

SECTION 133419  
METAL BUILDING SYSTEMS

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 1 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. This Section includes metal building systems that consist of integrated sets of mutually dependent components including structural framing and accessories.

1.3 DEFINITIONS

- A. Bay: Dimension between main frames measured normal to frame (at centerline of frame) for interior bays, and dimension from centerline of first interior main frame measured normal to end wall (outside face of end-wall girt) for end bays.
- B. Building Length: Dimension of the building measured perpendicular to main framing from end wall to end wall (outside face of girt to outside face of girt).
- C. Building Width: Dimension of the building measured parallel to main framing from sidewall to sidewall (outside face of girt to outside face of girt).
- D. Clear Span: Distance between supports of beams, girders, or trusses (measured from lowest level of connecting area of a column and a rafter frame or knee).
- E. Eave Height: Vertical dimension from finished floor to eave (the line along the sidewall formed by intersection of the planes of the roof and wall).
- F. Clear Height under Structure: Vertical dimension from finished floor to lowest point of any part of primary or secondary structure, not including crane supports, located within clear span.
- G. Terminology Standard: Refer to MBMA's "Metal Building Systems Manual" for definitions of terms for metal building system construction not otherwise defined in this Section or in referenced standards.

#### 1.4 SYSTEM DESCRIPTION

- A. General: Provide a complete, integrated set of metal building system manufacturer's standard mutually dependent components and assemblies that form a metal building system capable of withstanding structural and other loads, thermally induced movement, and exposure to weather without failure or infiltration of water into building interior. Include primary and secondary framing and accessories complying with requirements indicated.
  - 1. Provide metal building system of size and with spacings, slopes, and spans indicated.
- B. Primary Frame Type:
  - 1. Rigid Clear Span: Solid-member, structural-framing system without interior columns.
- C. End-Wall Framing: Manufacturer's standard, for buildings not required to be expandable, consisting of primary frame, capable of supporting one-half of a bay design load, and end-wall columns.
- D. Secondary Frame Type: Manufacturer's standard purlins and joists.
- E. Eave Height: As indicated by nominal height on Drawings.

#### 1.5 SYSTEM PERFORMANCE REQUIREMENTS

- A. Structural Performance: Provide metal building systems capable of withstanding the effects of gravity loads and the following loads and stresses within limits and under conditions indicated:
  - 1. Engineer metal building systems according to procedures in MBMA's "Metal Building Systems Manual."
  - 2. Design Loads: As indicated on Drawings.
  - 3. Design Loads: As required by MBMA's "Metal Building Systems Manual." and ASCE 7-10, "Minimum Design Loads for Buildings and Other Structures."
  - 4. Live Loads: Include vertical loads induced by the building occupancy indicated on Drawings. Include loads induced by maintenance workers, materials, and equipment for roof live loads.
  - 5. Wind Loads: Include horizontal loads induced by a basic wind speed corresponding to a 50-year, mean-recurrence interval at Project site of 155 mph.
  - 6. Collateral Loads: Include additional dead loads other than the weight of metal building system for permanent items such as sprinklers, mechanical systems, electrical systems, and ceilings.
  - 7. Auxiliary Loads: Include dynamic live loads, such as those generated by cranes and materials-handling equipment indicated on Drawings.

