTENANCE AND WEAR

All things wear out with time and usage. Having a plan in place for evaluating the wear and another plan in place for remediation are paramount to getting the most performance and longevity out of your tooling. Roll tooling is designed in a way that balances the workload from pass to pass until the part is in finish shape. That also means if the tooling is set up correctly and all the incoming material requirements are appropriate, essentially, the entire tool set would need to be reconditioned at the time that the part cross section begins to demonstrate variations beyond approved dimensional tolerancing.

We all know minor adjustments to the tooling setup can be made, but that should be a clear indication that the

toolset is no longer performing as it should. If a request for a shorter strip width is made, then the first investigation point should be a cross section review with emphasis on the corner radii.

A certain strip width is required with crisp, appropriate corners, and that strip width requirement changes as the corners wear and round off. This also shows evidence in die wear/markings and punch/cuts as the section no longer

fits the die the way it did originally. A rework or reconditioning service can be relatively inexpensive and quickly performed when it only requires a minimum of work to return the set to its prior glory. Regrinds become expensive when the wear becomes severe, and components are better served to be replaced at additional cost and increased delivery time.

Machine maintenance has a lot to do with tooling maintenance. A bent shaft or a misaligned shoulder is just adding additional workload to another pass that could potentially result in increased wear and tear. Keeping a machine tight and tidy is paramount to consistent results and profitable production.

OPERATIONAL CONTROL AND OPERATOR TRAINING

Although we never want to admit it, accidents do happen. We all know a story about a wrench that was rolled or a doubled strip wadded into a die. Those events are devastating to the bottom line in terms of lost productivity, scrap, damage, and of course, operator pride.



It happens; don't hang your head. But knowledge and training go hand in hand regarding operating complex machinery and getting maximum payback.

From assessing mill damage or alignment to tooling setup, timing concerns, and/or material issues, all considerations are in play regularly in a continuous operation. Training leads to knowledge and that leads to experience. A good motto to keep in mind is "shake hands with the mill often; it's your best friend," and most engineers and

operators will agree with that.

While machines are technically soulless, they do have personalities, and paying attention to subtle hints allows a great operator to stay in front of the changes they may be required to make during the day. A knowledgeable, experienced operator is worth their weight in gold and knows the value of documentation and record keeping. Setups are recipes. Wear points are measured. Footage is calculated. A disciplined operator can return or reset

a machine to the last documented run condition on a tooling setup or die assembly efficiently and consistently. Profit is made with efficiency just by reducing time, scrap costs, and tooling damage. We all have the same goal at the end of the day, but no individual has more impact on that goal more so than the operator.

In conclusion, this is just a quick list — almost an entry level review — of some of the intricacies regarding a roll form operation, with respect to tooling and die challenges and operational constraints. In the field, tooling and die production efficiency takes on different forms depending on the observer's viewpoint. But it ultimately comes down to communication and clarity in both design intent and product procurement, process improvement in everyday operation, operational maintenance, and training in day-to-day production decisions. **RF**

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Team Rubicon: Helping People In Crisis

Working Toward More Resilient Communities

■ By Linda Schmid

We mentioned in the December 2023 edition that the admission receipts from the 2023 Construction Rollforming Show would be donated to Team Rubicon. Here, we introduce you to the organization.

You may have heard of Team Rubicon, a humanitarian organization with local volunteers, or Greyshirts as they call them, in every state. The organization has grown from its inception 14 years ago when Jacob Wood, a Marine, pitched in to help Haiti after the 2010 hurricane that devastated the island. He met eight other volunteers during this mission, and they banded together to start a volunteer organization. Today Team Rubicon includes 160,000 Greyshirts. Once you find out a bit about Team Rubicon, you will understand how they manage to recruit so many volunteers!



Flooding response in San Diego. PHOTOS COURTESY OF TEAM RUBICON.

TEAM GOALS

Devon Miller, Sr. Communications Associate, explained that Team Rubicon engages in three phases of relief: mitigation, response, and recovery. Response is the part of their work that people are likely to hear about, it's the part that the media reports on, but all three phases are important.

Mitigation is about helping people to become prepared and even avoid problems when disasters strike. For example, clearing away the brush and flammable items from yards where wildfires are a threat and sandbagging in

areas that suffer from flooding.

Response is about showing up when disaster strikes and doing what needs to be done. This often means clearing the route so first responders can get to the people who need attention and organizing volunteers.

