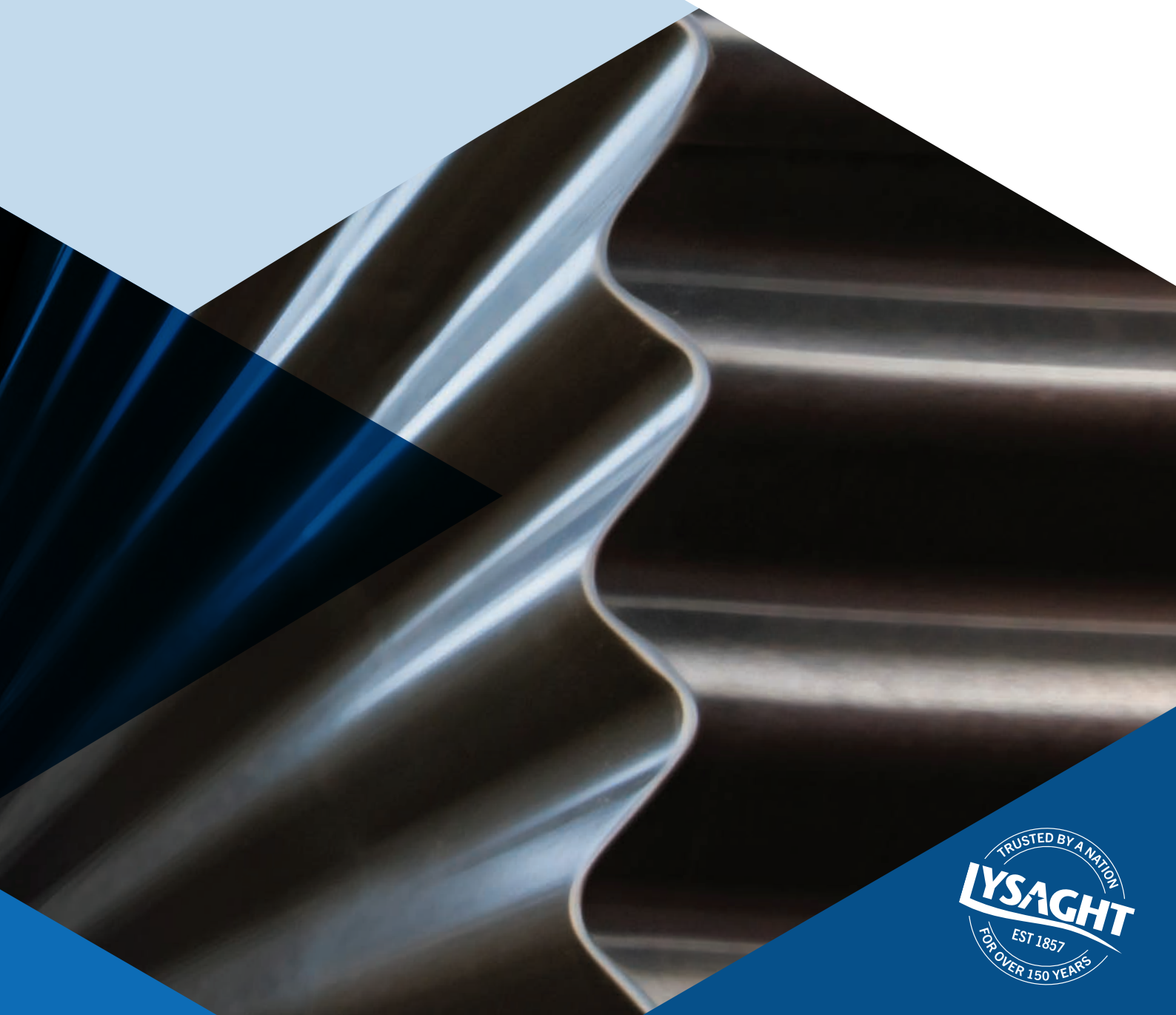


# FORMFLOW® C90™

DESIGN AND INSTALLATION GUIDE

**LYSAGHT**



# FORMFLOW® C90™

## THE ELEGANT BEND SOLUTION

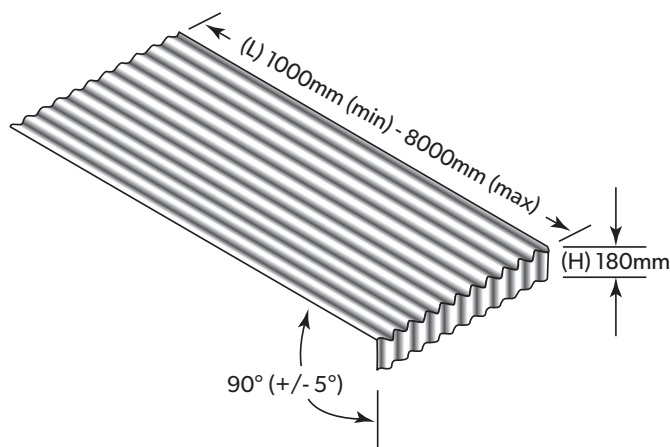
FORMFLOW® C90™ is the seamless corner solution for LYSAGHT CUSTOM ORB® clad buildings when combined in the LYSAGHT CUSTOMFLOW™ solution. With a bend geometry perfectly matched to CUSTOM ORB® corrugated cladding, FORMFLOW® C90™ corners provide a structurally independent, no-gaps solution to the challenges of joining corrugated sheets end to end at building corners and other junctions. In addition to delivering an elegant finished look, FORMFLOW® C90™ corners may also help deliver energy efficiency, maintenance, safety and installation benefits and can also improve fire resistance capabilities of a structure in some applications.

The publication is a supplement to the CUSTOM ORB® Design and Installation Guide and the LYSAGHT® Roofing & Walling Installation Manual, and should be used in conjunction with those publications with respect to design, fixing, installation & finishing.



### LENGTHS

FORMFLOW® C90™ corners comprise a corrugated sheet with a 90° (+/- 5°) bend on one end. The 'short leg' (H) created by the bend is 180mm in length; the 'long leg' (L) is a minimum of 1000mm and a maximum of 8000mm.



### MATERIAL OPTIONS

- ZINCALUME® steel
- COLORBOND® steel
- COLORBOND® Metallic steel\*
- COLORBOND® steel Matt\*
- COLORBOND® Ultra steel\*
- Galvanised Z450\*
- Heritage Galvanised Z600\*

\*Denotes non-standard material option.  
Please enquire for more information.

### MATERIAL SPECIFICATIONS

Next generation ZINCALUME® aluminium/zinc/magnesium alloy coated steel complies with AS 1397:2011 G550, AM125 (550 MPa minimum yield stress, 125g/m<sup>2</sup> minimum coating mass).

