



Installing curved panels

Michigan roofer Dan Perkins, owner of Dan Perkins Construction, recently ran into a problem attempting to curve panels and install them.

“This story begins with a mistake,” Perkins says. “I had bid and secured a trim package and entrance canopy for the new River Valley Bank being constructed by Moyle Incorporated in Marquette, Mich. The canopy was 22 feet wide and dropped 17 inches on either side and I figured it was shallow enough that I could stretch my panels over it. When the day came for us to install the roof we quickly realized the metal would not bend to the curve without causing severe deflection in the panels. Suddenly I found myself in immediate need of a panel curving machine.

“After a flurry of calls I was directed to Sam Blanck at Muza Sheet Metal Co. in Oshkosh, Wis. Muza is a fairly large operation with 60 employees and a 20,000-square-foot shop. Two years ago, Muza Sheet Metal purchased a Schleich RBM 25.38 panel curving machine to handle the eight jobs a year they were doing with curved panels at the time. The average rental was costing them \$1,000 per job and they figured at \$8,000 per year in rent, purchasing the machine made good sense. Since the purchase the word has spread and their work in curved panels has qua-



drupled. Oshkosh is a four-hour drive for me so I set out early with a trailer and some lumber for crating the finished panels.

“I was greeted at Muza Sheet Metal by Brian Bartel, estimator, and Chuck Schuster, president of Muza,” Perkins says. “They showed me their shop — a metal crafters dream, reflecting decades of ingenuity and efficiency designed into every working space. The rolling tables caught my eye. Large steel wheels

Any thoughts?

Do you see something you like or would do differently? Got a better way to install curved panels? 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.

were installed in the center of the base so large loads could be spun around and moved effortlessly.

“Muza Sheet Metal is a union shop that primarily trains and holds its personnel. The two who roll formed and curved my panels have both been with the company for more than 10 years.

“As I watch the panels being formed, Chuck Schuster asks me, “Do you use backer rod under your panels?” I tell him I do use backer rod under all my panels and we share a moment affirming our customers won’t accept oil canning in our work no matter what excuses we have for it.

“The next day, my foreman, Joel Vickstrom, and his brother Jared who had struggled to install the panels the first time, were pleased to report the panels fit the convex surface perfectly. They cut the counter flashing into the masonry in a stepped fashion and trimmed it to fit the contour of the roof. The drip edge on the gable was notched to accept the curve as well.”

Barrel type roofs are increasingly popular and contractors who are willing to tackle them are finding themselves in a growing niche market. “Muza Sheet Metal has an advantage in the Wisconsin commercial market because they have seasoned estimators, fabricators, and installers in house who speak the same language and who understand what each other is doing,” Perkins says. “Visiting them is a learning experience and a growth model for any small fabricator who sees opportunity in the ever expanding market metal roofing and fabrication industry.” ■



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