8. Load Combinations: Design metal building systems to withstand the most critical effects of load factors and load combinations as required by MBMA's "Metal Building Systems Manual." and ASCE 7-10, "Minimum Design Loads for Buildings and Other Structures."
  9. Deflection Limits: Engineer assemblies shall be designed to accommodate long-term irreversible deflections under sustained loads:
    - a. Purlins and Rafters: Vertical deflection of  $1/240$  of the span.
  10. Design secondary framing system to accommodate deflection of primary building structure and construction tolerances, and to maintain clearances at openings.
  11. Provide metal panel assemblies capable of withstanding the effects of loads and stresses indicated, based on testing according to ASTM E 1592.
- B. Seismic Performance: Design and engineer metal building systems capable of withstanding the effects of earthquake motions determined according to ASCE 7-10, "Minimum Design Loads for Buildings and Other Structures": Sections 11-23.
- C. Thermal Movements: Provide metal panel systems that allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures by preventing buckling, opening of joints, overstressing of components, failure of joint sealants, failure of connections, and other detrimental effects. Base engineering calculation on surface temperatures of materials due to both solar heat gain and nighttime-sky heat loss.
1. Temperature Change (Range): 120 deg F, ambient; 180 deg F, material surfaces.
- D. Wind-Uplift Resistance: Provide metal roof panel assemblies that comply with UL 580 for Class 90.
- 1.6 SUBMITTALS
- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, and finishes for each type of the following metal building system components:
    1. Structural-framing system.
    2. Accessories.
  - B. Shop Drawings: For the following metal building system components. Include plans, elevations, sections, details, and attachments to other work.
    1. For installed products indicated to comply with design loads, include structural analysis data signed and sealed by the qualified professional engineer responsible for their preparation.

2. Anchor-Bolt Plans: Submit anchor-bolt plans before foundation work begins. Include location, diameter, and projection of anchor bolts required to attach metal building to foundation. Indicate column reactions at each location.
  3. Structural-Framing Drawings: Show complete fabrication of primary and secondary framing; include provisions for openings. Indicate welds and bolted connections, distinguishing between shop and field applications. Include transverse cross-sections.
- C. Product Certificates: For each type of metal building system, signed by product manufacturer.
1. Letter of Design Certification: Signed and sealed by a qualified professional engineer. Include the following:
    - a. Name and location of Project.
    - b. Order number.
    - c. Name of manufacturer.
    - d. Name of Contractor.
    - e. Building dimensions including width, length, height, and roof slope.
    - f. Indicate compliance with AISC standards for hot-rolled steel and AISI standards for cold-rolled steel, including edition dates of each standard.
    - g. Governing building code and year of edition.
    - h. Design Loads: Include dead load, roof live load, collateral loads, roof snow load, deflection, wind loads/speeds and exposure, seismic design category or effective peak velocity-related acceleration/peak acceleration, and auxiliary loads (cranes).
    - i. Load Combinations: Indicate that loads were applied acting simultaneously with concentrated loads, according to governing building code.
    - j. Building-Use Category: Indicate category of building use and its effect on load importance factors.
    - k. AISC Certification for Category MB: Include statement that metal building system and components were designed and produced in an AISC-Certified Facility by an AISC-Certified Manufacturer.
- D. Welding certificates.
- E. Erector Certificate: Signed by manufacturer certifying that erector complies with requirements.
- F. Manufacturer Certificate: Signed by manufacturer certifying that products comply with requirements.
- G. Qualification Data: For Erector, manufacturer, professional engineer.
- H. Material Test Reports: Signed by manufacturers certifying that the following products comply with requirements:

1. Structural steel including chemical and physical properties.
  2. Bolts, nuts, and washers including mechanical properties and chemical analysis.
  3. Tension-control, high-strength, bolt-nut-washer assemblies.
  4. Shop primers.
  5. Nonshrink grout.
- I. Source quality-control test reports.
  - J. Field quality-control test reports.
  - K. Product Test Reports: Based on evaluation of comprehensive tests performed by manufacturer and witnessed by a qualified testing agency, for insulation and vapor retarders. Include reports for thermal resistance, fire-test-response characteristics, water-vapor transmission, and water absorption.
  - L. Surveys: Show final elevations and locations of major members. Indicate discrepancies between actual installation and the Contract Documents. Have surveyor who performed surveys certify their accuracy.
  - M. Warranties: Special warranties specified in this Section.

