

Double male panel



When working with single lock standing seam roofing, the ability to manufacture double male panels is useful for several situations.

Dan Perkins, owner of Dan Perkins Construction in Ishpeming, Mich., has found several circumstances where double male panels are useful. He and his crews have developed what they believe to be the quickest method to produce double male panels.

First of all, with a double male panel, Perkins says he can:

- Start roofing in the middle of opposing valleys so they can be both worked upward.
- Start roofing in the center of a hip and work down both sides so panels stay straight and balanced.
- Start a long straight run in the center of a roof so it finishes evenly and can be installed by two teams.



Any thoughts?

Do you see something you like or would do differently? Got a better way to manufacture a double male panel? Share it with the editors. Write to *Metal Roofing Magazine*, 700 East State St., Iola, WI, 54990-0001, or e-mail jim.austin@fwpubs.com.

"This is a quick method for making a double male pan developed by one of our operators," Perkins says. "First, run out a pan to the proper length — but leave it in the machine; do not shear it off."

The second step involves straightening the female leg — bend it straight up with hand tongs, working from the center out.

"Then start an inward fold over a standard speed square in duct tape, to prevent scratching," Perkins says.

To proceed, finish the 90-degree bend by hammering the rib over the speed square with the flat of the hand tongs. "Any excess material can be removed from the new male rib with a hand snips," Perkins says.

The panel pictured is for the center of a hip, so the end terminations must be finished. The panel is ready for installation.

"This 15-foot double male pan took 6-1/2 minutes to fabricate using this method," Perkins says. "We used to try and get the panel on a brake and make that male leg, but this is much simpler and quicker." ■

This is the 13th in a series produced by *Metal Roofing Magazine*, with the help of Michigan roofer Dan Perkins.

