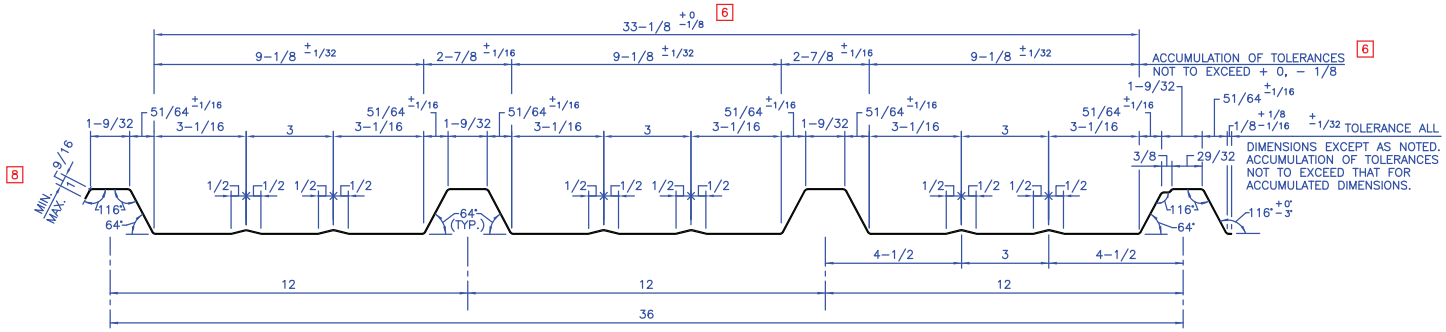
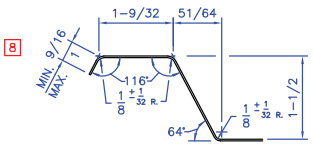
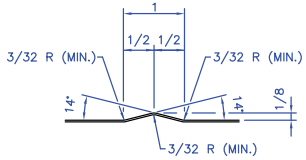


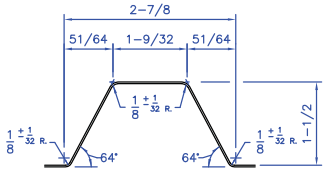
CROSS SECTION



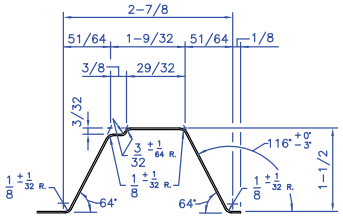
END CORRUGATION
(WITHOUT RETURN & SEALANT GROOVE)



TYPICAL BEAD



TYPICAL INTERIOR CORRUGATION



END CORRUGATION
(WITH RETURN AND SEALANT GROOVE)

NOTES:

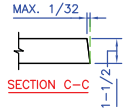
1. ALL ALUMINUM MUST BE ADEQUATELY OILED PRIOR TO ROLL FORMING TO PREVENT GALLING.
2. ANY REDUCTION IN AREA AT BEND RADII SHALL NOT EXCEED 10% OF ADJACENT MATERIAL THICKNESS.
3. ANGLE TOLERANCES ± 2 DEGREES, EXCEPT AS SHOWN. HORIZONTAL PLANES ± 2 DEGREES FROM HORIZONTAL, EXCEPT AS SHOWN. ANGLES TO BE MEASURED FROM A FLAT PLANE, WITH PANEL HELD TO THAT PLANE WITHOUT DISTORTION OF AS FABRICATED WIDTH AND WITH OUTSIDE CORRUGATION FREE.
4. CROSS SECTION TOLERANCES SHOWN TO BE HELD THROUGHOUT LENGTH OF PANEL EXCEPT WHERE PANEL IS DISTORTED BY SHEARING OR BENDING.
5. MAXIMUM ALLOWABLE LATERAL OR VERTICAL DISTORTION BY THE SHEARING OPERATIONS IS ± 1/32 FROM "AS ROLLED SHAPE".
6. DIMENSIONS SHOWN ARE FOR PANEL HELD IN FLAT PLANE, WITHOUT DISTORTION OF AS FABRICATED WIDTH AND WITH OUTSIDE CORRUGATIONS FREE.