#### 1.7 QUALITY ASSURANCE

- A. Erector Qualifications: An experienced erector who has specialized in erecting and installing work similar in material, design, and extent to that indicated for this Project and who is acceptable to manufacturer.
- B. Manufacturer Qualifications: A qualified manufacturer and member of MBMA.
  1. AISC Certification for Category MB: An AISC-Certified Manufacturer that designs and produces metal building systems and components in an AISC-Certified Facility.
  2. Engineering Responsibility: Preparation of Shop Drawings and comprehensive engineering analysis by a qualified professional engineer.
- C. Land Surveyor Qualifications: A professional land surveyor who is legally qualified to practice in jurisdiction where Project is located and who is experienced in providing surveying services of the kind indicated.
- D. Testing Agency Qualifications: An independent agency qualified according to ASTM E 329 for testing indicated, as documented according to ASTM E 548.
- E. Source Limitations: Obtain primary metal building system components, including structural framing and metal panel assemblies, through one source from a single manufacturer.

- F. Product Options: Drawings indicate size, profiles, and dimensional requirements of metal building system and are based on the specific system indicated. Refer to Division 1 Section "Product Requirements."
  - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- G. Welding: Qualify procedures and personnel according to AWS D1.1, "Structural Welding Code--Steel," and AWS D1.3, "Structural Welding Code--Sheet Steel."
- H. Structural Steel: Comply with AISC's "Specification for Structural Steel Buildings--Allowable Stress Design, Plastic Design," or AISC's "Load and Resistance Factor Design Specification for Structural Steel Buildings," for design requirements and allowable stresses.
- I. Pre-Erection Conference: Conduct conference at Project site to comply with requirements in Division 1 Section "Project Management and Coordination." Review methods and procedures related to metal building systems including, but not limited to, the following:
  - 1. Inspect and discuss condition of foundations and other preparatory work performed by other trades.
  - 2. Review structural load limitations.
  - 3. Review and finalize construction schedule and verify availability of materials, Erector's personnel, equipment, and facilities needed to make progress and avoid delays.
  - 4. Review required testing, inspecting, and certifying procedures.
  - 5. Review weather and forecasted weather conditions and procedures for unfavorable conditions.

## 1.8 DELIVERY, STORAGE, AND HANDLING

- A. Deliver components, sheets, panels, and other manufactured items so as not to be damaged or deformed. Package metal panels for protection during transportation and handling.
- B. Unload, store, and erect metal panels in a manner to prevent bending, warping, twisting, and surface damage.

## 1.9 PROJECT CONDITIONS

- A. Weather Limitations: Proceed with installation only when weather conditions permit metal panels to be installed according to manufacturers' written instructions and warranty requirements.

B. Field Measurements:

1. Established Dimensions for Foundations: Comply with established dimensions on approved anchor-bolt plans, establishing foundation dimensions and proceeding with fabricating structural framing without field measurements. Coordinate anchor-bolt installation to ensure that actual anchorage dimensions correspond to established dimensions.

1.10 COORDINATION

- A. Coordinate size and location of concrete foundations and casting of anchor-bolt inserts into foundation walls and footings. Concrete, reinforcement, and formwork requirements are specified in Division 3 Section "Cast-in-Place Concrete."

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Available Manufacturers: Subject to compliance with requirements, manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
- B. Manufacturers: Subject to compliance with requirements, provide products by one of the following:
- C. Basis-of-Design Product: The design for metal building systems is based on Ruffin Building Systems. Subject to compliance with requirements, provide the named product or a comparable product by one of the following:
  1. Alliance Steel, Inc.
  2. American Buildings Company.
  3. American Steel Building Company, Inc.; Division of NCI Building Systems, LLP.
  4. Behlen Mfg. Co.
  5. Butler Manufacturing Company.
  6. Ceco Building Systems; Division of Robertson-Ceco Corporation.
  7. Crown Metal Buildings, Inc.
  8. Garco Building Systems.
  9. Gulf States Manufacturers, Inc.
  10. Mesco Metal Buildings; Division of NCI Building Systems, LLP.
  11. Metallic Metal Building Company; Division of NCI Building Systems, LLP.
  12. Package Industries, Inc.
  13. Southern Structures, Inc.
  14. Spirco Manufacturing; Division of Metal Building Products, Inc.
  15. Star Building Systems; Division of Robertson-Ceco Corporation.
  16. Steelox Systems Inc.

