METAL WRITE UP INSTRUCTIONS

The purpose of metal on the panels is to cover the frame, protecting it from exposure and giving the panel aesthetic appeal. There are several variations of sheet metal used, however the most common two you will see are 26 gauge stucco galvanized (EG) and 26 gauge stucco white galvanized (EW). Acronyms have been adopted to easily identify the different variations of metal used.

METAL FINISH	ACRONYM	
.032 STUCCO ALUMINUM	EA	*(stucco .032 only)*
.032 WHITE STUCCO ALUMINUM	EWA	
26ga stucco galvanized BLACK	EB	
26ga stucco galvanized FAVORITE TAN	FT	
26ga stucco galvanized NATURAL	EG	
24ga SMOOTH PAINT LOCK	RZ	*(SM/P24)*
22ga STAINLESS STEEL	S/S	*(only stainless steel in metal dept.)*
26ga stucco galvanized WHITE	EW	
26ga stucco galvanized PAINT LOCK	PL	*(S/P)*
26ga stucco galvanized WALMART CASE GRAY	CG	

There are a few more rare variations. For example: there is also a .040 version of the stucco aluminum in both white and natural. ***Manually specify this finish***. The metal department only processes metal that comes on coils. Heavy gauge metal that comes in flat pieces is processed by the Trim department.

When writing up metal you must pay close attention to the:

- **Finish Material Type *(MUST be correct)***
- **Cut Size *(determines routing)***
- **Corners**
- **Splines**
- **Transitional Heights *(metal can change finishes, use thermal break to determine heights).***
- **Thermal Breaks**
- **Connection Configuration *(could affect length or width of cut size)***

All of these elements affect how you will determine how you write up the metal cut sheet. Below are the precise formulas used to determine what dimensions to cut the metal.

Nominal Size = **WHAT'S ON THE PRINT**

Actual Size = **THICKNESS OF THE LUMBER**

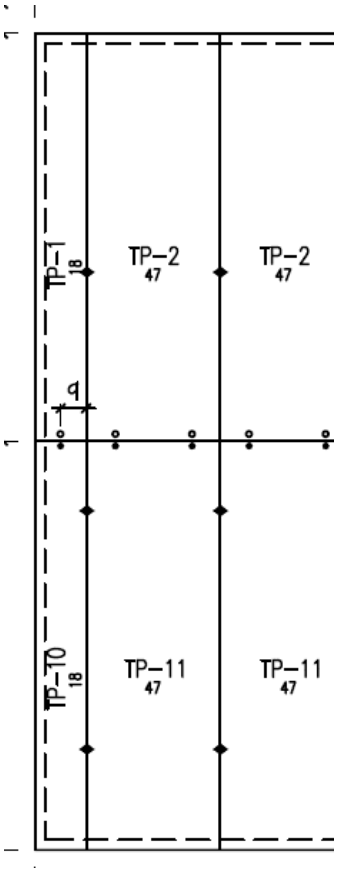
The actual size of the lumber/rail is 1/8 less than what is listed on the drawing. (See above) The drawing lists the walls as 3 ½", therefore the actual size of the rail is 3 3/8" (3.5 – 1/8).

W x H (width x height)

