



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.

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.

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 Pre-formed Tape Sealants

[C879](#) Test Methods for Release Papers Used with Pre-formed 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 LLC Standard*:³

Approval Standard for Class 1 Panel Roofs, Class Number 4471

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

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.

Current edition approved Aug. 15, 2011. Published September 2011. Originally approved in 1994. Last previous edition approved in 2003 as E1637 – 98 (2003). DOI: 10.1520/E1637-98R11.

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 LLC, 1151 Boston Providence Turnpike, P.O. Box 9102, Norwood, MA 02062, <http://www.fmglobal.com>.

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

⁵ Available from Aluminum Association (AA), Inc., 1525 Wilson Blvd., Suite 600, Arlington, VA 22209, <http://www.aluminum.org>.

⁶ Available from American Iron and Steel Institute (AISI), 1140 Connecticut Ave., NW, Suite 705, Washington, DC 20036, <http://www.steel.org>.

2.6 MBMA Document:⁷

MBMA Low Rise Building Systems Manual, Latest Edition

2.7 ASHRAE Document:⁸

1997 ASHRAE Handbook of Fundamentals

2.8 NCC Document:⁹

1981 B Climatology of U.S. #81

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.

4.1.2 The finished roof system shall be capable of sustaining a minimum 200-lb (0.9-kN) concentrated load on any 12-in. by 12-in. (300-mm 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

⁷ Available from Metal Building Manufacturers Association (MBMA), Inc., 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 Climatic Center (NCC), 151 Patton Ave., Asheville, NC 28801, <http://www.ncdc.noaa.gov/oa/ncdc.html>.

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 5.3 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**.

6.2 Aluminum alloy, temper, and metal thickness shall be as required to resist specified design loads.

7. Panel Clips

7.1 Connections of panels to structural members shall be made with concealed panel clips compatible with the panel design.

7.2 Provisions for the thermal movement between the panel and the structure to which it is attached shall be accomplished by the use of concealed panel clips allowing such movement, except as provided in 7.3.

7.3 When the building geometry and the rotational flexibility of the support members permit, it is permissible to resolve thermal movement through controlled rotation of the intermediate structural members rather than movement within the panel clip.

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

7.4 Where insulation is applied between the panels and supporting structure, the panel clips shall be designed to be compatible with the thickness and compressibility of the insulation. If thermal spacers are required for insulation performance, the panel clip must be compatible with the thermal spacer to reduce secondary stresses due to walking.

8. Panel and Clip Anchorage

8.1 A fixing line is required to anchor roof panels in order to maintain end alignment and to resist in-plane gravity and thermal force components.

8.2 Fasteners that penetrate the roof surface are permitted only at panel endlaps, penetrations, fixing lines, rib reinforcements, and at roof termination lines. Details at these locations shall allow for the expected thermal movement.

8.3 Nails shall not be used where subject to withdrawal loads.

9. Weather Tightness

9.1 Panel-to-panel sidelap connections and endlaps shall be weathertight.

9.2 Panels of maximum practicable lengths shall be used to minimize endlaps.

9.3 Sealers:

9.3.1 *Sidelap Sealer*—When the climate, roof slope, and roof system design warrant, the standing seam sidelap shall have a sealer (see [Note 3](#)). When the sealer is factory applied, it shall remain in place and be protected during transit. In some cases, the panel geometry will provide the required protection. All sealers shall remain in place during panel installation and be protected during storage and installation from any contamination and abrasion that unduly affects service.

NOTE 3—When the slope of the roof is steep, or when the roof system is in a geographic area with little rainfall or snowfall, a sidelap or endlap sealer may not necessarily be required.

9.3.1.1 The sealer shall be of sufficient size and shape to fill the maximum void to be sealed and to ensure compression after engagement. The minimum compression shall be 30 % by volume, or the adhesion plus webbing characteristics shall be as required to maintain watertightness. An appropriate test will be used to demonstrate the roof panel system's resistance to ponded water. The sealer shall remain flexible between 0°F (–18°C) and 140°F (60°C) to allow engagement and shall show no signs of cracking when tested in accordance with Test Method [C765](#) (wrapped 180° over a 1-in. (25-mm) diameter mandrel after 4 h at 0°F. The sealer shall not be exposed after assembly.

