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WELDLESS SHELF SUPPORT BEAMS AND SHELVING UNITS UTILIZING SAME

Abstract

A shelf support beam for use in a shelving unit to support a shelf. The support beam includes a first end and a second end at opposite longitudinal ends of the shelf support beam between which a structural member extends. The structural member has a C-shaped cross-section and includes a web separating a top flange configured to support the shelf from a bottom flange. The support beam further includes a tab located at each of the first and second ends of the structural member. Each tab includes a pair of securing fingers that are angled relative to a plane disposed perpendicular to a longitudinal axis of the shelf support beam such that each securing finger is angled inwardly toward a center of the structural member. The support beam further includes an enforcement tab formed in the web at each of the first and second ends of the structural member.

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Background/Summary

CROSS-REFERENCE TO RELATED APPLICATIONS [0001] This application is a divisional of U.S. application Ser. No. 18/427,968 filed Jan. 31, 2024 (pending), which is a continuation of U.S. application Ser. No. 17/972,683 filed Oct. 25, 2022 (pending), which claims the benefit of U.S. Provisional Application Ser. No. 63/315,744 filed on Mar. 2, 2022, and U.S. Provisional Application Ser. No. 63/272,385 filed on Oct. 27, 2021, the disclosures of which are incorporated by reference in their entirety.

TECHNICAL FIELD
[0002] This invention relates to shelving units, and more particularly to shelf support beams for use with shelving units.
BACKGROUND
[0003] Shelving units are commonly used for storing various items in a space-efficient manner. Such units typically include four vertical support posts arranged at corners of a generally rectangular pattern. Horizontal front and rear shelf support beams extend between the two front corner support posts and between the two rear corner support posts. Shorter horizontal shelf support beams are often positioned on opposing sides of the unit and extend between a front corner support post and a rear corner support post. In a conventional arrangement, such shelving units define multiple shelves and supporting beams one above the other with the corner support posts and shelf support beams of metal. For example, these components are often formed of sheet metal or steel and, in combination with shelves, are generally referred to as steel shelving or storage units.
[0004] As demand for metal shelving units rises, it becomes increasingly desirable to improve the design of shelving unit components to thereby reduce the cost to manufacture the components. This process may be referred to in industry as Design for Manufacturing (DFM), which is the process of designing components for ease of manufacturing those components at a lower cost. Reducing the number of parts in a product is one way to improve manufacturability and reduce cost. For example, certain components of a shelving unit, such as the shelf support beams, comprise several parts that are each individually manufactured, or machined, in a first manufacturing step and coupled together, such as by welding, in a second manufacturing step. Each step may be performed at a different manufacturing facility which requires the parts to be shipped for assembly, resulting in an additional manufacturing step and cost. For example, one way to improve a component's design for ease of manufacturing is to design the component in a way that eliminates one or more processing steps required to manufacture the component. Thus, an end goal of the DFM process is to achieve a component design that is both minimally complex from a manufacturing standpoint, yet the component retains a desired performance rating or has improved performance.
[0005] To this end, while metal shelving units are generally successful for their intended purpose and remain useful and popular with consumers, manufacturers and other providers continually

strive to improve upon their design for purposes of manufacturability. In this regard, it is desirable to reduce the cost, including materials, processing steps, and time required to manufacture certain components of shelving units without any significant loss in performance of those components. Furthermore, it is desirable to both improve the performance and ease of manufacturing of those components.

SUMMARY

[0006] In a first aspect of the invention, a shelf support beam for use in a shelving unit to support a shelf is disclosed. The shelf support beam includes a first end and a second end located at opposite longitudinal ends of the shelf support beam between which a structural member extends. The structural member is C-shaped in cross-section and includes a web that separates a top flange from a bottom flange. The bottom flange of the structural member is configured to support the shelf. The shelf support beam further includes a tab located at each of the first and second ends of the structural member. Each tab includes a pair of securing fingers. The shelf support beam also includes an enforcement tab formed in the web at each of the first and second ends of the structural member. To this end, each securing finger is angled inwardly toward the enforcement tab relative to a plane disposed perpendicular to a longitudinal axis of the shelf support beam to define a securing finger angle for each securing finger. The securing finger angle for each securing finger may be within a range of between 10° to 20°. The shelf support beam is designed for ease of manufacturing and is capable of being formed from a single piece of material. Furthermore, the arrangement of each securing finger and enforcement tab, which may be punch-formed in the shelf support beam, cooperate to provide the shelf support beam with an improved load carrying capacity compared to conventional, multi-piece horizontal support beams used for shelving units.

[0007] In one embodiment, each securing finger may include a stiffening rib. For example, in one embodiment, each stiffening rib may arcuately extend from a first terminal end on the tab to a second terminal end on the securing finger. The stiffening rib reinforces the respective securing finger against out of plane deformation when the support beam is under load. To this end, each securing finger and stiffening rib may be punch-formed.

[0008] In one embodiment, the top flange and the bottom flange of the structural member may be truncated at each of the first and second end of the shelf support beam to define abutment edges. In that regard, each tab may extend a distance beyond the abutment edges the first and second ends of the shelf support beam so as to be an extension of the web. In a further embodiment, each enforcement tab may include an outer surface that is generally coplanar with the abutment edges at each of the first and second end of the shelf support beam.

[0009] In yet another embodiment, each enforcement tab may terminate at base edge and a top edge. For example, the base edge may be located opposite a first one of the pair of securing fingers and the top edge may be located opposite a second one of the pair of securing fingers. In a further embodiment, each enforcement tab may define an elongate length between the base edge and the top edge. In that regard, the elongate length of each enforcement tab may be less than a distance that the pair of securing fingers are spaced apart.

[0010] In a second aspect of the invention, a shelving unit is disclosed. The shelving unit includes a plurality of posts, a plurality of shelves, and a plurality of shelf support beams. Each of the plurality of shelf support beams is configured to be attached to two posts of the plurality of posts to thereby support one of the plurality of shelves. Each shelf support beam includes a first end and a second end located at opposite longitudinal ends of the shelf support beam between which a structural member extends. The structural member is C-shaped in cross-section and includes a web that separates a top flange from a bottom flange. The bottom flange of the structural member is configured to support the shelf. Each shelf support beam further includes a tab located at each of the first and second ends of the structural member. Each tab includes a pair of securing fingers. Each shelf support beam also includes an enforcement tab formed in the web at each of the first and second ends of the structural member. To this end, each securing finger is angled inwardly toward

the enforcement tab relative to a plane disposed perpendicular to a longitudinal axis of the shelf support beam to define a securing finger angle for each securing finger. The securing finger angle for each securing finger may be within a range of between 10° to 20°.
[0011] In one embodiment, each securing finger may include a stiffening rib. For example, in one embodiment, each stiffening rib may arcuately extend from a first terminal end on the tab to a second terminal end on the securing finger. The stiffening rib reinforces the respective securing finger against out of plane deformation when the support beam is under load. To this end, each securing finger and stiffening rib may be punch-formed.
[0012] In one embodiment, the top flange may include an elevated portion and a shelf support portion separated by a sidewall. For example, the sidewall may have an S-shaped configuration with the shelf support portion being configured to support the shelf and the sidewall being configured to prevent lateral motion of the shelf toward the web.
[0013] In another embodiment, the top flange and the bottom flange of the structural member may be truncated at each of the first and second end of the shelf support beam to define abutment edges. For example, in one embodiment, each enforcement tab may include an outer surface that is coplanar with the abutment edges at each of the first and second ends of the shelf support beam.
[0014] In one embodiment, each of the plurality of posts of the shelving unit may include pairs of keyholes distributed along a length of the corner post. Each keyhole may be configured to receive a respective one of the pair of securing fingers therein to secure the shelf support beam to a respective post. In that regard, each keyhole may include a V-shaped portion that transitions to a rectangular-shaped portion. The V-shaped portion may have a vertical edge and a step-shaped angled edge that each extend from the V-shaped portion to the rectangular-shaped portion. To this end, the angled edge may have an angular relationship relative to the vertical edge that defines a keyhole angle. For example, in one embodiment, the keyhole angle for each keyhole is within a range of between 10° to 20°.
[0015] Additional features and advantages will be set forth in the detailed description which follows, and in part will be readily apparent to those skilled in the technical field of optical connectivity. It is to be understood that the foregoing general description, the following detailed description, and the accompanying drawings are merely exemplary and intended to provide an overview or framework to understand the nature and character of the claims.

Description

BRIEF DESCRIPTION OF THE DRAWINGS
[0016] The accompanying drawings are included to provide a further understanding and are incorporated in and constitute a part of this specification. The drawings illustrate one or more embodiment(s), and together with the description serve to explain principles and operation of the various embodiments. Features and attributes associated with any of the embodiments shown or described may be applied to other embodiments shown, described, or appreciated based on this disclosure.
[0017] FIG. **1** is an isometric view of an exemplary shelving unit in accordance with an embodiment of the invention.
[0018] FIG. **2** is a perspective view of a front side of a shelf support beam according to one embodiment of the invention.
[0019] FIG. **3** is a cross-sectional view of the shelf support beam of FIG. **2** taken along line **3**-**3**, illustrating a first end of the shelf support beam.
[0020] FIG. **4** is a perspective view of a back side of the shelf support beam of FIGS. **2**-**3**.
[0021] FIG. **5** is a cross-sectional view of the shelf support beam taken along line **5**-**5** of FIG. **4**, illustrating a second end of the shelf support beam.

