MERLINIETALS[®]Company Product Information

STS Panels[®] - TSS Panels[®] - Reveal Panels Wall Capping - Rainwater Goods - Flashings - Coils



Thank you for your interest in Merlin Metals products.

We are a UK-based supplier of premium metal building materials, dedicated to delivering exceptional quality through our long-standing partnership with a trusted UK manufacturer. This collaboration reflects our unwavering commitment to providing reliable and high-quality products year after year. Our primary focus is on material supply, we do not currently offer installation services.



For straightforward projects, we may be able to provide a quotation based on our interpretation of the drawings you supply.

Provided they are sufficiently clear.

In some cases, if the drawings do not allow for accurate estimation, we will require detailed material schedules to be supplied.

Estimates generated from drawings offer a total estimated figure.

Whether customers provide material schedules or approve the provisional schedules we supply,

it is essential that all material schedules are thoroughly reviewed by the customer to ensure accuracy and identify any necessary corrections before placing an order.

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Contents





This document has been designed as a valuable resource, offering detailed information about our products alongside easy-to-use order forms. Whether you are an experienced customer or new to our products, our aim is to make the ordering process as seamless and straightforward as possible.

Looking ahead, we are excited to introduce the Merlin Metals AI system,

Which is being developed to provide even greater support and convenience for our customers.

Quick Guide For New Customers

Never ordered for a project before? it may seem quite daunting, However the basics for any order are as follows.

- The metal and finish.
- The panel lengths and quantities required.
- The flashing types, lengths and quantities required.
- Providing related drawings for flashings that show any project specific dimensions or angles.
- Other items such as underlay, clips, screws, sealant, touch up paint, rainwater goods etc.
- Clear roof plan layout drawings. (If a project requires custom made roof light flashing kits.)

Assisted Ordering:

When customers need assistance to prepare their order details for accurate quoting & so they are production ready, we can help by generating provisional material schedules.

We outline potential items that may be required and highlight project-specific dimensions that may require clarification.

Before Placing an Order

To ensure orders are accurately quoted and prepared for production, it is essential to provide clear and concise information..

For flashings and custom panels, detailed drawings must be submitted, clearly showing:

Dimensions Angles Finish side, etc.

Relevant details can be supplied by completing the appropriate product order forms and emailing them to mail@merlinmetals.com.



Lead Times & Delivery

Lead Time Confirmation:

The lead time for your order is confirmed on the day of ordering. This duration encompasses the fabrication production queue, fabrication time, and delivery to the specified site address. While certain products are available for quick ordering, most of our offerings, including custom-made items like panels, flashings, and certain rainwater goods, are produced on-demand. The fulfillment time is contingent on the current lead time and coil stock levels. Non-peak lead times typically range from 2-3 weeks.

Lead Time On Additional Items For Existing Projects:

For projects requiring more materials after the initial order has been delivered the lead time will be what it is on the day. So it is important to order correctly to avoid delays if more materials are required. However in cases where more items are needed for existing projects to finish, we always try to get made and sent out as soon as possible. But please be aware it could be a long lead time if things are very busy.

Delivery Process:

Orders are dispatched on a protected pallet to the delivery address specified in the order. It is the customer's responsibility to unload the orders, either utilizing a forklift truck if available or with an adequate number of people on-site to manually off-load pallets and their contents safely within the allocated time slot. If a dedicated vehicle capable of off-loading pallets is required, additional costs may apply.

Production Queue and Dispatch:

Upon placing an order, it is scheduled into the production queue. A provisional dispatch date is generally provided within 1-2 weeks. The day before the scheduled delivery, customers are contacted to confirm the impending delivery and ensure there are no restrictions that may affect the driver's ability to access the site, such as narrow roads requiring a smaller delivery lorry.

Delivery Costs and Discounts:

To calculate delivery costs, we require the site post code and details of the order. We may offer discounts or free delivery in certain cases.





Quote To Production

Estimates

When provided with non-specific information, estimates are based on assumptions. For more accurate pricing, we recommend supplying specific details.

Quotations

Quotations are issued based on material schedules that customers confirm to be correct. These schedules can either be:

- Supplied by the customer.
- Generated by us and then reviewed by the customer for revisions, if needed.

Booking In

For confirmed orders, customers must review and finalize all details, ensuring any necessary adjustments are made before committing to purchase.

Requesting Current Rates

To begin estimating your project costs:

Request current rates for your selected metals, panels, and flashings. Use our online forms or email us directly with your order information, including exact lengths, quantities, and any additional details.

Requesting Estimates from Drawings

For some projects, we can provide a provisional material take-off from drawings to establish a more accurate estimate. This includes:

A detailed breakdown of lengths, quantities, and items. Customers and installers need only review and adjust order details before finalizing the price.

Note:

If we create provisional material schedules for customer review, a small deposit is required. This ensures priority is given to customers ready to place an order, while discouraging our efforts are not wasted on those avoiding preparing their own project order details.

Supplying Material Schedules

Providing concise and complete material schedules includes:

Panel lengths and quantities. Flashing lengths and quantities. Other item quantities. Related drawings for flashings or bespoke panels, showing all required dimensions, angles, and finish details. Type of metal/finish, delivery postcode, and site contact number.

Tip for Discounts:

Material schedules provided by customers without requiring us to calculate quantities, details, or create drawings allow us to offer the best rates. These inquiries require less time and work, enabling more competitive pricing.







Greencoat PLX Pural BT Pre Coated Aluminium Roofinox Stainless Steel Corten Steel ZM Silesia Zinc Zintek Coloured Zinc Nedzink Aurubis Copper

We are always prompt to post samples. If you have not received any requested samples within 7 days, do let us know!

Sample Swatches

Samples of metals are always sent before orders are booked in to the production queue.

Compare samples and confirm the right finish for your project before committing to buy.

Sample images of metals, may not always accurately represented the colours and textures. So it is always better to have them in hand.

After selecting from small samples, larger samples are available if required to further finalise the decision.





105mm x

73mm

Aurubis Copper

A natural copper product that develops a green patina over time.

0.6mm sheet material for roof panels and flashings.

Nordic Standard

0.6mm

Natural copper changes appearance over time, if you want a copper look but more control and stability with its appearance you might like to consider some of the other copper effect options in Aluminium or Greencoat steel.





Metallic Copper





25 Year Coating Warranty, 50 Year

Metallic Gold



Anthracite Grey*



Tile Red



Nordic Night Black*



Cottage Red



Quarry Grey



Leaf Green



Snow White







Mountain Grey*



Silver Fir Green



Metallic Dark Silver*



Metallic Sterling



Chestnut Brown



Metallic Silver



Roofinox Stainless Steel





Tin-Matte

Classic

Corten Steel







Coated Aluminium 0.7mm



Zinc Patina



Copper Oxide



Gold



Zinc Blue



Dark Zinc Patina



Copper Patina



Copper Metallic



Zinc Green



Graphite



RAL 7016



Corten



Zinc Red





ZM Silesia





Natural

0.7mm & 0.8mm





Nedzink





Neo





Noir



Nuance Red

Naturel



Nuance Green

Nuance Blue



Lagoon Green



Graphite Black



Mediterranean Blue



Antique Red



Earth Brown



Rock Grey



| | STS Panels® Snap together standing seam panels. | 16 |
|-------------------|--|-------|
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RF & EMI Shielding

Copper mesh 100

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Related Products

Clips, Screws, Underlay etc.

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Products

STS Panels®

STS Panels® are a modern take on traditional standing seam panels.

The seams have a unique design which reduces the installation time when installing panels.

Seams snap together onto concealed stainless steel clips (300mm spacings)

Seam Options

STS Panels® have two profiles options both can be used for roof or walls.

25mm seam x 425mm cover width panels for a minimum roof pitch of 7°

The 38mm seam x 386mm panels for a minimum roof pitch of 3°

Custom widths are possible as long as the custom cover width is less than the standard width.

Greencoat PLX Pural BT Our prime material offering for STS Panels®

With it's 25 year coating warranty and 50 year technical guarantee. It offers a long lasting visually pleasing alternative solution to more expensive metals.

Also available, Pre coated aluminum options, stainless steel & copper.

STS Panels® for both roof and walls.

Design Requirements

Panels need to be fully supported so they cannot span battens/rails.

Can be supplied with various flashings to make up a roof or wall panels system.

STS Panels® are ideal for simple projects which do not have complicated details.

For more complex projects TSS Panels® would be more suited as the seams can be folded by trained installers to produce other details.

STS Panels® *

Not available in real zinc.

For real zinc roofing and cladding you will require TSS Panels® to select from Nedzink, ZM Silesia or Zintek Coloured Zinc options.







Snap Together Seam

STS Panel Roof In Progress



Standard Flashings: Various standard roof and wall flashings are available, custom made flashings are possible when supplied with a drawing clearly showing any dimensions, angles and the intended the finish side.



Roof Kits - For Simple Roofs

Panels are supplied in the lengths requested, flashings as overleaf in standard 2000mm lengths. The following roof kits are designed for simple roof styles with no hips, valleys or roof penetrations/ roof llights. Such upgrades may be possible but for the purpose of making the initial ordering/enquiry as simple as possible.

We offer the following kit styles to choose from & making an enquiry is as simple as providing the building width.

The length of the slope, selecting a metal finish and letting us know the postcode for delivery.

A quote will be sent to the email provided so a final check & any adjustments if required can be made.

25mm x 425mm panels are for roofs with a minimum pitch of 7 ° if your roof pitch is less than this let us know.



Lean To Roof Kit

Panels & Flashings

Eaves - Abutment - Chase - Verge Clips Screws Sealant Underlay

Mono Pitch Roof Kit

Panels & Flashings Eaves -Mono Ridge - Verge

Clips

Screws

Sealant

Underlay

Double Pitch Roof Kit

Panels & Flashings

Eaves -Ridge - Verge Clips Screws Sealant Underlay





Standard Roof Flashings



Chase Flashing - 75mm Depth For use with abutment flashing.



Verge Flashing - 75mm Depth + Seam Height Supplied with liner flashing.



Mono Ridge -185mm Face 75mm + Seam Supplied with liner flashing, foam fillers and butt straps



Ridge Flashing - 185mm Each Side Supplied with liner flashing, foam fillers and butt straps



Abutment Flashing - 185mm, 75mm upstand Supplied with liner flashing, foam fillers and butt straps



Eaves Flashing -30mm overhang 75 mm depth Supplied with eaves liner flashing.



Panel Cover Widths



386mm

N

425mm

STS Panels®

A modern take on traditional standing seam panels.

The seams have a unique design which reduces the installation time when installing panels.

Seams snap together onto concealed clips stainless steel clips (300mm spacings)

without any need for tools to form the seams.

Although bear in mind some tools are required for cutting & folding panels at the eaves/verge/ridge details.

Seam Options

STS Panels® have two profiles options both can be used for roof or walls. 25mm seam x 425mm cover width panels for a minimum roof pitch of 7° The 38mm seam x 386mm panels for a minimum roof pitch of 3° Custom widths are possible as long as the custom cover width is less than the standard width.

Installing Panels

Align the first panel accordingly to the setting out plan, then secure with fixing clips at nominal 300mm centres.

Align the next panel seam over the upstand of the first and press down firmly on the seam. So it snaps together with the first.

Installing Flashings

Information on how to install flashings will be provided with each order.

| Customer Name | Project Ref. | Email | Date |
|---------------|--------------|-------|------|
| | | | |



Delivery & Installation

Cost

The cost of delivery varies depending on the size of the order, the length of longest item and distance from the North West of England.

Off loading

Orders are delivered on a protected pallet to the delivery address specified on the order.

It is a customers responsibility to off load any orders, either using a fork lift truck if available.

Or with enough people on site to safely off load any pallets and the contents manually, without damage. Within an allocated time slot.

Installing

Included in the kit is a short pdf with simple instructions on how to install the items included in the order. It does not cover extra details of potential upgrades such as roof light flashing kits.

Available Metals

0.6mm Greencoat PLX Pural BT

*Mountain Grey *Nordic Night Black Metallic Dark Silver Quarry Grey Leaf Green Metallic Gold Cottage Red Tile Red Silver Fir Green **Chestnut Brown** *Anthracite Grey Snow White Metallic Copper Metallic Silver *Metallic Sterling *Also PLX Pro BT

0.7mm Pre Coated Aluminium

Zinc Patina Dark Zinc Patina Copper Patina Copper Oxide Graphite RAL 7016 Copper Metallic Gold Corten Zinc Red Zinc Red Zinc Blue

0.5mm Roofinox Stainless Steel Tin Matte Classic 0.5mm Corten Steel Corten 0.6mm Aurubis Copper Nordic Standard

| Style | Roof Width | Slope Length | Post Code | Metal Finish |
|-------|------------|--------------|-----------|--------------|
| | | | | |



TSS Panels®

TSS Panels® are traditional standing seam panels that offer versatile installation options.