- 17. United Structures of America, Inc.
- 18. VP Buildings, Inc.; a United Dominion Company.

## 2.2 STRUCTURAL-FRAMING MATERIALS

- A. W-Shapes: ASTM A 992/A 992M; ASTM A 572/A 572M, Grade 50 or 55; or ASTM A 529/A 529M, Grade 50 or 55.
- B. Channels, Angles, M-Shapes, and S-Shapes: ASTM A 36/A 36M; ASTM A 572/A 572M, Grade 50 or 55; or ASTM A 529/A 529M, Grade 50 or 55.
- C. Plate and Bar: ASTM A 36/A 36M; ASTM A 572/A 572M, Grade 50 or 55; or ASTM A 529/A 529M, Grade 50 or 55.
- D. Steel Pipe: ASTM A 53/A 53M, Type E or S, Grade B.
- E. Cold-Formed Hollow Structural Sections: ASTM A 500, Grade B or C, structural tubing.
- F. Structural-Steel Sheet: Hot-rolled, ASTM A 1011/A 1011M, Structural Steel (SS), Grades 30 through 55, or High-Strength Low Alloy Steel (HSLAS), Grades 45 through 70; or cold-rolled, ASTM A 1008/A 1008M, Structural Steel (SS), Grades 25 through 80, or High-Strength Low Alloy Steel (HSLAS), Grades 45 through 70.
- G. Joist Girders: Manufactured according to "Standard Specifications for Joist Girders," in SJI's "Standard Specifications, Load Tables, and Weight Tables for Steel Joists and Joist Girders," with steel-angle, top- and bottom-chord members; with end- and top-chord arrangements as indicated and required for primary framing.
- H. Steel Joists: Manufactured according to "Standard Specifications for Open Web Steel Joists, K-Series," in SJI's "Standard Specifications, Load Tables, and Weight Tables for Steel Joists and Joist Girders," with steel-angle, top- and bottom-chord members; with end- and top-chord arrangements as indicated and required for secondary framing.
- I. Non-High-Strength Bolts, Nuts, and Washers: ASTM A 307, Grade A, carbon-steel, hex-head bolts; ASTM A 563 carbon-steel hex nuts; and ASTM F 844 plain (flat) steel washers.
  - 1. Finish: Mechanically deposited zinc coating, ASTM B 695, Class 50.
- J. High-Strength Bolts, Nuts, and Washers: ASTM A 325, Type 1, heavy hex steel structural bolts; ASTM A 563 heavy hex carbon-steel nuts; and ASTM F 436 hardened carbon-steel washers.
  - 1. Finish: Mechanically deposited zinc coating, ASTM B 695, Class 50.

2. Tension-Control, High-Strength Bolt-Nut-Washer Assemblies: ASTM F 1852, Type 1, heavy-hex-head steel structural bolts with splined ends.
  - a. Finish: Mechanically deposited zinc coating, ASTM B 695, Class 50.
- K. High-Strength Bolts, Nuts, and Washers: ASTM A 490, Type 1, heavy hex steel structural bolts; ASTM A 563 heavy hex carbon-steel nuts; and ASTM F 436 hardened carbon-steel washers, plain.
- L. Unheaded Anchor Rods: ASTM F 1554, Grade 36.
  1. Configuration: Straight.
  2. Nuts: ASTM A 563 heavy hex carbon steel.
  3. Plate Washers: ASTM A 36/A 36M carbon steel.
  4. Washers: ASTM F 436 hardened carbon steel.
  5. Finish: Hot-dip zinc coating, ASTM A 153, Class C.
- M. Headed Anchor Rods: ASTM F 1554, Grade 36, straight.
  1. Nuts: ASTM A 563 heavy hex carbon steel.
  2. Plate Washers: ASTM A 36/A 36M carbon steel.
  3. Washers: ASTM F 436 hardened carbon steel.
  4. Finish: Hot-dip zinc coating, ASTM A 153, Class C.
- N. Threaded Rods: ASTM A 36.
  1. Nuts: ASTM A 563 heavy hex carbon steel.
  2. Washers: ASTM A 36 carbon steel.
  3. Finish: Hot-dip zinc coating, ASTM A 153.
- O. Primer: SSPC-Paint 15, Type I, red oxide.