[0022] FIG. **6** is plan view of the front side of the first end of the shelf support beam of FIGS. **2-5**.
[0023] FIG. **7** is a cross-sectional view of the shelf support beam taken along line **7-7** of FIG. **6**, illustrating the first end of the shelf support beam.
[0024] FIG. **8** is plan view of the back side of the second end of the shelf support beam of FIGS. **2-7**.
[0025] FIG. **9** is a cross-sectional view of the first end of the shelf support beam taken along line **9-9** of FIG. **8**.
[0026] FIG. **10** is an end view of the shelf support beam of FIGS. **2-9**.
[0027] FIG. **11** is a cross-sectional view of the shelf support beam of FIGS. **2-10** taken at a midpoint along the shelf support beam.
[0028] FIG. **12** is a partial cross-sectional view of a corner post of the exemplary shelving unit of FIG. **1**, illustrating the engagement between a pair of securing fingers, an enforcement tab, and the corner post according to an embodiment of the invention.
[0029] FIG. **13** is a partial cross-sectional view of a corner post for use with the shelving unit of FIG. **1** in accordance with another embodiment of the invention.
[0030] FIG. **14** is plan view of a front side of a second end of a shelf support beam according to another embodiment of the invention.
[0031] FIG. **15** is plan view of a back side of a first end of the shelf support beam of FIG. **14**.
[0032] FIG. **16** is plan view of a front side of a second end of a shelf support beam according to another embodiment of the invention.
[0033] FIG. **17** is plan view of a back side of a first end of the shelf support beam of FIG. **14**.
[0034] FIG. **18** is a perspective view of a front side of a shelf support beam according to another embodiment of the invention.
[0035] FIG. **19** is a cross-sectional view of the shelf support beam of FIG. **2** taken along line **19-19**, illustrating a first end of the shelf support beam.
[0036] FIG. **20** is a perspective view of a back side of the shelf support beam of FIGS. **18-19**.
[0037] FIG. **21** is a cross-sectional view of the shelf support beam of FIG. **20** taken along line **21-21**, illustrating a second end of the shelf support beam.
[0038] FIG. **22** is plan view of the front side of the first end of the shelf support beam of FIGS. **18-21**.
[0039] FIG. **23** is a cross-sectional view of the shelf support beam taken along line **23-23** of FIG. **22**.
[0040] FIG. **24** is plan view of the back side of the second end of the shelf support beam of FIGS. **18-22**.
[0041] FIG. **25** is a cross-sectional view of the second end of the shelf support beam taken along line **25-25** of FIG. **24**.
[0042] FIG. **26** is plan view of a front side of a second end of a shelf support beam according to another embodiment of the invention.
[0043] FIG. **27** is plan view of a back side of a first end of the shelf support beam of FIG. **26**.
[0044] FIG. **28** is a perspective view of a front side of a shelf support beam according to another embodiment of the invention.
[0045] FIG. **29** is a cross-sectional view of the shelf support beam of FIG. **28** taken along line **29-29**, illustrating a first end of the shelf support beam.
[0046] FIG. **30** is a perspective view of a back side of the shelf support beam of FIGS. **28-29**.
[0047] FIG. **31** is a cross-sectional view of the shelf support beam of FIG. **30** taken along line **31-31**, illustrating a second end of the shelf support beam.
[0048] FIG. **32** is plan view of the front side of the first end of the shelf support beam of FIGS. **28-31**.
[0049] FIG. **33** is a cross-sectional view of the shelf support beam taken along line **33-33** of FIG. **32**.

[0050] FIG. **34** is plan view of the back side of the second end of the shelf support beam of FIGS. **28-33**.
[0051] FIG. **35** is a cross-sectional view of the second end of the shelf support beam taken along line **35-35** of FIG. **34**.
[0052] FIG. **36** is an end view of the shelf support beam of FIGS. **28-35**.
[0053] FIG. **37** is a cross-sectional view of the shelf support beam of FIGS. **28-35**.
[0054] FIG. **38** is a side view of a crossbeam.
[0055] FIG. **39** is an end view of the crossbeam of FIG. **38**.
[0056] FIG. **40** is a top view of a blank used to form a beam according to one embodiment of the invention.
[0057] FIG. **41** is a top view of a blank used to form a beam according to another embodiment of the invention.

DETAILED DESCRIPTION

[0058] With reference to FIG. **1**, details of a shelving unit **10** are shown in which shelf support beams according to embodiments of the present invention have particular utility and/or aesthetic value. As shown, the shelving unit **10** includes four corner posts **12** arranged in a generally rectangular configuration. A front pair of corner posts **12** cooperate to carry one or more front horizontal shelf support beam(s) **14**, and a rear pair of corner posts **12** cooperate to carry one or more rear horizontal shelf support beam(s) **14**. As described in further detail below, the support beams **14** are formed by bending a single sheet of material, such as sheet of metal. Furthermore, appropriate fastening means used to selectively couple the shelf support beams **14** to corresponding corner posts **12** are punch-formed in the single sheet of material. In this regard, conventional shelf support beam designs require at least one secondary manufacturing operation, such as welding, to attach a fastening means to the formed beam **14**, which results in at least one additional manufacturing step, if not several. Applicant discovered that by punch-forming the fastening means and roll-forming the beam **14**, the beam **14** may be formed from a single piece of material thereby eliminating the need for additional manufacturing or processing steps. Thus, according to embodiments of the present invention, horizontal shelf support beams **14** are designed for ease of manufacturing and are capable of being formed from a single piece of material, requiring only minimal manufacturing processing steps, yet the shelf support beams **14** maintain or have improved load carrying capacity compared to conventional, multi-piece horizontal support beams used for shelving units.
[0059] With continued reference to FIG. **1**, one or more side rails **16** and/or diagonal braces **18** couple each front corner post **12** with a corresponding rear corner post **12**. Although not shown, corner posts **12** can carry side horizontal shelf support beams in addition or as an alternative to the side rails **16** and/or diagonal braces **18**. In this configuration, horizontal shelf support beams **14** would form an outer rim at one level of the shelving unit **10** and so extend between each post **12**. In either case, extending between each pair of horizontal shelf support beams **14** are one or more crossbeams **20**. Collectively, the pair of horizontal shelf support beams **14** and one or more crossbeams **20** support a shelf **22** of the shelving unit **10**. Items (not shown) may be stored on the shelf **22** in the normal course of using the shelving unit **10**. These items produce a load due to gravity on each of the shelf support beams **14** and crossbeams **20**, which is transferred to the posts **12**. One or more of the shelves **22** of the shelving unit **10**, and preferably each of the shelves **22** of the shelving unit **10**, may be configured as a wire rack. Other shelf **22** configurations, such as solid shelves, are also possible.
[0060] The horizontal shelf support beams **14** are configured to be selectively coupled to the posts **12** via releasable fastening means located at opposite ends of the shelf support beam **14**. More particularly and as will be described in further detail below, each end of the horizontal shelf support beams **14** includes a pair of punch-formed securing fingers **24** that are configured to be received within corresponding H-shaped or V-shaped keyholes **26** that are distributed along the length of the

corner posts **12**. The horizontal shelf support beams **14** couple to the corner posts **12** at the keyholes **26** and may be moved vertically with respect to the posts **12** such that the number of horizontal shelf support beams **14** and their respective heights along the posts **12** may be varied. Each end of the horizontal shelf support beams **14** further includes an enforcement tab **38** that serves to increase the surface contact between the shelf support beam **14** and the corner posts **12** to which the beam **14** is coupled to reduce torsion of the beam **14** when under load, as will be described in further detail below. As shown in FIG. **1**, the shelving unit **10** includes four horizontal shelves **22** supported by shelf support beams **14** and corresponding crossbeams **20** according to embodiments of the invention. However, it will be appreciated that any number of shelves **22** and corresponding horizontal shelf support beams **14** and crossbeams **20** may be used.

[0061] As described above, according to aspects of the present invention, the horizontal shelf support beams **14** are each formed from a single piece or sheet of material, otherwise referred to as a blank. The material may be sheet metal such as alloy steel, stainless steel, carbon steel, aluminum, or other suitable metal, for example. The horizontal shelf support beams **14** may be formed without the need for secondary manufacturing processes such as welding one or more components together to form the finished horizontal shelf support beam. Thus, the horizontal shelf support beam **14** is not a multi-piece or multi-component beam. Rather, the horizontal shelf support beam **14** is a unitary or monolithic beam. As will be described in further detail below, the horizontal shelf support beams **14** may be formed with minimal processing steps.

[0062] With reference to FIGS. **2**-**11**, details of the horizontal shelf support beam **14** according to one embodiment of the invention are shown and will now be described. In this regard, the shelf support beam **14** includes a first end **28** and a second end **30** located at opposite longitudinal ends of the shelf support beam **14** between which a structural member **32** that is formed in a generally C-shape extends. The generally C-shaped structural member **32** is partially truncated near each of the first and second ends **28**, **30** to define abutment edges **34** of the structural member **32** as well as plate-like tabs **36** at each end **28**, **30** of the shelf support beam **14**. The plate-like tabs **36** each extend a distance, in a longitudinal direction along an axial length of the support beam **14**, from each corresponding abutment edge **34** of the structural member **32**. Each tab **36** includes a pair of punch-formed securing fingers **24** for securing ends **28**, **30** of the shelf support beam **14** to corresponding corner posts **12** of the shelving unit **10**, and an enforcement tab **38**.