They can be delivered to the site as pre-rolled panels, accompanied by various flashings in different lengths. Alternatively, we can coordinate the on-site roll forming of panels to meet specific length requirements.

The standard cover widths for TSS Panels® are 530mm for roof panels and 430mm for wall panels, with a seam height of 25mm. This design makes them suitable for roof pitches as low as 3 degrees, although a 5-degree pitch is recommended.

TSS Panels® require the expertise of skilled and experienced hard metal roofing professionals for some roof designs.

We can guide you to a training center where you can acquire the necessary skills to proficiently install either snap-together or traditional standing seam panel systems. This ensures that your roofing project is executed with precision and meets the highest standards of quality and durability.

For those seeking a comprehensive package that includes tool hire, we incorporate the tool costs into the order. Upon the return of the tools, we facilitate a refund, deducting a 10% hire charge from the tools' value.





Traditional Standing Seam



Standing Seam Roof - Angle Seam Walls

The above example shows TSS Panels[®] in roof and wall format.



Roof Flashings

Standard lengths are 2000mm - 3600mm long. up to 4000mm long may be possible upon request.

To provide a quote for custom flashings we needto know the metal, the length and width (total girth of the unfolded metal)

To order custom flashings we require a clear drawing showing the dimensions/angles/finish side.

Note* Flashings with a galve liner such as;

Ridge, Apex & Abutment are normally sold in 2000mm lengths because the liners come in 2000mm standard lengths.



Valley Flashings*



Head Seam Slider*

* Have 1 or more project specific dimensions/angles that will need to be known before placing the order.





Chase Flashing For use with abutment flashing.



Verge Flashings Supplied with liner flashing.



Apex Flashing*

Supplied with liner flashing, foam fillers and butt straps



Ridge Flashing* Supplied with liner flashing, foam fillers and butt straps



Abutment Flashing* Supplied with liner flashing, foam fillers and butt straps



Eaves Flashing* Supplied with eaves liner flashing.



Wall Flashings

Standard lengths are 2000mm - 3600mm long. up to 4000mm long may be possible upon request.

To provide a quote for custom flashings we need to know the metal, the length and width (total girth of the unfolded metal)

To order custom flashings we require a clear drawing showing the dimensions/angles/finish side.



External Corner



Internal Corner



Head*



Reveal Flashings 1 2 & 3*

* Have 1 or more project specific dimensions/angles that will need to be known before placing the order.





PLX

Base 1*

Base 2*



Box Abutment



Coulisseau



Cill*



Ventilated Cill*



STS Panels®

Profile Type

STS Panels®

Minimum Pitch 7° 25mm Seam x 425mm Minimum Pitch 3

38mm Seam x 386mm

*Circle to select the standard profile option required & metal finish. Custom centres must be less than the standard cover width

| Panel Ref. | Custom Centres | Length mm | Quantity |
|---------------|----------------|-----------|----------|
| Example Ref A | 225mm | 4500 | 42 |
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Cover Widths



386mm

Ñ

425mm

| Customer Name | Project Ref. | Sheet No. | Date |
|---------------|--------------|-----------|------|
| | | | |

Materials

0.6mm Greencoat PLX Pural BT

*Mountain Grey *Nordic Night Black Metallic Dark Silver Quarry Grey Leaf Green Metallic Gold Cottage Red Tile Red Silver Fir Green **Chestnut Brown** *Anthracite Grey Snow White Metallic Copper Metallic Silver *Metallic Sterling *Also PLX Pro BT 0.7mm Pre Coated Aluminium Zinc Patina Dark Zinc Patina **Copper Patina** Copper Oxide Graphite RAL 7016 Copper Metallic Gold Corten Zinc Red Zinc Green Zinc Blue 0.5mm Roofinox Stainless Steel Tin Matte Classic 0.5mm Corten Steel Corten 0.6mm Aurubis Copper Nordic Standard





TSS Panels®

| Profile Type | Walls | Roof |
|--------------|-------------------|-------------------|
| TSS Panels® | 25mm Seam x 430mm | 25mm Seam x 530mm |

*Circle to select the standard profile option required & metal finish. Custom centres must be less than the standard cover width

| Panel Ref. | Custom Centres | Length mm | Quantity |
|---------------|----------------|-----------|----------|
| Example Ref A | 225mm | 4500 | 42 |
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Materials

0.6mm Greencoat PLX Pural BT

*Mountain Grey *Nordic Night Black Metallic Dark Silver Quarry Grey Leaf Green Metallic Gold Cottage Red Tile Red Silver Fir Green **Chestnut Brown** *Anthracite Grey Snow White Metallic Copper Metallic Silver *Metallic Sterling *Also PLX Pro BT 0.7mm Pre Coated Aluminium Zinc Patina Dark Zinc Patina **Copper Patina** Copper Oxide Graphite RAL 7016 Copper Metallic Gold Corten Zinc Red Zinc Green Zinc Blue 0.5mm Roofinox Stainless Steel Tin Matte Classic 0.5mm Corten Steel Corten 0.6mm Aurubis Copper Nordic Standard



Nuance Green

0.8mm ZM Silesia Natural Pre Aged Carbon

0.8mm Zintek Rock Grey Lagoon Green Antique Red Earth Brown Graphite Black Mediterranean Blue

*The Zinc Options Above Are Only Available in TSS Panels® (Traditional Standing Seam)

| Customer Name | Project Ref. | Sheet No. | Date |
|---------------|--------------|-----------|------|
| | | | |

Roof Flashings

Panel Profile Type STS Panels® Minimum Pitch 7 [°] 25mm Seam Minimum Pitch 3

TSS Panels®

38mm Seam 25mm Seam

*Circle to select the panel profile option these flashings relate to.

| Standard | Drawing Ref. | Girth | Length mm | Quantity |
|----------|--------------|-------|-----------|----------|
| Eaves | | | | |
| Ridge | | | | |
| Apex | | | | |
| Verge | | | | |
| Abutment | | | | |
| Chase | | | | |
| Valley | | | | |

Materials

0.6mm Greencoat PLX Pural BT 0.7mm Pre Coated Aluminium 0.5mm Roofinox Stainless Steel 0.5mm Corten Steel 0.6mm Aurubis Copper 0.8mm Nedzink 0.8mm ZM Silesia 0.8mm Zintek

* If planning to use STS Panels®

The Zinc Options Above Are Only Available in TSS Panels® (Traditional Standing Seam)

| Custom | Drawing Ref. | Girth | Length mm | Quantity |
|--------|--------------|-------|-----------|----------|
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Note:

Please provide related drawings. Clearly showing all dimensions. Angles & the finish side.

Ensure the person installing, Checks & confirms all items, As correct before ordering.

We can not be held responsible, For the accuracy of schedules. Customers must thoroughly, check order details to avoid, production errors & additional related costs. Related to correcting any errors.

| Customer Name | Project Ref. | Sheet No. | Date | Metal Finish |
|---------------|--------------|-----------|------|--------------|
| | | | | |



Wall Flashings

Panel Profile Type

Custom

Minimum Pitch 7

Minimum Pitch 3 °

25mm Seam

STS Panels® TSS Panels®

38mm Seam 25mm Seam

*Circle to select the panel profile option these flashings relate to.

| Standard | Drawing Ref. | Girth | Length mm | Quantity |
|---------------------|--------------|-------|-----------|----------|
| Ventilated Cill | | | | |
| Cill | | | | |
| Head | | | | |
| Wall Abutment | | | | |
| Box Abutment | | | | |
| Base 1 | | | | |
| Base 2 | | | | |
| Internal Corner | | | | |
| External Corner | | | | |
| External Coulisseau | | | | |
| Reveal 1 | | | | |
| Reveal 2 | | | | |
| Reveal 3 | | | | |

Drawing Ref.

Girth

Length mm

Materials

0.6mm Greencoat PLX Pural BT 0.7mm Pre Coated Aluminium 0.5mm Roofinox Stainless Steel 0.5mm Corten Steel 0.6mm Aurubis Copper 0.8mm Nedzink 0.8mm ZM Silesia 0.8mm Zintek

* If planning to use STS Panels®

The Zinc Options Above Are Only Available in TSS Panels® (Traditional Standing Seam)

Note:

Quantity

Please provide related drawings. Clearly showing all dimensions. Angles & the finish side.

Ensure the person installing, Checks & confirms all items, as correct before ordering.

We can not be held responsible, for the accuracy of schedules. Customers must thoroughly, check order details to avoid, production errors & additional related costs. Related to correcting any errors.

| Customer Name | Project Ref. | Sheet No. | Date | Metal Finish | |
|---------------|--------------|-----------|------|--------------|--|
| | | | | | |



Roof Flashings



Wall Flashings

Add your own project specific dimensions and angles.



Reveal Panels

Reveal Panels are a flat interlocking wall or soffit panels.

They interlock in a tongue and groove manner so concealing any fixings.

Can span battens/rails at 600mm centres.

Various flashings are available to make up a complete wall or soffit panel system.



0.9mm Greencoat S280

Standard Options include Mountain Grey - Nordic Night Black - Metallic Dark Silver.

1mm Aluminium

Standard Options include Zinc and dark zinc patina, copper oxide and copper patina.

1mm ZM Silesia (Zinc)

Options include Pre-Aged & Carbon

1mm NedZinc (Zinc)

Options include Neo, Noir and Nuance Green, Blue & Red.

Walls & Soffit Panel System





Reveal Wall & Soffit Panels

Panels can have a shadow gap of between 0-20mm



Reveal Panel Flashings

Pages 36 & 37 are flashing for use when installing reveal panels horizontally. Pages 38 & 39 are flashing for use when installing reveal panels vertically.



Internal Corner


Horizontal Lay Reveal Panel Flashings





Jamb 1H

Jamb 2



Corner 3



Corner 4



Box Abutment



Panel Abutment



Vertical Lay Reveal Panel Flashings





Corner 1

Corner 2







Corner 4



Internal Corner



Wall Abutment



Vertical Lay Reveal Panel Flashings





Jamb 1V

Jamb 2



PLX

Ventilated Cill





Base Head 1



Box Abutment



Reveal Panel Order Form

Reveal Panel MODULE (max 333mm - depending on manufacturers guidlines) FACE (min 180mm) MODULE = FACE + SHADOW GAP 15 MATERIAL BLANK = MODULE + 110mm 14 30 - 50 44

| Panel Ref. | Face | Shadow Gap | Length | Closed Ends | Quantity |
|---------------|-------|------------|--------|-------------|----------|
| Example Ref A | 300mm | 4500 | 42 | | |
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| Material |
|-------------------------|
| Greencoat S280 Pural BT |
| Pre coated Aluminium |
| ZM Silesia |
| NedZink |

| Customer Name | Project Ref. | Sheet No. | Date | Metal Finish |
|---------------|--------------|-----------|------|--------------|
| | | | | |



Reveal Panel Flashings Form

| Standard | Drawing Ref. | Girth | Length mm | Quantity |
|-------------------|--------------|-------|-----------|----------|
| Cill 1 | | | | |
| Cill 2 | | | | |
| Wall Abutment | | | | |
| Box Abutment | | | | |
| Base/Head 1 | | | | |
| Base/Head 2 | | | | |
| Internal Corner V | | | | |
| Internal Corner H | | | | |
| External Corner | | | | |
| Jamb 1V | | | | |
| Jamb 2 | | | | |
| Corner 1 | | | | |
| Corner 2 | | | | |
| Corner 3 | | | | |
| Corner 4 | | | | |
| Panel Abutment | | | | |

| Custom | Drawing Ref. | Girth | Length mm | Quantity |
|--------|--------------|-------|-----------|----------|
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| Material | |
|-------------------------|--|
| Greencoat S280 Pural BT | |
| Pre coated Aluminium | |
| ZM Silesia | |
| NedZink | |

| Customer Name | Project Ref. | Sheet No. | Date | Metal Finish |
|---------------|--------------|-----------|------|--------------|
| | | | | |



Vertical Lay Reveal Wall Panel Flashing Drawing Templates

Standard vertical lay reveal panel wall flashing drawing templates shown below can be used to place orders. Simply add your own project specific dimensions and angles.



| Customer Name | Project Ref. | Sheet No. | Date | Metal Finish |
|---------------|--------------|-----------|------|--------------|
| | | | | |



Horizontal Lay Reveal Wall Panel Flashing Drawing Templates

Standard horizontal lay reveal panel flashing drawing templates shown below can be used to place orders. Simply add your own project specific dimensions and angles.



| Customer Name | Project Ref. | Sheet No. | Date | Metal Finish |
|---------------|--------------|-----------|------|--------------|
| | | | | |



Reveal Flashings







Jamb 1H

Jamb 1H flashings are normally supplied in 2000mm lengths.

