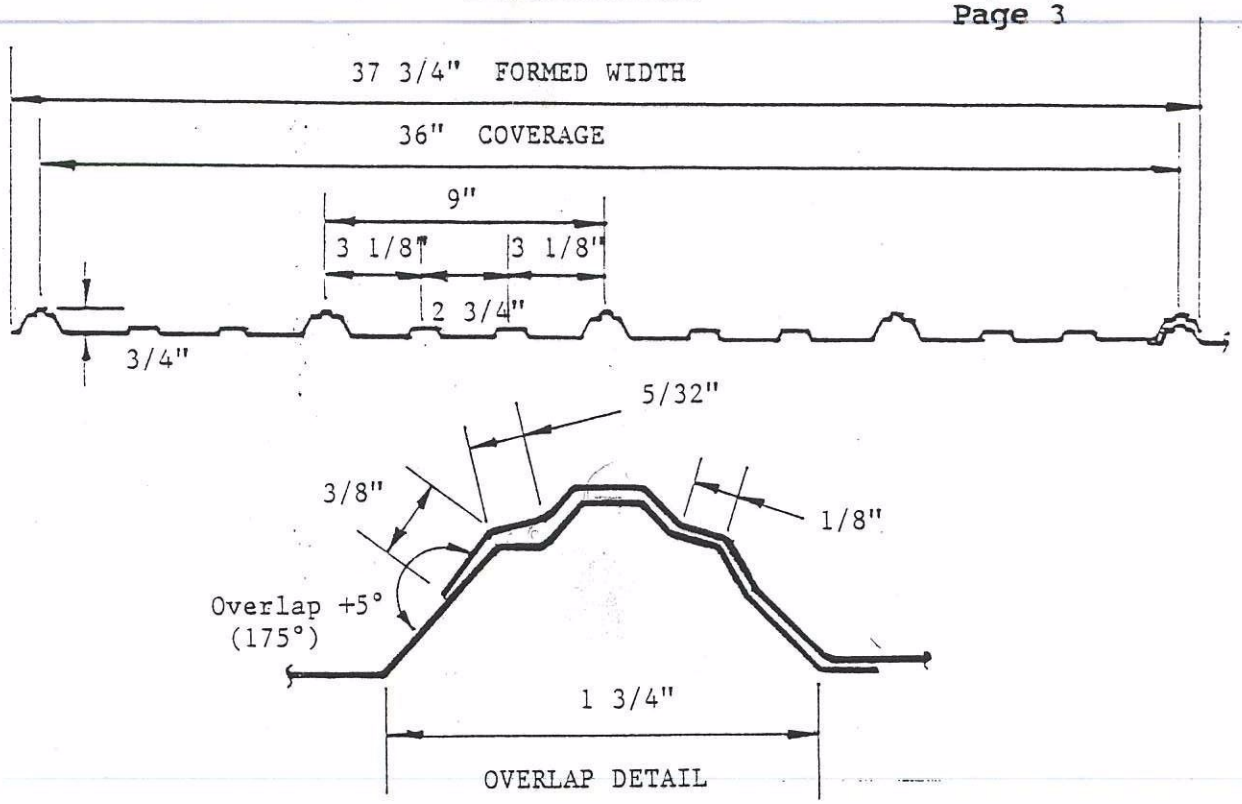

1. Rib Height: 3/4" ± .020.
2. Rib to rib: 9" on pitch, coverage ± 1/16" (aim to ± 0").
3. Overlap Flange: aim to 3/8" (+0, - 1/16). UNIFORMITY IS MOST CRITICAL.
4. Underlap Flange: non-critical 1/8" minimum, 5/16" maximum. The underlap flange must be overbent slightly (upward) so it laps tightly as viewed from the underside of the sheet.
5. Material Usage:

Gauge	Flat Width	Coverage	Formed Width
29 - 28	40 13/16"	36"	37 3/4"
29	41"	36"	37 3/4"

6. Special attention should be paid to the forming of nailing crowns as fracturing of the paint or metal due to tight or misaligned dies is a potential problem. The nailing crown definition is important. The shoulders of the nailing crowns should be fully formed with equal definition from rib to rib.
7. Change in coverage should be done with caution as the last two passes controlling width should form equally.
8. The overlap rib may have a tendency to drop or spread if overlap dies are not fully or properly utilized. The height and base angle of the overlap rib must be checked as part of the sidelap evaluation.
9. Fastening should be simulated for both screw fastening (in the valley behind the rib) as well as for nails (in rib crowns) over 2' distance. When simulating fastening the overlap flange must seal completely and under slight tension over the entire 2'.
10. Date stamp (month/year) centered on the outer leg of the underlap rib.
11. Minimum vanishing oil.