COLORBOND® is pre-painted steel for exterior roofing and walling. The painting complies with AS/NZS 2728:2013 and the steel base is an aluminium/zinc/magnesium alloy-coated steel complying with AS 1397:2011 G550, AM100 (550MPa minimum yield stress, 100g/m<sup>2</sup> minimum coating mass).

COLORBOND® Metallic is pre-painted steel for superior aesthetic qualities displaying a metallic sheen.

COLORBOND® steel Matt is pre-painted steel for superior aesthetic qualities displaying a matt finish.

COLORBOND® Ultra is pre-painted steel for severe coastal or industrial environments (generally within about 100-200 metres of the source). The painting complies with AS/NZS 2728:2013 and the steel base is an aluminium/zinc/magnesium alloy-coated steel complying with AS 1397:2011 G550, AM150 (550MPa minimum yield stress, 150g/m<sup>2</sup> minimum coating mass).

### COLOURS

FORMFLOW® C90™ corners are available in a range of COLORBOND® steel colours, and in unpainted ZINCALUME® aluminium/zinc/magnesium alloy coated steel.

### FORMFLOW® C90™ MASSES

	BMT (mm)	kg/m	kg/m <sup>2</sup>	m <sup>2</sup> /t
ZINCALUME® steel	0.42	3.26	4.28	234
COLORBOND® steel	0.42	3.32	4.35	230

### TOLERANCES

Length: + 10mm, - 10mm; Width: + 4mm, - 4mm

### MINIMUM ROOF PITCH

5°

### NON-CYCLONIC AREAS

The information in this brochure is suitable for use only in areas where a tropical cyclone is unlikely to occur as defined in AS 1170.2:2011.



## MAXIMUM SUPPORT SPACINGS

The maximum recommended support spacings are based on testing in accordance with AS 1562.1:2018, AS 4040.1:1992 and AS 4040.2:1992.

### FORMFLOW® C90™ MAXIMUM SUPPORT SPACING (MM)

	BMT
<b>Type of Span</b>	<b>0.42mm</b>
<b>Roofs</b>	
Single span	700
End span	900
Internal span	1200
Unstiffened eaves overhang	200
Stiffened eaves overhang	300
<b>Walls</b>	
Single span	1800
End span	2500
Internal span	2700
Overhang	200

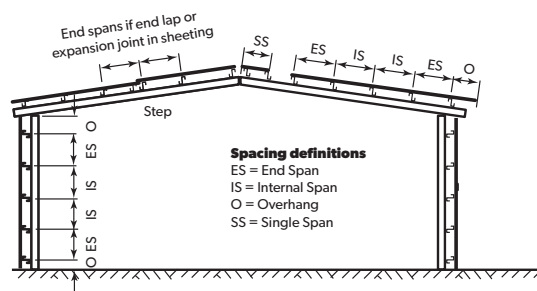
For roofs: the data are based on foot-traffic loading.