They are used at the sides windows & doors.

This jamb flashing is used when reveal panels are fitted horizontally.

| Reference | Length | Quantity | Width |
|-----------|--------|----------|-------|
| | 2000mm | | |

Jamb 1V

Jamb 1V flashings are normally supplied in 2000mm lengths.

They are used at the sides windows & doors.

This jamb flashing is used when reveal panels are fitted vertically.

| Reference | Length | Quantity | Width |
|-----------|--------|----------|-------|
| | 2000mm | | |

Jamb 2

Jamb 2 flashings are normally supplied in 2000mm lengths.

They are used at the sides windows & doors.

This jamb flashing is used when reveal panels are fitted either horizontally or vertically.

| Reference | Length | Quantity |
|-----------|--------|----------|
| | 2000mm | |



Panel Abutment

Panels abutment flashings are normally supplied in 2000mm lengths.

They are used to join panels when fitted horizontally.

| Reference | Length | Quantity |
|-----------|--------|----------|
| | 2000mm | |



Add the number of 2000mm or custom lengths required.



Abutment

Wall abutment flashings are normally supplied in 2000mm lengths.

| Reference | Length | Quantity |
|-----------|--------|----------|
| | 2000mm | |



Box Abutment

Box abutment flashings are normally supplied in 2000mm lengths.

| Reference | Length | Quantity |
|-----------|--------|----------|
| | 2000mm | |



Base/Head 1

Base/head 1 flashings are normally supplied in 2000mm lengths. They are used at the bottom of wall panels, top of windows & doors. The bottom of p panels sit on top of the drip section.

| Reference | Length | Quantity | Width |
|-----------|--------|----------|-------|
| | 2000mm | | |



Base/Head 2

Base/head 2 flashings are normally supplied in 2000mm lengths. They are used at the bottom of wall panels, top of windows & doors. The head flashing can be made with perforations for ventilation.

| Reference | Length | Quantity | Width |
|-----------|--------|----------|-------|
| | 2000mm | | |



Reveal Flashings

Flashings with a H or V represent flashings used either when reveal panels are laid horizontally or vertically.



Corner 1

Reveal corner 1 flashings are normally supplied in 2000mm lengths.

They are used when panels are fitted vertically.

| Reference | Length | Quantity |
|-----------|--------|----------|
| | 2000mm | |



Corner 2

Reveal corner 2 flashings are normally supplied in 2000mm lengths. They are used when panels are fitted vertically.

| Reference | Length | Quantity |
|-----------|--------|----------|
| | 2000mm | |



Corner 3

Reveal corner 3 flashings are normally supplied in 2000mm lengths. They are used when panels are fitted horizontal & vertically.

| Reference | Length | Quantity |
|-----------|--------|----------|
| | 2000mm | |



Corner 4

Reveal corner 4 flashings are normally supplied in 2000mm lengths. They are used when panels are fitted horizontall & vertically.

| Reference | Length | Quantity |
|-----------|--------|----------|
| | 2000mm | |



Add the number of 2000mm or custom lengths required.



Internal Corner H

Reveal internal corner H flashings are normally supplied in 2000mm lengths.

They are used when panels are fitted horizontally.

| Reference | Length | Quantity |
|-----------|--------|----------|
| | 2000mm | |



Internal Corner V

Reveal internal corner V flashings are normally supplied in 2000mm lengths.

They are used when panels are fitted vertically.

| Reference | Length | Quantity |
|-----------|--------|----------|
| | 2000mm | |



Cill A

Cill A flashings are normally supplied in 2000mm lengths. They come with a liner.

| Reference | Length | Quantity | Width |
|-----------|--------|----------|-------|
| | 2000mm | | |



Cill B

Cill flashings are normally supplied in 2000mm lengths.

| Reference | Length | Quantity |
|-----------|--------|----------|
| | 2000mm | |



Wall capping system in a variety of metals

Wall capping system in a variety of metals.

Comes with liner flashings, structured underlay, double vulcanized joints with cover strip.

Can be supplied with preformed internal/external corner sections, capping lengths with or without end caps/up stands.

The front face is typically a minimum of 75mm with any down stand/drip edge being a minimum or 20mm from the supporting structure. The total girth possible depends on the available metals in stock. Capping lengths are 2000mm - max 3000mm, Movement joints should be within 500mm from a corner or T junction.

For capping in excess of 300mmm a double lock standing seam joint is recommended.

Capping Components

- Capping open ended
- Capping Pre Formed end cap
- Up stands
- Preformed Corners
- Capping Liner Flashings
- Structured Underlay
- Capping Joints
- Capping Joint Cover Strips



Greencoat PLX Pural BT in Metallic Copper



Pre Formed Corners Each preformed corner section is carefully soldered along the joint.



Joint Joining sections with double vulcanized seals & cover flashing.



End Caps Wall capping sections can be supplied with an end cap folded and soldered place.



Wall Capping System

COLORFUL STEEL

Available Metals:

Wall capping is available in GreenCoat PLX Pural BT options. Coated Aluminium, NedZink, ZM Silesia & Aurubis Copper

Types of joints that can be used for capping

- The joint plate
- The Coulisseau welt
 - The london welt
- The double lock standing seam
 - Top clip capping joint



| Recommended Metal Thicknesses | | | | | |
|-------------------------------|-----------|--------|------------------|-----------------|------|
| Girth | Aluminium | Copper | Galvanised Steel | Stainless Steel | Zinc |
| Up to 300 mm | 0.7 | 0.7 | 0.5 | 0.5 | 0.7 |
| Up to 500 mm | 0.7 | 0.7 | 0.5 | 0.5 | 0.8 |



Gapping Example Drawing **Na**



Capping Order Form

Materials

| Front Face | Rear Face | | | Width | |
|-----------------|-----------|----------|--|---------|----------|
| mm | | mm 425mm | | 25mm | |
| | | | | | |
| #Lenaths@2000mm | 1 | Joints | | Corners | End Caps |

Ordering Capping

*Circle to select the required metal finish. Total girth is limited by the coil sizes available.

The minimum recommended face is 75mm

This form allows for requesting a budget price. Based on number of 2 metre capping sections. Number of joints, corners & end caps.

To price accurately we need an accurate plan Example capping section drawing below. Full plan example can be found at.

https://merlinmetals.com/docs/mml-wallcappingexampleplandrawing.pdf



| | | | Ento Brao |
|---------------|------------------|--------------------|--------------------------|
| 0.8mm Nedzink | 0.8mm ZM Silesia | 0.8mm Zintek | 0.5mm Roofinox Stainless |
| Naturel | Natural | Rock Grey | Tin Matte |
| Neo | Pre Aged | Lagoon Green | Classic |
| Noir | Carbon | Antique Red | 0.5mm Corten Steel |
| Nuance Red | | Earth Brown | Corten |
| Nuance Blue | | Graphite Black | 0.6mm Aurubis Copp |
| Nuance Green | | Mediterranean Blue | Nordic Standard |
| | | | |

| Customer Name | Project Ref. | Sheet No. | Date |
|---------------|--------------|-----------|------|
| | | | |



0.6mm Greencoat PLX Pural BT *Mountain Grey

*Nordic Night Black Metallic Dark Silver Quarry Grey Leaf Green Metallic Gold Cottage Red Tile Red Silver Fir Green Chestnut Brown *Anthracite Grey Snow White Metallic Copper Metallic Silver *Metallic Sterling *Also PLX Pro BT 0.7mm Pre Coated Aluminium Zinc Patina Dark Zinc Patina **Copper Patina** Copper Oxide Graphite RAL 7016 Copper Metallic Gold Corten Zinc Red Zinc Green Zinc Blue s Steel er





TOPCLIP CAPPING

A universal connector with double vulcanised seals . Used to join metal capping.

The Topclip System

The Topclip is a universal connector with double vulcanised seals, for the joining of metal capping.

Topclip is suitable for all metal roofing materials i.e. copper, zinc, stainless steel, precoated aluminium & GreenCoat steel.

Material

Standard configuration of 1.2mm aluminium or 0.8mm stainless steel with elastomeric black rubber seals.

Size

3000mm long x 150mm wide.

Advantages

Universal: The aluminium Topclip is suitable for all materials except copper, for which stainless steel Topclip is used.

Rain Proof: The two vulcanised 8mm seals, on both sides of the Topclip, huddle against the caping profile, building a safe barrier against capillary penetration of water.

Cost Effective: The Topclip is easy to install, without any soldering or further sealing. Also expansion joints are not necessary as the open joint caters for lateral movement.

Installation

The Topclip is easy to fix with conventional metal roofing tools. It can be formed on-site or in the workshop as required. A stiffening welt is made as each and on the capping profiles.

ISO-Mat Metal separating membrane is installed between the connectors to compensate for the height of the seals and to ventilate and protect the under side of the capping profile.





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Installing Topclip Capping





Fix Topclip to the substrate on both edges with stainless steel annular ring nails or screws.

Install angle fixing strips between Topclip joints with stainless steel annular ring nails or screws.





Lay ISO-Mat Metal separating membrane between the connectors, over the fixing strips.

Hook the capping profile onto the fixing strip on one side. Lower into position. Leave an open joint of 5mm - 10mm. Close the welt around the fixing strip on the opposite side.





Capping profiles consisting of colour coated or preweathered finishes, place a small 40mm -45mm wide strip of the same material in the centre of the joint.

Fix the Topclip joint to the substrate at the corner capping junctions and the retaining clips as shown, with stainless steel annular ring nails or screws.





Lay the ISO-Mat Metal separating membrane between the connectors, over the retaining angles.

Lower the corner profile into position, locating the retaining angles and locking the corner capping welt.



9 Close the welt at the internal angle of the corner profile.

Complete the installation of the adjacent capping.





GreenLine

Full System:

GreenLine® Gutters come in standard lengths of 2400mm.

They are 125mm half round gutters with a rolled front edge.

Can be ordered a with all components to make up a system.

Including joints, stop ends, outlets pipes, pipe brackets, shoes, hoppers etc.

Available Colours:

GreenLine® Gutters are normally supplied in nordic night black, mountain grey and metallic dark silver.

Other colours may be available.



Greenline Gutter (Metallic Dark Silver)









Greenline Gutters Order Form

Greenline Gutter System Components

| Product # | Component | Quantity |
|-----------|------------------------------------|----------|
| 1 | Half round gutter 125mm x 2400mm | |
| 2 | Half round gutter fascia bracket | |
| 3 | Half round gutter rafter bracket | |
| 4 | Half round gutter internal corner | |
| 5 | Half round gutter external corner | |
| 6 | Internal Corner - Custom Angle | |
| 7 | External corner - Custom Angle | |
| 8 | Half round gutter stop ends | |
| 9 | Half round gutter drop outlet | |
| 10 | Half round gutter joint | |
| 11 | Round Pipe 60 deg bend | |
| 12 | Round rainwater pipe 90mm x 500mm | |
| 13 | Round rainwater pipe 90mm x 1000mm | |
| 14 | Round rainwater pipe 90mm x 2400mm | |
| 15 | Round pipe bracket | |
| 16 | Round pipe Y-Branch | |
| 17 | Round pipe water diverter | |
| 18 | Round pipe shoe | |
| 19 | Rainwater pipe hopper | |

Metal/Finishes

| 0.6mm Greenline |
|--------------------|
| Mountain Grey |
| Nordic Night Black |
| |
| |
| |
| |
| |



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| Customer Name | Project Ref. | Sheet No. | Date |
|---------------|--------------|-----------|------|
| | | | |