Recovery is about helping people get back into their homes. Sometimes that entails repairs and sometimes that requires rebuilding. The organization employs local tradespeople for these projects with the mindset that the money spent is invested in the local economy.

DOMESTIC & INTERNATIONAL SERVICES

The goal of the domestic services is to develop a bank of volunteers across the US that can jump into action when needed. Local volunteers who know the area and work to develop connections with local leaders and communities is invaluable. In times of crisis, they can help the team to find the areas where they are most needed, as well as helping them with places to shelter. Besides the local people, they have about 40,000 Greyshirts who will deploy to crisis areas as needed.

The international operation has many of the same goals as the domestic team, but there is greater focus on medical services, water, and hygiene. This is because these items are often scarce in the environment even before the disaster or crisis hit. Team Rubicon deploys mobile medical units, type 1, which means they are small and able to reach remote areas, and they are self-sustaining so the volunteers are not using resources that the locals need.

TEAM RUBICON IN HAWAII

Team Rubicon was fortunate enough to be part of the initial response to the devastating wildfires on Maui in August 2023. Erin O'Rourke, Operations Manager, said they operated in the up-country region of Kula which was attacked by the same fire that did so much damage in Lahaina. Their operation consisted of clearing the access route to the area, managing local volunteers, and handling the donations that came in. Post-disaster work is continuing in the region.

THE VETERAN CONNECTION

With labor shortages what they are, especially in hands-on work like the trades, one might think that it would be hard to



Hurricane response in Florida.

find workers and volunteers to fulfill the team's mission. One great resource is veterans.

The organization was developed by a veteran, and O'Rourke said, "We have found that military people are especially suited to do this work. They have the grit and determination we need."

She explained that their volunteer activities depend on what is needed in each individual case, but often Greyshirts use power saws to cut up trees and remove them from the access route and

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Hawaii wildfire recovery.

perform other manual labor. They work in grim circumstances and may be subjected to stark living conditions, and these are things that veterans have generally experienced before.

“Working with Team Rubicon often gives veterans a sense of purpose that they may be missing after they leave the [military] service,” O’Rourke said.

Miller estimates that about half of their volunteers are veterans. Training is provided to Greyshirts for such things as using power tools and leadership training, and some veterans have taken the skills they have developed with the organization and found employment opportunities, such as firefighting, working for FEMA, or as EMTs.

THE TRADES ACADEMY

Team Rubicon is working on a new initiative; they are developing a Trades Academy. The mission is to train people in skills such as carpentry, HVAC, and electrical work so they



Flooding response in San Diego.

will be able to better help with recovery, getting people back in their homes.

The Academy’s goal is to provide tuition-free training with the help of generous sponsors and partners like the A. James & Alice B. Clark Foundation. The academy will be open to all, as O’Rourke said, it’s for “people who want to give their time and make the world a better place.”

SUPPORTING THE MISSION

During a natural disaster, war, or a pandemic, people need many things. Miller quoted founder Jake Wood: “There are a thousand things that are more important than money, and all of them cost money.”

The team needs funds and volunteers, or “kick-ass civilians” who are willing to help, so they can continue coming to the aid of people in need across the country and the globe. If you would like to support Team Rubicon, visit teamrubiconusa.org/give. **RF**



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SCAN TO VIEW

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Show You Care

Legacy Metals' Quick Turn-Around Sets Them Apart

■ By Linda Schmid

AN OFFSHOOT OF PINE CREEK CONSTRUCTION

Legacy Metals Roofing & Siding was started to supply siding and roofing for its parent company, Pine Creek Construction (established 2003). There appeared to be room in the industry for a provider for contractors and homeowners too.

In 2015 at its inception, the company was called PC Metals by Amos Stoltzfus, owner and Henry Blank, manager. Management was shortly thereafter handed off to Henry Lapp who passed it to Daniel Stoltzfus in 2020. Daniel was out building pole barns among other things prior to becoming the manager. His experience in the field taught him a few things, such as the importance of exemplary customer service.

When there is a disaster, a builder can't do anything for the people affected unless a supplier goes out of their way to get the needed supplies to them quickly. "That kind of care takes you a long way in a business relationship," Daniel said.

In 2023, PC Metals was renamed Legacy Metals Roofing and Siding to help the company establish its own identity.

