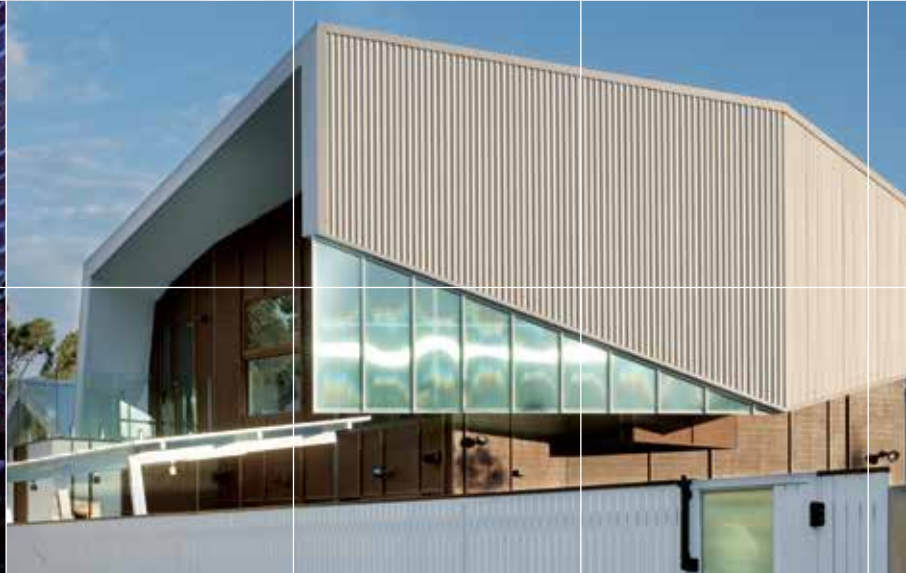
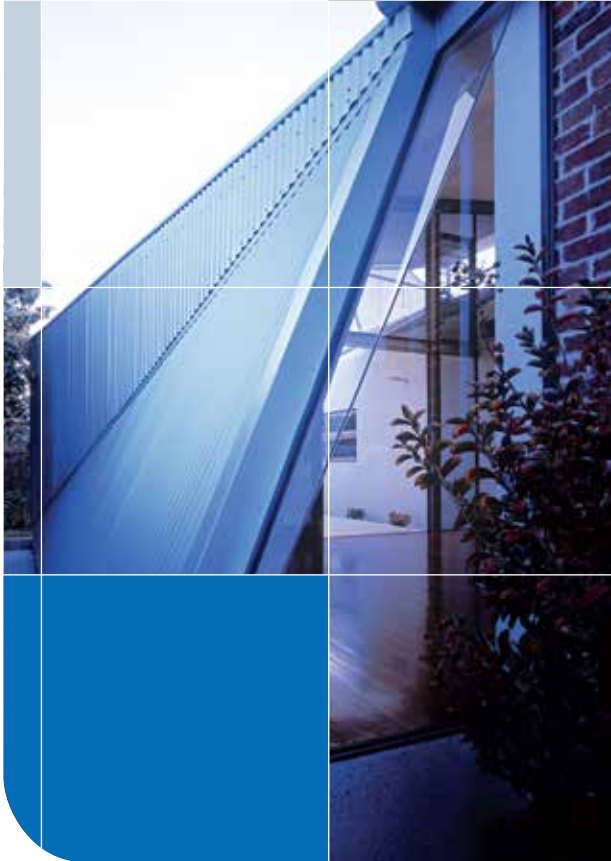


NS BLUESCOPE LYSAGHT MALAYSIA

# LYSAGHT® CUSTOM ORB® CUSTOM BLUE ORB®

Traditional corrugated  
steel cladding



Structural Solutions

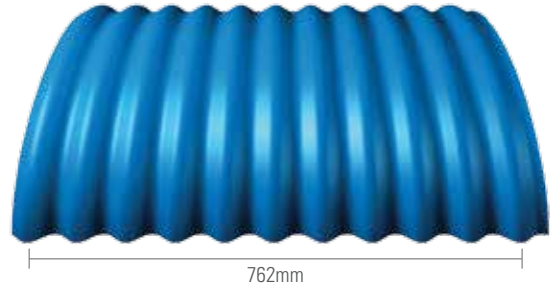


Roofing & Walling Solutions



Truss

# LYSAGHT® CUSTOM ORB® CUSTOM BLUE ORB®



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

## SIMPLE, LOW-COST FIXING

LYSAGHT® CUSTOM ORB® and LYSAGHT® CUSTOM BLUE ORB® can be fixed with hex head screws ensuring fast and simple installation with the recommended side lap (one and half corrugateds).