9.3.1.2 The sealer shall be sufficiently resilient to maintain the seal after the movement of joints due to fluctuation in external load or expansion and contraction, or both. When tested in accordance with Specification [D1667](#), the maximum set shall be 5 % if compression alone is required to maintain the seal. The sealer shall be capable of maintaining the above level of watertightness after exposure to the service temperature range, –40°F (–40°C) to 200°F (93°C) unless local or project conditions justify that the specifier impose a different range. This watertightness shall be independent of the temperature at the time of panel installation.

9.3.1.3 The sealer shall be noncorrosive and non-staining to adjacent materials and shall exhibit these characteristics after testing in accordance with Test Method [D3310](#), including water and with elevated temperature exposures for 21 days at 160°F (71°C); the rating shall not exceed 2. The sealer shall be fungus resistant and exhibit this property after testing in accordance with Practice [G21](#); the rating shall not exceed 1. In meat and poultry processing facilities or other areas requiring USDA inspection, the sealer shall be chemically acceptable to USDA and shall be requested by the specifier. Appropriate FDA regulation(s) shall be included by the specifier when FDA compliance is required.

9.3.1.4 If the seam design utilizes sealant, and the location of a clip component interrupts the sealant, the design shall not rely on differential movement between the panel seam and the clip component.

9.3.1.5 If the sidelap sealer is interrupted by the installation of a sidelap clip, and if required by the panel system design, the seal shall be completed around the clip. The performance characteristics of the supplemental sealer shall be equal to the primary sidelap sealer. Both sealers' aging characteristics shall sustain the above performance during the design service life of the roof.

9.3.2 *Endlap Sealer*—The panel endlap shall be sealed with either field-applied tape or cartridge-type sealer, or both (see Note). The endlap sealer shall be equal in performance to the sidelap sealer. Minimal sealer exposure shall be allowed after installation.

9.3.2.1 The following requirements shall apply additionally. Cartridge sealers shall remain fluid, and sealing tapes shall release cleanly from any backing paper at temperatures ranging from 0°F (–18°C) to 140°F (60°C). Backing paper shall release cleanly after exposure to moisture and when tested in accordance with Test Method [C879](#) using the Procedure, Alternative A. Tape sealers shall exhibit no cracks or loss of adhesion after exposure in accordance with Test Method [C765](#) with the modified 0.25-in. (6-mm) mandrel requirement (bent 180° over a 0.25-in. mandrel). Cartridge-type sealers shall be tested in accordance with Test Method [C711](#). When required, Test Methods [C765](#) and [C711](#) shall both be modified using a cold temperature preparation at 0°F. When adhesion is required to achieve a seal, sealers shall adhere to panel surfaces and remain tacky and toolable for 12 min after the initial application over the same temperature range. Moderate foot traffic during or after installation shall not pump the sealer out of the joint. Sealers shall perform on panels that are coated lightly with lubricants or airborne contaminants unless the sealer manufacturer requires and the specifier accepts a panel cleaning procedure. Sealers and tapes must be compatible when used in tandem; both must be compatible with contiguous materials. The endlap sealer must maintain a watertight seal when tested in a lapped joint and in accordance with the ponding procedure of [9.3.1](#).

9.3.3 *Exposed Exterior Sealants*—Follow or exceed the panel manufacturer's recommendation concerning type and installation and maintenance procedures for exposed sealants at flashings, penetrations, and perimeter details. The sealer installation characteristics shall be equal to those of endlap cartridge

sealers, for example, compatibility, service temperature range, adhesion, and so forth. The exposed sealer shall also develop a surface skin to minimize contaminant pickup. The sealer shall be flexible and shall maintain performance during and after movement within the system caused by either external loads or thermal response. Exposed sealers shall be unaffected substantially by exposure to sunlight, ultraviolet radiation, ice, snow, rain, and the temperature range, -40°F (-40°C) to 200°F (93°C) unless local or project conditions justify that the specifier impose a different range. They shall maintain their adhesive, cohesive, and weathertightness properties throughout the design service life of a properly maintained system. The detail weathertightness shall be equal to that of the adjacent system.