[0063] As best shown in FIGS. **10**-**11**, the structural member **32** has a C-shaped cross-sectional configuration and includes a top flange **40** and a bottom flange **42** between which a web **44** extends. The web **44** forms a vertical portion of the structural member **32** during use. Collectively, the web **44**, top flange **40**, and bottom flange **42** form the C-shape of the structural member **32** and further define a channel **46** that extends a length of the structural member **32**. The web **44** may be radiused at each of the locations at which the structural member **32** transitions to the top flange **40** and to the bottom flange **42**. In any event, the top flange **40** is configured to receive a shelf **22** and extends generally inwardly in the shelving unit **10** (e.g., FIG. **1**) and in a direction away from the web **44**. More particularly, the top flange **40** has an S-shaped configuration with an elevated portion **48** defining a top surface **50** and a lower portion **52** defining a lower surface **54**. A sidewall **56** transitions from the elevated portion **48** to the lower portion **52** to provide the S-shaped configuration.

[0064] A shelf **22** is supported on lower portion **52** with the sidewall **56** providing a stop for lateral movement of the shelf **22** in an outward direction (i.e., toward the web **44**) in the shelving unit **10**. The lower portion **52** may have one or more bores **58** located therein with at least one bore **58** being located near each end **28**, **30** of the shelf support beam **14** (e.g., FIGS. **4**-**5**). The bores **58** are configured to receive a tie member, such as a wire tie clip, used to increase the load capacity of the shelving units. This positive connection prevents the shelves **22** from unintentional and undesirable movement during use and during movement or transport of the shelving unit **10**. By way of example only, tie clips are shown and described in commonly owned U.S. Pat. No. 10,806,251,

which is incorporated by reference herein in its entirety. In any event, a pair of existing shelf support beams **14** positioned on the front and rear sides of the shelf **22** captures the shelf **22** between opposing sidewalls **56** to prevent unwanted lateral movement of the shelf **22**. Generally, a height of the sidewall **56** (e.g., a distance between the lower surface **54** and the top surface **50**) may be approximately a thickness of a shelf **22**. The shelf **22** is then approximately flush with the top surface **50**. The top surface **50** may be a flat surface and generally planar or parallel with the lower surface **54** and the bottom flange **42**.

[0065] The bottom flange **42** joins the web **44** on an opposite end of the web **44** from the top flange **40**. The bottom flange **42** is configured to receive the one or more crossbeams **20** and extends generally inwardly in the shelving unit **10** (e.g., FIG. **1**) and in a direction away from the web **44**. The bottom flange **42** includes one or more spaced apart apertures **60** (e.g., FIG. **4**) configured to receive and secure an end of a corresponding crossbeam **20** to the bottom flange **42**. The apertures **60** are oblong in shape and are spaced apart a desired distance along a length of the bottom flange **42**. For example, each horizontal shelf support beam **14** may have three apertures **60** spaced equally apart along a length of the beam **14** to support three corresponding crossbeams **20**.

[0066] Referring now to FIGS. **2-9**, the plate-like tabs **36** are an extension of the web **44** at each end **28**, **30** of the shelf support beam **14**. In this regard, the top flange **40** and the bottom flange **42** define the abutment edges **34** at each end **28**, **30** of the shelf support beam **14**. When coupled between a pair of corner posts **12**, each tab **36** is configured to engage with an outwardly facing surface **62** of the corner post **12** while the abutment edges **34** are configured to engage with an inwardly facing surface **64** of the corner post **12** (e.g., FIG. **12**). The H-shaped or V-shaped keyholes **26** are formed in the outwardly facing surface **62** of each corner post **12**. The engagement between the tabs **36** and abutment edges **34** and corresponding corner posts **12** is maintained as a result of the engagement between each securing finger **24** and corresponding keyhole **26**, as well as the enforcement tab **38** and the corner post **12**, as will be described in further detail below.

[0067] With continued reference to FIGS. **2-9**, details of the securing finger **24** are shown and will now be described with respect to the first and second ends **28**, **30** of the shelf support beam **14**. While the securing fingers **24** and enforcement tab **38** are shown and described with respect to certain ends **28**, **30** of the shelf support beam **14**, it is understood that the securing fingers **24** and enforcement tab **38** at each end **28**, **30** of the shelf support beam **14** are similarly configured. In that regard, each end **28**, **30** of the shelf support beam **14** includes two securing fingers **24** that extend generally inwardly in the shelving unit **10** (e.g., FIG. **1**) and in a direction toward the channel **44** and the center of the beam **14**. Each securing finger **24** is punch-formed in the respective tab **36** of the support beam **14** so as to be partially cut from the tab **36** and bent inwardly (i.e., in a direction toward to the channel **46** formed by the beam **14**) to form the shape of the securing finger **24**. In that regard, each securing finger **24** may have a same thickness as the tab **36**. As shown, each securing finger **24** further includes a stiffener or stiffening rib **66** that is formed in each finger **24** and the tab **36** during punch-forming of the securing finger **24**, as will be described in further detail below.

[0068] As shown in FIGS. **6-9**, the securing fingers **24** are aligned on the tab **36** and spaced apart a distance along a height of the tab **36**. The height of the tab **36** is a distance between an upper edge **68** and a lower edge **70** of the tab **36**. In that regard, one securing finger **24** is located closer to the upper edge **68** of the tab **36** with the other securing finger **24** being located closer to the lower edge **70** of the tab **36**. Further, the securing fingers **24** are positioned between an end edge **72** of the tab **36** and the abutment edges **34** so as to be generally centered therebetween on the tab **36**. However, the securing fingers **24** may be slightly offset in either direction so as to be closer to the end edge **72** of the tab **36** or the abutment edges **34**, for example.

[0069] With continued reference to FIGS. **6-9**, each securing finger **24** has a generally rectangle-shaped profile and includes a base edge **74**, a top edge **76**, a distal edge **78**, an outer surface **80**, and an inner surface **82**. As best shown in FIG. **9**, the inner and outer surfaces **82**, **80** of each securing

finger **24** are curved to provide each securing finger **24** with a generally S-shaped configuration. Each securing finger **24** projects from a bend line **84** on the tab **36**, in a direction toward the enforcement tab **38**, to the distal edge **78** which is spaced a distance away from the tab **36**. Forming of the securing finger **24** results in a rectangle-shaped aperture **86** being formed in the tab **36** beneath the inner surface **82** of the finger **24** (e.g., FIGS. **5-6**). To this end, the space between the inner surface **82** of each finger **24** and the respective aperture **86** of the tab **36** defines a pocket **88**. The pocket **88** is configured to face, or open towards the enforcement tab **38**, and may be V-shaped, for example. In that regard, when the shelf support beam **14** is engaged with the corner post **12**, each securing finger **24** is engaged with a corresponding keyhole **26** such that a portion of the corner post **12** is received within each pocket **88**.

[0070] As briefly described above, each securing finger **24** also has a stiffening rib or stiffener **66** that is formed during the punch-forming of each securing finger **24**. In that regard, the same punch may be used to form both the securing finger **24** and the stiffener **66** at the same time, for example. The stiffener **66** is configured to strengthen or stiffen the securing finger **24** against out of plane deformation when the support beam **14** is under load, particularly along the bend line **84** of the securing finger **24**. As shown in FIGS. **6-8**, each stiffener **66** is formed so as to arcuately extend from the tab **36** a distance along the outer surface **82** of the respective securing finger **24**. Each stiffening rib **66** includes a raised spine **90** that defines a generally flat surface and a pair of radiused sidewalls **92** that extend between the spine **90** and surfaces of the securing finger **24** and the tab **36**. As shown, each spine **90** arcuately extends from a first terminal end on the tab **36** to a second terminal end on the securing finger **24**. More particularly, each stiffener **66** extends across the bend line **84** in a generally perpendicular manner such that a height of each stiffener **66** is generally greatest in a region where the stiffener **66** passes over the bend line **84**.

[0071] Referring now to FIG. **8**, the bend line **84** of each securing finger **24** is angled relative to a plane axis **94** disposed perpendicular to a longitudinal axis **96** of the shelf support beam **14** such that the entirety of each securing finger **24** is angled inwardly away from the end edge **72** of the tab **36** and toward a center of the structural member **32**. Stated another way, the securing fingers **24** are each angled inwardly toward the enforcement tab **38**. In this regard, the top edge **76** of each securing finger **24** is positioned closer to the enforcement tab **38** compared to the base edge **74** of each securing finger **24**. The angled relationship between the bend lines **84** and the plane axis **94** defines a securing finger angle θ.sub.st for each securing finger **24**. The securing finger angle θ.sub.sf may be the same or different for each securing finger **24**. In any event, the securing finger angle θ.sub.st for each securing finger **24** may be within a range of between 5° to 30°, for example. Preferably, the angle θ.sub.sf is within a range of between 10° to 20° and, in the embodiment shown, the securing finger angle θ.sub.sf is 11° for each securing finger **24**. As described in further detail below, the securing finger angle θ.sub.sf generally corresponds to a configuration of the keyholes **26** formed in the corner posts **12**.

[0072] With reference to FIGS. **2-10**, ends **28**, **30** of the shelf support beam **14** also include the enforcement tab **38** which is formed in the structural member **32** between the top flange **40** and the bottom flange **42** so as to be generally in-line (or co-planar) with the abutment edges **34** (e.g., FIGS. **7-8**). Each enforcement tab **38** serves to increase the surface contact between the shelf support beam **14** and the corner posts **12** to which the beam **14** is coupled. The increase in surface contact reduces torsion of the shelf support beam **14** when under load, thereby increasing the load bearing capacity of the shelf support beam **14**. Moreover, the combination of the pair of securing fingers **24** and the enforcement tab **38** at each end **28**, **30** of the shelf support beam **14** results in an increased load bearing capacity for the shelf support beam **14**. Each enforcement tab **38** is also punch-formed in in the beam **14**. To this end, each of the securing fingers **24** and enforcement tabs **38** are punch-formed and comprise a single layer, or sheet, of material which reduces the manufacturing steps needed to form the single-piece shelf support beam **14**.

