

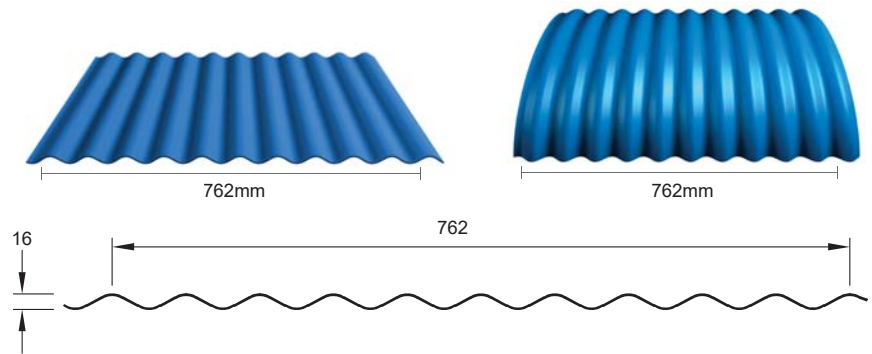
The Lysaght logo is positioned in the top right corner. It features the word "LYSAGHT" in a bold, white, sans-serif font. A white swoosh underline is positioned beneath the letters "AGHT". The background of the entire page is a dark blue/black color with a faint, intricate pattern of white architectural blueprints and technical drawings. A large, diagonal, semi-transparent graphic element, resembling a corrugated steel profile, runs from the top left towards the bottom right, with a color gradient from light blue to yellow.

LYSAGHT

**LYSAGHT[®] CUSTOM ORB[®] &
CUSTOM BLUE ORB[®]**

**Tough & Versatile
Corrugated Steel
Cladding for Modern &
Traditional Architecture**

LYSAGHT® CUSTOM ORB® and CUSTOM BLUE ORB®



LYSAGHT® CUSTOM ORB® and CUSTOM BLUE ORB® are the famous corrugated profiles, equally at home with traditional and contemporary design. It is a wide, strong and lightweight profile that can be quickly and easily installed. Add up these features and you have a steel roof or wall cladding that simply offers outstanding value.

CURVING

LYSAGHT® CUSTOM ORB® is not intended for machine curve. For bullnosing we recommend LYSAGHT® CUSTOM BLUE ORB®. The long-curved lengths of LYSAGHT® CUSTOM BLUE ORB® can be easily placed and aligned. From the traditional verandah to the double curves and complex shapes of modern homes and offices, we offer a full range of curving styles to suit almost any building.

The extra ductility of LYSAGHT® CUSTOM BLUE ORB® allows easy curving without distortion of its profile, and without damage to the finish.

PHYSICAL PROPERTIES

		STANDARD
LYSAGHT® CUSTOM ORB®		
Base Metal Thickness (mm)	0.42	0.48
Total Coated Thickness (mm)	0.47	0.53
Mass per Unit Area – COLORBOND® Steel (kg/m ²)	4.35	4.93
Mass per Unit Area – ZINCALUME® Steel (kg/m ²)	4.28	4.86
LYSAGHT® CUSTOM BLUE ORB®		
Base Metal Thickness (mm)	0.60	
Total Coated Thickness (mm)	0.65	
Mass per Unit Area – COLORBOND® Steel (kg/m ²)	6.09	
Mass per Unit Area – ZINCALUME® Steel (kg/m ²)	6.02	
Coating Class (min)	AZ150	
Grade of Steel (MPa)	CUSTOM ORB® - G550 (550MPa minimum yield stress) CUSTOM BLUE ORB® - G300 (300MPa minimum yield stress)	
Effective Cover Width	762mm	
Rib Depth	16mm	
Min Recommended Roof Pitch/ Slope	5° (1 in 12)	
Tolerances	Length ± 10.0mm / Width ± 4.0mm	
Custom Cut Lengths	Any measurement to a maximum transportable length.	



Scan for online resources

MAXIMUM ALLOWABLE SUPPORT SPACING

The maximum recommended support spacing are based on testing in accordance with AS1562.1, AS4040.0 and AS4040.1. Roof spans consider both resistance to wind pressure and light foot traffic (traffic arising from incidental maintenance). Wall spans consider resistance to wind pressure only.