## CURVING

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

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

## COLOURS

Both LYSAGHT® CUSTOM ORB® and LYSAGHT® CUSTOM BLUE ORB® are available in an attractive range of colours in COLORBOND® pre-painted steel and in unpainted ZINCALUME® aluminium/zinc coated steel.

## MINIMUM ROOF PITCH

A special anti-capillary forming in the lap allow you to use LYSAGHT® CUSTOM ORB® (or LYSAGHT® CUSTOM BLUE ORB® for curved surfaces) for roof pitches as low as 5 degrees (1 in 12).

## RAINFALL CAPACITIES

Peak rainfall intensity mm/hr	Roof slope		
	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

## MASSES

	BMT (mm)	kg/m	kg/m <sup>2</sup>
<b>LYSAGHT® CUSTOM ORB®</b>			
ZINCALUME® steel	0.42	3.26	4.28
	0.48	3.70	4.86
COLORBOND® steel	0.42	3.32	4.35
	0.48	3.76	4.93
<b>LYSAGHT® CUSTOM BLUE ORB®</b>			
ZINCALUME® steel	0.60	4.59	6.02
	0.80	6.06	7.96
COLORBOND® steel	0.60	4.64	6.09
	0.80	6.12	8.03

## MATERIAL SPECIFICATIONS

### LYSAGHT® CUSTOM ORB®

- ZINCALUME® aluminium/zinc alloy-coated steel complying with AS1397:2001 G550, AZ150 (550 mPa minimum yield stress, 150g/m<sup>2</sup> minimum coating mass); or
- Stainless steel standard grade designation is AISI/ASTM Type 430; UNS No. S4300
- COLORBOND® prepainted steel complies with AS/NZS2728:1997.

### LYSAGHT® CUSTOM BLUE ORB®

- ZINCALUME® aluminium/zinc alloy-coated steel complying with AS1397:2001 G300, AZ150 (300 mPa minimum yield stress, 150g/m<sup>2</sup> minimum coating mass);
- COLORBOND® prepainted steel complies with AS/NZS2728:1997.

## LENGTH

Sheets are supplied custom cut.

## TOLERANCES

Length: + 10mm, -10mm

Width: + 4mm, -4mm

**LYSAGHT® CUSTOM ORB®  
MAXIMUM SUPPORT SPACINGS (mm)**

Type of span BMT (mm)	0.42	0.48
<b>Roofs</b>		
Single span	700	800
End span	900	1300
Internal span	1200	1700
Unstiffened eaves overhang	200	250
Stiffened eaves overhang	300	350
<b>Walls</b>		
Single span	1800	1800
End span	2500	2700
Internal span	2700	2700
Overhang	200	250

- For roofs: the data are based on foot-traffic loading.
- For walls: the data are based on pressures (see wind pressures table).
- Table data are based on supports of 1mm BMT.

**MAXIMUM SUPPORT SPACINGS**

The maximum recommended support spacings are based on testing in accordance with AS1562.1-1992, AS4040.1-1992 and AS4040.2-1992.

Roof spans consider both resistance to wind pressure and light roof traffic (traffic arising from incidental maintenance). Wall spans consider resistance to wind pressure only.

The pressure considered is based on buildings up to 10m high in Region B, Terrain Category 3,  $M_s=0.85$ ,  $M_t=1.0$ ,  $M_r=1.0$  with the following assumptions made:

**ROOFS**

$C_{pe}=+0.20$ ,  $C_{pi}=0.90$ ,  $K_f=2.0$  for single and end spans,  $K_f=1.5$  for internal spans.

**WALLS**

$C_{pe}=+0.20$ ,  $C_{pi}=0.65$ ,  $K_f=2.0$  for single spans,  $K_f=1.5$  for internal spans. These spacings may vary by serviceability and strength limit states for particular projects.