[0073] As shown in FIGS. **6-9**, the enforcement tab **38** has a generally rectangle-shaped profile and

includes a base edge **98**, a top edge **100**, a distal edge **102**, an outer surface **104**, and an inner surface **106**. The inner and outer surfaces **104**, **106** are generally planar such that the enforcement tab **38** has a cross-section that is generally rectangular in shape. The enforcement tab **38** projects from a bend line **108** to the distal edge **102** so as to be generally perpendicular to the tab **36** and web **42**, as shown in FIG. **9**. Punch-forming of the enforcement tab **38** results in a rectangle-shaped aperture **110** being formed generally in the web **42** of the structural member **32**. To this end, the aperture **110** is located between the enforcement tab **38** and the center of the structural member **32**. Once formed, the enforcement tab **38** has a height defined by a distance between the bend line **108** and the distal edge **102**, and a length defined by a distance between the base edge **98** and the top edge **100**. As shown, the length is greater than the height of the enforcement tab **38** to maximize surface contact potential between the enforcement tab **38** and the post **12** while limiting a width of the aperture **110** (e.g., a distance that the aperture **110** extends along the longitudinal axis **96** of the shelf support beam **14**). An aperture **110** with a large width may weaken the beam **14** at the ends **28**, **30**, particularly with respect to torsional forces, and compromise the load bearing capacity of the beam **14**. A longitudinal axis of the enforcement tab **38** (i.e., a line extending along the length of the enforcement tab **38**) is generally perpendicular to the longitudinal axis **96** of the shelf support beam **14** and generally parallel with plane axis **94**. To this end, the securing fingers **24** are also angled relative to the enforcement tab **38**.

[0074] With continued reference to FIGS. **6-9**, the enforcement tab **38** is spaced away from the pair of securing fingers **24** so as to be located between the top flange **40** and the bottom flange **42** of the structural member **32**. More particularly, the enforcement tab **38** is generally centered between the lower portion **52** of the top flange **40** and the bottom flange **42**. The enforcement tab **38** is positioned such that the top edge **100** of the enforcement tab **38** opposes one of the securing fingers **24** and the base edge **98** of the enforcement tab **38** opposes the other one of the securing fingers **24**. The enforcement tab **38** does not, for example, extend to the top edge **68** and the lower edge **70** of the tab **36**, but instead has a length configured to provide sufficient contact between the shelf support beam **14** and the corner post **12** to which it is attached. The length may also be determined based on manufacturing considerations. As such, in one embodiment it is preferable that the enforcement tab **38** have a length such that neither the base edge **98** nor the top edge **100** extend beyond respective securing fingers **24** but may be at a position between the respective securing finger **24** and the upper or lower edge **68**, **70** of the tab **36**. In one specific example, the base edge **98** and the top edge **100** terminate approximately at a location opposite the midpoint of the respective securing fingers **24**. As shown in FIG. **10**, the height of the enforcement tab **38** is greater than a height of the pair of securing fingers **24** measured from surfaces of the web **44** and tab **36**, for example. As the enforcement tab **38** is located on the web **44** of the structural member **14**, rather than the tab **36**, for example, the outer surface **104** of the enforcement tab **38** is coplanar with the abutment edges **34** to engage with the inwardly facing surface **60** of the corner post **12** (e.g., FIG. **9**), as will be described in further detail below.

[0075] FIG. **12** illustrates the second end **30** of the shelf support beam **14** engaged with a corner post **12** of the shelving unit **10**. When so positioned, each securing finger **24** is received within a respective keyhole **26** to position the enforcement tab **38** in an abutting or near abutting relationship with the inwardly facing surface **64** of the corner post **12**. As shown, each keyhole **26** includes a generally V-shaped portion **112** at one end that transitions to a generally rectangular-shaped portion **114** at the opposite end. The V-shaped portion **112** is defined by a vertical edge **116** and an angled edge **118** which meet at a base **120**. The vertical edge **116** is parallel with a longitudinal axis of the corner post **12** and extends from the V-shaped portion **112** to the rectangle-shaped portion **114**. At the transition to the rectangle-shaped portion **114**, the vertical edge **116** transitions to an angled portion **122** that extends to a top edge **124** of the keyhole **26**. The angled edge **118** extends from the V-shaped portion **112** to the rectangular-shaped portion **114** in a step-shaped manner and at an angle relative to the vertical edge **116**. More particularly, the angled edge

118 is angled away from the vertical edge **116**, in a direction toward a nearest sidewall **126** of the corner post **12**, to define a keyhole angle θ.sub.k. The keyhole angle θ.sub.k may be the same or substantially similar to the securing finger angle θ.sub.sf. Thus, the keyhole angle θ.sub.k may be within a range of between 5° to 30°, for example. Preferably, the angle θ.sub.k is within a range of between 10° to 20° and, in the embodiment shown, the angle θ.sub.k is 12°.

[0076] The step-shaped configuration of the angled edge **118** defines a base portion **128**, a shoulder **130**, and a top portion **132** of the angled edge **118**. The base portion **128** forms part of the V-shaped portion **112** of the keyhole **26** and transitions to the top portion **132** via the shoulder **130**. The top portion **132** forms part of the rectangle-shaped portion **114** of the keyhole **26**. The base portion **128** and the top portion **132** may have the same angle θ.sub.k relative to the vertical edge **116**. The rectangle-shaped portion **114** of the keyhole **26** may be defined by the top portion **132** of the angled edge **118**, the top edge **124**, and the angled portion **122** of the vertical edge **116**. The V-shaped portion **112** may be defined by the shoulder **130** and base portion **128** of the angled edge **118**, the radiused base **120**, and the vertical edge **116**. The V-shaped portion **112** is configured to receive a corresponding securing finger **24** for coupling the shelf support beam **14** to the corner post **12**, as described in further detail below.

[0077] With continued reference to FIG. **12**, each tab **36** is configured to engage with a front wall **134** (i.e., the outwardly facing surface **62** of the front wall **134**) of the corner post **12** while the abutment edges **34** and enforcement tab **38** are configured to engage with the sidewall **126** (i.e., the inwardly facing surface **64** of the sidewall **126**) of the corner post **12** to couple the shelf support beam **14** to the corner post **12**. As shown, the front wall **134** of each corner post **12** includes the keyholes **26**. The engagement between the tabs **36**, abutment edges **34**, enforcement tab **38**, and corresponding corner posts **12** is maintained as a result of the engagement between each securing finger **24** and corresponding keyhole **26**, as will be described in further detail below.

[0078] To couple the shelf support beam **14** to the corner post **12**, as shown in FIG. **12**, the securing fingers **24** are first received through the rectangle-shaped portion **114** of each respective keyhole **26**. Once the securing fingers **24** are received within each keyhole **26**, the shelf support beam **14** may be lowered until the base edge **74** of each securing finger **24** engages with the base **120** of each respective keyhole **26**. When so positioned, as shown, the angled portion **128** of each keyhole **26** and part of corner post **12** are received within the pocket **88** of each respective securing finger **24**. More particularly, each securing finger **24** is engaged with the radiused base **120** and the angled portion **128** of each keyhole **26**, and extends between the radiused base **120** and the shoulder **130**. As the securing fingers **24** are seated in respective keyholes **26**, the enforcement tab **38** is brought into engagement with the sidewall **126** of the corner post **12**. When the securing fingers **24** are fully seated within the keyholes **26**, as shown, the sidewall **126** is pressed into engagement with the outer surface **104** of the enforcement tab **38**.

[0079] The angled engagement between the securing fingers **24** and the keyholes **26** causes a friction fit between the enforcement tab **38**, abutment edges **34**, and the sidewall **126** of the corner post **12** to prevent the shelf support beam **14** from being inadvertently uncoupled from the corner post **12**. The weight of the shelf support beam **14**, shelf **22**, and any items supported thereon, generate a force in a downward direction on the support beam **14** that acts to further maintain the engagement between each securing finger **24** and corresponding keyhole **26**. Moreover, the engagement between each tab **36** and each front wall **134**, and each enforcement tab **38** and each sidewall **126** of the corner posts **12** counteracts any torsional forces acting on the beam **14** that would cause the securing fingers **24** to disengage with the keyholes **26**. To this end, the tab **36**, which has a height similar to a height of the web **42** of the structural member **32**, improves the performance and load carrying capacity of the shelf support beam **14**.

[0080] FIG. **13** illustrates a corner post **12***a* having pairs of V-shaped keyholes **26***a* distributed along a length of the corner post **12***a* in accordance with another embodiment of the invention. The corner post **12***a* is similar in many respects to the embodiment of the corner post **12** previously

described and shown with regard to FIGS. **1-12**, and thus like numerals represent like features. The primary difference between the corner post **12***a* of this embodiment and the corner post **12** of the above-described embodiment is the configuration of the keyholes **26***a*. In this regard, the keyholes **26***a* are distributed along the length of the corner post **12***a* in a manner similar to the keyholes **26** described above. However, the keyholes **26***a* have a different shape to facilitate coupling of the shelf support beam **14** to the corner post **12***a*, as will be described in further detail below.

[0081] As shown in FIG. **13**, each keyhole **26***a* has a generally vertical edge **136** and an angled edge **138** which meet at a base **140**. Together, the vertical edge **136** and angled edge **138** define a generally V-shaped configuration of each keyhole **26***a*. In this regard, the angled edge **138** is angled relative to the vertical edge **136** to define a keyhole angle θka. Like the embodiment described above with respect to FIG. **12**, the keyhole angle θka may be the same or substantially similar to the securing finger angle θ.sub.sf of each securing finger **24**. Thus, the keyhole angle θka may be within a range of between 5° to 30°, for example. Preferably, the angle θka is within a range of between 10° to 20° and, in the embodiment shown, the angle θka is 12° for each keyhole **26***a*.