### 2.3 MISCELLANEOUS MATERIALS

- A. Fasteners: Self-tapping screws, bolts, nuts, self-locking rivets and bolts, end-welded studs, and other suitable fasteners designed to withstand design loads. Provide fasteners with heads matching color of materials being fastened by means of plastic caps or factory-applied coating.
  1. Fasteners for Metal Roof Panels: Self-drilling or self-tapping, zinc-plated, hex-head carbon-steel screws, with a stainless-steel cap or zinc-aluminum-alloy head and EPDM or neoprene sealing washer.
  2. Fasteners for Metal Wall Panels: Self-drilling or self-tapping, zinc-plated, hex-head carbon-steel screws, with nylon or polypropylene washer.
  3. Fasteners for Metal Roof and Wall Panels: Self-drilling Type 410 stainless-steel or self-tapping Type 304 stainless-steel or zinc-alloy-steel hex washer head,

with EPDM or PVC washer under heads of fasteners bearing on weather side of metal panels.

4. Fasteners for Flashing and Trim: Blind fasteners or self-drilling screws with hex washer head.
5. Blind Fasteners: High-strength aluminum or stainless-steel rivets.

## 2.4 FABRICATION, GENERAL

- A. General: Design components and field connections required for erection to permit easy assembly.
  1. Mark each piece and part of the assembly to correspond with previously prepared erection drawings, diagrams, and instruction manuals.
  2. Fabricate structural framing to produce clean, smooth cuts and bends. Punch holes of proper size, shape, and location. Members shall be free of cracks, tears, and ruptures.
- B. Tolerances: Comply with MBMA's "Metal Building Systems Manual": Chapter IV, Section 9, "Fabrication and Erection Tolerances."

## 2.5 STRUCTURAL FRAMING

- A. General:
  1. Primary Framing: Shop fabricate framing components to indicated size and section with baseplates, bearing plates, stiffeners, and other items required for erection welded into place. Cut, form, punch, drill, and weld framing for bolted field assembly.
    - a. Make shop connections by welding or by using high-strength bolts.
    - b. Join flanges to webs of built-up members by a continuous submerged arc-welding process.
    - c. Brace compression flange of primary framing with steel angles or cold-formed structural tubing between frame web and purlin or girt web, so flange compressive strength is within allowable limits for any combination of loadings.
    - d. Weld clips to frames for attaching secondary framing members.
    - e. Shop Priming: Prepare surfaces for shop priming according to SSPC-SP 2. Shop prime primary structural members with specified primer after fabrication.
  2. Secondary Framing: Shop fabricate framing components to indicated size and section by roll-forming or break-forming, with baseplates, bearing plates, stiffeners, and other plates required for erection welded into place. Cut, form, punch, drill, and weld secondary framing for bolted field connections to primary framing.