**USE LYSAGHT® CUSTOM ORB® FOR LONG STRAIGHT STRETCHES**

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

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

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

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

**CURVING TOLERANCES OF LYSAGHT® CUSTOM BLUE ORB®**

Straight vertical min. (SV) = 100 mm

(80mm in Victoria)

Radius min. (R) = 300 mm

**LYSAGHT® CUSTOM BLUE ORB®  
MAXIMUM SUPPORT SPACINGS (mm)**

Type of span BMT (mm)	0.60	0.80
<b>Roofs including bullnosed roofs</b>		
Single span	1600	1800
End span	1600	1800
Internal span	1800	2600
Unstiffened eaves overhang	200	400
Stiffened eaves overhang	300	600
<b>Walls</b>		
Single span	2400	2400
End span	3000	3200
Internal span	3300	3600
Overhang	200	400

- For roofs: the data are based on foot-traffic loading.
- For walls: the data are based on pressures (see wind pressures table).
- Table data are based on supports of 1mm BMT.

**USE LYSAGHT® CUSTOM BLUE ORB® FOR CURVES**

**CURVING RADII**

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

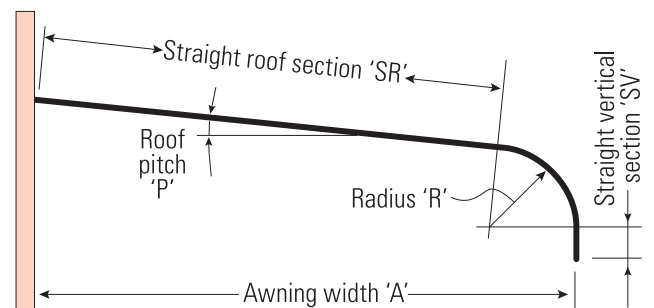
**SPRING CURVE**

The minimum radii for convex spring curving is 9m.

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

Penetrations will alter the flow of water on a roof.

For assistance in design of roofs with penetrations, please seek advice from our information line.



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

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

Span type	Fasteners per sheet per support		Span (mm)							
			600	900	1200	1500	1800	2100	2400	2700
<b>Base metal thickness 0.42 mm</b>										
<b>SINGLE</b>	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	-	-	-
<b>END</b>	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
<b>INTERNAL</b>	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
<b>Base metal thickness 0.48 mm</b>										
<b>SINGLE</b>	3	Serviceability	2.12	1.47	1.03	0.77	0.60	-	-	-
		Strength	12.00	9.80	6.55	5.30	5.10	-	-	-
	5	Serviceability	7.48	3.74	2.23	1.26	0.57	-	-	-
		Strength	12.00	12.00	10.75	8.65	8.10	-	-	-
<b>END</b>	3	Serviceability	1.92	1.66	1.48	1.35	1.19	1.01	0.81	0.60
		Strength	11.70	9.05	6.80	4.95	4.10	3.45	3.00	2.65
	5	Serviceability	8.00	4.75	2.86	1.97	1.39	0.97	0.66	0.44
		Strength	12.00	12.00	12.00	10.60	8.00	6.20	5.00	4.25
<b>INTERNAL</b>	3	Serviceability	1.98	1.96	1.84	1.62	1.36	1.07	0.82	0.62
		Strength	12.00	10.15	8.50	7.10	5.70	4.55	3.60	2.90
	5	Serviceability	9.00	5.42	4.34	3.31	2.37	1.57	0.95	0.54
		Strength	12.00	12.00	12.00	12.00	11.00	8.65	6.75	5.25

Supports must be not less than 1 mm BMT.

**LIMIT STATES WIND PRESSURE**

LYSAGHT® CUSTOM ORB® offers the full benefits of the latest methods for modelling wind pressures. The wind pressure capacity table is determined by full scale tests conducted at BlueScope Lysaght's NATA-registered testing laboratory, using the direct pressure-testing rig.

Testing was conducted in accordance with AS 1562.1–1992 Design and Installation of Sheet Roof and Wall Cladding–Metal, and AS 4040.2–1992 Resistance to Wind Pressure for Non-cyclonic Regions.