TAKING OFF

Legacy Metals is an Amish-run company, located in Elizabethtown, Pennsylvania, and a lot of its business has come from word of mouth. It also invested in local and magazine advertising, and catalogs. Amish companies are not always focused on an online presence; however, Legacy uses social media to engage with prospective customers in conjunction with its website. Daniel says that they have in-house designers and experts who handle these things for them. In-house means at corporate headquarters in Gratz, Pennsylvania.



Legacy Metals Shop in Elizabethtown, Pennsylvania.



Several machines from Acu-Form Equipment on the Legacy Metals production floor. PHOTOS COURTESY OF LEGACY METALS ROOFING & SIDING.

"We have English employees as well as Amish," Daniel said. "It has just worked out that way as the company grew. We have benefitted from being part of a larger company."

Legacy Metals supplies many markets, including agricultural, commercial, post-frame buildings, garages, and residential. The company manufactures snap-lock standing seam for homes, and last year it added a board and batten machine, too. Hixwood in Wisconsin supplies the company with coil.

NURTURING GROWTH

The company serves customers within a 100-mile radius of its shop in central Pennsylvania. According to Daniel, their main challenge is competition, but he says their brand identity helps them to stand out from the crowd. They are committed to outstanding customer service and quality products.

"We have 24-hour turn-around," Daniel said. "Get your metal package in hours, not days."

Of course, that is in addition to delivering a good quality product. Daniel's years in the field taught him the importance of quality. For example, inconsistent trim can cause problems, so the company worked hard early on to ensure their trim is uniform, and their happy customers can attest that they got it right.

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David Cox (left), CEO of The Bradbury Group, and Gary Moore, General Manager of Press Room Equipment Co.

THE BRADBURY GROUP ACQUIRES PRESS ROOM EQUIPMENT COMPANY

The Bradbury Group, a designer and manufacturer of roll forming and coil processing equipment, has announced the acquisition of the assets of Press Room Equipment Co. (PRE), a provider of press feed and coil handling equipment based in Springfield, Missouri.

Press Room Equipment Co. has over four decades of experience designing and manufacturing high-quality equipment for the metal stamping and fabrication industries. The company offers a wide range of products, including stock reels, pallet decoilers, straighteners, coil upenders, press feed systems, high-speed precision servo feeds and automated processing lines. In addition to the PRE brand, the acquisition includes the Norwalk and Waddington Electronic brands.

This acquisition marks a significant step in the long-standing collaborative relationship between The Bradbury Group and PRE, with PRE supplying equipment for Bradbury's roll forming lines for several decades. This new phase will enhance the companies' offerings and bolster their collaborative efforts.

David Cox, CEO of The Bradbury Group, expressed enthusiasm about welcoming PRE into their family.

"The alignment in values and the high quality of PRE's products and the integration of The Bradbury Group's technology and service capabilities are anticipated to expand PRE's product range, creating synergies and new opportunities for both entities and their customers," Cox says.

"We are thrilled to be part of the Bradbury Group," says Gary Moore, General Manager of Press Room Equipment. "Bradbury has been an established customer of ours and we have great respect for their roll forming lines

and engineering excellence. By joining their team, we will share resources and industry expertise, enabling us to offer cutting-edge solutions to the stamping and coil processing markets."

The Bradbury Group plans to maintain the operation of Press Room Equipment Co., LLC as an independent entity, with no alterations to its management, staff, or location. They will, however, provide technological and engineering support to facilitate PRE's growth and business expansion.

MILL STEEL WELCOMES NEW CFO

Mill Steel Co., one of the nation's largest distributors of flat-rolled carbon steel and aluminum, has announced the appointment of Justin Powell as its new Chief Financial Officer (CFO) following the retirement of its former CFO, Marc

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Rabito. Powell brings a wealth of experience and a proven track record of delivering financial success.

As a commercially focused finance executive, Powell drives identification, development, and execution of strategies that enhance company value. His extensive background spans flat-rolled production, engineered metal buildings, and building products manufacturing, reflecting a deep understanding of diverse steel industry dynamics.



Justin Powell, CFO, Mill Steel

Before joining Mill Steel Company, Powell served as CFO at ClarkDietrich Building Solutions, where he played a pivotal role in optimizing the steel framing business while expanding the portfolio of value added, downstream brands, products, and services. Prior to that, Powell spent 15 years with BlueScope Steel in various executive finance roles across BlueScope's global portfolio. In each role, Powell contributed to strategic planning and execution, championed successful technology upgrades, and drove improved profitability.