For walls: the data are based on pressures (see wind pressure table).

Table data are based on supports of minimum 1mm BMT. Refer to the TOPSPAN® Quick Selection Guide for support thickness less than 1.0 mm BMT, or seek advice from our information line. The FORMFLOW® C90™ end can be considered to provide stiffening to the overhang at eaves, providing the side-laps are stitched atop and at free end of the FORMFLOW® C90™ formation.

## SPAN TYPES

### Roofing & Walling Profiles



### FORMFLOW® C90™ 0.42 BMT LIMIT STATE WIND PRESSURE CAPACITIES (KPA)

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

## RAINFALL CAPACITIES (M)

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

# INSTALLATION

## GENERAL

The manufacture of FORMFLOW® C90™ corners results in a "corrugation reversal". The crest/rib of the sheet on one side of the bend becomes the trough/valley on the other side of the bend. Thus, at the sheet edges the overlap rib on one side of the bend is reversed and becomes a valley on the other side of the corner.

Due to this profile reversal feature the installer must become familiar with the product, capabilities, installation and available product range (including right-hand & left-hand bends, external and internal bends). It is important to note that the installer must be familiar with the installation of the FORMFLOW® C90™ corners prior to placing an order to ensure the correct orientation of the FORMFLOW® C90™ corners are ordered. Furthermore, all material requirements (both FORMFLOW® C90™ corners and CUSTOM ORB® sheets) must be ordered together. The installer must plan the whole project to ensure the best laying sequence.

## HANDLING

When walking along the length of FORMFLOW® C90™ corners, walk on at least two ribs or corrugations. When walking across the width of the sheeting, walk over or close to the roofing supports.

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

Always wear gloves when handling sheets.

Handle sheets carefully to avoid damage by not dragging them over one another and tools.

## CONDENSATION

To minimise the risk of condensation on the underside of cladding, a suitable membrane must be used for all FORMFLOW® C90™ corner installations. The membrane must be slightly draped between supports so that the cold cladding is not in contact with the membrane (except at the supports).

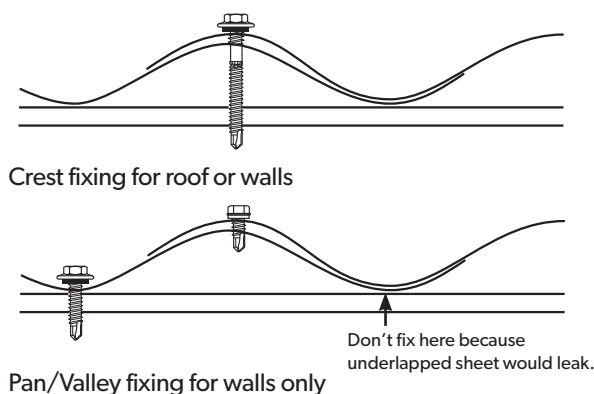
## FASTENING SHEETS TO SUPPORTS

FORMFLOW® C90™ corners are pierce-fixed to timber or steel supports. This means that fastener screws pass through the sheeting.

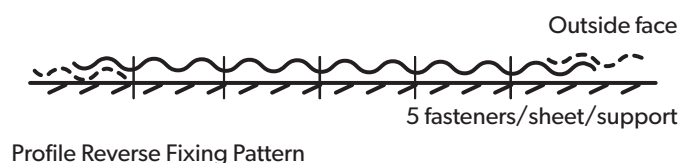
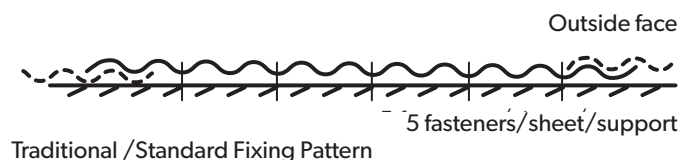
You can place screws through the crests or in the valleys. To maximise watertightness, always place roof screws through crests. For walling, you may use either crest or valley-fixing, however valley-fixing is the preferred industry practice.

Always drive screws perpendicular to the sheeting, and in the centre of the corrugation (rib, valley/pan).

Don't place fasteners less than 25mm from the end of sheets.