LYSAGHT® CUSTOM ORB® Type of Span	BASE METAL THICKNESS (BMT)	
	0.42	0.48
Roofs (mm)		
Single Span	700	800
End Span	900	1300
Internal Span	1200	1700
Unstiffened Eaves Overhang	200	250
Stiffened Eaves Overhang	300	350
Walls (mm)		
Single Span	1800	1800
End Span	2500	2700
Internal Span	2700	2700
Overhang	200	250

LYSAGHT® CUSTOM BLUE ORB® Type of Span	BASE METAL THICKNESS (BMT)
	0.60
Roofs (mm)	
Roofs including bullnosed roofs	1600
End Span	1600
Internal Span	1800
Unstiffened Eaves Overhang	200
Stiffened Eaves Overhang	300
Walls (mm)	
Single Span	2400
End Span	3000
Internal Span	3300
Overhang	200

- For roofs: the data are based on foot-traffic loading.
- For walls: the data are based on pressures (see wind pressures table).
- Table data are based on supports of 1mm BMT.
 Basic wind speed (Strength Limit State) = 57m/sec
 Terrain category co-efficient = 0.83
 Shielding factor = 0.85
 Topography factor = 1
 Design wind speed Strength Limit State (with above factors) = 40.2m/sec
 Basic wind speed (Strength Limit State) = 40m/sec
 Terrain category co-efficient = 1
 Shielding factor = 1
 Topography factor = 1
 Design wind speed Strength Limit State (with above factors) = 40m/sec

Walls

$C_{pe} = -0.65$, $K_1 = 2$ for single and end spans, $K_1 = 1.5$ for internal spans
 $C_{pi} = +0.2$

Roofs

$C_{pe} = -0.9$, $K_1 = 2$ for single and end spans, $K_1 = 1.5$ for internal spans
 $C_{pi} = +0.2$

These spacings may vary by Serviceability and Strength Limit States for particular projects.

MAXIMUM ROOF LENGTHS FOR DRAINAGE MEASURED FROM RIDGE TO GUTTER (m)

Peak Rainfall Intensity (mm/hr)	Roof Slope (degrees)		
	5	7.5	10
100	29	34	38
150	20	23	25
200	15	17	19
250	12	14	15
300	10	11	13
400	7	8	10
500	6	7	8

Penetrations will alter the flow of water on a roof. For assistance in design of roofs with penetrations, please seek advice from Lysaght representative.

LIMIT STATE WIND PRESSURE CAPACITIES (kPa)
LYSAGHT® CUSTOM ORB®

0.42mm BMT			SPAN (mm)								
TYPE OF SPAN	FASTENERS PER SHEET PER SUPPORT	LIMIT STATE	600	900	1200	1500	1800	2100	2400	2700	
Single	3	Serviceability	1.91	1.46	1.08	0.77	0.49	-	-	-	
		Strength *	12.00	8.60	5.80	4.65	4.50	-	-	-	
	5	Serviceability	5.39	3.20	1.75	0.94	0.45	-	-	-	
		Strength *	12.00	12.00	10.15	8.10	7.40	-	-	-	
End	3	Serviceability	1.66	1.40	1.18	1.00	0.83	0.67	0.52	0.38	
		Strength *	9.15	7.55	5.90	4.50	3.40	2.70	2.30	2.00	
	5	Serviceability	6.08	4.27	2.79	1.59	1.02	0.65	0.42	0.30	
		Strength *	12.00	12.00	9.90	7.55	5.75	4.50	3.60	3.05	
Internal	3	Serviceability	1.91	1.67	1.45	1.23	1.03	0.85	0.69	0.56	
		Strength *	11.35	9.25	7.45	6.00	4.85	3.90	3.20	2.70	
	5	Serviceability	7.00	4.92	3.32	2.21	1.49	1.05	0.78	0.59	
		Strength *	12.00	12.00	12.00	10.80	8.85	7.10	5.65	4.50	