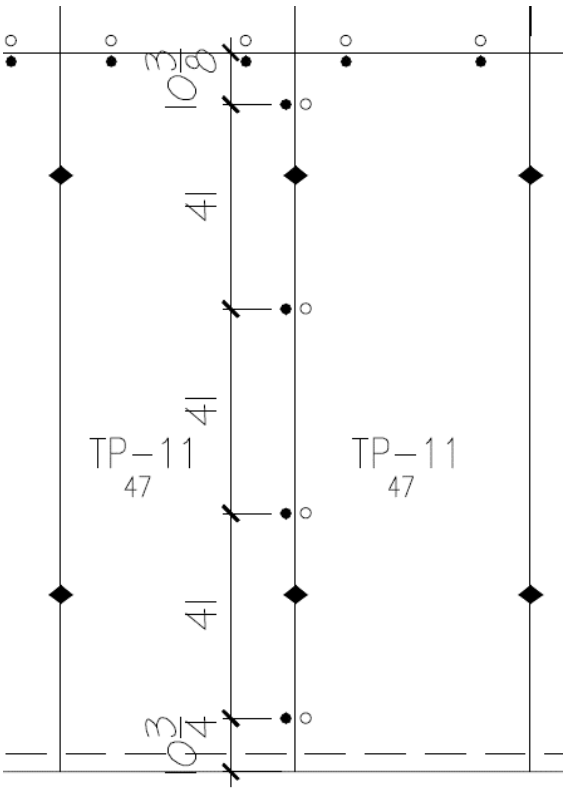
	EXT			INT
WP	(W + 1) x (H + 1)		*Drill Holes are interior*	(W + 1) x (H + 1)
TP *CENTERS*	(W + 1) x (H + 1)		*Drill Holes are exterior*	(W + 1) x (H - 2)
TP *STARTERS* *(end pieces)*	(W + 1) x (H + 1)			(W - .5) x (H - 2)
SP/HP	(W + 1) x (H + 1)		***If there is "wrap around" connecting to a* TP:**	(W + 1) x (H + 1)
		TP =	EXT = (W + wood - 1/8 + .5) x (H + 1)	
			INT = (W - wood - 1/8) x (H +1)	
CP	(W + L + 1) x (H + 1)			(W - wood - 1/8 + 1.6875) x (H + 1)
				if the 2 outer dimensions are listed
WS	(W + 1) x (H + 1)		CT/CS/WS	(W + 1.6875 (*buildup*)) x (H + 1)
			Precedents when cutting wall:	*(There are 2 interior wall splines)*
			FREEZERS	
CT	(W + 1) x (H + 1)		*TALLEST*	*Include 2 for both sidesof wall*
			CLOCKWISE	(W - wood - 1/8 + 1.6875) x (H + 1)
CS	(W - wood - 1/8 + 1.6875) x (H + 1)			
			If NON NSF (no buildup)	(L - wood - 1/8 + .5 for each flange) x (H + 1)
			If dimensions are detailed (no buildup)	(W + 1) x (H + 1)
CA *Walls*	(W + 1) x (H + 1)			(W + 1) x (H + 1)
CA *Tops*	(W + 1) x (L + 1)			(W + 1) x (H - 2)
FP (standard)	(W + 1) x (H + 1)		WALL to WALL STARTERS	(W - T + 1.5) x (L - Tx2 + 2)
			SPLIT STARTERS	(W - T + 1.5) x (L - T + 1.5)
	(W + 1) x (H + 1)		CENTERS	(W + 1) x (L - Tx2 + 2)
			FOAM (ALL)	(W + 1) x (H + 1)
FP (NSF)	(W + 1) x (H + 1)		STARTERS	(W-wood + 1 3/16) X (L - both walls +1 3/8 for each walll)
	(W + 1) X (L +1)		CENTERS	(W +1) X (L - both walls +1 3/8 for each walll)

EXCEPTIONS:

- CAM LOCK TOPS (*see write up template for formulas*)
- Tops with no thermal break on 1 side: the formula for length would be (H - .5) *(see below for example)*



This is an example of two rows of tops with a M/F connection, there is no partition wall, so therefore there is no thermal break where the tops connect. The interior pieces for these tops are longer than the interior pieces for tops that rest on two walls.