10. Installation

10.1 Standing seam roof panel systems shall be installed in accordance with the system design requirements.

11. Keywords

11.1 aluminum; anchorage; clips; construction; deflection; endlaps; environmental; exposed; exposures; fasteners; flashings; installation; joints; loading; loads; low-sloped; metal; oil canning; panels; penetrations; ponding; roof; sealer; seismic; service life; sidelap; slope; snow; standing seam; structural; superimposed; tapes; thermal; uplift; water; weathertightness

APPENDIXES

(Nonmandatory Information)

X1. ADDITIONAL ROOF PERFORMANCE CONSIDERATIONS

X1.1 Scope

X1.1.1 This appendix, although it may not be all inclusive, provides a quick checklist of additional design considerations to assist the specifier in the use of this specification.

X1.2 Design Considerations

X1.2.1 Prescribe the anticipated service life to the system.

X1.2.2 Specify the design loads: Live, snow, rain, ice, seismic, construction, and maintenance. To avoid various interpretations, it is preferred that the design loads be specified rather than that codes or standards be referenced. It is the responsibility of the specifier to notify the owner and the responsibility of the owner's maintenance personnel to not exceed the specified maintenance loads.

X1.2.3 Provide any unusual temperature extremes or ranges that are unique to a project (whether the temperatures occur throughout the roof field or are localized, for example, hot stacks).

X1.2.4 Notify the engineer of records that additional wind bracing might be required for the primary structure and that additional bridging may be required at the purlins.

X1.2.5 Consider oil canning as the specification is prepared.

X1.2.6 Establish the allowable deflection at design load.

NOTE: X1.1—Deflection will be relative to the adjacent purlins.

X1.2.7 Specify the required wind uplift test procedure, if any is required. See **Appendix X2** for commentary.

X1.2.8 Provide unusual local environmental or atmospheric conditions (interior or exterior, or both) that can affect the choice of base materials, accessories, and organic coatings, for

example, marine environment, high SO_2 or acidic conditions, localized settlement from exhaust stacks high humidity inside building, and so forth.

X1.2.9 Provide a description of the building end use.

X1.2.10 Specify the acceptable level of air infiltration and water penetration or default to the requirements of **9.3, Sealers**. (See Test Methods **E1646** and **E1680** for water penetration and air leakage test methods.)

X1.2.11 Consider illumination requirements. Provide the location and type of penetrations and of roof-mounted equipment.

X1.2.12 Provide fire-resistance considerations.

X1.2.13 Provide interface details with other parts of the structure.

X1.2.14 Provide details for the configuration and flashing of all penetrations through the roof surface.

X1.2.15 In certain applications of uninsulated construction, it is necessary to protect the panel underside from abrasion at the purlin or secondary members that may arise from wind flutter or differential movement between the panel and support member. This may be accomplished by the use of insulation, thermal spacer, or other buffer material.

X1.2.16 Relative movement of separate components that make up a panel system may occur if factors, such as snow or thermal movement, are not considered. Secure components such that their direction of movement is considered.

X1.2.17 Provide a means for mitigation of condensation, which could adversely affect the roof system, the structure, or its contents.

X2. UPLIFT TESTS

X2.1 Commentary

X2.1.1 Wind represents a complex loading, which cannot be duplicated in a laboratory by uniform static pressure. Real wind pressures vary in magnitude, as well as in duration. Uniform static pressure test methods with edge conditions representative of actual field conditions, such as Test Method

E1592, generally will yield conservative results when compared with system performance under actual wind loadings. With current code design pressures, uniform pressure tests may yield conservative results. Procedures have not been developed yet to account for the load sharing that can occur in multiple layer roof construction.

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