8

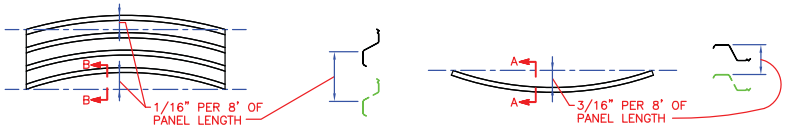
MATERIALS		
FLAT MAT'L. ORDER WIDTH	THICKNESS & MATERIAL	MAT'L. SPECS.
45.00"	.019 & .024 M.T. GALV., PAINTED, ALZN	10090, 10156, 10179
45.00"	.020 & .025 M.T. ALCO	10178
45.12"	.026 HI-TEN ALUMINUM	10162
45.12"	.032 ALUMINUM	10105
45.06"	.019 & .024 M.T. HIGH YIELD STEEL	10090, 10156, 10179

ALLOWABLE COMBINATION OF CAMBER AND BOW
(PER L' OF PANEL LENGTH)

CAMBER IN L' OF PANEL LENGTH							BOW IN L' OF PANEL LENGTH						
32	28	24	20	16	12	8	8	12	16	20	24	28	32
1/4	7/32	3/16	5/32	1/8	3/32	1/16	0	0	0	0	0	0	0
3/16	11/64	9/64	1/8	3/32	5/64	3/64	1/32	3/64	1/16	5/64	3/32	7/64	1/8
1/8	7/64	3/32	5/64	1/16	3/64	1/32	1/16	3/32	1/8	5/32	3/16	7/32	1/4
1/8	7/64	3/32	5/64	1/16	3/64	1/32	3/32	9/64	3/16	15/64	9/32	21/64	3/8
1/8	7/64	3/32	5/64	1/16	3/64	1/32	1/8	3/16	1/4	5/16	3/8	7/16	1/2
1/16	1/16	3/64	3/64	1/32	1/32	1/64	5/32	15/64	5/16	25/64	15/32	35/64	5/8
0	0	0	0	0	0	0	3/16	9/32	3/8	15/32	9/16	21/32	3/4



SECTION C-C



ALLOWABLE EDGE CAMBER-EITHER DIRECTION

SECTION B-B

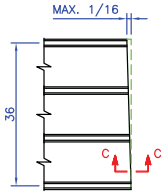
ALLOWABLE BOW-EITHER DIRECTION

SECTION A-A

FOR PANELS WITH OUTSIDE CORRUGATIONS, CAMBERED IN OPPOSITE DIRECTIONS, THE TOTAL IS NOT TO EXCEED 1/16" PER 8' PANEL LENGTH.

8

MATERIALS		
FLAT MAT'L. ORDER WIDTH	THICKNESS & MATERIAL	MAT'L. SPECS.
45.06"	.015" M.T. HIGH YIELD STEEL	ASTM A446 80 K.S.I. MIN. GRADE E MOD. (AIM 90 K.S.I. YIELD 4% ELONGATION)



SQUARENESS TOLERANCE

NO.	REVISION	DRAWN KB. NO.	CHECKED ENGRG.
7	REVISED FLAT MAT'L. WIDTH ON 24 GAGE & 26 GAGE 42 K.S.I. STEEL TO 45-1/16 (WAS 45-1/8).	RWR / KB-6971 / DATE: 02/25/77	RWR
8	9/16 MIN. WAS 5/8 MIN. 45.00 WAS 45-1/16. GENERAL MATERIAL CALLOUT REVISION.	RWR / KB-7393 / DATE: 07/18/78	RWR
9	REVISED & REDRAWN FROM "D" SIZE TO "C" SIZE. CONVERTED TO AUTOCAD.	RHE / KB-9555 / DATE: 08/04/94	VLT
4	REVISE TOLERANCE ON 38-1/8" DIM.	RES / DATE: 11/11/69	NAB
5	REVISE BEND RADII AND ADD TOLERANCES ADD NOTES 1 AND 2 AND MATERIAL SPEC NUMBERS.	RES / DATE: 07/28/70	RWR
6	REMOVED U.L. NOTE #7-24929. MATERIAL WIDTH-24970. TOLERANCES-ADDED 80 K.S.I. STEEL.	D.E. / KB-5905 / DATE: 09/12/73	J.A.

1. TOLERANCES AS FOLLOWS UNLESS OTHERWISE NOTED:
   A. MACHINING ± 1/64"
   B. SHEET METAL SHEARING THRU 10 GA. ± 1/16"
   C. STRUCTURAL LENGTH ± 1/8"
   D. BRAKE PARTS ± 2°
   E. PUNCHING LOCATION ± 1/16"
2. ALL WELDING SYMBOLS ARE ACCORDING TO BUTLER STDS.
3. FOR MACHINING FINISHES SEE BUTLER STANDARDS BOOK

ITEM NO.	NO. REQ'D.	PART NUMBER	NAME AND SIZE	MAT'L. OR SPEC.
			BUTLERIB II ROOF PANEL	

DRAWN BY	CHECKED BY	PRODUCT ENGRG. APPR.	KB NUMBER	NEXT ASSM. DWG. NO.	PART GROUP NO.
JDA	RLA	RKP		SHIPPABLE	008-30
PART WT.	BUTLER MANUFACTURING COMPANY			FIRST RELEASE DATE 10/25/68	REVISION DATE 08/04/94
ORDER NUMBER	GENERAL OFFICES – KANSAS CITY, MISSOURI			C 027159	09