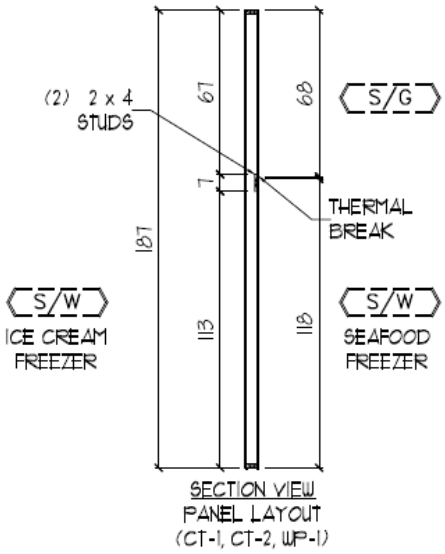


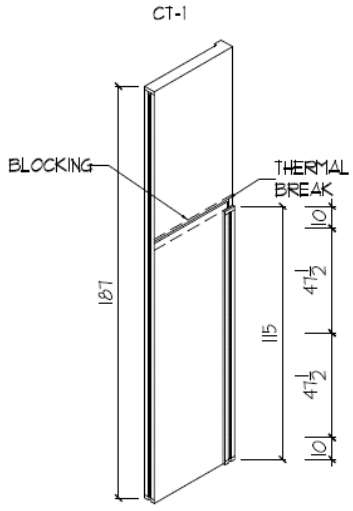
SNAPSHOT FROM WALMART 157-1017-1A

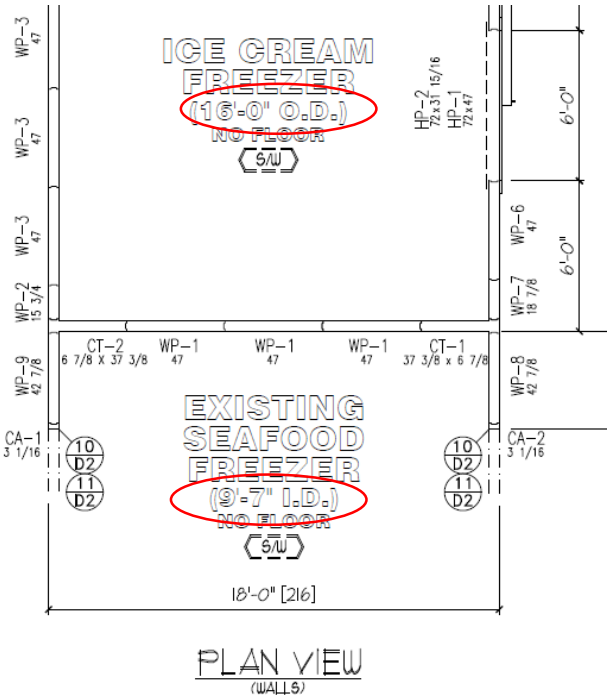
<u>LOCK SPACING</u> is listed on the IP LINE pieces only. For standard tops and walls, you simply list the 1st and 2nd lock as listed on the drawing. If the configuration is special, such as above, or if the bottom end plate is a male, the 1st lock will not be the same as the last lock. The rules are different for walls and tops.

- Walls with male bottom plates: List the bottom lock **1st**
- Tops with a male connection: List lock closest to blank (edge) **1st**
- Tops with cam lock holes **located on the interior**. You must account for setback (1st lock - 1)

<u>TRANSITIONAL HEIGHTS</u> (most common on WALMART).