- a. Make shop connections by welding or by using non-high-strength bolts.
  - b. Shop Priming: Prepare uncoated surfaces for shop priming according to SSPC-SP 2. Shop prime uncoated secondary structural members with specified primer after fabrication.
- B. Primary Framing: Manufacturer's standard structural primary framing system, designed to withstand required loads and specified requirements. Primary framing includes transverse and lean-to frames; rafter, rake, and canopy beams; sidewall, intermediate, end-wall, and corner columns; and wind bracing.
  1. General: Provide frames with attachment plates, bearing plates, and splice members. Factory drill for field-bolted assembly. Provide frame span and spacing indicated.
    - a. Slight variations in span and spacing may be acceptable if necessary to meet manufacturer's standard, as approved by Architect.
  2. Rigid Clear-Span Frames: I-shaped frame sections fabricated from shop-welded, built-up steel plates or structural-steel shapes. Interior columns are not permitted.
  3. Frame Configuration: Two-directional sloped.
  4. Exterior Column Type: Tapered.
  5. Rafter Type: Tapered.
- C. End-Wall Framing: Manufacturer's standard primary end-wall framing fabricated for field-bolted assembly to comply with the following:
  1. End-Wall and Corner Columns: I-shaped sections fabricated from structural-steel shapes; shop-welded, built-up steel plates; or C-shaped, cold-formed, structural-steel sheet; with minimum thickness of 0.0598 inch.
  2. End-Wall Rafters: C-shaped, cold-formed, structural-steel sheet; with minimum thickness of 0.0598 inch; or I-shaped sections fabricated from shop-welded, built-up steel plates or structural-steel shapes.
- D. Secondary Framing: Manufacturer's standard secondary framing members, including purlins, girts, eave struts, flange bracing, base members, gable angles, clips, headers, jambs, and other miscellaneous structural members. Fabricate framing from cold-formed, structural-steel sheet or roll-formed, metallic-coated steel sheet prepainted with coil coating, unless otherwise indicated, to comply with the following:
  1. Purlins: C- or Z-shaped sections; fabricated from minimum 0.0598-inch thick steel sheet, built-up steel plates, or structural-steel shapes; minimum 2-1/2-inch wide flanges.
    - a. Depth: As required to comply with system performance requirements.
  2. Purlins: Steel joists of depths indicated.

3. Girts: C- or Z-shaped sections; fabricated from minimum 0.0598-inch thick steel sheet, built-up steel plates, or structural-steel shapes. Form ends of Z-sections with stiffening lips angled 40 to 50 degrees to flange and with minimum 2-1/2-inch wide flanges.
  - a. Depth: As required to comply with system performance requirements] <Insert dimension.
4. Eave Struts: Unequal-flange, C-shaped sections; fabricated from 0.0598-inch thick steel sheet, built-up steel plates, or structural-steel shapes; to provide adequate backup for metal panels.
5. Flange Bracing: Minimum 2-by-2-by-1/8-inch structural-steel angles or 1-inch diameter, cold-formed structural tubing to stiffen primary frame flanges.
6. Sag Bracing: Minimum 1-by-1-by-1/8-inch structural-steel angles.
7. Base or Sill Angles: Minimum 3-by-2-by-0.0598-inch zinc-coated (galvanized) steel sheet.
8. Purlin and Girt Clips: Minimum 0.0598-inch thick, steel sheet. Provide galvanized clips where clips are connected to galvanized framing members.
9. Secondary End-Wall Framing: Manufacturer's standard sections fabricated from minimum 0.0598-inch thick, structural-steel sheet.
10. Framing for Openings: Channel shapes; fabricated from minimum 0.0598-inch thick, cold-formed, structural-steel sheet or structural-steel shapes. Frame head and jamb of door openings, and head, jamb, and sill of other openings.
11. Miscellaneous Structural Members: Manufacturer's standard sections fabricated from cold-formed, structural-steel sheet; built-up steel plates; or zinc-coated (galvanized) steel sheet; designed to withstand required loads.

## 2.6 ACCESSORIES

- A. General: Provide accessories as standard with metal building system manufacturer and as specified. Fabricate and finish accessories at the factory to greatest extent possible, by manufacturer's standard procedures and processes. Comply with indicated profiles and with dimensional and structural requirements.

## 2.7 FINISHES, GENERAL

- A. Comply with NAAMM's "Metal Finishes Manual for Architectural and Metal Products" for recommendations for applying and designating finishes.