0.48mm BMT			SPAN (mm)								
TYPE OF SPAN	FASTENERS PER SHEET PER SUPPORT	LIMIT STATE	600	900	1200	1500	1800	2100	2400	2700	
Single	3	Serviceability	2.12	1.47	1.03	0.77	0.60	-	-	-	
		Strength *	12.00	9.80	6.55	5.30	5.10	-	-	-	
	5	Serviceability	7.48	3.74	2.23	1.26	0.57	-	-	-	
		Strength *	12.00	12.00	10.75	8.65	8.10	-	-	-	
End	3	Serviceability	1.92	1.66	1.48	1.35	1.19	1.01	0.81	0.60	
		Strength *	11.70	9.05	6.80	4.95	4.10	3.45	3.00	2.65	
	5	Serviceability	8.00	4.75	2.86	1.97	1.39	0.97	0.66	0.44	
		Strength *	12.00	12.00	12.00	10.60	8.00	6.20	5.00	4.25	
Internal	3	Serviceability	1.98	1.96	1.84	1.62	1.36	1.07	0.82	0.62	
		Strength *	12.00	10.15	8.50	7.10	5.70	4.55	3.60	2.90	
	5	Serviceability	9.00	5.42	4.34	3.31	2.37	1.57	0.95	0.54	
		Strength *	12.00	12.00	12.00	12.00	11.00	8.65	6.75	5.25	

LYSAGHT® CUSTOM BLUE ORB®

0.60mm BMT			SPAN (mm)										
TYPE OF SPAN	FASTENERS PER SHEET PER SUPPORT	LIMIT STATE	600	900	1200	1500	1800	2100	2400	2700	3000	3300	3600
Single	3	Serviceability	3.32	2.58	1.94	1.48	1.08	0.73	0.39	-	-	-	-
		Strength *	12.00	10.55	7.25	5.85	5.05	4.55	4.30	-	-	-	-
	5	Serviceability	10.50	6.03	2.62	1.30	0.62	0.36	0.32	-	-	-	-
		Strength *	12.00	12.00	12.00	10.00	8.35	7.25	6.35	-	-	-	-
End	3	Serviceability	2.85	2.41	1.99	1.62	1.29	1.01	0.78	0.58	0.41	0.26	-
		Strength *	12.00	12.00	0.10	6.75	5.25	3.60	4.05	3.60	3.15	2.70	-
	5	Serviceability	11.00	7.72	4.80	2.62	1.40	0.89	0.73	0.58	0.41	0.23	-
		Strength *	12.00	12.00	12.00	9.05	7.35	6.55	6.20	5.70	5.05	4.30	-
Internal	3	Serviceability	3.05	2.55	2.11	1.75	1.48	1.25	1.05	0.84	0.63	0.42	0.21
		Strength *	12.00	12.00	9.15	6.80	5.65	5.15	4.95	4.55	4.00	3.30	2.60
	5	Serviceability	10.94	7.43	4.51	2.59	1.55	1.07	0.88	0.72	0.54	0.37	0.19
		Strength *	12.00	12.00	12.00	9.95	8.30	7.70	7.45	7.00	6.25	5.35	4.40

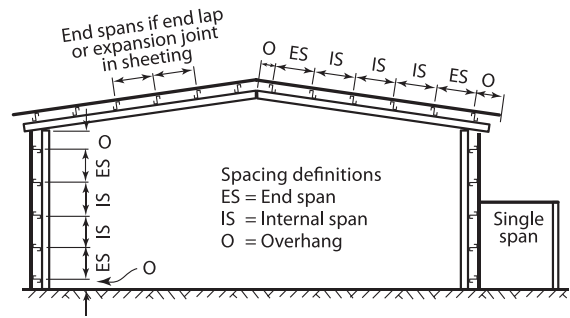
* A capacity reduction factor of 0.9 is applied to strength capacities. These capacities are based on tests conducted at BlueScope Steel's NATA registered testing laboratory using a direct pressure testing rig. Supports must not be less than 1mm BMT.

