



Designation: E1637 – 98 (Reapproved 2017)^{ε1}

Standard Specification for Structural Standing Seam Aluminum Roof Panel Systems¹

This standard is issued under the fixed designation E1637; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

^{ε1} NOTE—Editorial changes were made in 2.7, 5.2.2, and throughout in October 2017.

1. Scope

1.1 This specification covers the design, construction, and weatherability of structural standing seam aluminum roof panel systems. It includes performance requirements for the following elements only: panels, concealed panel clips, panel/clip anchorage, and panel joint sealers.

NOTE 1—These systems are used on both low-slope and steep-slope roof applications. They also are used with or without an underlying deck or sheathing.

1.2 The objective of this specification is to provide for the overall performance of the structural standing seam aluminum roof panel system as defined in 3.2.6 during its service life in order to provide weather protection, carry the specified design loads, and allow proper access over the roof surface in order to provide for periodic maintenance of the equipment by the building owner.

1.3 In addition to structural characteristics, the specifier shall evaluate other characteristics beyond the scope of this specification that affect the final choice of roof construction. These include, but are not limited to, functional, legal, insurance, and economic considerations. See Appendix X1 for the specifier's checklist.

1.4 This specification is not intended to exclude products or systems not covered by the referenced documents.

1.5 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.6 The text of this specification contains notes and footnotes that provide explanatory information and are not requirements of this specification.

1.7 *This international standard was developed in accordance with internationally recognized principles on standard-*

ization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.

2. Referenced Documents

2.1 ASTM Standards:²

B209 Specification for Aluminum and Aluminum-Alloy Sheet and Plate

C711 Test Method for Low-Temperature Flexibility and Tenacity of One-Part, Elastomeric, Solvent-Release Type Sealants

C765 Test Method for Low-Temperature Flexibility of Preformed Tape Sealants

C879 Test Methods for Release Papers Used with Preformed Tape Sealants

D1667 Specification for Flexible Cellular Materials—Poly (Vinyl Chloride) Foam (Closed-Cell)

D3310 Test Method for Determining Corrosivity of Adhesive Materials

E631 Terminology of Building Constructions

E1592 Test Method for Structural Performance of Sheet Metal Roof and Siding Systems by Uniform Static Air Pressure Difference

E1646 Test Method for Water Penetration of Exterior Metal Roof Panel Systems by Uniform Static Air Pressure Difference

E1680 Test Method for Rate of Air Leakage through Exterior Metal Roof Panel Systems

G21 Practice for Determining Resistance of Synthetic Polymeric Materials to Fungi

2.2 FM Approvals Standard:³

Approval Standard for Class 1 Panel Roofs, Class Number 4471

¹ This specification is under the jurisdiction of ASTM Committee E06 on Performance of Buildings and is the direct responsibility of Subcommittee E06.57 on Performance of Metal Roof Systems.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ Available from FM Approvals, 1151 Boston-Providence Turnpike, P.O. Box 9102, Norwood, MA 02062, <http://www.fmapprovals.com>.

2.3 *UL Standard:*⁴

UL 580 Standard for Safety, Tests for Uplift Resistance of Roof Assemblies

2.4 *AA Document:*⁵

Aluminum Design Manual, Latest Edition

2.5 *AISI Document:*⁶

S100 North American Specification for the Design of Cold-Formed Steel Structure Members

2.6 *MBMA Document:*⁷

MBMA Low Rise Building Systems Manual, Latest Edition

2.7 *ASHRAE Document:*⁸

ASHRAE Handbook of Fundamentals

2.8 *NCC Document:*⁹

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3. Terminology

3.1 *Definitions:*

3.1.1 Refer to the latest edition of the MBMA Low Rise Building Systems Manual and Terminology **E631** for definitions of terms used in this specification.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *construction loads, n*—those loads encountered during the erection of the roof system only.

3.2.2 *fixing line, n*—a line or adjacent lines of fixed points.

3.2.3 *maintenance loads, n*—loads including, but not limited to, personnel, equipment, and materials required to maintain functionality of the building.

3.2.4 *oil canning, n*—a waviness that occurs in flat areas of metal.