"We are thrilled to welcome Justin to our executive team. His extensive experience and strategic mindset make him an invaluable asset as we continue to expand our business. We are confident his financial acumen will contribute to Mill Steel's success" said Pam Heglund, CEO of Mill Steel Company.

Powell expressed his enthusiasm for joining Mill Steel Company, stating, "I am honored to be part of such a dynamic and forward-thinking organization. I look forward to the continued success and growth ahead for Mill Steel Company."

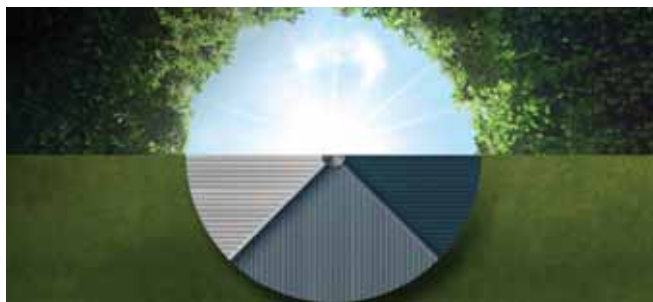
AKZONOBEL EXPLAINS ROLE OF COIL COATINGS IN BUILDING SUSTAINABLY

Modern coatings and digital technologies can help significantly reduce CO₂ emissions and increase circularity (i.e., reduce, reuse, and recycle) within the built environment, but the pace with which they can be introduced and the detail of future regulation will decide who wins and who loses future building contracts.

This is one of the key themes explored in a new White Paper from AkzoNobel that also examines traditional PVDF and FEVE coatings and their future use as protective metal coatings.

As governmental bodies around the world increase regulation to push the industry towards achieving net zero by 2050, coil manufacturers, along with their customers and suppliers are likely to be affected. Both have a business imperative to improve the sustainability of the built environment.

Amanda Paterline, Americas Commercial Marketing



Modern cool chemistry coatings can reduce the temperature of a building's roof by around 20°C/ 36°F.

Manager, Coil and Extrusion Coatings at AkzoNobel, says that coatings contribute to the circularity of the built environment in two ways: "On the one hand they insulate buildings against the cold and the heat, and on the other they protect metal building components from corrosion for years so that they can be recovered and reused."

"Modern cool chemistry coatings can reduce the temperature of a building's roof by around 20°C/ 36°F," Amanda adds, "which significantly lowers energy consumption, and consequently, Scope 3 downstream emissions."

Amanda says that even though metal substrates can be infinitely recycled, there are many ways that coating manufacturers can help contribute to circularity: "Our focus is reducing the amount of coating used and wasted and striving for a 'right first time' approach, using accurate dosing units, reusing excess paint, and implementing digital tools which assess and improve production efficiencies.

"The tools support coil coaters with just-in-time delivery to reduce over-ordering, storing and waste, and enable us to move to digital color sampling and matching instead of traditional painted panels, which also reduces waste and emissions."

AkzoNobel's white paper, *The Role of Coil Coatings in Building a Sustainable Environment* [download: <https://bit.ly/3wmjYxS>], is part of the company's ongoing campaign to help its partners

and coatings customers navigate the changing sustainability landscape and the reporting requirements; and help them make more informed decisions about how best to contribute to achieving net zero.

AMBASSADOR SUPPLY NAMES JOEL USINA MARKETING DIRECTOR

Ambassador Supply has named Joel Usina as the company's marketing director, effective immediately.

"Joel will elevate Ambassador Supply's brand and marketing strategies to new heights as the company gears up for serious growth," said Randy Carman, president of Ambassador Supply. "With his extensive marketing background and his diverse experiences from working as an independent contractor, Joel is well-equipped to drive advancements for our companies. Plus, Joel's community involvement aligns with Ambassador's values."

Usina's career includes over 12 years of marketing experience working as a website and graphic designer and as a director of marketing for Redfli Electronics / Redfli Design Build. In addition, Usina has held the role of director of operations and director of family services for Genesis Outreach.

"I'm excited to work with Ambassador Supply, and I look forward to leveraging my experience and expertise to propel the company's marketing efforts," said Usina. "Having spent over a decade engaged in marketing strategies for a variety of industries, I feel confident in my ability to collaborate with the team and lead the development and execution of our marketing vision."