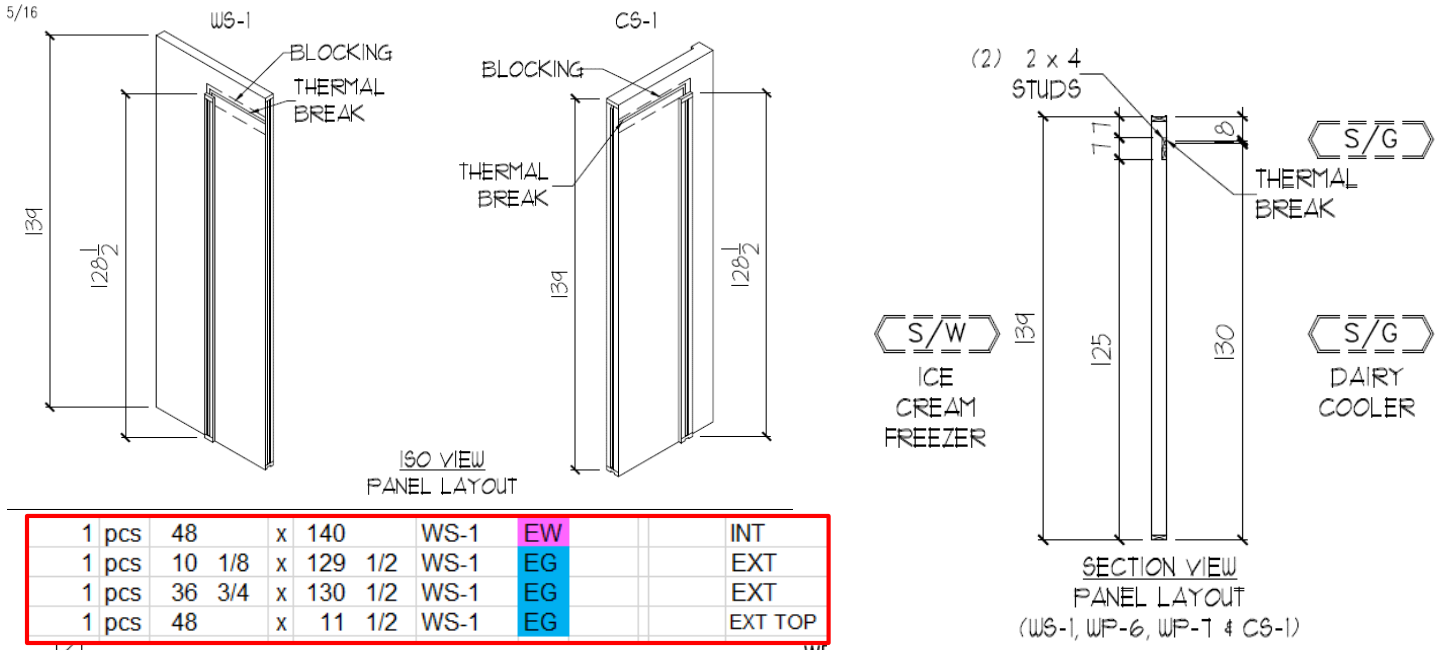




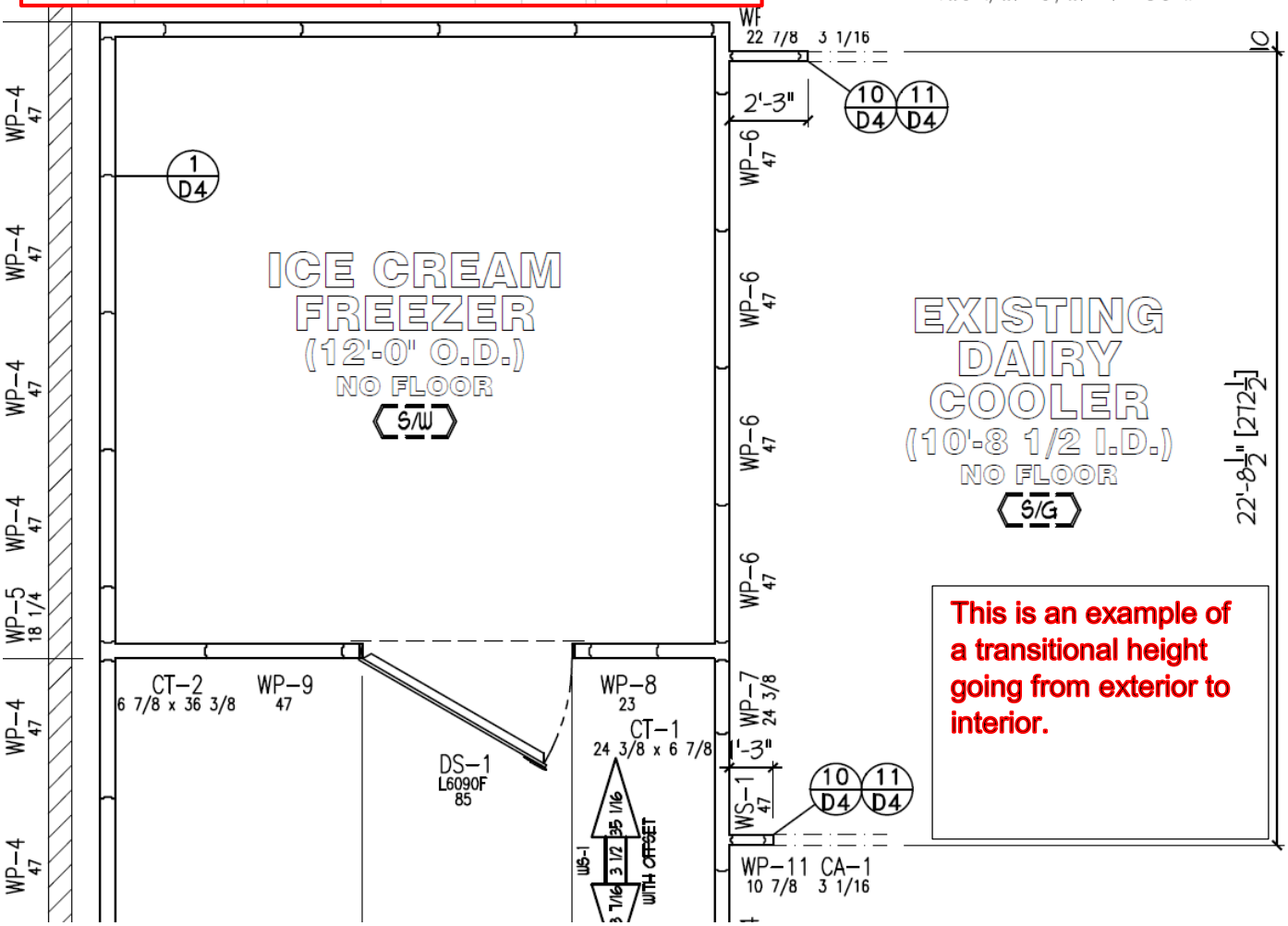


Refer to these 3 views to determine the correct cut size. (snapshot from drawing 157-2284-4)

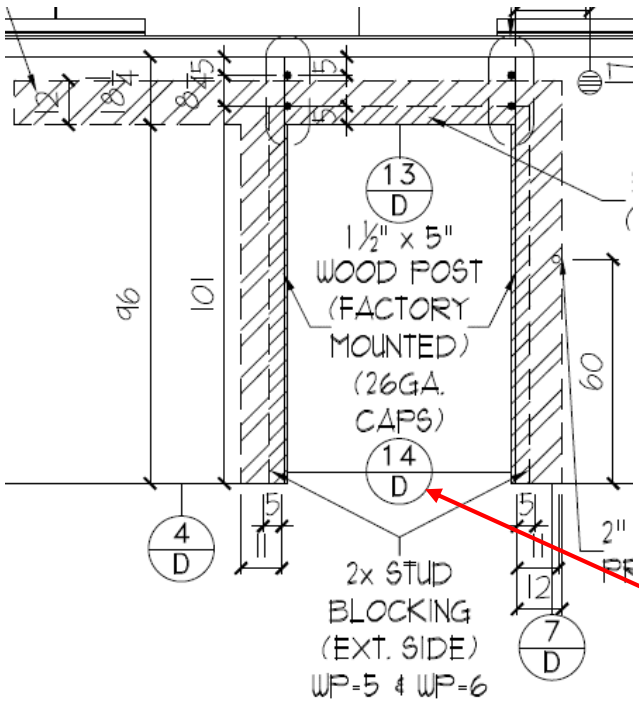
- If the thermal break will be exposed (exterior), make a cap to cover the frame.
- If the thermal break will be covered by a top (interior), add ½" to each side of thermal break dimensions.
- To write up a cap for the exterior, use the height of the shorter panel + 1.