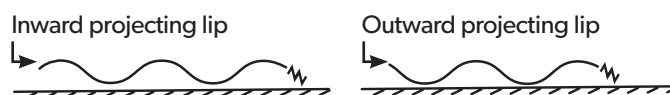


Fixing at the end-lap is recommended as requiring 5 fasteners/sheet/support pattern. With the end laps requiring 5 fasteners/sheet/support pattern it would be prudent to retain the same pattern throughout to provide a consistent aesthetic outcome. However, structurally only 3 fasteners/sheet/support pattern may be adequate (the designer should be consulted). Below are the fixing patterns for 5 fasteners/sheet/support for valley fixing.

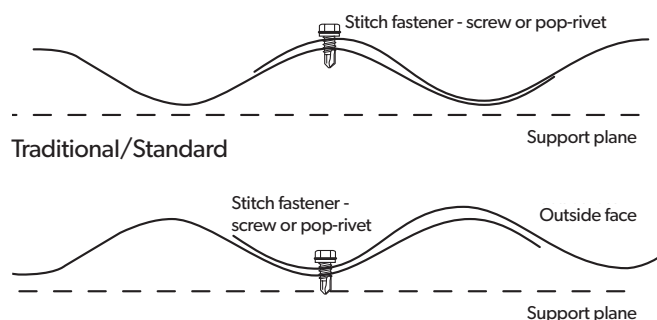


## SIDE-LAPPING & STITCHING

Traditionally the side-lapping of sheets is with the overlapping sheet having a side rib that overlays the rib of the lower sheet. The lip of the overlapping rib is pointed downward towards (inward projecting) the underlapping sheet. However, with the profile reversal feature of the FORMFLOW® C90™ corner, one side of the bend of the overlapping rib becomes the valley and will overlap the underlying valley. The lip is reversed and becomes outwardly pointing (outwardly projecting).

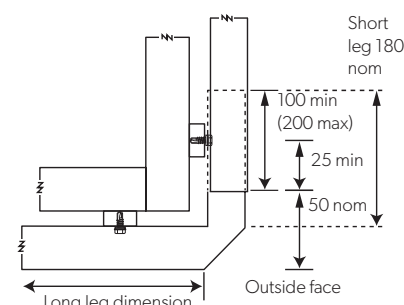


Side-lap stitching between supports, where required, is normally provided through the crest/rib of the profile – as detailed in the LYSAGHT® Roofing & Walling Manual. However, with the profile reversal feature of the FORMFLOW® C90™ corner where side-lap stitching is required it may also be required through the valley edge of the overlapping sheet.



## END LAPPING

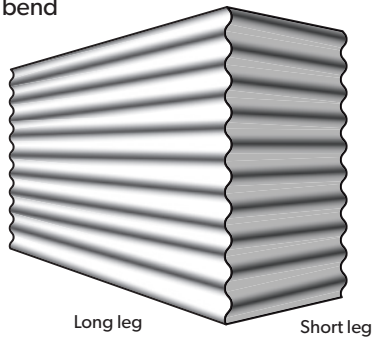
Where end-lapping occurs, ensure support centres are located from ends of the sheet as detailed. End lap length for walling is a minimum of 100mm and maximum of 200mm.



## BEND TYPES

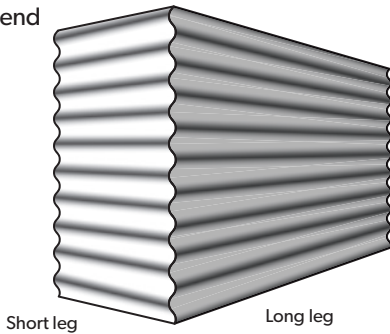
**External Corner, Right-hand Bend** - when viewing COLORBOND® steel painted surface, the long leg top lip edge is outward projecting, and the short leg is formed/cornered away on the right-hand side of the long leg

Right hand bend

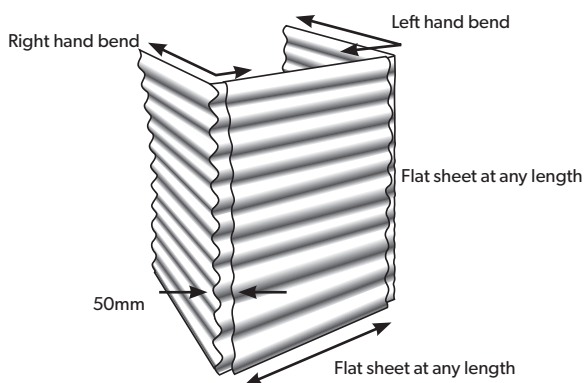


**External Corner, Left-hand Bend** - when viewing COLORBOND® steel painted surface, the long leg top lip edge is outward projecting, and the short leg is formed/cornered away on the left-hand side of the long leg