SHEFFIELD METALS OPENING NEW BRANCH IN PLANT CITY, FLORIDA

Sheffield Metals International (SMI), a provider of coated and bare metal coil and sheet products, has announced a new branch opening in Plant City, Florida.

It's the sixth Sheffield Metals branch to open and the closest to its Acworth, Georgia, location. This new branch will provide convenience for existing customers in Florida and the Caribbean and help Sheffield Metals reach more of its target market.

Those customers currently buying products from Sheffield's Acworth, Georgia, location will now be able to get products from the Plant City location. **RF**

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SmartBuild, the industry leading all-metal building design software, is now capable of designing interior floor plans for Barndominiums and Offices.

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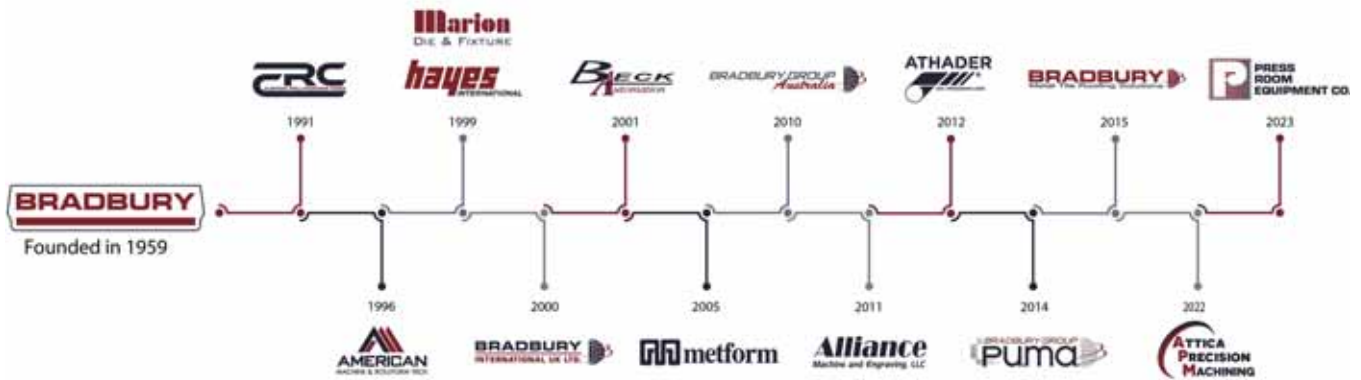


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Milestones))



The Bradbury Company marks 65th anniversary in 2024

The Bradbury Company, a global family of companies dedicated to the manufacturing of industry-leading metal processing equipment, is celebrating its 65th anniversary this year.

Founded in 1959, the Bradbury Company has expanded its global presence and diversified its product portfolio through several acquisitions and ventures to create The Bradbury Group. With a focus on innovation and customer satisfaction, The Bradbury Group caters

to a wide range of industries worldwide.

“At the Bradbury Group, we are dedicated to upholding our values, leveraging our core competencies and continuously enhancing our range of solutions,” says David Cox, CEO at The Bradbury Group. “We strive to live by these principles, allowing us to consistently meet the evolving needs of our customers and drive innovation in the industries we serve. We are open to new ideas that help our companies, employees, equipment and customers grow and evolve.”

The companies that make up the group include Alliance Machine and Engraving, American Machine and Rollform Tech, Athader Slitting Lines, Attica Precision Machining, Beck Automation, The Bradbury Co., Inc., Bradbury Group AUSTRALIA, Bradbury Group P.U.M.A., Bradbury Metal Tile Roofing Solutions, Bradbury UK, Custom Rollforming Corporation, Hayes International, Marion Die & Fixture, Metform International and Press Room Equipment Company. [RF](#)

Van Mark Products Inc. Celebrates 60 Years in 2024

Van Mark, manufacturer of portable metal bending and forming tools, has announced the celebration of its 60th anniversary, marking six decades of commitment to excellence, durability, and customer satisfaction. Since its inception in 1964, Van Mark has consistently delivered quality products, setting industry standards for heritage-quality tools.

Over the past six decades, Van Mark has evolved and adapted to the changing methods, materials, techniques, and design styles used in the construction industry, residential and commercial. The company’s longevity is a testament to its resilience, ingenuity, and dedication to providing tools that last.

Van Mark has been designing, manufacturing, and assembling portable metal bending brakes for the roofing and siding industries in Michigan since 1964. Offering a wide range of highly durable



Right: Early Van Mark brake with platform.
PHOTOS COURTESY OF VAN MARK

brakes that incorporate a unique-to-Van Mark cam lock design for reduced wear while requiring virtually no maintenance.