LIMIT STATES WIND PRESSURES

The wind pressure capacities are based on tests conducted at BlueScope Lysaght's NATA-registered testing laboratory. Testing was conducted in accordance with AS 1562.1 - 1992 Design and Installation of Sheet Roof and Wall Cladding - Metal, and AS 4040.2 - 1992 Resistance to Wind Pressure for Non-cyclonic Regions.

The pressure capacities for serviceability are based on a deflection limit of $(\text{span}/120) + (\text{maximum fastener pitch}/30)$.

The pressure capacities for strength have been determined by testing the cladding to failure (ultimate capacity). These pressures are applicable when the cladding is fixed to a minimum of 1.0mm, G550 steel.



METHOD STATEMENT AND GENERAL NOTES

WALKING ON ROOFS

Keep your weight evenly distributed over the soles of both feet to avoid concentrating your weight on either heels or toes. Always wear smooth soft-soled shoes; avoid ribbed soles that pick up and hold small stones, swarf, and other objects.

Whatever direction you walk, always walk in the pans. When walking across the width of the roof, walk over, or close to, the roof supports.

ADVERSE CONDITIONS

If this product is to be used in marine, severe industrial, or unusually corrosive environments, ask for advice from our Lysaght representative.

METAL & TIMBER COMPATIBILITY

Lead, copper, free carbon, bare steel and green or some other chemically treated timbers are not compatible with this product. Don't allow any contact of the product with those materials, nor discharge of rainwater from them onto the product. Supporting members should be coated to avoid problems with underside condensation. If there are doubts about the compatibility of other products being used, ask for advice from our Lysaght representative.

MAINTENANCE

Optimum product life will be achieved if all external walls are washed regularly. Areas not cleaned by natural rainfall (such as the tops of walls sheltered by eaves) should be washed down every six months.

SAFETY, STORAGE AND HANDLING

LSYAGHT's product may be sharp and heavy. It is recommended that heavy-duty cut resistant gloves and appropriate manual handling techniques or a lifting plan be used when handling material.

Keep the product dry and clear off the ground. If stacked or bundled product becomes wet, separate it, wipe it with a clean cloth to dry thoroughly.

Handle materials carefully to avoid damage: don't drag materials over rough surfaces or each other; don't drag tools over material; protect from swarf.

CUTTING

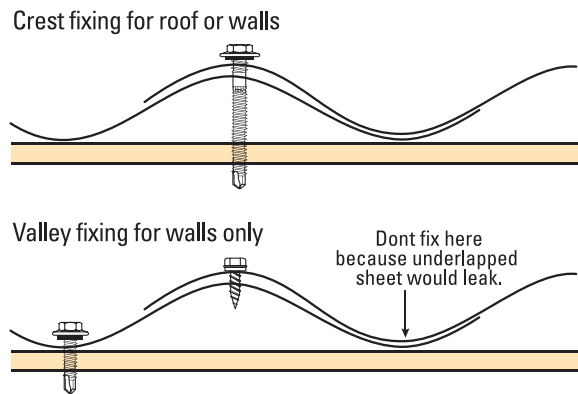
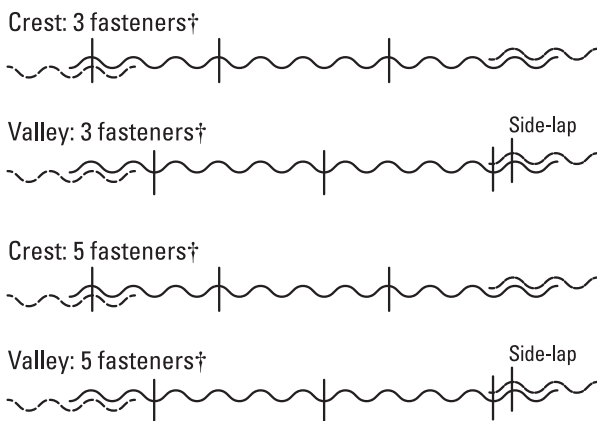
For cutting thin metal on site, we recommend a circular saw with a metal cutting blade because it produces fewer damaging hot metal particles and leaves less resultant burr than a carborundum disc does.