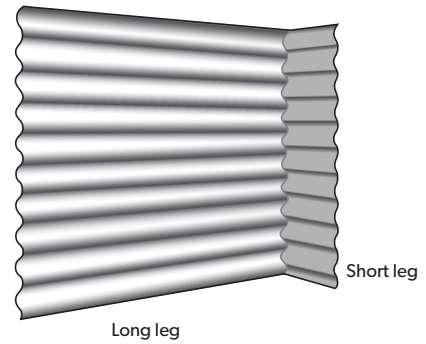
Left hand bend



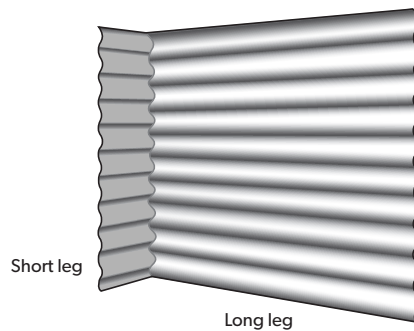
When two external corners (one right-hand and one left-hand) are used together and in conjunction with a CUSTOM ORB® sheet the following result is achieved.



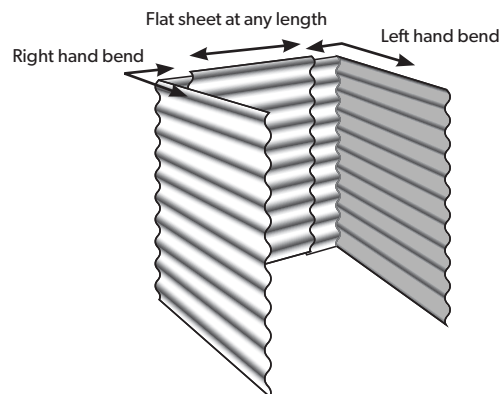
**Internal Corner, Right-hand Bend** - when viewing COLORBOND® steel painted surface, the long leg top lip edge is outward projecting, and the short leg is formed/cornered forward on the right-hand side of the long leg



**Internal Corner, Left-hand Bend** - when viewing COLORBOND® steel painted surface, the long leg top lip edge is outward projecting, and the short leg is formed/cornered forward on the left-hand side of the long leg



When two internal corners (one right-hand and one left-hand) are used together and in conjunction with CUSTOM ORB® sheet the following result is achieved.



## CORNER TRIMMING

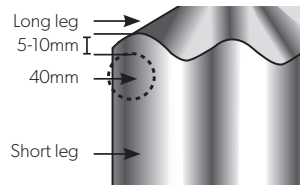
The short leg of a FORMFLOW® C90™ corner may need to be trimmed. Trimming may be necessary to ensure a snug fit on the corner, or to improve the aesthetics of the corner. Trimming may not be necessary where it is overlapped by following sheets.

Where trimming is required and will not be visible then the installer may develop their own trimming details to suit the situation. The trimming details could be along similar (or simplified) lines to the details given below. Where trimming is required and is visible then a suitable quality of workmanship is recommended.

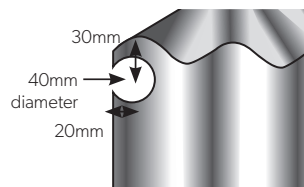
Where trimming is conducted the resulting material overlap onto the underlying sheet is reduced. Thus, sealing may be required.

The trimming details below, although sophisticated, have been used with success.

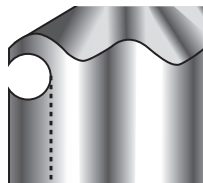
1. Mark out a 40mm circle with the edge closest to the bend, approximately 5-10mm from the bent edge of the sheet and touching the bottom of the sheet. The centre of the circle is 30mm from the end edge and 20mm from the bottom of the sheet.



2. Cut to 40mm hole in the sheet with suitable sheet metal cutting device.



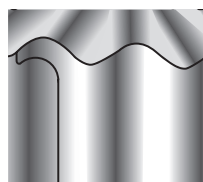
3. Mark out a straight line from the inside of the circle parallel to the edge of the sheet all the way to the cut end of the short leg.



4. Cut straight down the line with suitable sheet metal cutting device.



5. Trim sharp corners, remove sharp edges, burrs and the like.



## WALL INSTALLATION

The following installation is a typical description for walling applications.

### HORIZONTAL CLADDING

When FORMFLOW® C90™ corners are used on the vertical corners with horizontal cladding they replace the normal corner flashing. A standard flat CUSTOM ORB® sheet overlaps the short leg (180mm nominal) of the FORMFLOW® C90™ corner to provide an efficient barrier against weather ingress.

In horizontal applications where the end lap at the corners are in severe exposed applications, sealing at both ends of the lap (as described in the LYSAGHT® Roofing & Walling Installation Manual) may be required. It is important to note that added pop-rivets may be required to ensure the ends of the lap are adequately stitched together and sealed.