Bespoke Rainwater Goods Checklist





Other Items Order Form

| Product | Description | Quantity |
|-------------------------------|--|----------|
| Iso Mat Pro Underlay | Breather membrane for use on all types of domestic and commercial roofing and cladding applications. 50 m2 Roll | |
| Iso Mat Metal Underlay | ISO-Mat Metal® is a condensation control and drainage system for metal roofing. It is a fully vapour-permeable, strong, durable and waterproof barrier. 35 m2 Roll | |
| Alutrix 600 Vapour Barrier | A high performance, self-adhesive, cold applied vapour barrier. 40 m2 Roll | |
| Insect Mesh | 30lm Fibre glass insect mesh. | |
| STS 25mm Seam Clips | 400 x 25mm Seam Clips for STS Panels® | |
| STS 38mm Seam Clips | 400 x 38mm Seam Clips for STS Panels® | |
| TSS 25mm Seam Clips (fixed) | 500 x 25mm Fixed Seam Clips for TSS Panels ${}^{\mathbb{R}}$ | |
| TSS 25mm Seam Clips (sliding) | 500 x 25mm Sliding Seam Clips for TSS Panels ${\mathbb R}$ | |
| 27m Flat Clips | 500 x 27mm Flashing Clips | |
| 25mm Screws | 100 x Stainless screws for fixing into timber | |
| 25mm Ring Shank Nails | 2500 x Stainless nails for fixing into timber | |
| Tube Sealant | Tube For sealing joints | |
| Tool Kit | Basic toolkit for standing seam roofing. | |
| Copper Shielding Mesh | Block EMI & RFI Frequencies 1 metre by 1220mm | |

| Customer Name | Project Ref. | Sheet No. | Date |
|---------------|--------------|-----------|------|
| | | | |





Width: 1220mm Length: Up to 30.5 metres Weave Type: Plain Mesh Count Per 25.4mm: Warp 100.00 _ Weft 100.00 Aperture Size: Warp 198 micron _ Weft 198 micron Aperture Tolerance: +/- 4% Wire Diameter: Warp 0.056mm _ Weft 0.056mm Wire Tolerance: According to ISO 4782 Open Area: 60.77% Nominal Weight: 0.16KG/M2 Wire Specification: Copper Finish: Bright Drawn



Metal Coils



Metals

The main metals we can supply products in are;

Greencoat PLX Pural BT Greencoat PLX Pro BT Coated Aluminium Roofinox Stainless Steel Aurubis Copper Nedzink ZM Silesia Zinc Zintek Coloured Zinc Corten Steel Metals can be supplied in coil format.

The most common size coils are 600mm wide. Other coil sizes are possible subject to stock levels.

Stock levels change regularly so lead times may vary. Some metals may require a large minimum order.

Can be cut to specific widths and lengths & supplied as flat sheets.

Contact us with your requirements .



What substrates are suitable?

TSS Panels® & STS Panels® can be mounted on all roof build-ups, the only pre-requisite being that it is fully supported;

- Ventilated 18mm wbp plwood, OSB3 or softwood boards.
- Hard Metal Board
- Composite Panel
- SIPS Panel
- Rigid Insulation
- Cellular Glass Insulation

Can panels be lapped together?

STS Panels are specifically engineered for seamless installation from eaves to ridge in a single piece. In standard circumstances, the use of cross joints is neither necessary nor recommend-ed. However, there may be specific situations, such as accommodating roof penetrations, where the incorporation of cross joints is required.

How do I carry out maintenance?

Annual inspection would be a common-sense approach Check security of panels / flashings / sealants Check for leaf / debris build-up Check for mechanical / substance damage caused by external factors

How much do panels weigh?

Greencoat PLX Pural BT

0.6mm - 6.01 kg/m2 - 386mm centres 0.6mm - 5.45 kg/m2 - 425mm centres

(excluding underlay / fixings / substrate)

Can panels span battens?

STS Panels® are versatile and can be installed on various roof build-ups, provided they are adequately supported. It's essential to note that these panels cannot span over battens, purlins, or wall rails. To ensure optimal performance and structural integrity, it's crucial that the panels are fully supported in accordance with the recommended guidelines.

What fixings should I use?

Stainless fixings are used depending on the type of substrate to be fixed to;

25mm x 3.38mm ring shank nails 25mm x 2.8mm Paslode nails 20mm x 4.3mm wood screws 22mm x 4.8mm self-drilling screws



Where can I buy Tools?

Tools / Toolkits can be ordered that will make installing easier. For all your roofing tool needs visit https://roofing-tools.com(Not a Merlin Metals Website)

What are the available metal finishes for Greencoat PLX Pural BT?

*Mountain Grey *Nordic Night Black Metallic Dark Silver Quarry Grey Leaf Green Metallic Gold Cottage Red Tile Red Silver Fir Green Chestnut Brown *Anthracite Grey Snow White Metallic Copper Metallic Silver *Metallic Sterling *Also PLX Pro BT

What are the available metal finishes for Coated Aluminium?

Zinc Patina Dark Zinc Patina Copper Patina Copper Oxide Graphite RAL 7016 Smooth RAL 7016 Matt Copper Metallic Gold Corten Zinc Red Zinc Green Zinc Blue

What are the available metal finishes for Roofinox Stainless Steel?

Tin Matte (Roofs) Classic (Walls)

What are the available metal finishes for Aurubis Copper?

Nordic Standard



What are the available metal finishes for Corten Steel?

Corten

What are the available metal finishes for Zintek (Coloured Zinc)?

Rock Grey Lagoon Green Antique Red Earth Brown Graphite Black Mediterranean Blue

What are the available metal finishes for ZM Silesia (Zinc)?

Natural Pre Aged Carbon

What are the available metal finishes for Nedzink (Zinc)?

Naturel Neo Noir Nuance Red Nuance Blue Nuance Green

What comes with a lean to roof kit?

Panels & Flashings Eaves - Abutment - Chase - Verge Clips Screws Sealant Underlay

What comes with a mono pitch roof kit?

Panels & Flashings Eaves - Mono Ridge - Verge Clips Screws Sealant Underlay



What comes with a double pitch roof kit?

Eaves - Ridge - Verge Clips Screws Sealant Underlay

Do you supply simple roof kits?

Yes, panels are supplied in the lengths requested, flashings in standard 2000mm lengths. Simple roof kits are designed for simple roof styles with no hips, valleys or roof penetrations/ roof lights.

Upgrades may be possible but for the purpose of making the initial ordering/enquiry as simple as possible.

We offer a lean to, mono pitch and double pitch roof kits.

What does delivery Include?

Delivery includes protective packaging and delivery to site but not unloading. There needs to be enough people on site able to offload in a safe and timely manner or alternatively having a suitable fork lift truck available to use.

How do I book the installer course?

The class based installer courses available to pre book. Courses are held in a test centre located in Bolton. Contact Metal Solutions Limited on 01204 491800 Or email reception@metalsolutions.uk.com

What flashing lengths are possible?

Standard flashing lengths are generally 2000mm up to 3600mm.

It may be possible to make flashings up to 4000mm long. If this is required, please send a flashing drawing, and we will check to see if it is possible.

What are STS Panels®?

STS stands for Snap Together Seam, representing a contemporary standing seam panel system. This innovative profile features both an undercloak and an overcloak. The undercloak side is securely fixed using stainless steel fixing clips, while the over cloak side can be effortlessly 'snapped' into place, streamlining the installation process.

What panel lengths are available?

Factory-produced panels are supplied in lengths of up to 12 meters. If required, alternative lengths may be available, provided they can be transported logistically. TSS Panels® can potentially be roll formed on site to any length.



What warranties are available?

Warranties on metals vary 0.6mm Greencoat PLX Pural BT - 25 year coating and 50 year technical guarantee. 0.7mm Pre-Coated ALuminium - 15 year coating roofs, 20 years on walls, 40+ year lifespan. 0.5mm Roofinox Stainless Steel - 50 years. 0.55mm Corten Steel - tbc 0.6mm Aurubis Copper - up to 100 years

What underlay is recommended?

The following underlays are recommended;

Facades – ISO-Mat Pro Ventilated Roofs – ISO-Mat Pro Non-ventilated roofs – ISO-Mat Metal

What is the correct clip spacing?

Clips are normally fitted every 300mm throughout the installation. This applies to both panels and flashing clips. In exposed locations such as the eaves or verge, clip spacing may be reduced to every

TSS Panels® cover widths available?

200mm for additional strength.

25mm Seam x 530mm Cover Width (roof) 25mm Seam x 430mm Cover Width (walls) Panels can be made smaller for example; 25mm Seam x 250mm Cover Width but not greater than the max standard cover.

STS Panels® cover widths available?

25mm Seam x 425mm Cover Width (roof walls) 38mm Seam x 386mm Cover Width (roof walls) Panels can be made smaller for example; 25mm Seam x 250mm Cover Width but not greater than the max standard cover.

Are roof light flashing kits available?

We offer custom-made flashing kits tailored to fit any size window or opening in a roof. To facilitate this, we require an accurate roof plan illustrating the dimensions and locations of each roof window that necessitates a flashing kit.

Our bespoke kits are crafted from the same metal as the roof panels, ensuring a seamless integration with your roofing system. However, if matching metal finishes is not a priority for your project, Velux provides standard roof light flashing kits suitable for standing seam roofing, particularly for roof pitches of 15° or greater.



Will a metal roof be noisy?

If a metal roof were to be installed without any form of insulated build up then yes, you would likely hear the rain hitting the metal.

However, for homes this is highly unlikely as homes are often well insulated, so are no noisier than other roofing materials.

Required air gap for a ventilated roof?

The minimum air gap recommended for a ventilated roof is 50mm.

How to store materials?

Materials should be kept dry and on a flat surface.

If panels or flashings are allowed to get wet, moisture can get between the protective film and the panel material finish.

When heated up for example on a hot day, the moisture evaporates and can leave a stain that may be hard to remove.

Required air gap for a ventilated walls?

The minimum air gap recommended for a ventilated roof is 50mm.

The minimum air gap required behind the board is 38mm, with a continuous 25mm inlet at the bottom of the wall and 25mm outlet at the top.

How to order custom roof or wall flashings?

For any custom flashings, drawings must be provided showing any dimensions, angles & which side is to be the exposed/colour side.

What payment methods are accepted?

Merlin Metals accept payment for orders via bank transfer only. If deposits are paid to secure materials at the current rates. The balance of the order must be paid before an order is booked into the production queue.

Are touch up paints available?

Touch up paints are available for some materials please get in touch if you need some so we can check if there is one available to suit your project's metal.

Is delivery with offloading possible?

Yes although expensive relative to an order size, it is possible. It would need to be a dedicated vehicle (Hiab & Moffett).

We would only be able to provide a price for this, once we know the postcode and approximate dimensions and weights.



What size vehicle will deliver my order?

The size of the vehicle used to deliver an order can be confirmed before delivery. If you have any concerns over access, please inform us as soon as possible, so we can check to make sure delivery is possible.Such as for panels 12 metres or more.

Can panels fix directly onto a SIP panel?

To install onto Structural Insulated Panels (SIPS), it is recommended that the top board be a minimum of 18mm thick to ensure proper pull-out values for the seam clips. Despite this, it's observed that not many manufacturers produce panels with 18mm boards.

At present, Merlin Metals provides guide prices for a 15mm boarded panel. The company is in the process of confirming whether the pull-out values for the seam clips are acceptable with this thickness. Once this information is validated, we will confidently recommend their use on residential or commercial projects as a substrate for the standing seam panels we supply. The details will be promptly published here for reference.

While some companies may have successfully fixed into 11mm boards, we do not endorse this practice unless for smaller structures such as garden buildings. The 15mm thickness appears more suitable for larger projects. However, it's important to emphasize that although 15mm may suffice, we are committed to verifying this through testing to ensure it meets or exceeds the recommended pull-out values of 560 Newtons (minimum) per clip, as stipulated in the UK Guide to Good Practice in Fully Supported Metal Roofing and Cladding 3rd edition.

Are panels made in the UK?

Yes the roof and wall panels Merlin Metals supply are all made in the UK unless otherwise stated.

How much does delivery cost?

Delivery costs vary depending on the size of the order & its location.

The cost is confirmed once the delivery address is provided and when the order details have been fully established.

On small orders we cannot offer any discount on delivery costs however for larger orders we often reduce the delivery cost or in some cases provide it free of charge.

What are the lead times on orders?

Lead times can vary depending on the current production queue. From 2-3 weeks to 5-6 weeks during high demand. The Lead time starts from orders being placed and booked in with the production team.

What are the current lead times on orders?

Please call or email for current lead times.



Metals are suitable for coastal locations?

As a rule of thumb, aluminium and coated steel are often not suitable for coastal areas, copper and stainless steel are more suitable choices, along with zinc. Whichever metal is deemed suitable for a coastal project. The available warranty needs to be confirmed, as it is often reduced due to the harsher environment.

What is the minimum pitch?

For STS Panels® the 38mm profile height is suitable for a minimum roof pitch of 3 °. The 25mm profile height is suitable for a minimum roof pitch of 7 °.