Cut materials over the ground and not over other materials. Sweep all metallic swarf and other debris from roof areas and gutters at the end of each day and at the completion of the installation. Failure to do so can lead to surface staining when the metal particles rust.

FASTENERS

LYSAGHT® CUSTOM ORB® and CUSTOM BLUE ORB® requires 3 fasteners per sheet per support for internal spans and 5 fasteners for single and end spans. Fastener should comply to AS3566, Class 3 or Class 4.

Fasteners without insulation			
	Fix to Steel up to 0.75mm BMT	Fixing to Steel 0.75 to 3.0mm BMT	Fixing to Timber
Crest fixed	Self-drilling, self-tapping screws with hex. washer head and EPDM seal and shank guard 13-13x41 or Type 17 screws with hex. washer head EPDM seal & shank guard 12-11x40	Self-drilling, self-tapping screws with hex. washer head and EPDM seal and shank guard 12-14x35	Type 17 screws with hex washer head EPDM seal Softwood: 12-11x50 with higrup & shank guard Hardwood: 12-11x40 with shank guard
Valley fixed	Self-drilling, self-tapping screws with hex. washer head and EPDM seal and shank guard 10-16x16 or Type 17 screws with hex. washer head EPDM seal & shank guard 10-12x20	Self-drilling, self-tapping screws with hex. washer head and EPDM seal and shank guard 10-16x16	Type 17 screws with hex. washer head EPDM seal Softwood: 10-12x30 Hardwood: 10-12x20
Side lap (if required)	Needle point stitching screws with hex. washer head & EPDM seal: 10-12x20 or Sealed blind rivets: 4.8mm diameter aluminium		



FASTENING SHEETS TO SUPPORTS

LYSAGHT® CUSTOM ORB® and CUSTOM BLUE ORB® are pierced-fixed to timber or steel supports. This means that fastener screws pass through the sheeting.

You can place fasteners through the crests or in the pans. To maximize watertightness, always place roof fasteners through the crests. For walling, you may use either crest or valley-fixing.

Always drive the fasteners perpendicular to the sheeting, and in the center of the corrugation or rib. Do not place fasteners less than 25mm from the ends of sheets.

SEALED JOINTS

For sealed joints use screws or rivets and neutral-cure silicone sealant branded as suitable for use with galvanized or ZINCALUME® steel.

SIDE-LAPS

LYSAGHT® CUSTOM ORB® and CUSTOM BLUE ORB® is overlapped at the sides not less than 1.5 corrugations. It is generally considered good practice to use fasteners along side-laps. However, when cladding is supported as indicated in maximum support spacings, side-lap fasteners are not usually needed for strength.

END LAPS

End-laps are not usually necessary because LYSAGHT® CUSTOM ORB® and CUSTOM BLUE ORB® is available in long lengths. If you want end-laps, seek advice from our Lysaght representative on the sequence of laying and the amount of overlap.

END OF SHEETS

It is usual to allow roof sheets to overlap into gutters by about 50mm. If the roof pitch is less than 25° or extreme weather is expected, the pans of sheets should be turned-down at lower ends and turned-up at upper ends by about 80°.

USE LYSAGHT® CUSTOM ORB® FOR LONG STRAIGHT STRETCHES

On most jobs one sheet will cover from ridge to gutter without end-laps. Where there are long straight lengths you may like to use LYSAGHT® CUSTOM ORB® for the straight sections.

If you have a design where LYSAGHT® CUSTOM BLUE ORB® laps with LYSAGHT® CUSTOM ORB®, it is recommended both should be ordered together to ensure perfect lapping.

TURNING-UP LYSAGHT® CUSTOM ORB® OR LYSAGHT® CUSTOM BLUE ORB®

With pliers, multi-grips or a shifting spanner closed down to approximately 2mm, grip the valley corrugations 20mm in from the end of the sheet and turn up as far as possible. Be careful not to tear the sheet.