The installer must determine the wall faces that are most important for the project where the aesthetics are of utmost importance. The install process can then be determined to ensure the most aesthetically pleasing result. The installer must then order the appropriate FORMFLOW® C90™ corner to ensure that this process is followed.

Typical installation processes are described below. The description below is for a typical external corner. Other methods may be developed by the installer to suit the installer's needs, or the project requirements, providing the basic principles of lapping (end lapping and side lapping) and fixing are adhered to. The installer must plan the whole project to ensure the best laying sequence. For example, a right-hand bend could be turned upside down and used in a left hand bend application to minimise the extent of trimming of the short leg, however consideration must be given to the profile reversal on each leg to enable lapping onto other sheets.

### Installation Method A

This installation process sees the bottom layer on all walls around the whole structure fixed first before proceeding to the next layer up the wall.

### PREPARATION

1. Design, detail and specify the components of the wall system to address all the relevant requirements of moisture management (vapour control and condensation), ventilation, thermal performance, weather resistance, bushfire protection, vermin entry and the like.
2. Plan and construct the wall in a suitable sequence/order and ensure the correct positioning, securing (fixing), sealing of the components including the insulation, membrane(s), flashings and trims (at toe, around windows & doors, etc.), battens/supports, spacers, etc. During the installation of the battens/supports it is important to ensure they are in the same plane, the plane is plumb, and the face of the supports are flat/square to the plane.

### CLADDING INSTALLATION

3. Mark the supports to adequately show the alignment of the sheets around all walls to ensure level installation.
4. Always commence installation with a FORMFLOW® C90™ corner.
5. Orient the FORMFLOW® C90™ corner around the structure so that the long leg has the top edge lip projecting outwards. Thus, the short leg will have the edge lip projecting inwards. Orient the straight/flat CUSTOM ORB® sheets around the structure so that the top edge lip is projecting inwards to match the short leg of the FORMFLOW® C90™ corner.

6. Commence laying with the first FORMFLOW® C90™ corner positioned at the bottom of the wall.
  7. Initially fix the first FORMFLOW® C90™ corner in one of the middle valleys and check alignment and squareness of the sheet.
  8. Fastener location to be as detailed
  9. Commence laying with the first straight/flat CUSTOM ORB® sheet, on the other side of the corner, positioned at the bottom of the wall.
  10. The first straight/flat CUSTOM ORB® sheet is to be laid with the top edge lip projecting inwards, matching the short leg of the FORMFLOW® C90™ corner.
  11. This first straight/flat CUSTOM ORB® sheet to be laid overlap the short leg of the FORMFLOW® C90™ corner, ensuring there is a 50mm spacing from the end of the sheet to the peaks of the corner bend.
  12. Initially fix the first straight/flat CUSTOM ORB® sheet in one of the middle valleys and check alignment and squareness of the sheet.
  13. Fastener location to be as detailed
  14. Continue around the structure with FORMFLOW® C90™ corners and straight/flat CUSTOM ORB® sheets following the above process to complete the first layer, ensuring the first layer is aligned and square.
  15. Return to the first layer to finish off the fixing and then proceed to the subsequent layers.
  16. Fastener location to be as detailed.
  17. Consideration to be given to side-lap stitching between supports.
7. Initially fix the first FORMFLOW® C90™ corner in one of the middle valleys and check alignment and squareness of the sheet. The sheet can be fixed off but allowing for the next sheet installation, alternatively the fixing off can be completed once all subsequent sheets are pinned.
  8. Fastener location to be as detailed
  9. Subsequent sheets are to be progressively laid and fixed working up the wall checking for squareness and level. Prior to installing the subsequent sheets consideration need to be given to trimming the short leg.
  10. Commence laying with the first straight/flat CUSTOM ORB® sheet, on the other side of the corner, positioned at the bottom of the wall.
  11. The first straight/flat CUSTOM ORB® sheet is to be laid with the top edge lip projecting inwards, matching the short leg of the FORMFLOW® C90™ corner.
  12. This first straight/flat CUSTOM ORB® sheet to be laid overlap the short leg of the FORMFLOW® C90™ corner, ensuring there is a 50mm spacing from the end of the sheet to the peaks of the corner bend.
  13. Initially fix the first straight/flat CUSTOM ORB® sheet in one of the middle valleys and check alignment and squareness of the sheet. Then fix off the sheet but allowing for the next sheet installation (both vertical sheet and next end-lapping sheet, remembering that the short leg of any FORMFLOW® C90™ corner is to be laid under the straight/flat CUSTOM ORB® sheet). Alternatively, the fixing off can be completed once all subsequent sheets are pinned.
  14. Fastener location to be as detailed.
  15. Subsequent straight/flat CUSTOM ORB® sheets are to be progressively laid and fixed working up the wall checking for squareness and level.
  16. Consideration to be given to side-lap stitching between supports.