For TSS Panels® the 25mm profile height is suitable for a minimum roof pitch of 3 $^\circ$ Although 5 $^\circ$ is recommended.

What are the advantages of a standing seam roof system?

Standing seam roof systems offer several advantages that contribute to their popularity in both residential and commercial construction. Here are some key advantages:

Weather Resistance: Standing seam roofs are known for their exceptional weather resistance. The raised seams and concealed fasteners prevent water infiltration, reducing the risk of leaks. This makes them ideal for areas with heavy rainfall or snow.

Durability: These roofs are highly durable and can withstand various environmental challenges, including strong winds, hail, and UV radiation. The materials used, often metal like steel or aluminium, are inherently resistant to rust and corrosion.

Longevity: Standing seam roofs have a long lifespan, often exceeding 50 years with proper maintenance. This longevity makes them a cost-effective investment in the long run, as they require fewer replacements compared to some other roofing materials.

Energy Efficiency: Many standing seam roofs come with reflective coatings that can help in reducing energy consumption by reflecting sunlight and heat away from the building. This can contribute to lower cooling costs in hot climates.

Aesthetic Appeal: The clean lines and vertical seams of standing seam roofs contribute to a sleek and modern appearance. They are available in a variety of colours and finishes, allowing for customization to match the architectural style of the building.

Ease of Installation: Standing seam roofs are designed for easy and efficient installation. The interlocking panels and concealed fasteners simplify the installation process, reducing labour time and costs.

Low Maintenance: Once installed, standing seam roofs generally require minimal maintenance. Regular inspections and occasional cleaning are usually sufficient to keep the roof in good condition.

Versatility: Standing seam roofs are versatile and can be used on a wide range of architectural designs, including both residential and commercial buildings. They can be adapted to various roof shapes and slopes.



MERLINMETALS°

Recyclability: Many standing seam roofing materials, such as metal panels, are recyclable at the end of their lifespan. This makes them an environmentally friendly choice compared to some non-recyclable roofing materials.

Increased Property Value: The durability, longevity, and aesthetic appeal of standing seam roofs can contribute to an increase in the overall property value. Potential buyers often see these roofs as a desirable and durable feature.

While standing seam roofs have numerous advantages, it's essential to consider factors such as cost, climate, and specific project requirements when choosing a roofing system.

What are the components that make up the Greenline Gutter System?

Half round gutter 125mm x 2400mm Half round gutter fascia bracket Half round gutter rafter bracket Half round gutter internal corner Half round gutter external corner Internal Corner - Custom Angle External corner - Custom Angle Half round gutter stop ends Half round gutter drop outlet Half round gutter joint Round Pipe 60 deg bend Round rainwater pipe 90mm x 500mm Round rainwater pipe 90mm x 1000mm Round rainwater pipe 90mm x 2400mm Round pipe bracket Round pipe Y-Branch Round pipe water diverter Round pipe shoe Rainwater pipe hopper

How should I prepare before installing?

Before commencing the installation ensure that the substrate works are of a suitable standard to support the system.

Any defects to the substrate left unresolved before installation may affect the quality and or performance of the system.

Make sure that the substrate is correctly prepared;

- Check for flatness of the surface
- No steps or large gaps between boards / panels.
- No spring in the boards / panels
- No protruding screws or nail heads
- Surface is dry
- Surface is swept clean.



How should metal be cut?

Suitable cutting tools must be used for the material.

For example using left and right handed tin snips, or other styles of snips or metal shears.. Grinders must not be used to cut, as sparks / metal filings can damage the surface.

How should panels be carried?

Panels should be carried on their edge at all times, so as to avoid damage or bending. Panels must NEVER be handled or carried face up or face down.

Although panels are lightweight they ideally should be carried by two persons for shorter panels ,

and more than two people for longer panels..

How should I set out my roof plan?

Before commencing the installation it is important that the setting out of the panels is considered, to avoid any clashes with roof lights, penetrations or windows, doors or other elements.

How are panels delivered?

Panels are delivered to site flat on the back of a rigid vehicle or trailer.

Easy access must be provided to allow the panels to be unloaded safety and without damage.

Panels must be checked for visible defects before unloading and any discrepancies or damage must be reported to the office immediately.

How should panels be stored before use?

Panels should be stored on a clean, flat, dry surface. Panels stored whilst wet may develop staining to the surface, which in most cases cannot be removed. No liability will be accepted for damage caused by improper handing or storage.

What are the size limitations for wall capping?

Custom wall capping is limited in width by the coil sizes available to fabricate the capping from.

We recommend a minimum face depth of 75mm either side.

To price & book a wall capping order in for fabrications.

We require an accurate wall capping plan to work from.

Bare in mind when working out the enough space to get tools in to fold the capping to the liner.

+ 50mm for example to the capping width.



How can I order a gutter system?

Standard gutter components, including the Greenline series, are available for order. Please specify the quantity of each required component when placing your order. Important Notes

Brackets should be securely fixed at intervals not exceeding 600 mm.

To ensure effective water drainage, the gutter drop towards the downpipe should be maintained at 3–5 mm per running meter.

For bespoke gutter systems, we request a provided drawing to ensure accurate customization. Alternatively, you can choose from existing options by referring to the bespoke rainwater goods checklist

What are flashing Drawings?

Drawings are required for ordering flashings.

That clearly show all dimensions, angles/finish side.

Order standard flashings, by selecting the relevant drawing from the available templates. Then add the missing dimensions and any angles to the drawings to suit your projects requirements.

For any custom flashing requirements please supply drawings that are clear and easy to read.

What are the available lengths for panels?

Drawings are required for ordering flashings.

That clearly show all dimensions, angles/finish side.

Order standard flashings, by selecting the relevant drawing from the available templates. Then add the missing dimensions and any angles to the drawings to suit your projects requirements.

For any custom flashing requirements please supply drawings that are clear and easy to read.

Should I order extra panels?

It is advisable to contemplate the possibility of ordering additional panels as a precautionary measure in the event of mistakes or on-site damages. Ordering extra panels with the initial order is not only a prudent step but also cost-effective, as it generally proves more economical than placing a separate order later.

Post-initial order panel acquisitions may lead to project delays, particularly if the current lead time is substantial. Additionally, it's worth noting that the delivery cost, including pallet charges, may remain the same if the same pallet size is required for subsequent orders.


How should I work out panel quantities?

Work out the number of panels required by taking the width of the area in millimetres, For example 10 metres wide = 10000 millimetres, divided by the cover width of the panel 425mm.

10000mm / 425mm = 23.52 panels, This is rounded up to 24 panels.

How thick are reveal panels?

Supplied in material 1mm thick in standard cover widths related to the metal coil size being used.

For example

Greencoat S280 Pural BT can have a max cover width of 306mm including a shadow gap of 0 to 20mm.

Cover widths can be reduced but cannot be made greater than the standard cover width dimension.

Can metals be supplied in coil format?

Metals can be supplied in coil format.

The most common size coils are 600mm wide. Other coil sizes are possible subject to stock levels.

Stock levels change regularly so lead times may vary. Some metals may require a large minimum order.

Contact us with your requirements.

What metals are available?

The main metals we can supply products in are;

Greencoat PLX Pural BT Greencoat PLX Pro BT Coated Aluminium Roofinox Stainless Steel Aurubis Copper Nedzink ZM Silesia Zinc Zintek Coloured Zinc Corten Steel



What are the specifications for copper shielding mesh?

Width: 1220mm Length: Up to 30.5 metres Weave Type: Plain Mesh Count Per 25.4mm: Warp 100.00 _ Weft 100.00 Aperture Size: Warp 198 micron _ Weft 198 micron Aperture Tolerance: +/- 4% Wire Diameter: Warp 0.056mm _ Weft 0.056mm Wire Tolerance: According to ISO 4782 Open Area: 60.77% Nominal Weight: 0.16KG/M2 Wire Specification: Copper Finish: Bright Drawn

What is wall capping?

Comes with liner flashings, structured underlay, double vulcanized joints with cover strip. Can be supplied with preformed internal/external corner sections, capping lengths with or without end caps.

The front face is typically a minimum of 75mm. The total girth possible depends on the available metals in stock. Coil widths are often 600mm which defines the total available girth for the capping. Larger coils for larger capping may be available. Capping lengths are 2000mm, other lengths may be possible.

What components make up a wall capping system?

Capping - open ended Capping - Pre Formed end cap Up stands Preformed Corners Capping Liner Flashings Structured Underlay Capping Joints Capping Joint Cover Strips

What are reveal panels?

Reveal Panels are a flat interlocking wall or soffit panels. They interlock in a tongue and groove manner so concealing any fixings. Can span battens/rails at 600mm centres. Various flashings are available to make up a complete wall or soffit panel system.



What metals are available for reveal panels and flashings?

0.9mm Greencoat S280 Standard Options include Mountain Grey - Nordic Night Black - Metallic Dark Silver.

1mm Aluminium Standard Options include Zinc and dark zinc patina, copper oxide and copper patina.

1mm ZM Silesia (Zinc) Options include Pre-Aged & Carbon

1mm NedZinc (Zinc) Options include Neo, Noir and Nuance Green, Blue & Red.

What are TSS Panels®?

TSS Panels® are traditional standing seam panels that offer versatile installation options. They can be delivered to the site as pre-rolled panels, accompanied by various flashings in different lengths. Alternatively, we can coordinate the on-site roll forming of panels to meet specific length requirements.

The standard cover widths for TSS Panels® are 530mm for roof panels and 430mm for wall panels, with a seam height of 25mm. This design makes them suitable for roof pitches as low as 3 degrees, although a 5-degree pitch is recommended.

TSS Panels® require the expertise of skilled and experienced hard metal roofing professionals for some roof designs.

We can guide you to a training centre where you can acquire the necessary skills to proficiently install either snap-together or traditional standing seam panel systems. This ensures that your roofing project is executed with precision and meets the highest standards of quality and durability.

For those seeking a comprehensive package that includes tool hire, we incorporate the tool costs into the order. Upon the return of the tools, we facilitate a refund, deducting a 20% hire charge from the tools' value.

What are STS Panels?

STS Panels® are a modern take on traditional standing seam panels.

The seams have a unique design which reduces the installation time when installing panels. Seams snap together onto concealed stainless steel clips (300mm spacings)

Seam Options

STS Panels® have two profiles options both can be used for roof or walls.

25mm seam x 425mm cover width panels for a minimum roof pitch of 7°

The 38mm seam x 386mm panels for a minimum roof pitch of 3°

Custom widths are possible as long as the custom cover width is less than the standard width.



Can STS Panels be made in zinc?

No they are not available in real zinc.

For real zinc roofing and cladding you will require TSS Panels® to select from Nedzink, ZM Silesia or Zintek Coloured Zinc options.

What are the design requirements for STS Panels?

STS Panels® for both roof and walls.

Design Requirements

Panels need to be fully supported so they cannot span battens/rails.

Can be supplied with various flashings to make up a roof or wall panels system.

STS Panels® are ideal for simple projects which do not have complicated details.

For more complex projects TSS Panels® would be more suited as the seams can be folded by trained installers to produce other details.

Can I order some samples of metal?

Samples of metals are always sent before orders are booked in to the production queue.

Compare samples and confirm the right finish for your project before committing to buy.

Sample images of metals, may not always accurately represented the colours and textures. So it is always better to have them in hand. After selecting from small samples, larger samples are available if required to further finalise the decision.

We are always prompt to post samples.

If you have not received any requested samples within 7 days, do let us know!

When will I receive lead time confirmation?

The lead time for your order is confirmed on the day of ordering. This duration encompasses the fabrication production queue, fabrication time, and delivery to the specified site address. While certain products are available for quick ordering, most of our offerings, including custom-made items like panels, flashings, and certain rainwater goods, are produced on-demand. The fulfilment time is contingent on the current lead time and coil stock levels. Non-peak lead times typically range from 2-3 weeks.

What is the lead Time On additional items for existing projects?

For projects requiring more materials after the initial order has been delivered the lead time will be what it is on the day. So it is important to order correctly to avoid delays if more materials are required. However in cases where more items are needed for existing projects to finish, we always try to get made and sent out as soon as possible. But please be aware it could be a long lead time if things are very busy.



What is the delivery process?

Orders are dispatched on a protected pallet to the delivery address specified in the order. It is the customer's responsibility to unload the orders, either utilizing a forklift truck if available or with an adequate number of people on-site to manually off-load pallets and their contents safely within the allocated time slot. If a dedicated vehicle capable of off-loading pallets is required, additional costs may apply.

What is the production queue and dispatch procedure?