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

The pressure capacities for strength have been determined by testing the cladding to failure (ultimate capacity). These pressures are applicable when the cladding is fixed to a minimum of 1.0mm, G550 steel. For material less than 1.0mm thick, seek advice from our information line.

**WALKING ON ROOFS**

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

**ADVERSE CONDITIONS**

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

**METAL & TIMBER COMPATIBILITY**

Lead, copper, bare steel and green or some chemically-treated timber are not compatible with this product; thus do not allow any contact of the product with those materials, nor discharge of rainwater from them onto the product. If there are doubts about the compatibility of products being used, ask for advice from our information line.

**MAINTENANCE**

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.

**STORAGE AND HANDLING**

Handling Safety - LYSAGHT® product may be sharp and heavy.

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

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

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

**CUTTING**

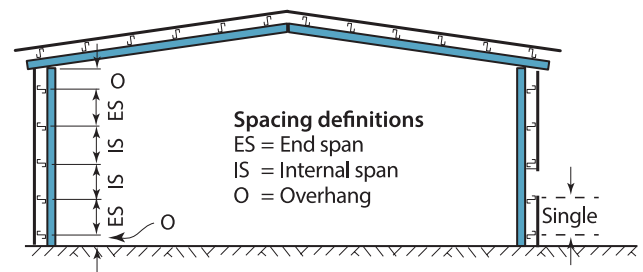
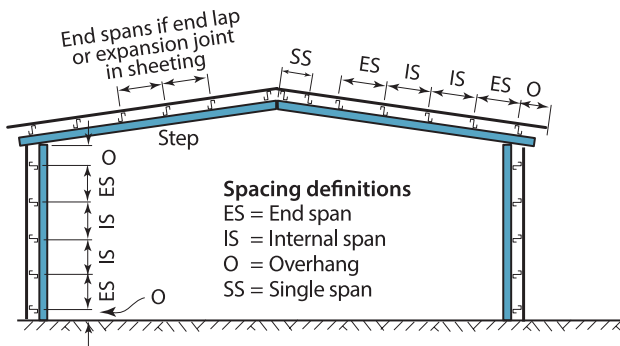
For cutting thin metal on site, we recommend a circular saw with a metal-cutting blade because it produces fewer damaging hot metal particles and leaves less resultant burr than does a carbonrundry disc.

Cut materials over the ground and not over materials.

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

Span type	Fasteners per sheet per support		Span (mm)										
			600	900	1200	1500	1800	2100	2400	2700	3000	3300	3600
<b>Base metal thickness 0.6 mm</b>													
<b>SINGLE</b>	3	Serviceability	3.32	2.58	1.94	1.48	1.08	0.73	0.39	-	-	-	-
		Strength	12.00	10.55	7.25	5.85	5.05	4.55	4.30	-	-	-	-
	5	Serviceability	10.50	6.03	2.62	1.30	0.62	0.36	0.32	-	-	-	-
		Strength	12.00	12.00	12.00	10.00	8.35	7.25	6.35	-	-	-	-
<b>END</b>	3	Serviceability	2.85	2.41	1.99	1.62	1.29	1.01	0.78	0.58	0.41	0.26	-
		Strength	12.00	12.00	0.10	6.75	5.25	3.60	4.05	3.60	3.15	2.70	-
	5	Serviceability	11.00	7.72	4.80	2.62	1.40	0.89	0.73	0.58	0.41	0.23	-
		Strength	12.00	12.00	12.00	9.05	7.35	6.55	6.20	5.70	5.05	4.30	-
<b>INTERNAL</b>	3	Serviceability	3.05	2.55	2.11	1.75	1.48	1.25	1.05	0.84	0.63	0.42	0.21
		Strength	12.00	12.00	9.15	6.80	5.65	5.15	4.95	4.55	4.00	3.30	2.60
	5	Serviceability	10.94	7.43	4.51	2.59	1.55	1.07	0.88	0.72	0.54	0.37	0.19
		Strength	12.00	12.00	12.00	9.95	8.30	7.70	7.45	7.00	6.25	5.35	4.40
<b>Base metal thickness 0.8 mm</b>													
<b>SINGLE</b>	3	Serviceability	5.26	3.92	2.80	2.08	1.49	0.99	0.53	-	-	-	-
		Strength	12.00	12.00	9.15	7.45	6.30	5.50	4.95	-	-	-	-
	5	Serviceability	12.00	8.63	3.44	1.54	0.64	0.40	0.50	-	-	-	-
		Strength	12.00	12.00	12.00	11.50	9.70	8.55	7.70	-	-	-	-
<b>END</b>	3	Serviceability	5.91	4.61	3.43	2.46	1.77	1.31	1.00	0.75	0.54	0.36	-
		Strength	12.00	12.00	11.50	8.55	6.80	6.00	5.45	4.80	4.00	3.15	-
	5	Serviceability	12.00	9.67	5.86	3.06	1.60	1.10	1.01	0.86	0.62	0.33	-
		Strength	12.00	12.00	12.00	12.00	9.85	8.80	8.25	7.00	6.20	4.85	-
<b>INTERNAL</b>	3	Serviceability	5.49	4.53	3.66	2.94	2.38	1.93	1.56	1.24	0.96	0.70	0.46
		Strength	12.00	12.00	12.00	9.00	7.25	6.35	5.85	5.25	4.65	3.95	3.20
	5	Serviceability	12.00	12.00	6.86	3.23	1.61	1.45	1.37	1.36	1.15	0.80	0.40
		Strength	12.00	12.00	12.00	12.00	12.00	10.45	9.05	7.40	6.30	5.65	5.20

