



## How Much Is Left on the Coil?

CHARTS HELP ELIMINATE GUESSWORK AND LEFTOVER MATERIAL

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**MANY METAL ROOFING** contractors are realizing the benefits of owning a portable, standing-seam-panel rollforming machine rather than purchasing preformed panels. Having your own machine offers the ability to produce engineered profiles and longer lengths, as well as generates less handling and freight. In many cases, it's even cheaper to rollform your own panels.

Keep in mind, however, that once you own a rollforming machine, you assume the role of manufacturer. That means you also assume the responsibility for ordering enough coils to complete a project.

Coils are available to fit every profile from standing-seam to R-panel, from Kynar 500/Hylar 5000 to polyester paint systems. Each profile requires a

## COILS WITH A 16-INCH INNER DIAMETER

24 gauge x 24-inch width

6	2400	2451	1226
5 1/2	2160	2206	1103
5	1920	1961	980
4 1/2	1680	1716	858
4	1488	1520	760
3 1/2	1296	1324	662
3	1104	1128	564
2 1/2	960	980	490
2	816	833	417
1 1/2	624	637	319
1	480	490	245
1/2	240	245	123

24 gauge x 22-inch width

6	2200	2247	1228
5 1/2	1980	2022	1105
5	1760	1798	983
4 1/2	1540	1573	860
4	1364	1393	761
3 1/2	1188	1213	663
3	1012	1034	565
2 1/2	880	899	491
2	748	764	418
1 1/2	572	584	319
1	440	449	245
1/2	220	225	123

24 gauge x 20-inch width

6	2000	2043	1223
5 1/2	1800	1838	1101
5	1600	1634	978
4 1/2	1400	1430	856
4	1240	1266	758
3 1/2	1080	1103	661
3	920	940	563
2 1/2	800	817	489
2	680	695	416
1 1/2	520	531	318
1	400	409	245
1/2	200	204	122

24 gauge x 16-inch width

6	1600	1634	1229
5 1/2	1440	1471	1106
5	1280	1307	983
4 1/2	1120	1144	860
4	992	1013	762
3 1/2	864	882	663
3	736	752	565
2 1/2	640	654	492
2	544	556	418
1 1/2	416	425	320
1	320	327	246
1/2	160	163	122

## COILS WITH A 20-INCH INNER DIAMETER

26 gauge x 24-inch width

6	2400	3070	1535
5 1/2	2160	2762	1381
5	1920	2456	1228
4 1/2	1680	2148	1074
4	1488	1904	952
3 1/2	1296	1658	829
3	1104	1412	706
2 1/2	960	1228	614
2	816	798	539
1 1/2	624	614	466
1	480	492	393
1/2	240	306	153

24 gauge x 24-inch width

6	2880	2942	1471
5 1/2	2640	2696	1348
5	2400	2452	1226
4 1/2	2160	2206	1103
4	1920	1960	980
3 1/2	1680	1716	858
3	1440	1470	735
2 1/2	1200	1226	613
2	960	980	490
1 1/2	720	734	368
1	480	490	245
1/2	240	246	123

24 gauge x 22-inch width

6	2640	2696	1473
5 1/2	2420	2472	1351
5	2200	2247	1228
4 1/2	1980	2022	1105
4	1760	1798	983
3 1/2	1540	1573	860
3	1320	1348	737
2 1/2	1100	1123	614
2	880	899	491
1 1/2	660	674	368
1	440	449	245
1/2	220	225	123

24 gauge x 20-inch width

6	2400	2451	1468
5 1/2	2200	2247	1346
5	2000	2043	1223
4 1/2	1800	1838	1101
4	1600	1634	978
3 1/2	1400	1430	856
3	1200	1226	734
2 1/2	1000	1021	611
2	800	817	489
1 1/2	600	613	359
1	400	409	245
1/2	200	204	122

particular gauge and width. For rollform- ing of standing-seam and snap-lock pro- files, the industry uses standard coil widths of 24, 22, 20 and 16 inches (610, 559, 508 and 406 mm). For agricultural products, such as the R-Panel, the standard widths are 40.875 and 41.562 inches (1038 and 1056 mm). In some cases, coil can be left over on a project because the machine operator for- got to keep track of the amount of lineal footage on the coil. But how can you tell how much coil is left? It's easy. Follow these four simple steps:

1. Measure the inner diameter of the coil. It's probably going to be 16 or 20 inches (406 or 508 mm).