

# Rollforming Guide

FOR SUPERIOR MOISTURE MANAGEMENT



Dridex® combines the proven performance of COLORSTEEL® with an innovative absorbent fleece material that's bonded to the underside of the sheet, completely replacing the need for roofing underlay. Dridex® delivers superior condensation & ventilation management for a warmer, drier & healthier internal environment.

The absorbent fleece changes the handling characteristics of the product. This information bulletin provides advice for ordering, machine set up and handling of COLORSTEEL Dridex® from coil to site.

## Ordering Guide

To ensure that the overlap of the profile is supplied free of fleece, Dridex® needs to be ordered with the correct fleece alignment. When looking from the uncoiler to the guillotine, if the underlap is on the left hand side, the fleece needs to be aligned to the left (M). If the underlap is on the right hand side, the fleece must be aligned to the right (O). The illustrations portray how left and right aligned fleece will be run. Please make sure to include the alignment symbol (M or O) on your ordering form.

### COIL OPTIONS

<b>WIDTHS AVAILABLE</b>	940mm 1221mm
<b>COLOURS</b>	All COLORSTEEL® Colours
<b>MINIMUM ORDER</b>	½ tonne
<b>MAXIMUM COIL SIZE</b>	2.5 tonnes

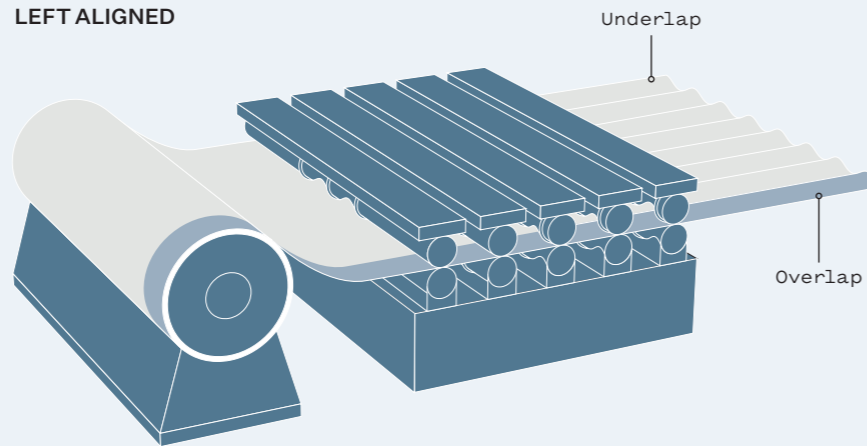
SPEC		YIELD
WIDTH	GAUGE	MAXAM™ (Lineal meters/tonne)
940	0.40	306
940	0.55	229
1221	0.40	237
1221	0.55	177

# M

### FLEECE IS ALIGNED TO THE LEFT AS DRAWN

Roofing profile underlap enters rollforming machine on the left side. Fleece on underside of sheet.

LEFT ALIGNED

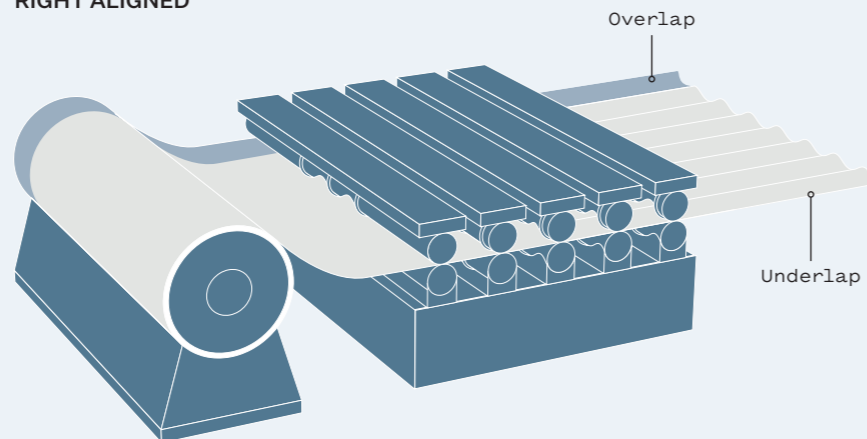


# O

### FLEECE IS ALIGNED TO THE RIGHT AS DRAWN

Roofing profile underlap enters rollforming machine on the right side. Fleece on underside of sheet.

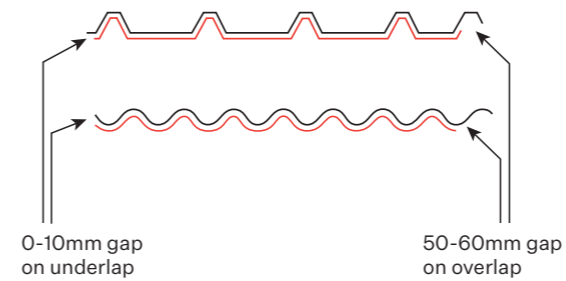
RIGHT ALIGNED



### Prior to manufacture:

- ⌋ Check that the profile is approved for Dridex®: i.e. all corrugate, all trapezoidal and select trough (secret fixed) profiles.
- ⌋ Check that the fleece is aligned to the correct side of the coil, away from the overlap. A 0-10mm gap on underlap side is normal and acceptable (see figure 1).
- ⌋ Has the installer been certified? If not contact your COLORSTEEL® Key Account Manager.

figure 1.



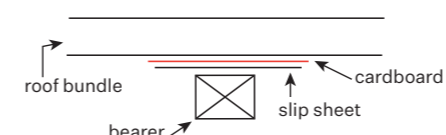
### Rollforming:

- ⌋ Increase clearance in the tooling. Generally, easing it up for normal settings for next gauge up is adequate. For example; for 0.40mm material, increase the clearances to those used for 0.55mm.
- ⌋ Run test piece. If excessive bruising of the fleece, or fleece delamination is observed, increase tooling clearances. Small dark lines on internal bends are normal and acceptable.
- ⌋ Check profile is in tolerance.
- ⌋ Check fleece periodically while running to ensure it is not being damaged by excessive pressure, or torn by contact with other tooling such as the guillotine.

### Stacking & Transport:

- ⌋ Treat product as per other material with pre-finished under side.
- ⌋ Use a short slip sheet with overlay of cardboard on all bearers, before stacking sheets (see figure 2).
- ⌋ Avoid wet stack storage as per other COLORSTEEL® products.
- ⌋ It's good practice is to insert a sheet of light waterproof material under the end of the top sheet and wrapped around bundle ends. This will help minimise water penetration if delivering in wet conditions.

figure 2.



Any other queries please contact your COLORSTEEL® Key Account Manager or call 0800 697 833.



**NOTE:** Buyers and users of New Zealand Steel Limited products and services must make their own assessment of the products for their own conditions. All queries regarding product specification, purpose or application should be directed to New Zealand Steel Limited, phone 0800 697 833. New Zealand Steel Limited reserves the right to modify products, techniques, equipment and statements to reflect improvements in the manufacture and application of its products. The information contained in this brochure is accurate as at July 2024 and supplied without prejudice to New Zealand Steel Limited's standard terms and conditions of sale. In the event of conflict between this information and the standard terms and conditions, the standard terms and conditions prevail. This brochure supersedes all previous brochure editions. COLORSTEEL®, MAXAM™ and Dridex® are registered trademarks of New Zealand Steel Limited. Copyright® New Zealand Steel Limited. July 2024. DR02

COLORSTEEL.CO.NZ