Upon placing an order, it is scheduled into the production queue. A provisional dispatch date is generally provided within 1-2 weeks. The day before the scheduled delivery, customers are contacted to confirm the impending delivery and ensure there are no restrictions that may affect the driver's ability to access the site, such as narrow roads requiring a smaller delivery lorry.

What are the delivery costs and are there any discounts on delivery charges?

To calculate delivery costs, we require the site post code and details of the order. Please note that delivery costs may be substantial, but we may offer discounts or free delivery in certain cases.

Do Merlin Metals provide a complete breakdown of items to check before an order is placed?

In our commitment to transparency and customer satisfaction, we generate a comprehensive breakdown of all items before orders are placed. This allows our valued customers the opportunity to meticulously review and confirm the exact details, making any necessary adjustments before finalising the price and placing an order. The best rates are reserved for customers that provide clear and concise material schedules.

Can Merlin Metals quote from non specific information?

When estimates are generated from drawings or non-specific information, We offer a total estimated figure. This will involve higher rates to cover the additional work involved making order details production ready. Alternatively customers can provide their own material schedules and receive better rates.



About Merlin Metals?

We are UK-based suppliers of premium metal building materials.

Our long-standing partnership with a trusted manufacturer underscores and secures our commitment to delivering high-quality products consistently over the years. Our primary focus is on material supply, and at present, we do not engage in installation services.

At Merlin Metals, we are dedicated to ongoing enhancements in our services, aiming to better serve our diverse customer base. Recognising that our clientele varies in experience levels, some possessing extensive familiarity with our materials or similar products, while others may be in the early stages of navigating the ordering process, we strive to cater to all.

The development of our Ai assistant is set to form the back bone of our operations. Enabling customers to find what they need.

How clear does information need to be when requesting prices?

We emphasize the importance of customers providing concise information to expedite the order processing.

Clear and precise details enable us to swiftly handle order information, increasing our overall efficiency and enhancing the potential for error free ordering by leaving nothing to guess work.

How important is it to be clear about what items need to be ordered?

When our customers articulate their quotation requests with clarity and outline their order requirements, it not only enhances the productivity of our time but also positions us to offer competitive discounts.

This collaborative approach ensures a mutually beneficial interaction and a streamlined order fulfilment process.

In other words, we share success with those responsible for helping us achieve it.

What are the final checks required before placing an order?

Prior to placing an order, customers are strongly advised to thoroughly review all detail. It is essential to verify items, quantities, dimensions, and drawings.

Any errors detected after the commencement of production will incur additional charges, for the required materials, including associated delivery fees.

We appreciate your understanding and diligence in ensuring ,the accuracy of your order details.



Is having the right tooling important?

Access to the right tools is paramount, significantly influencing the ease of installation and the ultimate quality of the finished product. At Merlin Metals, we understand the importance of providing our customers with access to the tools necessary for a seamless installation process and a superior final finish.

What are the key points for ordering panels?

Checking you are ordering the correct panel profile to suit the projects requirements Checking the panel lengths, ensuring you have allowed any extra for folds Checking the required quantity of panels and allowed any extras Suppliying a drawing for any custom panels such as tapered or wall abutment

What are the key points for ordering flashings?

Checking you are ordering the correct flashing types needed for the project Checking the flashing lengths, ensuring you have allowed any extra for lapping or folds Checking the required quantity of flashings and allowed any extras Suppliying a drawing for any custom flashings Suppliying drawings for any standard flashings, clearly showing dimensions, angles

What are the key points for ordering other items?

Put a list together of other items such as underlay, clips, screws, sealants etc. Requested other items be suggested in a quote

What are the key points for ordering tools?

Considered adding any tools to the order. To help with the installation and quantity of finish.

What are the key points for ordering samples?

Viewed a sample of your preferred metal finish. And can confirm it is correct for your project.

What are the key points for supplying schedules?

Have you supplied complete schedules for panels, flashings, other items Along with any related drawings clearly showing all dimensions and angles

What are the key points for requesting an estimate?

Have you supplied enough dimensional information, drawings or other images.? Have you provided a delivery postcode and selected metal / finish.? Do you understand an estimate is a guide and requires accurate schedules to finalise the price.?



Can I request help generating provisional schedules?

If you require assistance to compile the details of an order after receiving an estimate. We can generate & supply provisional schedules for you to review and revise accordingly.

Deposit may be required before issuing provisonal schedules.

What are the guidelines for a seamless ordering experience?

Thank you for considering us for your order. The following pages are crafted to assist you in navigating the order placement process effortlessly.

Production Ready Details:

The success of every order is in the precision of the details provided, bringing them to a point where they are production-ready.

Your Quick Guide:

Take a moment to explore the provided information. It holds the key to unlocking answers crucial for generating concise and accurate order details.

Precision Matters:

Ensure that every detail is exact and tailored to production requirements. This not only expedites the process but also minimizes the likelihood of errors.

Concise Order Generation:

Use the insights gained from the provided information to create an order that is clear, concise, and aligned with your production needs.

Why It Matters:

By investing a brief moment to familiarize yourself with the information presented, you empower yourself to generate and submit orders efficiently. This not only saves time but also ensures a smoother journey from order placement to production + the best rates.

What is meant by being productions ready?

Before any orders can be accurately quoted for & made production ready. Clear and concise materials schedules must be generated.

For flashings/custom panels, drawings are required. That clearly show the dimensions/angles/ finish side etc.

Details can be supplied to us by completing the relevant product order forms, Emailing them to mail@merlinmetals.com

Drawing templates are available for standard flashings, simply add any missing dimensions/angles.



Tell me more about Estimates - Quotations - Booking in?

When provided with non specific information, we supply an estimate. With specific information we can provide quotations that are valid for the items on it.

Quotations are based on the material schedules a customer confirms to be correct. Whether or not those schedules are supplied to us or when created by us. For customers to then review & revise where necessary.

Can I request current rates for my preferred metal?

Yes, Request the current rates for the selected metal and associated panels and flashings.

Using this information you can start estimating most of the costs involved before proceeding further.

Can I place an order or enquiry via online forms?

Yes, Use our online form to submit accurate information. Entering exact lengths & quantities/upload schedules.

Can I receive a quote if I supply drawings?

I may be possible to provide a budget price from drawings but schedules are needed to finalise a price.

What is meant by supplying concise schedules?

This means, panel lengths & quantities, flashing lengths & quantities. Other item quantities along with any related drawings for flashings. Or bespoke panels clearly showing dimensions, angles, finish side etc.

Type of metal/finish, postcode/delivery address, site contact number.

Materials schedules supplied by customers,

Without any intervention on our part to work out quantities, details or create related drawings.

Provides the most opportunity for discounts & will receive the best rates,

Because theses enquiries have a lower impact on the time & work needed to process.

What is the ordering process overview?

The core to our ordering process is simply this. Before any orders can be accurately quoted for & made production ready. Clear and concise materials schedules must be generated.

This means, panel lengths & quantities, flashing lengths & quantities. Other item quantities along with any related drawings for flashings. Or bespoke panels clearly showing dimensions, angles, finish side etc.



How do Merlin Metals process orders?

The way we process orders is ultimately the same for every customer. Although the steps from initial enquiry to being production ready. Can vary a great deal from customer to customer & project to project.

Enquiries from customers that knows the specifics of what they need to order. Require the least amount of time and steps to process order information. So better rates are offered.

To varying degrees, some customers do not know what materials to order. Non specific enquiries can require numerous steps to work through information. Before a quotation can even be given or details made clear enough to proceed. For this reason we cannot always offer the best rates in these situations.

What are prices based on?

All quotations provided by Merlin Metals Limited. Are based on the material schedules that a customer confirms to be correct. Whether or not those schedules are supplied to us. Or when created by us, for customers to then review & revise where necessary. If a quotation is accepted & a sample of metal confirmed as correct. A proforma invoice is then issued with payment being required in full via bank transfer.

What happens after I make payment for my order?

After payment, orders are then booked into the production queue.

Whereby shortly after a provisional despatch date is given.

Customers are called the day before delivery to confirm its despatch and to check.

They are ready to accept and off load the order when it arrives.

Offloading orders is a customers responsibility.

Within an allocated time slot by hand should a fork lift truck not be available on site.

How important is it to supply concise material schedules?

When materials schedules are supplied by customers,

Without any intervention on our part to work out quantities, details or create related drawings.

It provides the most opportunity for discounts & will receive the best rates.

This is because of the lower impact on time & the work needed to process.

Can quotations be supplied from non-specific information?

When customers have not provided clear order detail information in the form of schedules.

That are concise enough to book orders into the production queue.

Merlin Metals Limited provide a total estimated price.

Based on our interpretation of drawings or other information supplied.

Although it may be impossible to estimate accurately if to much information is missing.



How are details and prices finalised?

After receiving an estimate.

Customers can then provide concise schedules themselves to finalise the price.

Or check and confirm from the provisional schedules we supply that display the potential elements involved.

The details of which can be finalised by customers making any necessary adjustments. Such as to the lengths/quantities/drawing dimensions/angles or other items.

Pricing and payment?

Once a customer has reviewed and where necessary revised the provisional schedules we supply.

The total order price is then recalculated accordingly and a balance payment figure is presented.

This may be less than initially stated, due to items being removed, changed or discounted.

Or the total may be more depending on the items added or changed in some way.

For example

Changes to panel/flashing lengths Or if more materials are required such as:

Fascias Soffits Bespoke items Extra Panels.

Production ready or cancelling?

Once order details have been reviewed, revised and made production ready. Customers can then choose to either pay the stated balance. This makes an order active within the production queue.

Or request a refund if a deposit was paid minus a 5% admin fee to cover our time. Generating the ordering information we have supplied.

This approach is designed to help us prioritise our time better. So that it is more likely spent helping genuine customers.



Roof & Wall Flashings

STS Panels®, TSS Panels®

The flashing map illustrates various locations on a building where flashings may be needed.

Custom Flashings

Custom-made flashings are available upon request. To provide a quote for bespoke flashings, we require a comprehensive drawing displaying all dimensions, angles, and a clear indication of the finish side. Merlin Metals are not responsible for the inaccuracies of customer drawings.

Standard lengths are 2000mm long. We can have most flashings made up to 3.6 metres long.

The pages that follow provide a catalog of standard flashings, accompanied by spaces for noting quantities and any additional information you wish to include. This allows customization, including specifying custom lengths or project-specific dimensions.



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Roof Flashings For STS and TSS Panels



Eaves

Eaves flashings are normally supplied in 2000mm lengths.

Includes a liner flashing and the top flashing.

Roof panels are folded underneath the eaves flashing.

| Reference | Length | Quantity | Roof Pitch |
|-----------|--------|----------|------------|
| | 2000mm | | |



Note:

Ridge

Ridge flashings are supplied in standard 2000mm lengths.

Including a liner flashing, foam fillers and buttstraps. to join each length.

The liner is made to suit, so for example a ridge beam as shown or a trussed roof.

| Reference | Length | Quantity | Roof Pitch |
|-----------|--------|----------|-------------------|
| | 2000mm | | |



Mono Ridge

Ridge flashings are supplied in standard 2000mm lengths.

Including a liner flashing, foam fillers and buttstraps. to join each length.

| Reference | Length | Quantity | Roof Pitch |
|-----------|--------|----------|-------------------|
| | 2000mm | | |



Roof Abutment

Ridge flashings are supplied in standard 2000mm lengths.

Including a liner flashing, foam fillers and buttstraps. to join each length.

| Reference | Length | Quantity | Roof Pitch |
|-----------|--------|----------|------------|
| | 2000mm | | |



Add the number of 2000mm or custom lengths required.



Verge

Verge flashings are normally supplied in 2000mm lengths.

Including a liner flashing and the top flashing.

Roof panels are folded to form an up stand that the verge flashing can fold over.

| Reference | Length | Quantity |
|-----------|--------|----------|
| | 2000mm | |



Valley

Valley flashings are normally supplied in 2000mm lengths.

Can be made up to 3.6 metres long.

Panels are folded so that they can be secured into the valley flashing.

| Reference | Length | Quantity | Angle |
|-----------|--------|----------|-------|
| | 2000mm | | |



Chase

Chase flashings are normally supplied in 2000mm lengths. Works with roof abutment flashings or panel up stands.

| Reference | Length | Quantity |
|-----------|--------|----------|
| | 2000mm | |



Head Seam Slider

Head seam sliders are supplied individually.