[0082] To couple the shelf support beam **14** to the corner post **12***a*, the securing finger **24** is first received through a widest part of the V-shaped keyhole **26***a* (e.g., where a distance between the vertical edge **82** and angled edge **84** is the greatest). Once the securing fingers **24** are received within respective keyholes **26***a*, the shelf support beam **14** may be lowered until the base edge **74** of each securing finger **24** engages with the corresponding base **140** of each keyhole **26***a*. When so positioned, the angled edge **138** and part of corner post **12***a* are received within the pocket **88** of each corresponding securing finger **24**. To this end, the weight of the shelf support beam **14**, shelf **22**, and any items support thereon, generate a force in a downward direction on the support beam **14** that acts to maintain the engagement between each securing finger **24** and corresponding keyhole **26***a*. Further, the engagement between each tab **36** and each outwardly facing surface **58** of the corner posts **12***a* counteracts any torsional forces acting on the beam **14** that would cause the securing fingers **24** to disengage with the keyhole **26***a*.

[0083] With reference to FIGS. **14-15**, details of a horizontal shelf support beam **14***a* are shown in accordance with another embodiment of the present invention. The shelf support beam **14***a* is similar in many respects to the shelf support beam **14** described above with respect to FIGS. **1-12** and therefore like numerals represent like features. The primary difference between the shelf support beam **14***a* of this embodiment and the shelf support beam **14** of the above-described embodiment is that the securing fingers **24***a* are formed without a stiffening rib **66**. To this end, the support beam **14***a* includes the structural member **32** having a C-shaped cross-sectional configuration, and therefore those details of the support beam **14***a* will not be redescribed for purposes of brevity.

[0084] As shown in FIGS. **14-15**, the tab **36***a* includes a pair of securing fingers **24***a* and an enforcement tab **38** like the embodiment of the support beam **14** described above with respect to FIGS. **1-12**. Each securing finger **24***a* is punch-formed so as to be partially cut from the tab **36** and bent inwardly (i.e., in a direction toward to the enforcement tab **38** formed by the beam **14***a*) to form the shape of the securing finger **24***a*. In that regard, each securing finger **24***a* has a generally rectangle-shaped profile and includes a base edge **74***a*, a top edge **76***a*, a distal edge **78***a*, an outer surface **80***a*, and an inner surface **82***a*. The inner and outer surfaces **82***a*, **80***a* are curved such that each securing finger **24***a* has an S-shaped cross-section. To this end, as each securing finger **24***a* is punch-formed without a stiffening rib **66**, the inner and outer surfaces **82***a*, **80***a* are generally planar as they extend from the bend line **84***a* to the distal edge **78***a* of the securing finger **24***a*. Forming of the securing finger **24***a* results in a rectangle-shaped aperture **86***a* being formed in the tab **36***a* beneath the inner surface **82***a* of each finger **24***a*.

[0085] As shown in FIG. **15**, the bend line **84***a* of each securing finger **24***a* is angled relative to a plane axis **94***a* disposed perpendicular to a longitudinal axis **96***a* of the shelf support beam **14***a* such that the entirety of each securing finger **24***a* is angled inwardly toward a center of the

structural member **32** and the enforcement tab **38**. The angled relationship between the bend lines **84***a* and the axis **94***a* defines a securing finger angle θ.sub.sfa for each securing finger **24***a*. The securing finger angle θ.sub.sta may be the same or different for each securing finger **24***a*. In either case, the securing finger angle θ.sub.sta for each securing finger **24***a* may be within a range of between 5° to 30°, for example. Preferably, the angle θ.sub.sfa is within a range of between 10° to 20° and, in the embodiment shown, the securing finger angle θ.sub.sta is 11° for each securing finger **24***a*.

[0086] With reference to FIGS. **16-17**, details of a horizontal shelf support beam **14***b* are shown in accordance with another embodiment of the present invention. The shelf support beam **14***b* is similar in many respects to the shelf support beam **14** described above with respect to FIGS. **1-12** and therefore like numerals represent like features. The primary difference between the shelf support beam **14***b* of this embodiment and the shelf support beam **14** of the above-described embodiment is that the shelf support beam **14***b* includes only one securing finger **24***b* formed without a stiffening rib **66**. While not shown, in an alternative embodiment, each securing finger **24***b* may include a stiffening rib **66** that is formed in each finger **24***b* during punch-forming of the securing finger **24***b*. In either case, the support beam **14***b* includes the structural member **32** having a C-shaped cross-sectional configuration, and therefore those details of the support beam **14***b* will not be redescribed for purposes of brevity.

[0087] As shown, the securing finger **24***b* is centrally located on the tab **36***b* and is punch-formed so as to be partially cut from the tab **36***b* and bent inwardly to form the shape of the securing finger **24***b*. In that regard, the securing finger **24***b* may have a same thickness as the tab **36***b*. More particularly, the securing finger **24***b* has a generally rectangle-shaped profile and includes a base edge **74***b*, a top edge **76***b*, a distal edge **78***b*, an outer surface **80***b*, and an inner surface **82***b*. The inner and outer surfaces **82***b*, **80***b* are curved such that each securing finger **24***b* has an S-shaped cross-section. To this end, as each securing finger **24***b* is punch-formed without a stiffening rib **66**, the inner and outer surfaces **82***b*, **80***b* are generally planar as they extend from the bend line **84***b* to the distal edge **78***b* of the securing finger **24***b*. Forming of the securing finger **24***b* results in a rectangle-shaped aperture **86***b* being formed in the tab **36***b* beneath the inner surface **82***b* of each finger **24***b*.

[0088] As shown in FIG. **17**, the bend line **84***b* of the securing finger **24***b* is angled relative to a plane **94***b* disposed perpendicular to a longitudinal axis **96***b* of the shelf support beam **14***b* such that the entirety of the securing finger **24***b* is angled inwardly toward a center of the structural member **32**. The angled relationship between the bend line **84***b* and the axis **94***b* defines a securing finger angle θ.sub.sfb for the securing finger **24***b*. The securing finger angle θ.sub.sfb for the securing finger **24***b* may be within a range of between 5° to 30°, for example. Preferably, the angle θ.sub.sfb is within a range of between 10° to 20° and, in the embodiment shown, the securing finger angle θ.sub.stb is 11° for the securing finger **24***b*.

[0089] With reference to FIGS. **18-25**, wherein like numerals represent like features relative to the shelf support beam **14** described above with respect to FIGS. **1-12**, for example, details of a horizontal shelf support beam **14***c* are shown in accordance with another embodiment of the present invention. The primary differences between the shelf support beam **14***c* of this embodiment and the shelf support beam **14** of the above-described embodiment is the configuration of the structural member **32***c*, tabs **36***c*, securing fingers **24***c*, and enforcement tabs **38***c*, each of which will be described in further detail below.

[0090] Similar to the shelf support beam **14** of the embodiment described with respect to FIGS. **1-12**, the shelf support beam **14***c* includes a first end **28***c* and a second end **30***c* located at opposite longitudinal ends of the shelf support beam **14***c* between which the structural member **32***c* extends. The generally C-shaped structural member **32***c* is partially truncated near each of the first and second ends **28***c*, **30***c* to define abutment edges **34***c* of the structural member **32***c* as well as the plate-like tabs **36***c* at each end **28***c*, **30***c* of the shelf support beam **14***c*. The plate-like tabs **36***c* each

extend a distance, in a longitudinal direction, from each corresponding abutment edge **34***c* of the structural member **32***c*. Compared to the tabs **36** of the above-described embodiment, the tabs **36***c* of this embodiment extend a greater distance from each corresponding abutment edge **34***c* of the structural member **32***c*. That way, each tab **36***c* has a larger surface area to engage with the corner post **12** when mounted thereto. To this end, each tab **36***c* includes a pair of punch-formed securing fingers **24***c* for securing ends **28***c*, **30***c* of the shelf support beam **14***c* to corresponding corner posts **12** of the shelving unit **10**, and an enforcement tab **38***c*.

[0091] With reference to FIGS. **19-21**, the structural member **32***c* has a C-shaped cross-sectional configuration and includes a top flange **40***c* and a bottom flange **42***c* between which a web **44***c* extends. The web **44***c* forms a vertical portion of the structural member **32***c* during use. Collectively, the web **44***c*, top flange **40***c*, and bottom flange **42***c* form the C-shape of the structural member **32***c* and further define a channel **46***c* that extends a length of the structural member **32***c*. The web **44***c* may be radiused at each of the locations at which the structural member **32***c* transitions to the top flange **40***c* and to the bottom flange **42***c*. The top flange **40***c* is configured to receive a shelf and extends generally inwardly in a shelving unit and in a direction away from the web **44***c*. The top flange **40***c* has an L-portion **142** and a cap portion **144**. The L-shaped portion **142** includes a lower portion **146** and a sidewall portion **148**, and the cap portion **144** is rounded to transition from the web **44***c* to the sidewall portion **148** to define a top edge **150** of the structural member **32***c*. The sidewall portion **148** transitions from the cap portion **144** to the lower portion **146** to provide the L-shaped configuration. The lower portion **146** may have one or more bores **152** located therein with at least one bore **152** being located near each end **28***c*, **30***c* of the shelf support beam **14***c* (e.g., FIG. **20**). In any event, the lower portion **146** is configured to support a shelf thereon with the sidewall **148** providing a stop for lateral movement of the shelf in an outward direction (i.e., toward the web **44***c*) in a shelving unit. To this end, a gap **154***c* between the sidewall **148** and the web **44***c* of the shelf support beam **14***c* is smaller compared to a gap **154** between the sidewall **54** and the web **42** of the embodiment of the shelf support beam **14** previously described with respect to FIGS. **1-12**. Thus, the shelf support beam **14***c* may be configured to support a shelf having a different width, for example. As a result of the smaller configuration of the gap **154***c*, the shelf support beam **14***c* may have a smaller load bearing capacity compared to the shelf support beam **14** of the previously described embodiment. For example, the shelf support beam **14***c* may have a load bearing capacity of 1000 lbs.

