# Panel Sequencing

* Maximum panel size is 165” x 456”
* Any panel section that is taller than 165” must be assembled horizontally on the casting bed.
* Multiple panel sections can be assembled on one casting bed. We want to utilize as much of the casting bed as possible IF possible.
* We build the panel sections on the casting bed in the order they are consumed in the craneway.

The following is an example of our sequence:

Casting bed 1 – Roof 1

Casting bed 2 – Roof 3/Roof 2

Casting bed 3 – Ceiling 1

Casting bed 4 – Ceiling 2

Casting bed 5 – A1

Casting bed 6 – C2/A2

Casting bed 7 – C1

Casting bed 8 – B/D

This sequence represents an average building. (Cyrus P01657)

As you notice on Casting bed 2, we build Roof 3 on the far-left side of the casting bed first before we build Roof 2 on the same bed to complete the roof. This is due to how we demold our panels. Assembling wall sections in this order will result in Roof 2 coming down the monorail first.

Sheet Metal BOMs need to be organized to match this sequence.