### Installation Method B - Traditional Installation Process

This installation process sees one wall fixed prior to proceeding to the next wall. This process lends itself to enabling end-lap sealing if required.

### PREPARATION

1. Design, detail and specify the components of the wall system to address all the relevant requirements of moisture management (vapour control and condensation), ventilation, thermal performance, weather resistance, bushfire protection, vermin entry and the like.
2. Plan and construct the wall in a suitable sequence/order and ensure the correct positioning, securing (fixing), sealing of the components including the insulation, membrane(s), flashings and trims (at toe, around windows & doors, etc.), battens/supports, spacers, etc. During the installation of the battens/supports it is important to ensure they are in the same plane, the plane is plumb, and the face of the supports are flat/square to the plane.

### CLADDING INSTALLATION

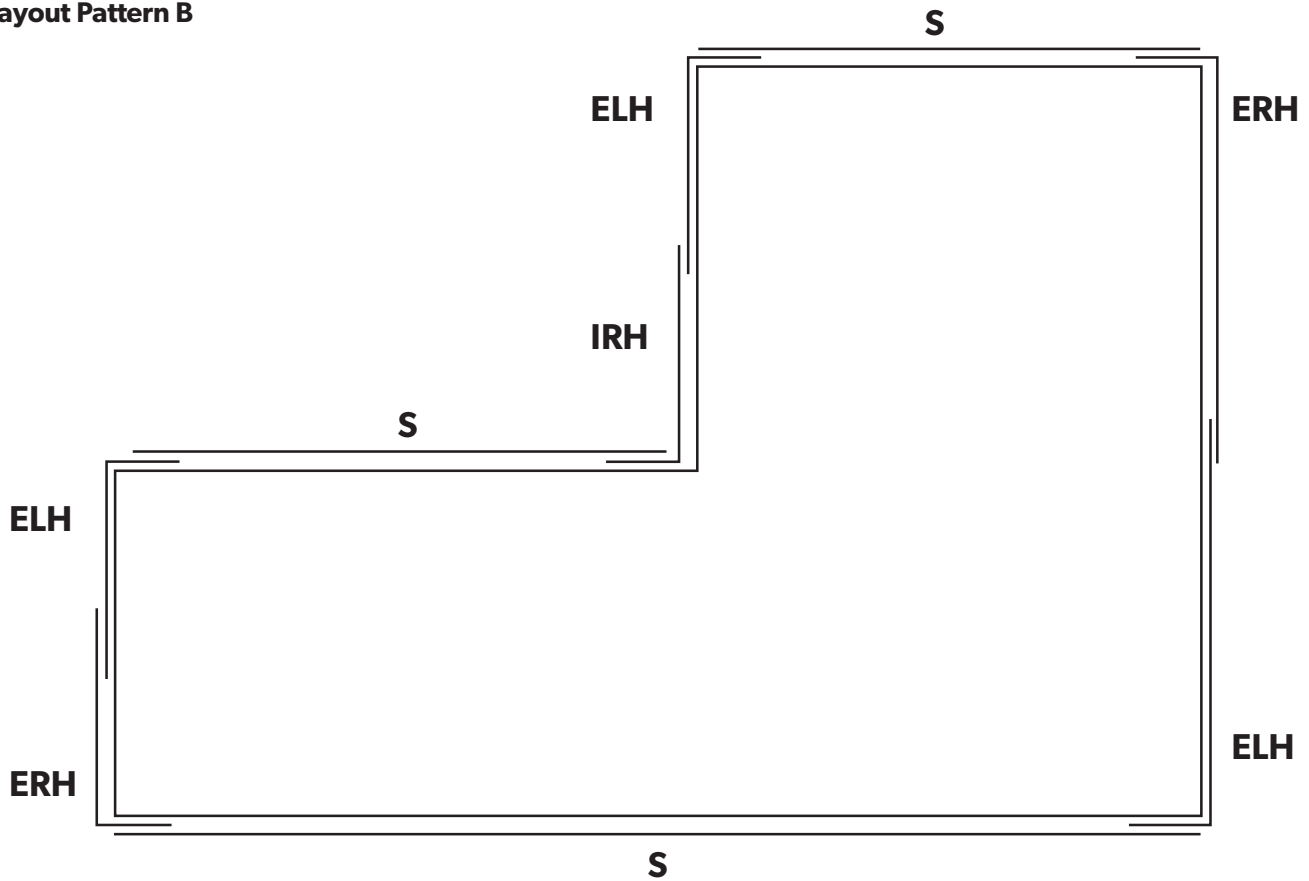
3. Mark the supports to adequately show the alignment of the sheets around all walls to ensure level installation.
4. Always commence installation with a FORMFLOW® C90™ corner.
5. Orient the FORMFLOW® C90™ corners so that the long leg has the top edge lip projecting outwards. Thus, the short leg will have the edge lip projecting inwards.
6. Commence laying with the first FORMFLOW® C90™ corner positioned at the bottom of the wall.