USE LYSAGHT® CUSTOM BLUE ORB® FOR CURVES

Curving Radius

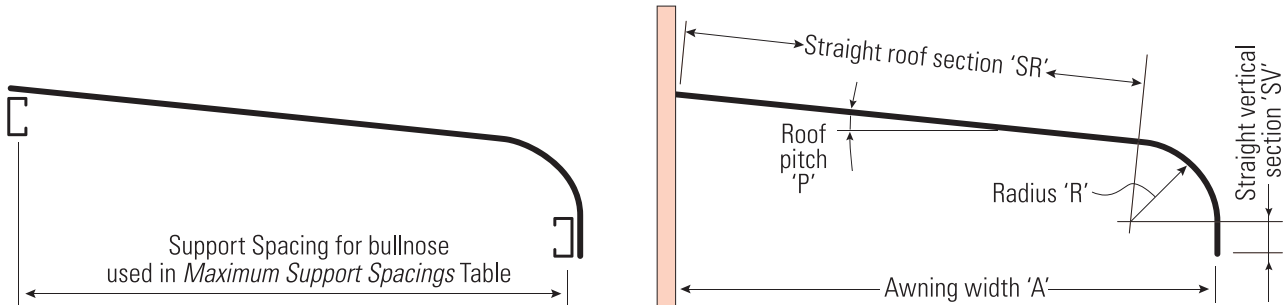
Straight vertical min. (SV) = 100mm

Radius min. (R) = 300mm

The minimum curving radius is 300mm. At the end of a curve, there must be a straight vertical section of at least 100mm.

Spring Curve

The minimum radius for convex spring curving is 9m.



$$\left. \begin{array}{l} \text{Span to be used in determining} \\ \text{wind pressure capacities of bullnoses} \end{array} \right\} = SR + (\text{arc of radius } R) \\
 = \frac{A - R(1 - \sin P)}{\cos P} + \frac{R\pi(90 - P)}{180}$$

GENERAL INSTALLATION METHOD

CHECK FLATNESS, SLOPE AND OVERHANG

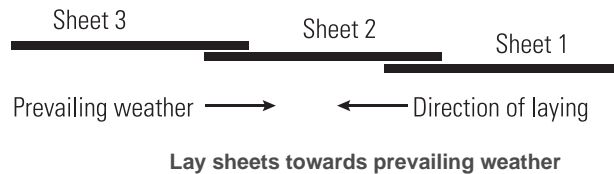
Before starting work ensure that:

- The supports for your cladding are truly in the same plane.
- The minimum roof slopes conform to our recommendations; and
- The overhangs of sheets from the top and bottom supports don't exceed our recommendations.

Make any necessary adjustments before you start laying sheets, because they will be difficult to rectify later.

ORIENT SHEETS BEFORE LIFTING

Consider which end of the building is best to start from. For maximum weather-tightness, start laying sheets from the end of the building that will be downwind of the worst-anticipated or prevailing weather.



It is much easier and safer to turn sheets on the ground than up on the roof. Before lifting sheets on to the roof, check that they are the correct way up and the overlapping side is towards the edge of the roof from which installation will start.

Place bundles of sheets over or near firm supports, not at mid span of roof members.

POSITION FIRST SHEET

With particular care, position the first sheet before fixing to ensure that it is correctly located in relation to other parts of the building.

Check that the sheet:

- is aligned with the end-wall (or its barge or fascia), bearing in mind the type of flashing or capping treatment to be used; and
- aligns correctly at its ends in relation to the gutter and ridge (or parapet or transverse wall).
- overhang requirements are not compromised.

POSITION OTHER SHEETS

After fixing the first sheet in position, align the following sheets using:

- the long edge of the previous sheet; and
- a measurement from the end of the sheet to the fascia or purlin at the gutter. It is important that you keep the gutter-end of all sheets in a straight line.

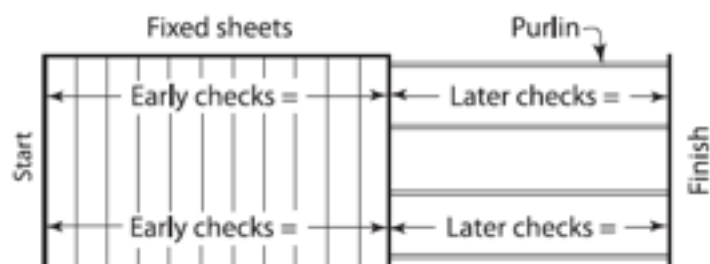
Fix the sheet by either:

- fixing each sheet completely, before laying the next; or
- fix the sheet sufficiently to ensure it can't move, complete laying all sheets, then return to place all the intermediate fasteners later.