[0092] With continued reference to FIGS. **19-21**, the bottom flange **42***c* joins the web **44***c* on an opposite end of the web **44***c* from the top flange **40***c*. The bottom flange **42***c* includes at least one aperture **156** located at a central position along the bottom flange **42***c* (e.g., FIG. **20**). The at least one aperture **156** is configured to receive a tie member, such as a wire tie clip, used to increase the load capacity of the shelving units. More particularly, the tie clip are configured to create a positive connection between the shelves **22** and the support beams **14***a*.

[0093] As shown in FIGS. **18-25**, each tab **36***c* is an extension of the web **44***c* at each end **28***c*, **30***c* of the shelf support beam **14***c*. In that regard, each tab **36***c* includes and end edge **72***c*, an upper edge **68***c*, and a lower edge **70***c*. Each end **280**, **30***c* of the shelf support beam **14***c* includes two securing fingers **24***c* which are spaced apart a distance along a height of the tab **36***c* (e.g., a distance between an upper edge **68***c* and a lower edge **70***c* of the tab **36***c*). In that regard, one securing finger **24***c* is located closer to the upper edge **68***c* of the tab **36***c* with the other securing finger **24***c* being located closer to the lower edge **70***c* of the tab **36***c*. The securing fingers **24***c* of this embodiment are located closer to the respective edges **68***c*, **70***c* of the tab **36***c* compared to the previously described embodiment. The ends **28***c*, **30***c* of the shelf support beam **14***c* also include a respective enforcement tab **38***c* which is located between the top flange **40***c* and the bottom flange **42***c* of the structural member **32***c* so as to be generally in-line (or co-planar) with the abutment edges **34***c* (e.g., FIG. **24**). While the enforcement tab **38***c* of the embodiment is located on the web **44***c*, the enforcement tab **38***c* is punch-formed such that the aperture **110***c* is located on the tab **36***c*, as will

be described in further detail below.
[0094] With reference to FIGS. **21-25**, each securing finger **24***c* has a generally rectangle-shaped profile and includes a base edge **74***c*, a top edge **76***c*, a distal edge **78***c*, an outer surface **80***c*, and an inner surface **82***c*. As best shown in FIG. **25**, the inner and outer surfaces **82***c*, **80***c* of each securing finger **24***c* are planar for most their length to provide each securing finger **24***c* with a generally rectangular cross-sectional profile. In this regard, each securing finger **24***c* is generally plate-like and projects from a bend line **84***c* on the tab **36***c*, in a direction toward the enforcement tab **38***c*, to the distal edge **78***c* which is spaced a distance away from the tab **36***c*. Forming of the securing finger **24***c* results in a rectangle-shaped aperture **86***c* being formed in the tab **36***c* beneath the inner surface **82***c* of each finger **24***c*. To this end, the space between the inner surface **82***c* of each finger **24***c* and the respective aperture **86***c* in the tab **36***c* defines a pocket **88***c*. The pocket **88***c* is configured to face, or open towards the enforcement tab **38***c*, and may be V-shaped, for example. Like the previously described embodiment, when the shelf support beam **14***c* is engaged with the corner post **12**, **12***a*, each securing finger **24***c* is engaged with a corresponding keyhole **26**, **26***a* such that a portion of the corner post **12**, **12***a* is received within each pocket **88***c*.
[0095] Referring now to FIG. **24**, the bend line **84***c* of each securing finger **24***c* is angled relative to a plane axis **94***c* disposed perpendicular to a longitudinal axis **96***c* of the shelf support beam **14***c* such that the entirety of each securing finger **24***c* is angled inwardly toward a center of the structural member **32***c* and the enforcement tab **38***c*. The angled relationship between the bend lines **84***c* and the axis **94***c* defines a securing finger angle θ.sub.sfc for each securing finger **24***c*. The securing finger angle θ.sub.sfc may be the same or different for each securing finger **24***c*. In any event, the securing finger angle θ.sub.stc for each securing finger **24***c* may be within a range of between 5° to 30°, for example. Preferably, the angle θ.sub.sfc is within a range of between 10° to 20° and, in the embodiment shown, the securing finger angle θ.sub.sfc is 11° for each securing finger **24***c*.
[0096] With reference to FIGS. **18-25**, the enforcement tab **38***c* has a generally rectangle-shaped profile and includes a base edge **98***c*, a top edge **100***c*, a distal edge **102***c*, an outer surface **104***c*, and an inner surface **106***c*. The inner and outer surfaces **104***c*, **106***c* are generally planar such that the enforcement tab **38***c* has cross-section that is generally rectangular in shape. The enforcement tab **380** projects from a bend line **108***c* to the distal edge **102***c* so as to be generally perpendicular to the tab **36***c* and web **42***c*. Forming of the enforcement tab **38***c* results in the rectangle-shaped aperture **110***c* being formed in the tab **36***c*. To this end, the aperture **110***c* is located in a region of the tab **36***c* between the enforcement tab **38***c* and the pair of securing fingers **24***c*. Once formed, the enforcement tab **38***c* has a height defined by a distance between the bend line **108***c* and the distal edge **102***c*, and a length defined by a distance between the base edge **98***c* and the top edge **100***c*. Similar to the previously described embodiment, the enforcement tab **38***c* has a length that is greater than the height to maximize surface contact potential between the enforcement tab **38***c* and the post **12**, **12***a* while limiting a width of the aperture **110***c* (e.g., a distance that the aperture **110***c* extends along the longitudinal axis **96***c* of the shelf support beam **14***c*). However, a height of the enforcement tab **38***c* may be generally equal to a height of the pair of securing fingers **24***c* (e.g., FIG. **25**). A longitudinal axis of the enforcement tab **38***c* is generally perpendicular to the longitudinal axis **96***c* of the shelf support beam **14***c* and generally parallel with plane axis **94***c*.
[0097] With reference to FIGS. **22-25**, each enforcement tab **38***c* is spaced away from the pair of securing fingers **24***c* so as to be located between the top flange **40***c* and the bottom flange **42***c* of the structural member **32***c*. More particularly, the enforcement tab **38***c* is generally centered on the web **44***c*, but is positioned closer to the top flange **40***c* compared to the bottom flange **42***c*. The positioning of the enforcement tab **38***c* is such that neither the top edge **100***c* of the enforcement tab **38***c* nor the base edge **98***c* opposes the securing fingers **24***c*. Rather, the top edge **100***c* terminates just below the base edge **74***c* of one securing finger **24***c* and the base edge **98***c* terminates just above the top edge **76***c* of the other securing finger **24***c*, as best shown in FIG. **24**. Thus, the length

of the enforcement tab **38***c* is generally less than the distance that the securing fingers **24***c* are spaced apart.

[0098] The enforcement tab **38***c* is positioned such that the outer surface **104***c* of the enforcement tab **38***c* is coplanar with the abutment edges **34***c* to engage with the corner post **12**, **12***a*, similar to the embodiment described above. For example, to couple the shelf support beam **14***c* to the corner post **12**, the securing fingers **24***c* are first received through the rectangle-shaped portion **114** of each respective keyhole **26**. Once the securing fingers **24***c* are received within each keyhole **26**, the shelf support beam **14***c* may be lowered until the base edge **74***c* of each securing finger **24***c* engages with the radiused base **120** of each respective keyhole **26**. When so positioned, the angled portion **128** of each keyhole **26** and part of corner post **12** are received within the pocket **88***c* of each respective securing finger **24***c*. More particularly, each securing finger **24***c* is engaged with the radiused base **120** and the angled portion **128** of each keyhole **26**, and extends between the radiused base **120** and the shoulder **130**. As the securing fingers **24***c* are seated in respective keyholes **26**, the enforcement tab **38***c* is brought into engagement with the sidewall **126** of the corner post **12**. When the securing fingers **24***c* are fully seated within the keyholes **26**, the sidewall **126** of the corner post **12** is pressed into a frictional engagement with the outer surface **104***c* of the enforcement tab **38***c*.

[0099] With reference to FIGS. **26-27**, details of a horizontal shelf support beam **14***d* are shown in accordance with another embodiment of the present invention. The shelf support beam **14***d* is similar in many respects to the shelf support beam **14***c* described above with respect to FIGS. **18-25** and therefore like numerals represent like features. The primary difference between the shelf support beam **14***d* of this embodiment and the shelf support beam **14***c* of the above-described embodiment is that the shelf support beam **14***d* includes only one securing finger **24***d* formed in the tab **36***d* at each end **28***d*, **30***d* of the beam **14***d*. Also, each end **28***d*, **30***d* of the beam **14***d* does not include an enforcement tab **38***c*. It will also be understood that the support beam **14***d* includes the structural member **32***d* having a C-shaped cross-sectional configuration including top and bottom flanges **40***d*, **42***d* that define abutment edges **34***d*. To this end, the structural member **32***d* is similar to the structural member **32***c* described above with respect to FIGS. **18-25**, and therefore additional details of the support beam **14***d* will not be redescribed for purposes of brevity.