“As we celebrate our 60th anniversary, we owe our success to the dedication of our employees, the trust and loyalty of our customers, and the support of our dealers and vendors. Looking ahead to the next 60 years, Van Mark plans to continue to innovate, evolve, and remain the qual-



ity leader in our industry,” stated Gary Weinert, Director of Sales & Marketing at Van Mark. [RF](#)



BRASS KNUCKLE MEDIUM-DUTY GLOVE

Brass Knuckle® has announced improvements on its SmartCut™ (BKCR303) medium-duty glove. The gloves feature A2 cut protection, dexterity, and grip. Now improved with better tactile sensitivity, better fit, and the same protection.

OSHA estimates that over 70% of hand and arm injuries could be prevented with the proper protective equipment. That means considering form and fit as well as function. A glove that fits well promotes compliance; it's one that workers will want to wear.

BKCR303 starts with ultra-high-molecular-weight polyethylene fiber for ANSI cut resistance level A2 protection and thinner, 13-gauge material for dexterity. A non-sticky polyurethane (PU) coating on the palm and fingers creates a solid-gripping glove. Polyurethane also delivers enhanced puncture protection and abrasion resistance, all without adding bulk or reducing sensitivity.

The glove is designed specifically to provide enhanced flexibility and deliver the right balance of protection, performance, and comfort for medium-duty jobs such as material-handling applications requiring cut resistance and dexterity.

The polyurethane palm and finger coat delivers excellent grip even against oils, fats, and greases. An uncoated back and wrist improves ventilation, while a seamless and stretchable full knit wrist provides a snug fit and prevents dirt, debris, and cold from getting inside the glove. Color-coded cuffs indicate glove size.

www.brassknuckleprotection.com/



FASTENMASTER FRAMEFAST FASTENER

FastenMaster has introduced the new FrameFAST fastener, now featuring the patented TORX® ttap® Drive system. This new design empowers pros with the choice of using a standard impact driver or the FrameFAST tool. FrameFAST replaces many commonly used hurricane ties, installing 5X faster without the need for compressors, nailers, and hoses. The new 50-piece box and 250-piece bucket will include a free alignment guide ensuring a code compliant connection and TORX® ttap® driver bits that deliver a wobble-free drive.

"In 2011, FastenMaster began replacing hurricane ties with structural screws and in 2017 we introduced FrameFAST, the first system specifically designed to replace hurricane ties," said Nikki Long, Structural Business Unit Director. "Our latest innovation delivers FrameFAST to more pros without the need for a specific tool while increasing productivity for home builders, remodelers and deck builders."

The new fastener is certified for continuous load path applications including securing roof trusses, wall studs and plates, in addition to attaching deck joists to carrying beams. Backed by FastenMaster's exclusive ProjectLife Guarantee™, FrameFAST is guaranteed for the life of the project and is approved for use in ACQ pressure treated wood.

www.FastenMaster.com

MALCO TOOLS C-RHEX® DRIVER ADDITION

Malco Tools has announced additions to its C-RHEX® line including C-RHEX drivers and C-RHEX SAWTOOTH in



3/8" and 7/16" hex sizes. The new models offer more options to quickly and easily install and remove fasteners commonly used on commercial sites.

With the addition of 3/8" and 7/16" hex sizes to Malco's C-RHEX lines, trade professionals now have access to more driver options that feature a heavy-duty, deep-set magnet that does not contact the screw, so the fasteners spin true, and the magnet retains its strength for years to come.

Built with S2 hardened steel for long life and superior durability, the removable and reversible hex driver allows users to easily clean the socket and magnet. Trade pros can get back to work quickly by removing the driver from the impact to push the drive side of the shaft through the socket to quickly clear sealant buildup.

With the new SAWTOOTH 3/8" and 7/16" hex drivers, pros can rapidly remove sealant and adhesive-coated fasteners when doing retrofits or removals of existing HVAC equipment and ducting with the sawtooth action.