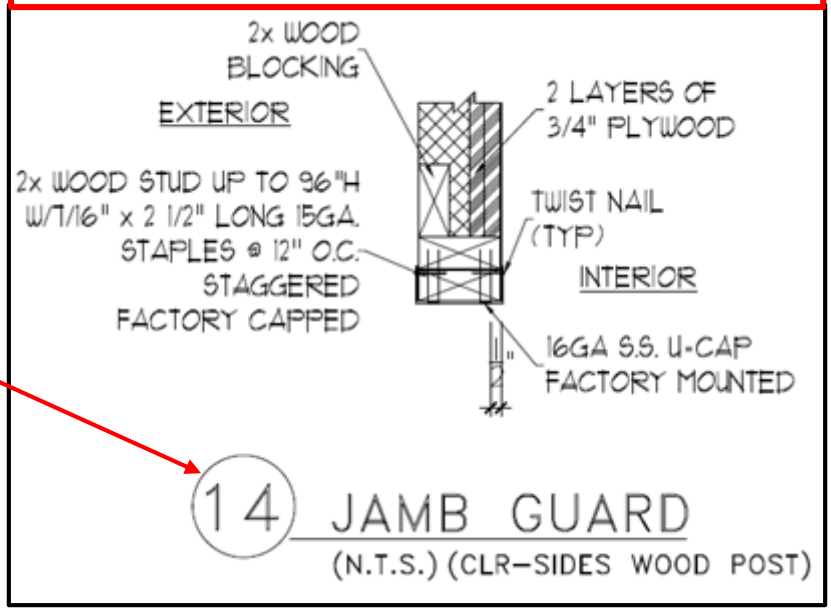
1	pcs	48	x	140	WS-1	EW			INT
1	pcs	10 1/8	x	129 1/2	WS-1	EG			EXT
1	pcs	36 3/4	x	130 1/2	WS-1	EG			EXT
1	pcs	48	x	11 1/2	WS-1	EG			EXT TOP



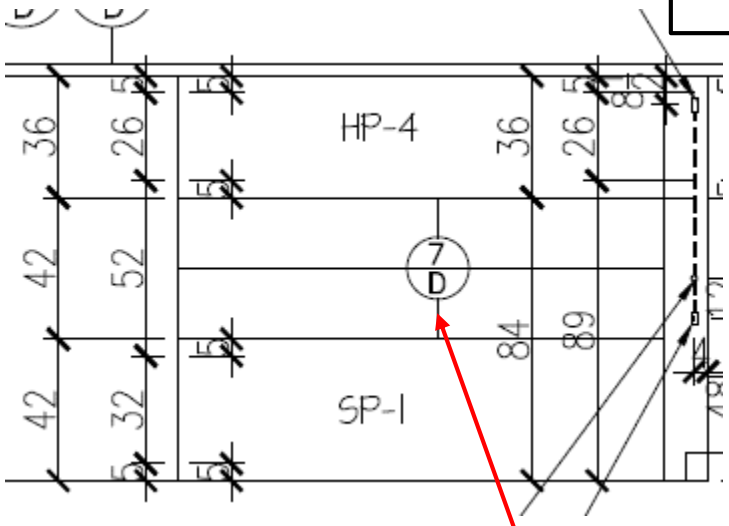
WALMART CANADA



Walmart Canada jobs usually have at least 1 box with wood posts on an opening. Look for "FACTORY MOUNTED WOOD POSTS". This requires additional caps of the same finish. Treat the extra piece of wood like a narrow wall panel. You would add 1" all around for flanges.