[0100] With reference to FIGS. **26-27**, each securing finger **24***d* is spaced away from edges **68***d*, **70***d*, **72***d* of each tab **36***d* so as to be centrally located on each corresponding tab **36***d*. More particularly, each securing finger **24***d* is punch-formed so as to extend generally inwardly in the shelving unit **10** and in a direction toward the channel **46***d*. As each securing finger **24***d* is punch-formed, each securing finger **24***d* is partially cut from each tab **36***d* and bent inwardly to form the shape of the securing finger **24***d*. In this regard, each securing finger **24***d* may have a same thickness as the corresponding tab **36***d*.

[0101] As shown, the securing finger **24***d* has a generally square shaped profile and includes a base edge **74***d*, a top edge **76***d*, a distal edge **78***d*, an outer surface **80***d*, and an inner surface **82***d*. The inner and outer surfaces **82***d*, **80***d* are generally planar for most their length such that the securing finger **24***d* has a rectangular cross-sectional shape. The securing finger **24***d* projects from a bend line **84***d* on the tab **36***d* to the distal edge **78***d* which is spaced a distance away from the tab **36***d*. Forming of the securing finger **24***d* results in a square shaped aperture **86***d* being formed in the tab **36***d* beneath the inner surface **82***d* of the securing finger **24***d*. To this end, the space between the inner surface **82***d* of the finger **24***d* and the aperture **86***d* of the tab **36***d* defines a pocket **88***d*. The pocket **88***d* may be V-shaped. Like the previously described embodiment, when the shelf support beam **14***d*, and more particularly the securing finger **24***d*, is engaged with the corner post **12**, the pocket **88***d* is configured to receive a portion of the corner post **12** therein.

[0102] As best shown in FIG. **27**, the bend line **84***d* of the securing finger **24***d* is angled relative to a plane axis **94***d* disposed perpendicular to a longitudinal axis **96***d* of the shelf support beam **14***d* such that the entirety of the securing finger **24***d* is angled inwardly toward a center of the structural member **32***d*. In this regard, the top edge **76***d* of the securing finger **24***d* is positioned closer to the

structural member **32***d* compared to the base edge **74***d* of the securing finger **24***d*. The angled relationship between the bend line **84***d* and the axis **94***d* defines a securing finger angle θ.sub.sfd. In this regard, the securing finger angle θ.sub.std may be within a range of between 5° to 30°, for example. Preferably, the angle θ.sub.sfd is within a range of between 10° to 20° and, in the embodiment shown, the securing finger angle θ.sub.sfd is 11°. To this end, while the securing finger **24***d* of one end of the shelf support beam **14***d* has been described in detail, it is understood that the securing finger **24***d* of the other end of the support beam **14***d* is similarly configured.

[0103] With reference to FIGS. **28-37**, wherein like numerals represent like features compared to the shelf support beam **14** described above with respect to FIGS. **1-12**, for example, details of a horizontal shelf support beam **14***e* are shown in accordance with another embodiment of the present invention. In many respects, the shelf support beam **14***e* is similar to the embodiment of the shelf support beam **14** previously described and shown with respect to FIGS. **1-12**. The primary differences between the shelf support beam **14***e* of this embodiment and the shelf support beam **14** of the above-described embodiment is the configuration of the structural member **32***e*, tabs **36***e*, and securing fingers **24***e*. More particularly, the structural member **32***e* includes an embossed portion **158** to increase the load bearing capacity of the shelf support beam **14***e*.

[0104] With reference to FIGS. **28-31**, the shelf support beam **14***e* includes a first end **28***e* and a second end **30***e* located at opposite longitudinal ends of the shelf support beam **14***e* between which a structural member **32***e* that is formed in a generally C-shape extends. The structural member **32***e* and the beam **14***e* have a longitudinal axis **96***e*. The generally C-shaped structural member **32***e* is partially truncated near each of the first and second ends **28***e*, **30***e* to define abutment edges **34***e* of the structural member **32***e* as well as tabs **36***e* at each end **28***e*, **30***e* of the shelf support beam **14***e*. The tabs **36***e* each extend a distance, in a longitudinal direction, from each corresponding abutment edge **34***e* of the structural member **32***e*. Each tab **36***e* includes one punch-formed securing finger **24***e* for securing ends **28***e*, **30***e* of the shelf support beam **14***e* to corresponding corner posts **12** of the shelving unit **10**, as will be described in further detail below.

[0105] With reference to FIGS. **36-37**, the structural member **32***e* has a C-shaped cross-sectional configuration and includes a top flange **40***e* and a bottom flange **42***e* between which a middle portion **160**, or web, of the structural member **32***e* extends. The middle portion **160** of the structural member **32***e* includes the embossed portion **158**. Collectively, the middle portion **160**, top flange **40***e*, and bottom flange **42***e* form the C-shape of the structural member **32***e* and further define a first channel **46***e* that extends a length of the structural member **32***e*. As will be described in further detail below, the embossed portion **158** defines a second channel **162** that extends a length of the structural member **32***e*.

[0106] With continued reference to FIGS. **36-37**, the top flange **40***e* extends generally inwardly in the shelving unit **10** and in a direction away from the middle portion **160**. More particularly, the top flange **40***e* has an S-shaped configuration with an elevated portion **48***e* defining a top surface **50***e* and a lower portion **52***e* defining a lower surface **54***e*. A sidewall **56***e* transitions from the elevated portion **48***e* to the lower portion **52***e* to provide the S-shaped configuration. The lower portion **52***e* is configured to support a shelf with the sidewall **56***e* providing a stop for lateral movement of the shelf in an outward direction (i.e., toward the middle portion **160**) in the shelving unit **10**. In this regard, a pair of existing shelf support beams **14***e* positioned on the front and rear sides of the shelf captures a shelf between opposing sidewalls **56***e* to prevent unwanted lateral movement of the shelf. Generally, a height of the sidewall **56***e* (e.g., a distance between the lower surface **54***e* and the top surface **50***e*) may be approximately a thickness of a shelf. The shelf is then approximately flush with the top surface **50***e*. The top surface **50***e* may be a flat surface and generally planar or parallel with the lower surface **54***e* and the bottom flange **42***e*.

[0107] The bottom flange **42***e* also extends generally inwardly in the shelving unit **10** and in a direction away from the middle portion **160**. The bottom flange **42***e* is configured to receive the one or more crossbeams **20**, if used. In this regard, the bottom flange **42***e* includes one or more spaced

apart apertures **60***e* (e.g., FIG. **30**) configured to receive and secure an end of a corresponding crossbeam to the bottom flange **42***e*. The apertures **60***e* are oblong in shape and are spaced apart a desired distance along a length of the bottom flange **42***e*. For example, each horizontal shelf support beam **14***e* may have three apertures **60***e* spaced equally apart along a length of the beam **14***e* to support three corresponding crossbeams.

[0108] As best shown in FIGS. **36-37**, the middle portion **160** joins the top flange **40***e* and the bottom flange **42***e* to define the C-shape of the structural member **32***e*. The middle portion **160** may be radiused at each of the locations at which the structural member **32***e* transitions to the top flange **40***e* and to the bottom flange **42***e*. In any event, the middle portion **160** includes a first web **164** and a second web **166** joined together by the embossed portion **158**. In this regard, the embossed portion **158** includes a third web **168** joined to the first and second webs **164**, **166** by a pair of sidewalls **170**. More particularly, the first web **164** extends from the top flange **40***e* to one sidewall **170** and the second web **166** extends from the bottom flange **42***e* to the other one of the sidewalls **170**. The sidewalls **170** extend outwardly from each of the first and second webs **164**, **166** to the third web **168**. To this end, the third web **168** and the sidewalls **170** collectively define the embossed portion **158**.

[0109] The sidewalls **170** are angled generally outwardly from a shelving unit and in a direction away from the first channel **46***e*. In this regard, the embossed portion **158** projects outwardly from the middle portion **160** of the structural member **32***e* and, more particularly, outwardly relative to a plane **172** defined by the first and second webs **164**, **166**. As briefly described above, the embossed portion **158** defines a second channel **162** which extends a length of the structural member **32***e*. In this regard, the third web **168** is vertical and generally planar with the first and second webs **164**, **166** and defines a base of the second channel **162**. More particularly, the third web **168** is spaced outwardly a distance beyond the plane **172** defined by the first and second webs **164**, **166**. The distance that the third web **168** is spaced outwardly from the plane **172** defines a depth **174** of the second channel **162**.

[0110] The embossed portion **158** may be generally trapezoidal in shape and the sidewalls **170** may be radiused at each of the locations at which the sidewalls **170** transition to the first, second, and third webs **164**, **166**, **168**. The embossed portion **158** is located adjacent to the bottom flange **42***e* and in the lower half or lower two-thirds of the middle portion **160**. Thus, a height of the second web **166** (e.g., a distance between the bottom flange **42***e* and the nearest sidewall **170**) is smaller compared to a height of the first web **164** (e.g., a distance between the top flange **40***e* and the nearest sidewall **170**). As described in further detail below, the securing finger **24***e* is located in the upper half or upper third of the middle portion **160** of the structural member **32***e*. The embossed portion **158** provides the shelf support beam **14***e* with a greater load carrying capacity compared to the shelf support beams **14-14***d* of the previously described embodiments.

