

These requirements are typical and should serve as a basis for all field curving projects. For an individual or unique project, additional requirements may be necessary. Contact IMETCO for clarification.

Schedules

Once an order is placed, IMETCO needs a preliminary field roll-forming schedule, which can have a range of two (2) to three (3) weeks for the field operations. This schedule allows IMETCO to coordinate other field operations and prevent overlapping schedules.

The preliminary schedule must be refined to an actual date as early as possible to minimize scheduling conflicts.

Material Cut List

The customer must provide the following information to IMETCO for the field rolling operation.

1. A material cut list (panel count and corresponding panel lengths) to determine raw material requirements (coil stock)
2. IMETCO must receive the final cut list three (3) weeks prior to the scheduled job site forming date to allow adequate production time for seam caps and head closures. Failure to provide final cut list to IMETCO in a timely manner will increase freight charges on most projects (in this event, seam caps and accessories will likely be shipped AFTER coil and equipment trucks have delivered to the job site).

IMETCO Personnel

IMETCO will provide an equipment operator and operator's assistant for the field roll-forming operation. IMETCO personnel are non-union; as a product manufacturer, neither IMETCO nor its personnel shall be responsible for union dues or fees, or union membership requirements. IMETCO personnel will provide a workman's compensation insurance certificate and drug screening results (within most recent 12 month period) upon customer's request, prior to arriving at the jobsite.

IMETCO personnel are NOT allowed to work from ladders or at roof level; IMETCO insurance does not cover working conditions that may be expected of roofers. Personnel are NOT experienced roofers or technical representatives; installation, hoisting, and handling questions should be directed to appropriate IMETCO technical support personnel.

If jobsite safety orientation is expected to exceed one hour per project, please advise, as an extended orientation will affect field roll-forming completion time and IMETCO quotation.

Job Site Requirements For Customer

The following items, equipment, personnel and preparation must be on the job site and at IMETCO's immediate disposal:

1. A level staging area measuring approximately 16' X 50', plus the panel length, must be provided for actual panel forming operation. For large jobs, additional space may be required for tractor trailer delivery of coil stock. Panels are always formed at the ground level on a true horizontal plane
2. Power supply is 440 volt with ground, 3 phase, 3 wire. A diesel generator to provide this power is provided by IMETCO with the roll-forming equipment
3. A forklift (or Lull) with a capacity rating of 10,000 pounds, which will be used for handling coil stock and towing/maneuvering the equipment trailer at the job site. The contractor shall provide an operator for the lift equipment.
4. A person every 15'-0" of panel length to off-load the panel as it exits the roll-former and to properly store the panel. Material should be stored as near to the roll-forming area as possible to maximize forming output and minimize equipment standby time.
5. Material storage is defined in the attached guidelines, *Field Storage of Materials*.

If any of the above items are not provided, the scheduled field curving date could be jeopardized.

Field-Rolling Time Estimate

IMETCO personnel are available to work weekends, overtime, and in mildly inclement weather (other than thunderstorms). IMETCO requires the customer's personnel to off-load panels from the roll-forming equipment for at least 8 hours per weekday, as long as weather conditions do not pose any safety hazards. IMETCO encourages the customer to work more than 8 hours per day, and on weekends, if conditions allow.

IMETCO estimates it will take three (3) to four (4) days to roll-form these panels. Any additional days required due to inadequate manpower or site preparation on behalf of the customer shall be invoiced at \$2,500 per day (including each additional weekend day).

Delays due to severe weather, roll-forming equipment breakdown, or other acts beyond the reasonable anticipation of IMETCO or the customer shall not result in monetary fees or charges to either IMETCO or the customer.