CHECK ALIGNMENT OCCASIONALLY

Occasionally check that the sheets are still parallel with the first sheet, by taking two measurements across the width of the fixed sheeting.

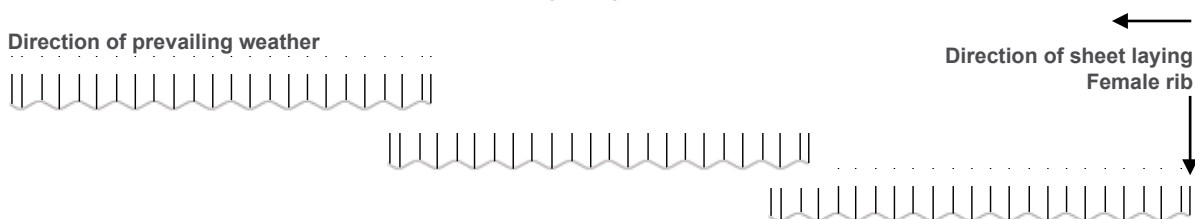
At about halfway through the job, perform a similar check but take the measurements from the finishing line to aim for the final sheet to be parallel with the end of the roof. If the measurements are not close enough, lay subsequent sheets very slightly out of parallel to gradually correct the error. To allow this to happen, flatten the tabs on the base of subsequent clips - the slot in the clip will allow the clips to be fixed out of standard pitch.



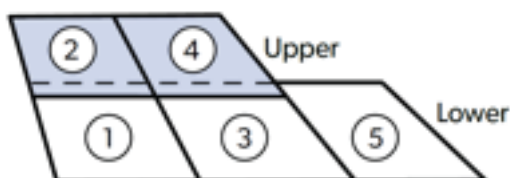
Check alignment occasionally

STEPS FOR INSTALLATION

- When lifting roofing sheets onto roof frames for installation, make sure all male and/or female ribs face the same direction. If not, sheets will have to be turned end-for-end during fixing.



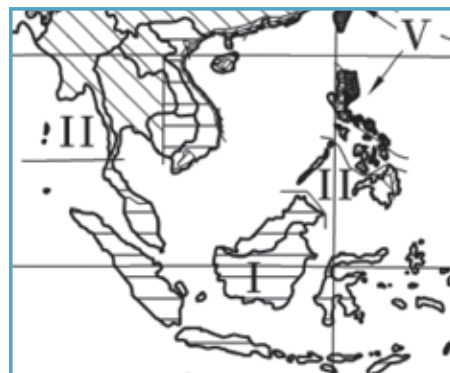
- The first sheet of LYSAGHT® CUSTOM ORB® profile must be positioned with care before fastening with hex head self-tapping screws to ensure that it lies straight and square.
- When the first sheet of LYSAGHT® CUSTOM ORB® profile is fastened to positions, a string line can be stretched across the lower end of the roof alignment. The line will then be used as a guide for the subsequent installation of roof panels.
- Position and fasten the next roofing sheet to each support of the male rib of the installed sheet. Place the second sheet over the second run of the roofing sheets and fastened the sheets together before proceeding to the next sheet.
- Make sure the side lapping is installed correctly. The side rib with the longitudinal anti capillary flute (male rib) is supposed to be covered by the side rib without a longitudinal flute (female rib).
- Each sheet should be fully fastened before proceeding to the next sheet. The side lap with preceding sheet should be fastened last.
- In the case that two or more shorter sheets are installed to provide full length coverage due to handling or transport considerations, lay each complete line of sheets in turn from gutter/ eaves to ridge, as shown in the diagram.



NON-CYCLONIC AREAS

The information in this brochure is suitable for use only in areas where a tropical cyclone is unlikely to occur as defined in AS 1170.2-2002. Map and table (below) taken from HB212-2002.