Works with panel up stands, rather than using the roof abutment flashings.

| Seam | Quantity | Upstand Height |
|-------------|----------|----------------|
| 25mm / 38mm | | |



Wall Flashings For STS and TSS Panels



Ventilated Cill

Ventilated Cill flashings are normally supplied in 2000mm lengths. Including a liner flashing.

| Reference | Length | Quantity | Width |
|-----------|--------|----------|-------|
| | 2000mm | | |



Cill

Cill flashings are normally supplied in 2000mm lengths.

| Reference | Length | Quantity | Width |
|-----------|--------|----------|-------|
| | 2000mm | | |



Head

Head flashings are normally supplied in 2000mm lengths.

| Reference | Length | Quantity | Width |
|-----------|--------|----------|-------|
| | 2000mm | | |



Abutment

Wall abutment flashings are normally supplied in 2000mm lengths.

| Reference | Length | Quantity |
|-----------|--------|----------|
| | 2000mm | |



Add the number of 2000mm or custom lengths required.





Box Abutment

Box abutment flashings are normally supplied in 2000mm lengths.

| Reference | Length | Quantity |
|-----------|--------|----------|
| | 2000mm | |



Reveal 1 flashings are normally supplied in 2000mm lengths.

Has a snap together seam over clock to snap onto the side of a wall panel that lines up with the side of a window or door.

| Reference | Length | Quantity | Width |
|-----------|--------|----------|-------|
| | 2000mm | | |



Reveal 2

Reveal 2 flashings are normally supplied in 2000mm lengths.

Has a snap together seam under cloak for wall panels to snap onto when lined up with the side of a window or door.

| Reference | Length | Quantity | Width |
|-----------|--------|----------|-------|
| | 2000mm | | |



Reveal 3

Reveal 3 flashings are normally supplied in 2000mm lengths.

| Reference | Length | Quantity | Width |
|-----------|--------|----------|-------|
| | 2000mm | | |



Wall Flashings For STS and TSS Panels



Base 1

Base 1 flashings are normally supplied in 2000mm lengths.

They are used at the bottom of wall panels.

The bottom of p panels are folded under the base flashing to secure.

| Reference | Length | Quantity | Width |
|-----------|--------|----------|-------|
| | 2000mm | | |



Base 2

Base 2 flashings are normally supplied in 2000mm lengths. They are used at the bottom of wall panels at the top of windows & doors. The bottom of p panels are folded under the base flashing to secure.

| Reference | Length | Quantity | Width |
|-----------|--------|----------|-------|
| | 2000mm | | |





External corner flashing A are normally supplied in 2000mm lengths.

They are used to form external corners.

The flat of a wall panel is folded 180 d, which then hook into the external wall flashing.

| Reference | Length | Quantity |
|-----------|--------|----------|
| | 2000mm | |



External Corner B

External corner flashing B are normally supplied in 2000mm lengths. They are used to form external corners in addition to wall abutment flashings. This eliminates the need to fold panels 180d

| Reference | Length | Quantity |
|-----------|--------|----------|
| | 2000mm | |



Add the number of 2000mm or custom lengths required.



External Coulisseau

External coulisseau flashing A are normally supplied in 2000mm lengths.

| Reference | Length | Quantity |
|-----------|--------|----------|
| | 2000mm | |



Internal Corner

Internal corner flashings are normally supplied in 2000mm lengths.

They are used to form internal corners.

The flat of a wall panel is folded 180 d, which then hook into the internal wall flashing.

| Reference | Length | Quantity |
|-----------|--------|----------|
| | 2000mm | |



Installing Overview

The installation process for either STS Panels® (snap-together seam) or TSS Panels® (Traditional Standing Seam) involves a series of steps. STS Panels® are well-suited for DIY projects, but it's important to note that some cutting and folding of metal may be necessary. Regardless of the choice, it is highly recommended to undergo suitable training before undertaking the installation.

This is especially crucial for traditional standing seam systems, or when dealing with STS Panels® in situations where there are numerous architectural details to consider, such as windows, valleys, hips, or roof lights.

Merlin Metals does not handle installations but can offer recommendations for training providers in the North West of England. However, below is a general step-by-step guide for reference:

Materials and Tools:

STS Panels® or TSS Panels® for Roofs Roof flashings STS Panels® or TSS Panels® or Reveal Panels for Walls Wall flashings Roofing underlay Roofing screws/nails Sealant/adhesive Solar Panel Seam Clamps Screw gun or hammer Metal Folding Tools Metal snips Measuring tape Level Safety equipment (gloves, safety glasses, etc.)

Step 1: Preparation:

Ensure the roof deck is clean, dry, and structurally sound. Install roofing underlay. STS Panels® or TSS Panels®both require full support so do not span battens. Reveal panels can be installed on rails or battens. (600mm centres)

Step 2: Measure and Plan:

Measure the roof area accurately, considering panel overlap if lapping traditonal standing seam. STS Panels® (cannot be lapped) Plan the layout, ensuring proper alignment and symmetrical placement of panels. Taking into account any extra length needed for folding the panels at the eaves, ridge or wall abutment.

Step 3: Install Flashings:

Install roof flashings at critical points like eaves, ridges, and valleys, following manufacturer guidelines. Apply sealant where flashings over lap.

Step 4: Panels:

Start at one end of the roof and fix the first panel into the correct position. Align subsequent panels with the preceding one and snap them into place. Ensure panels are level and straight. For standing seam panel suitable tools are required to fold the seams together.



Step 5: Secure Panels:

Fasten panels to the roof deck using appropriate screws or nails and spacing, Typically 300mm.

Step 6: Folding Panels:

Trim panels as needed at the edges and openings using metal snips. Using suitable tools, fold the panels around any flashings where required. Such as at the eaves or verge.

Step 7: Install Wall Panels:

Install wall panels using a similar method, ensuring proper alignment with roof panels.

Step 8: Install Wall Flashings:

Install wall flashings at junctions between wall panels and other surfaces, applying sealant where necessary.

Step 9: Inspect and Clean:

Inspect the entire installation. Clean any debris or excess sealant from the roof surface. Remove any protective film from panels and flashings as soon as possible after the install is completed.

Step 10: Follow Manufacturer Guidelines:

Remember, this is a general guide, and variations may exist depending on the specific product you're using. Always refer to the manufacturer's instructions and, if needed, consult with a roofing professional to ensure a proper and durable installation.



Installation Information

Roof Panels:

Align the initial panel, factoring in the roof's layout, and firmly secure it by using panel fixing clips at approximately 300mm intervals. Confirm precise placement at the eaves and ridge points. For the verge side, ensure secure attachment by nailing or screwing flashing clips at nominal 300mm intervals.

Position the subsequent panel seam over the upstand of the first panel.

Ensure proper alignment of the panel along its entire length.

Carefully press down the seam using either your hand or foot until the panel is securely in place

Eaves Flashing:

Secure the eaves flashing liner to the substrate by nailing or screwing it in place.

Ensure proper alignment of the eaves flashing so that it effectively engages with the eaves flashing liner.

Stabilize the eaves flashing by nailing or screwing flashing clips to the check-welt at 300mm intervals. It's crucial to note that eaves flashings are jointed with 100mm laps and sealed with 'Seal & Fix' when dealing with low pitches for enhanced waterproofing.

Eaves Panel Fold Detail:

Mark the folding line across the panel, ensuring it is 5mm beyond the edge of the eaves flashing.

Utilize the Notching Tool to create a notch precisely on the marked line.

Using Left or Right Handed Snips as necessary, meticulously cut a curved line from the seam end to the notch point.

Initiate the first fold at a minimum angle of 100 degrees along the eaves, employing either the Seaming Pliers or the optional Eaves Folding Tool.

Conclude the process by executing the second fold to seal the eaves using the Eaves/Verge Closing Tool..

Verge:

Secure the verge flashing liner to the substrate by either nailing or screwing it in place.

Position the verge flashing to ensure proper engagement with the verge flashing liner.

Utilize the Eaves/Verge Closing Tool to effectively close the verge flashing.

Note: Verge flashings are joined with 100mm laps.

Ridge/Hip:

Gently fold the top of the panel by 10mm to a 90-degree angle using the Bent Seaming Pliers or Upstand Piers. Allow a small dog-ear fold to naturally form in the corners. Step 1a: DO NOT SNIP THESE POINTS!

Carefully peel off the film and insert the Ventilated Foam Filler approximately 30mm from the top of the panel.

Install the ridge liner securely using screws spaced at 300mm intervals.

Position the ridge flashing over the ridge liner, closing it with Bent Seaming Pliers if necessary. Ridge flashings are jointed end to end with ridge butt-straps.



Note: Various methods can be employed to complete the ridge end detail, and this option utilizes the ridge itself to form the desired detail.

Ridge Liner Style:

The allocation of fixed clip points is determined by the roof pitch, as outlined in the table below.

Ridge Ends

Utilize the Left or Right handed Snips, as suitable, to make a precise cut to the verge point.

Commence the upper bend using the Upstand Folding Tool and finish the fold manually.

Initiate the lower bend with the Bent Seaming Pliers and conclude the process using the Eaves/Verge Closing Tool.:

Abutment, Chase::

The abutment flashing is installed much like a ridge flashing however the liner is fixed through into the adjoining wall. A chase flashing can then be usedover the top of the abutment or another flashing material such as lead.

Mono Ridge:

See Ridge Information.

Facias & Soffits:

Can be custom made to suit and have perforated metal as the soffit. Flashings can be overlapped but in some cases it is better to use a single lock.

Panel Abutment:

Panels can be sent with a pre formed upstand (Assuming roof square otherwise better to fold on site.

Valleys:

The valley, being a pre-manufactured flashing, should be installed by affixing flashing clips at 300mm intervals using either nails or screws.

It's important to note that valley flashings are connected with 150mm laps, and for low pitches, they should be sealed with 'Seal & Fix' to ensure proper waterproofing.

Roof Light Flashing Kits:

For larger penetrations and rooflights, we offer customized flashing kits tailored to your specific requirements. Precise measurements and detailed specifications are essential to ensure a seamless fit on-site.



Penetrations:

For roof penetrations, vents, or similar elements that are smaller than the sheet width, installation is straightforward and can be achieved through soldering, welting, or sealing, depending on the material in use. Alternatively, when suitable, penetrations and vents can be pre-installed directly into the panels for added convenience. The method chosen depends on the specific materials and project requirements.



These fixed clips can be established using one of the three options:

Cut and Fold Method:

Cut and fold a portion of the panel seam around the top side of the seam clip, and secure it by nipping together with pliers.

Crimping Method:

Crimp the seam using a suitable set of grips.

Riveting Method:

Secure the seam clip by placing a rivet through both the panels and the seam clip.

Choose the method that best suits the project requirements and materials used.

Wall Panels:

Align the initial panel, taking into consideration the wall's layout, and securely fasten it using panel fixing clips at 300mm intervals.

Position the subsequent panel seam over the upstand of the first panel.

Ensure precise alignment of the panel along its entire length.

For STS Panels (Snap Together Seam Panels), gently press down on the seam using either your hand or foot until the panel is firmly in place. Alternatively, for TSS Panels (Traditional Standing Seam Panels), employ the seam folding tool to join the panels securely.



Base Flashings:

Base flashings play a crucial role at the bottom of panels, whether positioned at the base of a wall or atop a window or door opening. Follow these steps for proper installation:

Placement: Install base flashings before affixing the panels. This applies to both the base of a wall and the upper edge of a window or door opening.

Panel Folding: Fold the panels in a manner that positions the bottom of each panel underneath the base flashing. This folding technique mirrors the approach taken with roof panels around eaves flashings.

External & Internal Corners:

Begin by fitting the corner flashing first, securing it in place using flat clips.

Panel Folding:

Fold the panels 180 degrees so that they can be seamlessly slotted into the corner flashing. If the panels are under the cloak, secure the other side with clips. If the panels are over cloak, secure them to the adjacent panel.

Pre-formed Corners:

Pre-formed corners can be supplied when detailed drawings are provided. These drawings should include dimensions for each side of the corner and indications for whether each side should be under or over cloak.

Note: For pre-formed corners, it is essential that the building is square to ensure a precise fit.

By following these steps, you ensure a professional and secure installation of external and internal corners, enhancing both the aesthetic appeal and structural integrity of the panel system.

Wall Abutment:

Prior to panel installation, fit the wall abutment flashing. Secure it at 300mm intervals using fixings appropriate for the substrate.

Panel Installation:

The flat side of the panels can now be smoothly slotted into the abutment. Secure the other side with either an undercloak seam or an overcloak seam, depending on the design and preference.

Box Abutment:

Begin by positioning the box abutment flashing before panel installation. This is particularly relevant for locations such as the top of walls.