Supports must be not less than 1 mm BMT.



# Installation

## FASTENERS WITHOUT INSULATION

	Fix to Steel Single & lapped steel thickness ≥0.55 up to 1.0mm BMT	Fix to Steel Single thickness steel ≥1.0mm BMT up to 3.0mm BMT	Fix to Steel Total lapped thickness of ≥1.0mm BMT up to 3.8mm BMT	Fix to Timber Hardwood J1-J3	Fix to Timber Softwood J4
<b>Crest Fixed</b>	RoofZips 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 RoofZips M6-11x50 HG, HH
<b>Pan Fixed</b>	10-16x16, Metal Tek's, HH or M5-16x25 Designer Head RoofZips 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 12-11x25, Type 17, HH	10-12x30, Type 17, HH 12-11x25, Type 17, HH M5-16x25 Designer Head or RoofZips 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: 1) For other steel thickness not specified please seek advice from screw manufacturer.  
2) Values given are: gauge/threads per inch/lengths (mm), HH = Hex. Head, WH = Wafer Head, HG = Hi-Grip  
3) Care is required during installation to prevent stripping of thin material. (Single ply.)  
4) Screw specification as above or equivalent fastener.  
5) All screws with EPDM sealing washer.

Crest: 3 fasteners†



Valley: 3 fasteners†



Crest: 5 fasteners†



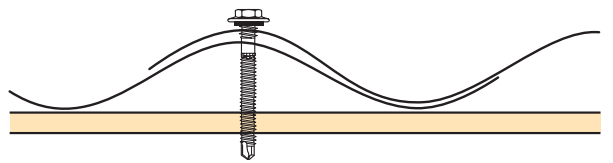
Valley: 5 fasteners†



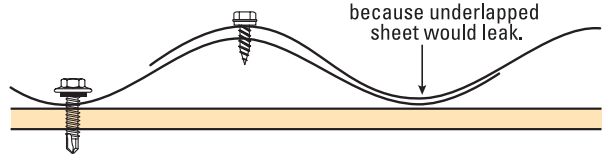
† Fasteners per sheet per support.

Most common practice is: 3 fasteners for internal spans and 5 fasteners for single and end spans.

Crest fixing for roof or walls



Valley fixing for walls only



### FASTENING SHEETS TO SUPPORTS

LYSAGHT® CUSTOM ORB® and LYSAGHT® CUSTOM BLUE ORB® 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 the crests. For walling, you may use either crest or valley-fixing.

Always drive the screws perpendicular to the sheeting, and in the centre of the corrugation or rib.

Do not place fasteners less than 25 mm from the ends of sheets.

### SIDE-LAPS

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

### END LAPPING

End-laps are not usually necessary because LYSAGHT® CUSTOM ORB® and LYSAGHT® CUSTOM BLUE ORB® are available in long lengths.