Wind speeds versus return period (3 s gusts, 10 m height, open country terrain)				
Handbook Level	Description	Equation for V_R	V_{50}	V_{500}
I	Strong thunderstorms and monsoon winds	$70 - 56R^{-0.1}$	32	40
II	Moderately severe thunderstorms and extra-tropical gales	$67 - 41R^{-0.1}$	39	45
III	Severe thunderstorms and moderate or weakening typhoons/tropical cyclones	$106 - 92R^{-0.1}$	44	57
IV	Strong typhoons/ tropical cyclones	$122 - 104R^{-0.1}$	52	66
V	Very strong typhoons/ tropical cyclones	$156 - 142R^{-0.1}$	60	80



Note: All the product images used in this brochure are for reference purposes only and does not reflect the actual configuration of the product. Kindly note that the product images are indicative and for illustration purposes only. Lysaght reserves the right to make any change to product images without prior notice. For accurate and up-to-date information, seek advice from Lysaght representative.

STRONG BRANDS, QUALITY MATERIALS

LYSAGHT® products are made of highest quality material, namely COLORBOND® steel and ZINCALUME® steel which are the leading materials for external cladding application. COLORBOND® steel and ZINCALUME® steel have been used on countless buildings to portray modern architecture works of art, ranges from the classic roofing to advance façade for industrial, commercial and residential buildings.

Colorbond®

COLORBOND® steel is a pre-painted finished product with ZINCALUME® steel substrate to deliver both superior corrosion resistance and excellent colour performance.

It comes with the THERMATECH® solar reflectance technology and Clean technology to minimize tropical dirt staining while lowering urban heat island effect, delivering longevity and minimal maintenance to your external cladding.

COLORBOND® steel is backed by a material warranty of up to 25 years*

Product Attributes

- Pre-painted finish on top of ZINCALUME® steel substrate to deliver superior corrosion resistance.
- Superior primer technology which prevents paint delamination.
- Proprietary super polyester paint system proven to provide excellent colour performance.
- Clean technology incorporated to resist against tropical dirt staining.
- THERMATECH® solar reflectance technology to allow for lower temperature cladding.
- Wide varieties of colours and finishes to cater for your building design needs.

Zincalume®

ZINCALUME® steel is a metallic coated steel product composed of 55% aluminium, 43.5% zinc and 1.5% silicon (aluminium-zinc alloy coating) that can provide superior corrosion resistance for your external cladding, with expected lifespan that's four times the life of generic alternatives (GI).

ZINCALUME® steel is backed by a material warranty of up to 25 years*

Product Attributes

- Superior corrosion resistance due to the minimum coating class of AZ150.
- Initial resistance to surface marking and wet storage corrosion due to the proprietary clear resin coating.
- Better aesthetics compared to generic alternatives (Al-Zn) due to less surface darkening, afforded by the proprietary clear resin coating.
- Lightweight and thermally efficient compared to conventional roofing materials (e.g. concrete and clay tiles)
- Excellent flexibility in design as steel can be bent and curved to form truly unique designs.

**Warranty terms and conditions apply*

This material warranty may vary to buildings nearer to marine or industrial environment and is subjected to prior agreement by BlueScope. For full terms and conditions and to determine the eligibility of your project for the warranty, please contact your Key Account Manager.

There are different internal and external environments affecting the longevity of COLORBOND® steel and ZINCALUME® steel, hence feel free to consult our material experts for more specialized recommendations.

Examples of recommendations:

- Direct contact between COLORBOND® steel or ZINCALUME® steel with copper, lead and stainless steel should be avoided.

If condensation on the reverse side of roofing sheet is likely, vapour barrier should be installed to shield COLORBOND® steel or ZINCALUME® steel from prolonged exposure to the condensation (moisture).

REFERENCES

Tawau Sports Complex, Sabah



SMK Gunsanad II Keningau, Sabah



Residential projects in Austria



Residential projects in Austria





NS BLUESCOPE LYSAGHT MALAYSIA SDN BHD

Company No: 196801000301 (7896-D)

NO 6, PERSIARAN KEMAJUAN, SEKSYEN 16,
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