Panel Placement:

Slot the panels upward into the box abutment. Ensure a snug fit to maintain a seamless appearance.

Folded Bottom Placement:

Simultaneously, fold the bottom of the panels upward, ensuring it slots securely behind the base flashing.



Cill Flashings:

Cill flashings to direct water away from the building, set to a 95 degree angle unless otherwise requested.

Reveal Flashings:

Reveal flashings can be made to interlock with a panels seam if the seams land in the right place. In cases where seams dont fall in line with doors or the side of windows. Some on site bending and folding may be required to form the reveals.

Head Flashings:

Head flashings are used at the top of doors, windows or as part of a soffit system.

Working Around Windows & Doors:

When embarking on the installation of a roof or walls, thoughtful consideration and meticulous planning of the layout are crucial. This ensures that the seams seamlessly intersect with other critical elements, including windows and doors, resulting in an aesthetically pleasing and structurally sound outcome.

A well-defined plan detailing how to navigate around specific areas, taking into account the nuances of the chosen panel profile, is essential. Haphazardly commencing the installation without strategic planning can compromise the overall quality of the finish. Therefore, a methodical approach that considers the panel profile, along with the placement of windows and doors, is imperative.

By incorporating a clear plan from the outset, you not only enhance the precision of the installation process but also contribute to the overall quality of the final result. Thoughtful planning is key to achieving a high-quality finish that meets both functional and aesthetic expectations.



Tools

Access to the right tools is paramount, significantly influencing the ease of installation and the ultimate quality of the finished product. At Merlin Metals, we understand the importance of providing our customers with access to the tools necessary for a seamless installation process and a superior final finish.

We sell a basic standing seam tool kit, including essential instruments that facilitate the efficient handling and installation of our metal products. This kit is thoughtfully curated to enhance user experience, ensuring that you have the basics needed for a successful project.

In addition to the standing seam tool kit, we also supply other key tools designed specifically for folding the metal.

Such as the disc bender set to the right. Or the wall capping closure tool below.





Our commitment to equipping our customers with the best resources extends beyond the products themselves, encompassing the tools required to achieve optimal results.

By providing access to these tools, we aim to empower our customers, making the installation process more straightforward and contributing to the overall quality and durability of the final finish.

At Merlin Metals, we prioritise not only the supply of top-notch materials but also the provision of the right tools to make your project a success.

Such tooling can be a large investment when for example when doing a one off self build.

So we do offer hire option which means buying the tools at full cost but then receiving a refunded less 20% hire cost for 45 days of use.



For all your roofing tool needs visit https://www.roofing-tools.com



Merlin Metals Terms (2024)

About Us:

Merlin Metals Limited is a UK-based supplier of metal building products, specializing in standing seam roof panels and related materials. We collaborate with a trusted manufacturer, ensuring quality products for several years. Our focus is on material supply, and we are not currently involved in installations.

Purpose:

These terms and conditions are intended to define the rights and obligations of the parties involved in the sale of goods via any websites owned and operated by Merlin Metals.

Contact Information:

Registered Office: Unit 6, Malton Enterprise Park, 6 Cherry Farm Close, Malton, North Yorkshire YO17 6AD The above address is for correspondence only. Company Registration: 09827864 Email: mail@merlinmetals.com

Website Usage:

Our website content offers general information that may change regularly. Accuracy or completeness is not guaranteed by us or third parties. Users are responsible for verifying information for their needs.

Risk and Liability:

Your use of the website is at your own risk; we are not liable for any damages. Purchasing goods requires adherence to Merlin Metals' terms and conditions.

Links and Domains:

Our website may have links to other sites; we're not responsible for any damage caused through these links. Merlin Metals manages multiple websites promoting various brands, subject to the same ordering terms unless specified. Use of trademarks, logos, or brands without our consent is strictly prohibited.

Product Information:

While we strive for accuracy on our sites, Merlin Metals and its suppliers are not liable for consequences, accidents, or special damages arising from electronic transmissions or inaccuracies in the information. This holds true even if Merlin Metals was aware of the possibility of such damages.

Manufacturer and brand names are used for identification purposes only. Product photos, descriptions, and prices are non-contractual, meaning they are not binding agreements.

Items We Sell:

The main items we supply are; Standing Seam Panels, Snap Together Seam Panels Reveal Wall & Soffit Panels Metal Wall Capping Metal roof and wall flashings Metal Rainwater Goods (Half Round Click Together System) Custom Metal Rainwater Goods Metal Swatch Samples Copper Shielding Mesh

Training:

Merlin Metals do not offer training services for the installation of our products. Some guidance can be found via the Merlin Metal Ai helper however information is limited. We can refer customers on to a training provider that can offer various training courses in hard metal roofing.

Metals:

Greencoat PLX Pural BT Greencoat PLX Pro BT Coated Aluminium Roofinox Stainless Steel Aurubis Copper Nedzink ZM Silesia Zinc Zintek Coloured Zinc Corten Steel

Metals in coil format are available contact us.



Storage:

Proper storage is crucial to prevent damage. We do not accept liability for items damaged due to improper storage. Any pallets should be stored on level ground and protected from water because if unprotected it may cause water staining to items like panels or flashings.

When moisture gets between the items surface and its protected wrapper the sun or heat causes the moisture to evaporate which can lead to staining. Merlin Metals accept no liability for items damaged through improper storage.

Quality Assurance:

Customers must report any damage within 24 hours, with photographic evidence. All orders are checked for damage prior to being shipped by 3 people. All products leave the manufacturers fully inspected and in perfect condition. The customer must notify the carrier of even the slightest trace of damage (holes, signs of crushing, etc.) to the delivery, and refuse the delivery if necessary.

No exchanges can be made at a later time for goods claiming to be damaged, during carriage without notification at the time of reception.

Ordering Process:

After order details and pricing are agreed upon, a proforma invoice is issued. Full payment is required before the order is booked for production, a process taking 24-48 hours, sometimes longer. Delivery lead times vary (2-3 weeks), longer during high demand. Thoroughly review and check order details before payment to ensure accuracy.

Payment:

Payment is accepted via bank transfer; card payments are not accepted. Custom orders such as panels, flashings, are non-refundable. Merlin Metals accept no liability for items ordered in error, any additional items required after the order is placed are chargeable along with the delivery cost which can be as much as the initial order delivery cost.

Quotation from Architect Drawings:

Customers often send architects' drawings for a quotation. An estimated total price is provided if the drawings are clear.

Total Price Estimate:

We supply a total figure without a breakdown of items based on the drawings.

Provisional Material Schedules:

If customers want detailed provisional material schedules creating, higher rates apply.

Adjustments and Finalisation:

Provisional schedules display potential elements, with details finalized through necessary adjustments, such as lengths, quantities, drawing dimensions, angles, or other items.

Recalculation and Balance Payment:

The total order price is recalculated based on finalized details. The balance payment figure is presented, which may be less or more than initially stated, depending on adjustments.

Order Activation:

After order details are reviewed, revised, and made production-ready, customers can choose to pay the stated balance. This activates the order within the production queue.

Orders Cancelled:

Only orders that have paid a deposit can cancel within 30 days of provisonally accepting an estimated price.

Sales Terms:

Price rates, available upon request, are subject to change without notice. Quoted prices are valid on the day of issuing the proforma invoice. Merlin Metals reserves the right to adjust prices based on market changes.

Quotations:

When requesting a quotation, specificity is crucial to avoid errors. All quotations from Merlin Metals are based on material schedules confirmed by the customer, whether supplied to us or created by us for customer review and revision.



Product Samples:

It's encouraged to request product samples before making a purchase.

Delivery and Offloading:

Products are delivered to specified addresses within serviced geographic zones. The delivery cost includes a protected pallet and site delivery but not offloading. It's crucial to have someone available for safe offloading, either by hand within an allocated time slot or with a forklift if available.

Delivery Updates:

After placing an order, it may take a few weeks to provide a delivery date update. During this time, the order progresses through the fabrication queue.

Pre-Delivery Communication:

Customers are contacted a day before delivery to ensure someone will be present to accept the delivery and assist with offloading. Alternatively, arrangements can be made for item collection by the customer.

Damaged Items:

In case of damaged or faulty items upon delivery, photographic evidence must be sent to mail@merlinmetals.com within 24 hours. If the damage is accepted, replacement items will be sent, with the customer agreeing to load the faulty items back onto the transport.

Delay or Loss of Goods:

If there is a delay or loss of goods, an investigation is initiated by the carrier. Efforts are made to locate the delivery, and if unsuccessful, the carrier reimburses Merlin Metals. A new, identical package is then delivered to the customer free of charge.

Responsibility for Delays:

Merlin Metals is not responsible for delayed delivery times due to the carrier, adverse weather conditions, or strikes.

Loss or Damage in Transit:

Claims for loss or damage must be made within three business days of delivery. Damaged goods must be held for inspection.

Delivery Errrors

Customers must promptly inform Merlin Metals of any delivery error or non-conformity in goods on the same day or, at the latest, the first business day following delivery.

Claim Rejection Policy:

Claims made after the specified time period will be rejected. All claims must be in writing and sent to Merlin Metals' registered office address.

Compliance Rules:

Claims not following the defined rules cannot be considered, releasing Merlin Metals from responsibility.

Return Process:

In the case of a delivery error or exchange, all goods for exchange or refund must be returned in their original packaging with seals intact and in perfect condition to the address specified on the product sticker.

Declaration and Consent:

To have claims accepted, customers must declare returns to Merlin Metals, receiving their consent. If accepted, the customer ships the package to the address specified on the product sticker.

Merlin Metals Ai Helper:

Merlin Metals Ai helper is a new tool for customers to use. And find information. It is an on going development and will continue to improove. However please note it may make mistakes while it learns more.



Installers Directory

Often we are asked if we can supply and install. For the foreseeable future Merlin Metals have no plans to offer install services. However we may create an installer directory in the future, as an installer if this interests you get in touch.

Warranty:

Merlin Metals is not the manufacturer. Products come with different warranties, as per manufacturers' terms. For example Greencoat PLX Pural BT comes with a coating warranty of 25 years^{*} and a technical guarantee of 50 years. Coated aluminium comes with a 15 year^{*} coating warranty for roofs and 20 years^{*} for walls with a expected service life of around 40 years.

*Subject to site location, corrosive environments such as coastal areas may have reduced warranty periods.

Right to Withdrawal:

Returns are not accepted for bespoke items. Returns must be indicated beforehand. Refunds may be subject to fees.

Force Majeure:

If either party cannot fulfill its obligations due to circumstances beyond their control, neither party is considered in breach. These unforeseen events, known as force majeure, include acts, events, or accidents that are unstoppable and inevitable, despite reasonable efforts. Examples are strikes, natural disasters, and technological issues.

Notification:

The party facing delays ("Delayed Party") must inform the other party ("Affected Party") within ten business days of learning about the force majeure event.

Discussion and Agreement:

Unless hindered by force majeure, both parties will meet within three months to assess the impact and agree on how to continue the contract. If the force majeure persists for over one month, the affected party may terminate the agreement.

Non-Waiver:

If a party doesn't enforce a right or require strict compliance with the terms, it doesn't mean that the party is giving up the right to demand strict compliance later on. Failure to exercise a power or insist on strict compliance does not waive the right to do so in the future.

Domains:

Merlin Metals Limited operate a number of website domains to help promote the products we supply these include but are not limited to snaplockseam.co.uk, merlinmetals.com, stspanels.com, roofkit.co,standingseamroof.uk

Data Protection:

Any personal data you share with us is solely used to process your orders. We handle this data in line with the principles of data protection as defined in the Data Protection Act 2018.

Applicable Law:

These terms are governed by English law. Any disputes are subject to the exclusive jurisdiction of English courts.

Disclaimers:

Prices and supply subject to fluctuation and availability. Quotations valid for 30 days. Additional costs may apply due to Brexit or coronavirus-related issues.

Merlin Metals Limited operates solely as material suppliers and does not engage in installations. While our commitment extends beyond our primary scope whenever possible, we expressly state that we are not responsible for calculating the precise requirements of a project.

Prior to placing an order, customers are strongly advised to thoroughly review all details provided in the quotation. It is essential to independently verify the accuracy of items, quantities, dimensions, and drawings. Any errors detected after the com-

mencement of production will incur additional charges for the required materials, including associate delivery fees.





Index to be added once more information has been added



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merlinmetals.com

UK Suppliers of Standing Seam Panels & Associated Flashings Reveal Wall/Soffit Panels Wall Capping Rainwater Goods

Phone: 01653 489 780 E-mail: mail@merlinmetals.com

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