If you want end-laps, seek advice from our information line on the sequence of laying and the amount of overlap.

If you intend to end-lap LYSAGHT® CUSTOM ORB® and LYSAGHT® CUSTOM BLUE ORB®, order the sheets at the same time and tell us you intend to lap them, to ensure a good fit of the profiles.

### ENDS OF SHEETS

It is usual to allow sheets to overlap into gutters by about 50 mm. The valleys of sheets should be tuned-down at lower ends, and turned-up at upper ends.

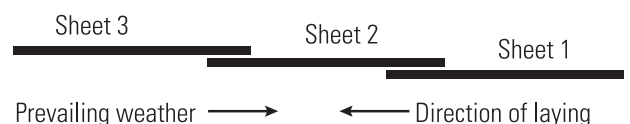
### LAYING PROCEDURE

For maximum weather-tightness, start laying sheets from the end of the building that will be in the lee of the worst-anticipated or prevailing weather.

Lay sheets toward prevailing weather. Also, it is much easier and safer to turn sheets on the ground than up on the roof.

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

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





COLORBOND® steel



ZINCALUME® steel

## ZINCALUME® steel and COLORBOND® steel

Strong brands, quality materials

LYSAGHT® PRODUCTS ARE MANUFACTURED FROM HIGH QUALITY ZINCALUME® STEEL AND COLORBOND® STEEL, WHICH ARE LEADING BRANDS WITH A WIDE RANGE OF APPLICATIONS. THESE PRODUCTS HAVE BEEN USED WITH STRIKING EFFECT BY LEADING ARCHITECTS TO CREATE THE LATEST IN MODERN BUILDING DESIGNS, THROUGH TO CLASSIC ROOFING STYLES FOR RESIDENTIAL PROJECTS.

### Zincalume®

ZINCALUME® steel is a premium metallic coated steel product that is composed of 55% aluminium, 43.5% zinc and 1.5% silicon. The zinc/aluminium alloy coating on ZINCALUME® steel imparts corrosion resistance of up to four times the life of galvanised steel.

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

Typical applications featuring ZINCALUME® steel include roofing, wall cladding and gutters.

#### Product Attributes

- Durable and strong.
- Superior corrosion resistance and has an excellent combination of physical and cut edge protection.
- Lightweight for easy handling.
- Thermally efficient roofing.
- Excellent flexibility in design, can be curved, for truly individual designs.
- Weather tight and secure when installed to manufacturer's specifications.
- Clear resin coating resists scuffing and handling marks.

\*Warranty terms and conditions apply

### Colorbond®

COLORBOND® pre-painted steel combines the superior strength of steel, the corrosion resistance and protection of a zinc/aluminium alloy (ZINCALUME® steel) coating that maintain its long lasting beauty with excellent colour retention.

It has been developed as a "Defence System Against Tropical Staining." Its unique oven-cured paint system prevents surface staining common to tropical environments caused mainly by temperature, moisture and air-borne contaminants.

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

#### Product Attributes

- Available in a range of attractive colours.
- The zinc/aluminium alloy coating on ZINCALUME® steel, plus the oven-baked, prepainted finish on COLORBOND® steel provide superior corrosion resistance for long life.
- Thermally efficient. Roofs made from COLORBOND® steel absorb less heat, thus cools very quickly.
- Light weight compared to concrete and clay tiles (on a per area basis) - reduced load on supporting structures.
- Excellent flexibility in design, can be curved, for truly individual designs.
- Flexibility of design allows for both traditional straight roof sheeting as well as innovative curved roofing designs.
- Resists cracking, chipping and peeling.

LEAD, COPPER and STAINLESS STEEL are not compatible with COLORBOND® steel and ZINCALUME® steel. Direct contact should therefore, be avoided. Where inside condensation conditions are likely, coated steel girts should be used so that any ZINCALUME® steel to bare steel contact is avoided.

Stainless steel fasteners are not recommended for ZINCALUME® and COLORBOND® steel.



# Trusted Partner for Building Systems

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SELANGOR DARUL EHSAN, MALAYSIA.  
**TEL: +603-5520 6600 FAX: +603-5520 6601/02**

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