## 2.8 SOURCE QUALITY CONTROL

- A. Testing Agency: Engage a qualified testing and inspecting agency to perform the following tests and inspections and to submit reports.

1. Special inspections will not be required if fabrication is performed by a manufacturer registered and approved by authorities having jurisdiction to perform such Work without special inspection.
  - a. After fabrication, submit certificate of compliance with copy to authorities having jurisdiction certifying that Work was performed according to Contract requirements.
- B. Tests and Inspections:
  1. Bolted Connections: Shop-bolted connections shall be tested and inspected according to RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."
  2. Welded Connections: In addition to visual inspection, shop-welded connections shall be tested and inspected according to AWS D1.1 and the following inspection procedures, at inspector's option:
    - a. Liquid Penetrant Inspection: ASTM E 165.
    - b. Magnetic Particle Inspection: ASTM E 709; performed on root pass and on finished weld. Cracks or zones of incomplete fusion or penetration will not be accepted.
    - c. Ultrasonic Inspection: ASTM E 164.
    - d. Radiographic Inspection: ASTM E 94.
- C. Correct deficiencies in Work that test reports and inspections indicate do not comply with the Contract Documents.

## PART 3 - EXECUTION

### 3.1 EXAMINATION

- A. Examine substrates, areas, and conditions, with Erector present, for compliance with requirements for installation tolerances and other conditions affecting performance of work.
  1. For the record, prepare written report, endorsed by Erector, listing conditions detrimental to performance of work.
- B. Before erection proceeds, survey elevations and locations of concrete- and masonry-bearing surfaces and locations of anchor rods, bearing plates, and other embedments to receive structural framing, with Erector present, for compliance with requirements and metal building system manufacturer's tolerances.
  1. Engage land surveyor to perform surveying.
- C. Proceed with erection only after unsatisfactory conditions have been corrected.

### 3.2 PREPARATION

- A. Clean and prepare surfaces to be painted according to manufacturer's written instructions for each particular substrate condition.
- B. Provide temporary shores, guys, braces, and other supports during erection to keep structural framing secure, plumb, and in alignment against temporary construction loads and loads equal in intensity to design loads. Remove temporary supports when permanent structural framing, connections, and bracing are in place, unless otherwise indicated.

### 3.3 ERECTION OF STRUCTURAL FRAMING

- A. Erect metal building system according to manufacturer's written erection instructions and erection drawings.
- B. Do not field cut, drill, or alter structural members without written approval from metal building system manufacturer's professional engineer.
- C. Set structural framing accurately in locations and to elevations indicated and according to AISC specifications referenced in this Section. Maintain structural stability of frame during erection.
- D. Base and Bearing Plates: Clean concrete- and masonry-bearing surfaces of bond-reducing materials, and roughen surfaces prior to setting plates. Clean bottom surface of plates.
  - 1. Set plates for structural members on wedges, shims, or setting nuts as required.
  - 2. Tighten anchor rods after supported members have been positioned and plumbed. Do not remove wedges or shims but, if protruding, cut off flush with edge of plate before packing with grout.
  - 3. Promptly pack grout solidly between bearing surfaces and plates so no voids remain. Neatly finish exposed surfaces; protect grout and allow to cure. Comply with manufacturer's written installation instructions for shrinkage-resistant grouts.
- E. Align and adjust structural framing before permanently fastening. Before assembly, clean bearing surfaces and other surfaces that will be in permanent contact with framing. Perform necessary adjustments to compensate for discrepancies in elevations and alignment.
  - 1. Level and plumb individual members of structure.
  - 2. Make allowances for difference between temperature at time of erection and mean temperature when structure will be completed and in service.