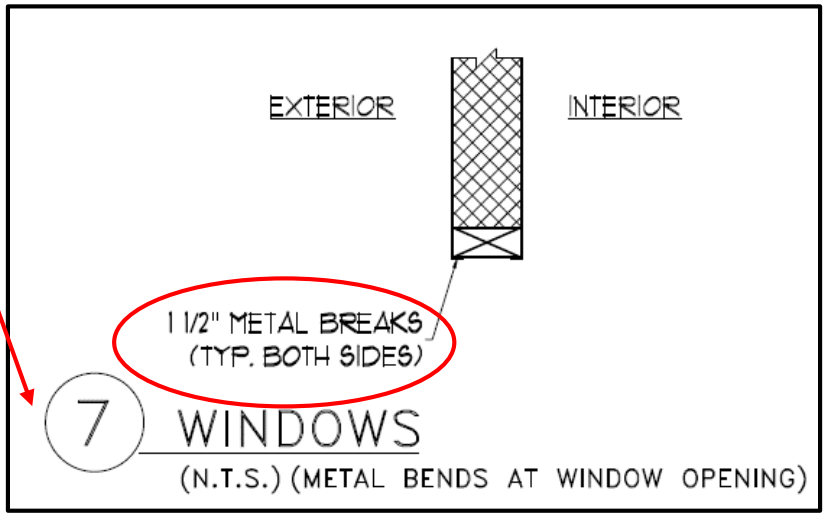


PUBLIX COMPLEXES

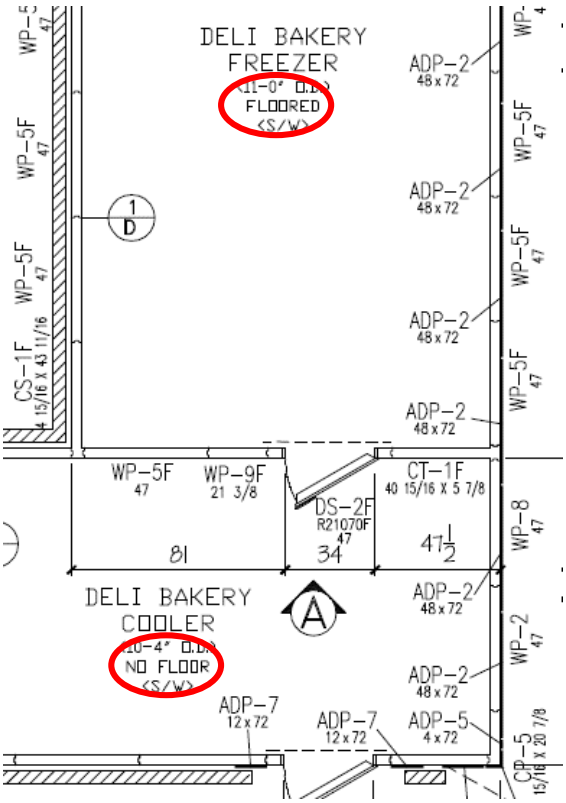


Most PUBLIX complexes will have this special opening. Instead of this standard ½" flange, these panels get 1 ½" flange all around the border of this window. In this example, that makes HP-4 and SP-1 and taller, the adjoining walls wider by 2".

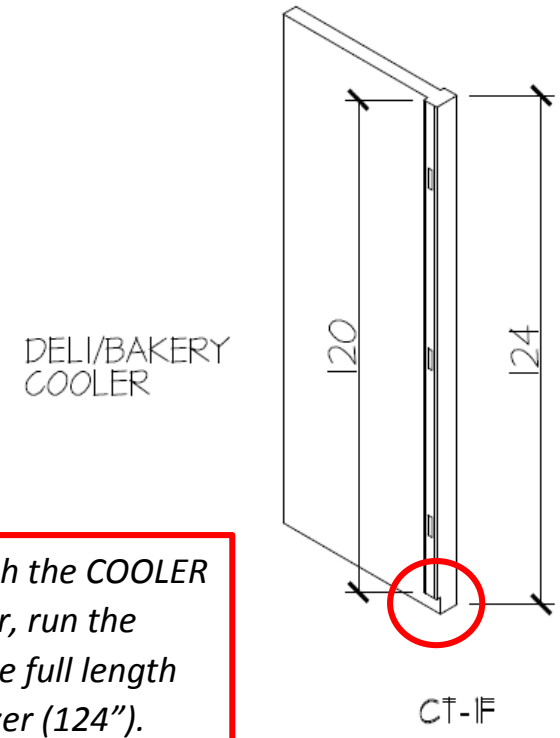
Look for a detail that points in 4 directions such as detail 7 pictured above.