The C-RHEX drivers portfolio allows trade professionals to quickly change between popular hex sizes and eliminate troublesome buildup of sheet metal shavings with the swipe of a glove or towel. C-RHEX drivers are quick to set up and change between sizes while the driver shank remains installed in the drill chuck. The new hex reversible sockets in the 3/8" and 7/16" sizes ensure trade pros have the right size without the need for additional tools.

www.malcotools.com RF

GET MORE INFORMATION ABOUT PRODUCTS & SERVICES SEEN IN THIS ISSUE. HERE'S HOW:



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RF APRIL/MAY 2024

CSI: Positive Sentiment For Construction Roll Forming

We are currently wrapping up the CSI-Annual & Market Report. We are running a little behind (new projects always do) but look for the report to land, free of charge, in your mail box in late May or early June.

One of the hallmarks of our magazines is we make sure to include good news. The future of roll forming and metal forming appears to fall into that category.

A good measure of industry sentiment is a participant's willingness to invest in capital equipment. These types of investment require time to earn out, so making that choice is based on a long term positive outlook for the industry.

From our survey:

Immediate plans to expand in 2024	43.9%
Future plans to expand	19.5%
No expansion plans	36.6%

Two thirds of companies involved in roll forming are likely to expand in the near future.

60% of manufacturers who are involved in metal forming plan to add manufacturing equipment in 2024.

With growth and expansion, the next question is typically what direction the industry will take moving forward. According to our survey, rank these product and tech innovations as the top ones that will have an impact on their businesses.

Manufacturing automation	62.5%
Design and engineering software	47.5%
Manufacturing software	40%
Artificial Intelligence	37.5%



Look for more detail on this and other facets of roll forming and metal forming in the CSI-Annual & Market Report by Shield Wall Media, which is mailing in late spring 2024. [RF](#)

If you like the CSI columns or find the information useful, help us help you. Shield Wall media sends a State of the Industry Survey in fall and a mid-year State of the Industry Survey in Spring.

Please complete the survey and share it with your colleagues. A larger survey sample generates more reliable information.



For more titles, check out Shield Wall Media online: www.shieldwallmedia.com

Rosie The Riveter says:

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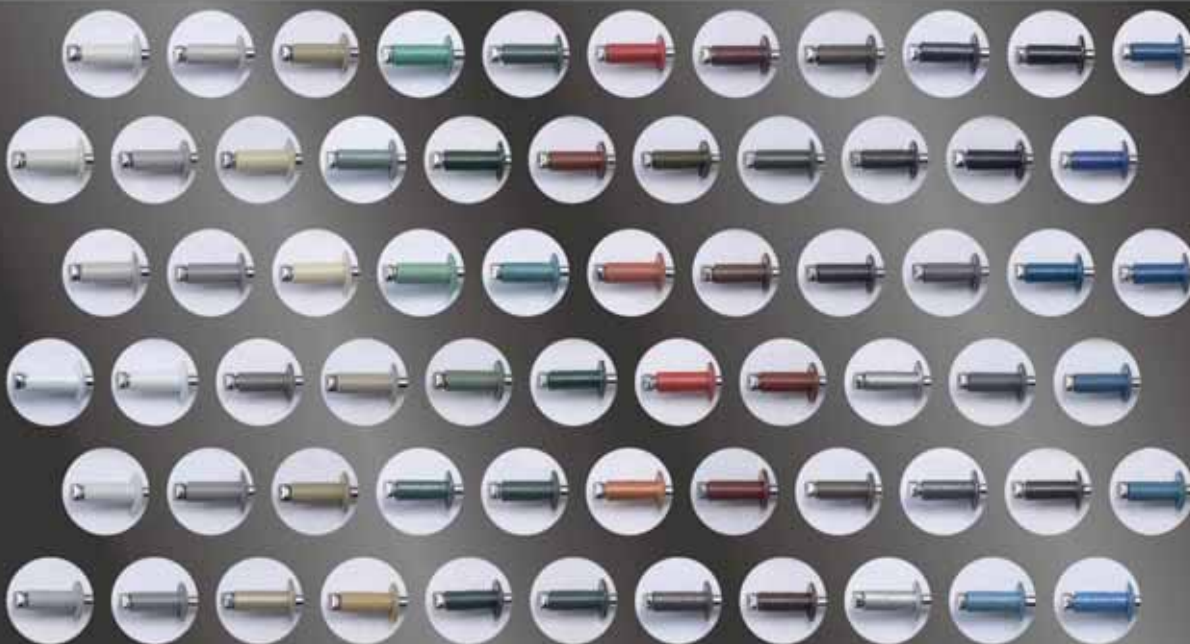


Rosie The Riveter says:
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