The installer must plan the whole project to ensure that the most appropriate sequence of installation is followed and the appropriate bends are then procured. Below is a simplified plan of a typical L-shaped building, with two possible laying patterns (Layout Pattern A, Layout Pattern B). The laying patterns can vary and would be dependent upon openings (windows, doors), sheet length limits and handleability, and other wall features.

Legend:	
<b>S:</b>	Straight/flat lengths of CUSTOM ORB®
<b>ERH:</b>	FORMFLOW® C90™ External Right Hand Corner
<b>ELH:</b>	FORMFLOW® C90™ External Left Hand Corner
<b>IRH:</b>	FORMFLOW® C90™ Internal Right Hand Corner
<b>ILH:</b>	FORMFLOW® C90™ Internal Left Hand Corner

A diagram showing a stepped profile. The profile consists of a large rectangle on the right and a smaller rectangle on the left. The labels are as follows: 'ERH' at the top left of the large rectangle, 'ELH' at the top right of the large rectangle, 'ILH' at the top right of the small rectangle, 'S' at the bottom left of the large rectangle, 'S' at the bottom right of the large rectangle, 'S' at the bottom left of the small rectangle, and 'S' at the bottom right of the small rectangle.

## Layout Pattern B



## VERTICAL CLADDING

Vertical cladding installation can follow the same process as described above for Installation Method B - Traditional Installation Process, however it may be necessary for some consideration be given to the direction of the prevailing weather.

## SHEET COVERAGE

Width of Installation (m)	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	30	40	50
Number of Sheets	4	6	7	8	10	11	12	14	15	16	18	19	20	21	23	24	25	27	40	53	66

## FASTENERS WITHOUT INSULATION

	<b>Fix to Steel Single &amp; lapped steel thickness ≥0.55 up to 1.0mm BMT</b>	<b>Fix to Steel Single steel thickness ≥1.0mm BMT up to 3.0mm BMT</b>	<b>Fix to Steel Total lapped thickness ≥1.00 BMT up to 3.8mm BMT</b>	<b>Fix to Timber Hardwood J1-J3</b>	<b>Fix to Timber Softwood J4</b>
<b>Crest Fixed</b>	Roof Zips M6-11x50	12-14x35, Metal Tek's HG, HH or AutoTek's M5.5-14x39	12-14x35, Metal Tek's HG, HH or AutoTek's M5.5-14x39	12-11x50, Type 17 HG, HH	12-11x50, Type 17 HG, HH or Roof Zips M6-11x50 HG, HH
<b>Pan Fixed</b>	10-16x16, Metal Tek's, HH or M5-16x25 Designer Head or Roof Zips M6-11x25	10-16x16, Metal Tek's, HH or M5-16x25 Designer Head	10-16x16, Metal Tek's, HH	10-12x25, Type 17, HH M5-16x25 Designer Head or 12-11x25, Type 17, HH	10-12x30, Type 17, HH M5-16x25 Designer Head 12-11x25, Type 17, HH or Roof Zips M6-11x25
<b>Side-laps</b>	(If required) 10-16x16, Metal Tek's, HH or Roof Zips M6-11x25 or M5-16x25 Designer Head or Sealed blind rivet ø4.8mm aluminium				

Notes:

- For other steel thicknesses not specified please seek advice from screw manufacturer.
- Values given are: gauge/threads per inch/ lengths (mm). HH = Hex. Head, WH = Wafer Head, HG = Hi-Grip
- Care is required during installation to prevent stripping of thin material. (Single ply.)
- Screw specification as above or equivalent fastener.
- All screws with EPDM sealing washer.

## **METAL & TIMBER COMPATIBILITY**

Lead, copper, bare steel and green or some chemically treated timbers are not compatible with this product; thus don't allow any contact of the product with those materials, nor discharge of rainwater from them onto the product.

## **CUTTING**

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

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

## **SEALED JOINTS**

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

## **SWARF**

Sweep all metallic swarf and other debris from cladding areas and gutters at the end of each day and at the completion of the installation. Failure to do so can lead to surface staining when the metal particles rust.

## **STORAGE**

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

## **CLEANING**

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

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## PRODUCT DESCRIPTIONS

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