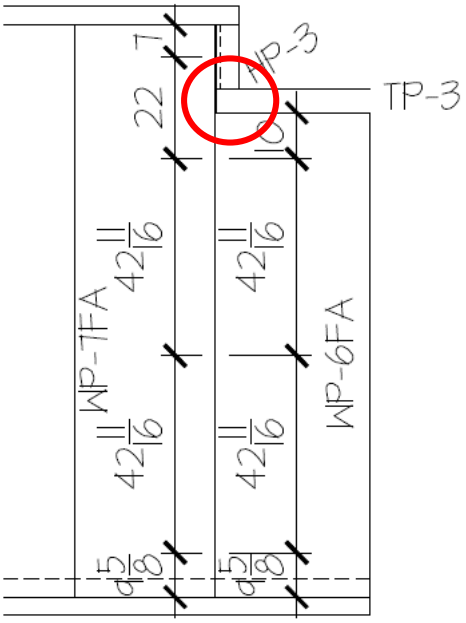
HARRIS TEETER FLOORS & TOPS (or SIMILAR)



(snapshot from drawing 155-0933-4)



Even though the COOLER has no floor, run the metal to the full length of the freezer (124”). Assembly will cut/flatten the metal.



(snapshot from drawing 155-0929-3A)

You would treat the interior of TP-3 like a NON-NSF corner. The side that is exposed to the interior of the box must get covered by metal. Use the standard top formula (no thermal break on 1 side) for exterior, but reverse EXT/INT. (Subtract a .5” from width of the top panel’s exterior).

METAL CUT SHEET ROUTING (PAGES = MACHINES)

Once the cut size is determined, you have to determine the routing of the metal on the cut sheet. The metal department uses 4 pages to process metal. It's important to organize the metal on the cut sheet in a practical fashion to deliver only what is needed to the appropriate machine operators. See below for routing:

CTL > SLITTER or SHEAR			
	SLITTER > FLAGLER > PRESS BRAKE		
	SHEAR > FLAGLER or PRESS BRAKE		
IP LINE	47" x (60"-__)		*(Give drill holes on IP LINE)*
	STANDARDS (TOPS, WALLS, & FLOORS)		
SLITTER	Narrower than 47"		
	Longer than 144"		
SHEAR	Narrower than 47"		
	Shorter than 144"		
FLAGLER	FINISH SIZE:	WIDTH:	8" - 47"
PRESS BRAKE	Narrower than 8"		
	Shorter than 144"		
Separate STAINLESS STEEL & ALUMINUM pages.			

Although the SHEAR and the FLAGLER are 2 different machines, only 1 page is created for both. Therefore metal pieces on this sheet must fit the criteria for both machines.

EXCEPTIONS:

- Corners **CAN NOT** go on the SLITTER *(except for extremely rare requests for seamless narrow corners):* All corners get processed by the PRESS BRAKE, which is limited to 145". If a corner is longer than 145" the metal must be split in two pieces. This also applies to any piece of metal that gets a bend (WS, CS interiors). When this occurs, a metal seam is usually given on the elevation.
- Narrow, but long pieces: Even if a metal piece does not get a bend, it must be 9" or greater in width to get processed by the SLITTER. If a piece is longer than 145", but narrower than 9", it must also get split in two pieces.
- If a top interior finishes at 7" or greater, it can be processed on the SLITTER or SHEAR/FLAGLER. This is because it only gets 1 bend.