- F. Primary Framing and End Walls: Erect framing true to line, level, plumb, rigid, and secure. Level baseplates to a true even plane with full bearing to supporting structures, set with double-nutted anchor bolts. Use grout to obtain uniform bearing and to maintain a level base-line elevation. Moist cure grout for not less than seven days after placement.
1. Make field connections using high-strength bolts installed according to RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts" for type of bolt and type of joint specified.
    - a. Joint Type: Snug tightened or pretensioned.
- G. Secondary Framing: Erect framing true to line, level, plumb, rigid, and secure. Fasten secondary framing to primary framing using clips with field connections using non-high-strength bolts.
1. Provide rake or gable purlins with tight-fitting closure channels and fasciae.
  2. Locate and space wall girts to suit openings such as doors and windows.
  3. Locate canopy framing as indicated.
  4. Provide supplemental framing at entire perimeter of openings, including doors, windows, louvers, ventilators, and other penetrations of roof and walls.
- H. Steel Joists and Joist Girders: Install joists, girders, and accessories plumb, square, and true to line; securely fasten to supporting construction according to SJI's "Standard Specifications, Load Tables, and Weight Tables for Steel Joists and Joist Girders," joist manufacturer's written recommendations, and requirements in this Section.
1. Before installation, splice joists delivered to Project site in more than one piece.
  2. Space, adjust, and align joists accurately in location before permanently fastening.
  3. Install temporary bracing and erection bridging, connections, and anchors to ensure that joists are stabilized during construction.
  4. Bolt joists to supporting steel framework using carbon-steel bolts, unless otherwise indicated.
  5. Bolt joists to supporting steel framework using high-strength structural bolts, unless otherwise indicated. Comply with RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts" for high-strength structural bolt installation and tightening requirements.
  6. Install and connect bridging concurrently with joist erection, before construction loads are applied. Anchor ends of bridging lines at top and bottom chords if terminating at walls or beams.
- I. Bracing: Install bracing in roof and sidewalls where indicated on erection drawings.
1. Tighten rod and cable bracing to avoid sag.
  2. Locate interior end-bay bracing only where indicated.

- J. Framing for Openings: Provide shapes of proper design and size to reinforce openings and to carry loads and vibrations imposed, including equipment furnished under mechanical and electrical work. Securely attach to structural framing.
- K. Erection Tolerances: Maintain erection tolerances of structural framing within AISC's "Code of Standard Practice for Steel Buildings and Bridges."

### 3.4 FIELD QUALITY CONTROL

- A. Testing Agency: Engage a qualified testing and inspecting agency to perform the following tests and inspections and to submit reports.
- B. Tests and Inspections:
  - 1. High-Strength, Field-Bolted Connections: Connections shall be tested and inspected during installation according to RCSC's "Specification for Structural Joints Using ASTM A 325 or A 490 Bolts."
  - 2. Welded Connections: In addition to visual inspection, field-welded connections shall be tested and inspected according to AWS D1.1 and the following inspection procedures, at inspector's option:
    - a. Liquid Penetrant Inspection: ASTM E 165.
    - b. Magnetic Particle Inspection: ASTM E 709; performed on root pass and on finished weld. Cracks or zones of incomplete fusion or penetration will not be accepted.
    - c. Ultrasonic Inspection: ASTM E 164.
    - d. Radiographic Inspection: ASTM E 94.
- C. Correct deficiencies in Work that test reports and inspections indicate do not comply with the Contract Documents.

### 3.5 CLEANING AND PROTECTION

- A. Repair damaged galvanized coatings on galvanized items with galvanized repair paint according to ASTM A 780 and manufacturer's written instructions.
- B. Touchup Painting: After erection, promptly clean, prepare, and prime or reprime field connections, rust spots, and abraded surfaces of prime-painted structural framing, bearing plates, and accessories.
  - 1. Clean and prepare surfaces by SSPC-SP 2, "Hand Tool Cleaning," or SSPC-SP 3, "Power Tool Cleaning."
  - 2. Apply a compatible primer of same type as shop primer used on adjacent surfaces.

- C. Touchup Painting: Cleaning and touchup painting are specified in Division 9 painting Sections.

END OF SECTION 133419