[0111] With reference to FIGS. **28-35**, the tabs **36***e* are an extension of the middle portion **160** at each end **28***e*, **30***e* of the shelf support beam **14***e*. In that regard, each tab **36***e* includes and end edge **72***e*, an upper edge **68***e*, and a lower edge **70***e*. Each tab **36***e* also includes the embossed portion **158** as described above. In addition to the embossed portion **158**, each tab **36***e* also includes one securing finger **24***e* and an aperture **171** configured to receive a corresponding fastener **173** therethrough which may be used to create a positive connection between the support beam **14***e* and a corner post **12** of the shelving unit **10**. As shown, the securing finger **24***e* is located on the part of the tab **36***e* that is an extension of the first web **164**. Thus, the securing finger **24***e* is adjacent to the top flange **42***e*. In this regard, locating the securing finger **24***e* on the tab **36***e* adjacent to the top flange **40***e* (e.g., in the upper half or upper third of the tab **36***e*) provides the shelf support beam **14***e* with a greater load carrying capacity compared to the shelf support beams **14-14***d* of the previously described embodiments. To this end, the shelf support beam **14***e* of this embodiment, equipped with three crossbeams **20**, may have a load bearing capacity of approximately 3,750 lbs., for example.

[0112] As shown in FIGS. **32-35**, each securing finger **24***e* includes a stiffening rib **66***e* and extends

generally inwardly in the shelving unit **10** and in a direction toward the channel **46***e*, similar to the above-described embodiments. Each securing finger **24***e* of this embodiment may also be punch-formed so as to be partially cut from the tab **36***e* and bent inwardly to form the shape of the securing finger **24***e*. Thus, the securing finger **24***e* may have a same thickness as the tab **36***e*. The securing finger **24***e* has a generally square shaped profile and includes a base edge **74***e*, a top edge **76***e*, a distal edge **78***e*, an outer surface **80***e*, and an inner surface **82***e*. The inner and outer surfaces **82***e*, **80***e* are curved such that the securing finger **24***e* has an S-shaped cross-section. The securing finger **24***e* projects from a bend line **84***e* on the tab **36***e* to the distal edge **78***e* which is spaced a distance away from the tab **36***e*.

[0113] The securing finger **24***e* of this embodiment also includes a stiffening rib, or stiffener **66***e*, that is formed during the punch-forming of the securing finger **24***e*. More particularly, the same punch is used to form both the securing finger **24***e* and the stiffener **66***e* at the same time. The stiffener **66***e* is configured to strengthen or stiffen the securing finger **24***e* against out of plane deformation when the support beam **14***e* is under load, particularly along the bend line **84***e* of the securing finger **24***e*. The stiffener **66***e* is formed so as to arcuately extend from the tab **36***e* a distance along the outer surface **82***e* of the respective securing finger **24***e*. Each stiffener **66***e* includes a raised spine **90***e* that defines a generally flat surface and a pair of radiused sidewalls **92***e* that extend between the spine **90***e* and surfaces of the securing finger **24***e* and the tab **36***e*. As shown, each spine **90***e* arcuately extends from a first terminal end on the tab **36***e* to a second terminal end on the securing finger **24***e*. More particularly, each stiffener **66***e* extends across the bend line **84***e* in a generally perpendicular manner such that a height of each stiffener **66***e* is generally greatest in a region where the stiffener **66***e* passes over the bend line **84***e*.

[0114] Forming of each securing finger **24***e* results in a square shaped aperture **86***e* being formed in the tab **36***e* beneath the curved inner surface **82***e* of the finger **24***e*. To this end, the space between the curved inner surface **82***e* of the finger **24***e* and the aperture **86***e* of the tab **36***e* defines a pocket **88***e*. The pocket **88***e* may be generally V-shaped. As described in further detail below, when the shelf support beam **14***e*, and more particularly the securing finger **24***e*, is engaged with the corner post **12***a*, the pocket **88***e* is configured to receive a portion of the corner post **12***a* therein.

[0115] As best shown in FIG. **34**, the bend line **84***e* of the securing finger **24***e* is angled relative to a plane axis **94***e* disposed perpendicular to the longitudinal axis **96***e* of the shelf support beam **14***e* such that the entirety of the securing finger **24***e* is angled inwardly toward a center of the structural member **32***e*. In this regard, the top edge **76***e* of the securing finger **24***e* is positioned closer to the structural member **32***e* compared to the base edge **74***e* of the securing finger **32***e*. The angled relationship between the bend line **84***e* and the axis **94***e* defines a securing finger angle θ.sub.ste. In this regard, the securing finger angle θ.sub.ste may be within a range of between 5° to 30°, for example. Preferably, the angle θ.sub.sfe is within a range of between 10° to 20° and, in the embodiment shown, the securing finger angle θ.sub.sfe is 11° for each securing finger **24***e*.

[0116] With reference to FIG. **38**-**39**, details of one crossbeam **20** are shown and will now be described. In this regard, the crossbeam **20** includes a first end **176** and a second end **178** located at opposite longitudinal ends of the crossbeam **20** between which a C-shaped body of the crossbeam **20** extends. The C-shaped body of the crossbeam **20** includes an upper flange **180** and a lower flange **182** between which a middle portion **184** of the body of the crossbeam **20** extends. The middle portion **184** of the crossbeam **20** may be step-shaped at each of the first and second ends **176**, **178** of the crossbeam **20**. The step-shaped configuration of the middle portion **184** defines a notch **186** and a foot portion **188** near each of the first and second ends **176**, **178** of the crossbeam **20**. Each notch **186** is adjacent to the upper flange **180** and each foot **188** is adjacent to the lower flange **182**. Each foot portion **188** may include a bore **190** therethrough. The upper flange **180** and the lower flange **182** are generally planar and extend a length of the crossbeam **20** (e.g., a distance between the first and second ends **176**, **178** of the crossbeam **20**).

[0117] The crossbeam **20** is configured to span a distance between a corresponding pair of shelf

support beams **14** that generally corresponds to a width of the supported shelf **22** (e.g., FIG. **1**). In this regard, the upper flange **180** is configured to engage with the top flange **40** of each corresponding shelf support beam **14** and the lower flange **182** of the crossbeam **20** is configured to engage with the bottom flange **42** of each corresponding shelf support beam **14**. As best shown in FIG. **1**, the top flange **40** of each shelf support beam **14** extends through corresponding notches **186** at each end of the crossbeam **20** such that the upper flange **180** of the crossbeam **20** engages with and is supported by the lower portion **52** of the top flange **40** of each corresponding shelf support beam **14**.

[0118] With reference to FIGS. **38-39**, the lower flange **182** of the crossbeam **20** includes downward-facing tabs **192** at each of the first and second ends **176**, **178** of the crossbeam **20**. In this regard, the tabs **192** extend from opposite ends of the lower flange **182** and may be bent, in a downward direction from horizontal, 90° or more, such as between 90° and 130°, for example. The tabs **192** are sized to fit into corresponding oblong apertures **60** formed in the bottom flange **42** of a pair of shelf support beam **14**, as shown in FIG. **1**. To this end, when coupled between the pair of shelf support beams **14**, the lower flange **182** of the crossbeam **20** is supported on the bottom flange **42** of each of the shelf support beams **14**.

[0119] With reference to FIG. **40**, an exemplary method of manufacturing any one of the shelf support beams described herein will now be described. In this regard, a blank **194** is provided that is cut from a sheet of material. The blank **194** is cut to the desired shape of the exemplary shelf support beam to be formed and is illustrated in a flat and unformed state. To form the shelf support beam from the blank **194**, each securing finger is first punch-formed in the respective tabs at either end of the blank **194**. Any other apertures are also punch-formed in the blank **194** at this time. Once each securing finger is formed in each tab, the blank **194** is fed into a roll-forming machine where the blank **194** is formed into a finished shelf support beam, such as the shelf support beam **14***b* described above with respect to FIGS. **16-17**. The roll forming machine is fit with grooved rolls to accommodate for the punch-formed securing fingers during the rolling process. That way, the configuration of the fingers is not changed in any way during the roll forming process.

[0120] FIG. **41** illustrates a blank **196** to be formed into a finished shelf support beam having enforcement tabs, such as the shelf support beam **14** described above with respect to FIGS. **1-12**. To form the shelf support beam from the blank **196**, each pair of securing fingers and enforcement tab is first punch-formed in the respective tabs at either end of the blank **196**. Any other apertures are also punch-formed in the blank **196** at this time. The punched blank **196** is then fed into a roll forming machine that is fit with one or more grooved rolls to accommodate for the punch-formed securing fingers and enforcement tabs during the rolling process. That way, the configuration of the fingers and enforcement tabs is not changed in any way during the roll forming process.

[0121] While the present invention has been illustrated by the description of various embodiments thereof, and while the embodiments have been described in considerable detail, it is not intended to restrict or in any way limit the scope of the appended claims to such detail. Thus, the various features discussed herein may be used alone or in any combination. Additional advantages and modifications will readily appear to those skilled in the art. The invention in its broader aspects is therefore not limited to the specific details and illustrative examples shown and described. Accordingly, departures may be made from such details without departing from the scope of the general inventive concept.

Claims

1. A method of manufacturing a shelf support beam for use in a shelving unit to support a shelf, comprising: cutting a blank from a sheet of material, the blank comprising a body that extends between a first end and an opposite second end and including a tab located at each of the first and second ends; punch-forming at least one securing finger in each tab; and roll-forming the body of

the blank into a structural member of the shelf support beam with a roll-forming machine, the structural member comprising a C-shaped cross-section and including a web separating a top flange that is configured to support the shelf from a bottom flange; wherein the at least one securing finger is punch-formed before the body of the blank is roll-formed.

2. The method of claim 1, further comprising punch-forming the at least one securing finger including a stiffening rib in each tab.

3. The method of claim 1, wherein the at least one securing finger comprises a pair of securing fingers.

4. The method of claim 1, further comprising punch-forming an enforcement tab in the body of the blank at each of the first and second ends before the body of the blank is roll-formed.

5. The method of claim 1, wherein the roll-forming machine includes one or more grooved rolls, the method further comprising: receiving the at least one securing finger by the grooved rolls.