3.2.5 *sealer, n*—any material that is used to seal cracks, joints, or laps.

3.2.6 *structural standing seam aluminum roof panel system, n*—an aluminum roof system designed to resist positive and negative loads applied normal to the panel surface without the benefit of a supporting deck or sheathing.

3.2.7 *thermal movement, n*—the reaction of the roof system in response to changes in the panel temperature.

4. Performance Requirements

4.1 *Design*—The roof system shall be designed for specified design loads and thermal effects.

4.1.1 Minimum environmental design loads shall be determined by the governing code or the design professional.

⁴ Available from Underwriters Laboratories (UL), 2600 N.W. Lake Rd., Camas, WA 98607-8542, <http://www.ul.com>.

⁵ Available from The Aluminum Association, 1400 Crystal Dr., Suite 430, Arlington, VA 22202, <http://www.aluminum.org>.

⁶ Available from American Iron and Steel Institute (AISI), 25 Massachusetts Ave., NW, Suite 800, Washington, DC 20001, <http://www.steel.org>.

⁷ Available from Metal Building Manufacturers Association (MBMA), 1300 Summer Avenue, Cleveland, OH 44115-2851, <http://www.mbma.com>.

⁸ Available from American Society of Heating, Refrigerating, and Air-Conditioning Engineers, Inc. (ASHRAE), 1791 Tullie Circle, NE, Atlanta, GA 30329, <http://www.ashrae.org>.

⁹ Available from National Centers for Environmental Information, Federal Building, 151 Patton Ave., Asheville, NC 28801-5001, <http://www.ncdc.noaa.gov>.

4.1.2 The finished roof system shall be capable of sustaining a minimum 200-lb (0.9-kN) concentrated load on any 12 by 12-in. (300 by 300-mm) area of finished roof without causing seam separation, permanent panel buckling, or loss of weathertightness.

4.1.3 Thermal movement shall be provided for in accordance with Sections 7 and 8. Temperature extremes for many localities are found in documents referenced in 2.6 – 2.8.

4.1.4 The standing seam roof system clips do not always provide full lateral support to secondary structural members. The degree of lateral support provided to the secondary structural members by the panel system shall be determined by an appropriate test, or in the absence of such test, the panel must be assumed to provide no lateral support.

NOTE 2—The Base Test Method for Purlins Supporting a Standing Seam Roof System in the AISI S100 Cold-Formed Steel Design Manual is used to evaluate lateral support when the secondary structural is cold-formed Zee or Cee purlins.

4.2 *Protection of Incompatible Materials*—Components constructed of incompatible materials shall not be placed together without an effective separating material.

4.3 *Oil Canning*—Oil canning is an inherent characteristic of products covered by this specification, particularly those with broad, flat areas. It is the result of several factors that include, but are not limited to, induced stresses in the base material, fabrication methods, and installation and thermal forces. While oil canning is an aesthetic issue, structural integrity is not normally affected. Oil canning is not grounds for panel rejection unless it does not meet prior standards established by the specifier.

5. Structural Integrity

5.1 *Panel System Design:*

5.1.1 Structural panels shall be designed in accordance with the Specifications for Aluminum Structures and in accordance with sound engineering methods and practices.

5.1.2 Deflection and serviceability shall be accounted for.¹⁰ The deflection shall be limited so as to allow the roof to perform as designed. The substrate deflection shall not cause strains to the panels that affect the serviceability of the system.

5.2 *Panel System Testing:*

5.2.1 *Static (Positive or Negative) Load Capacity*—When the panel system does not comply with the requirements for using the design procedures of the Specifications for Aluminum Structures, testing shall be performed to determine the roof's load capacity.

5.2.2 *Uplift Index*—When required by the specifier, the roof system shall be tested in accordance with the requirements of FM Approvals Approval Standard 4471, or Underwriters Laboratories UL 580 or Test Method **E1592** or other applicable tests (see **Appendix X2**).

6. Panel Material

6.1 The panel material shall be in accordance with the Specifications for Aluminum Structures and Specification **B209**.

¹⁰ Fisher, J. M. and West, M. A., "Serviceability Design Considerations for Low-Rise Buildings," *AISC Design Guide*, No. 3.