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**Metal and Wood Composite Framing Members for Residential and Light Commercial Construction (DIV E)**

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Metal and wood composites are used to create framing members (studs and tracks, joists and bands, rafters, headers and the like) for lightweight construction. Metal is utilized for its high strength, resistance to rot and insects, cost stability, and potentially lower cost through recycling. Metal that can be used includes roll formed steel approximately 18-22 gauge. Wood is used primarily for its lower thermal conductivity, and availability. The metal components form the primary structure while wood, either solid or other engineered wood, provides some structure and a thermal break. The invention connects J-shaped or triangular shaped metal forms to wood sections. The metal flange ends can have various J, C, L, right triangular, triangular, T and straight line cross-sectional shapes. The wood is fastened to the metal by machine pressing of the metal to wood. Alternatively the fastening includes nails, staples, screws, and the like, and also by adhesive glue. The outward faces of the metal members are pre-formed with four longitudinal ridges such that the contact surface area to applied sheathing is reduced by about 90%. 

5 Claims, 7 Drawing Sheets
Fig. 7
METAL AND WOOD COMPOSITE FRAMING MEMBERS FOR RESIDENTIAL AND LIGHT COMMERCIAL CONSTRUCTION

This is a divisional of application Ser. No. 08/664,442 filed Jun. 21, 1996.

This invention relates to composite framing members, more specifically to studs and tracks, joists and bands, headers, and rafters formed from wood and metal composites.

BACKGROUND AND PRIOR ART

Residential and light commercial construction generally use wood as the primary building material for studs, plates, joists, headers and trusses. However, all-wood construction has problems. The rapidly rising cost of raw wood supplies has in effect substantially raised the cost of these members. Further, the quality of available framing lumber continues to decline. Finally, wood is flammable and susceptible to insects and rot.

Due to these problems, many builders have been switching to using all steel framing. The cost savings from using wood or steel framing is getting closer. In January 1990, the cost of framing lumber was about $225 per thousand board feet, peaking to highs of $500 in both January, 1993 and January 1994. Since June 1995, the framing lumber composite price has risen from $300 per thousand board feet. Estimates from the AISI and NAHB Research Center state at a framing lumber cost of $340 to $385, there would be no difference between the cost of framing a house in steel as compared to wood. Thus, the break-even point between wood and steel framing is at about $360 per thousand board feet of framing lumber, and the lumber price has exceeded that point several times in recent years by as much as 40%, giving steel a competitive advantage.

Recycling has additionally helped the cost of steel to remain on a stable or downward trend. Steel costs have varied little in recent years. Traditionally, variations can be correlated to steel demand by the automobile industry when demand is high, steel usually increases slightly in price. Consequently, the use of metal framing in residential and light commercial construction is increasing, a trend recognized and encouraged by the American Iron and Steel Institute (AISI).

All steel studs, tracks and trusses are being manufactured by Tri-Chord, HL Stud Corporation, Truswall Systems, Techbuilt Manufacturing, Knudson Manufacturing, John McDonald, and MiTek Ultra-Span Systems.

A problem with using all steel framing is its high thermal conductivity, leading to thermal bridging, "ghosting", and greater potential for water vapor condensation on interior wall surfaces. "Ghosting" is when an unsightly streak of dust accumulates on the interior wallboard, where the steel studs lie behind, due to an acceleration of dust particles toward the colder surface. Another problem of using all steel framing is the increased energy use for space conditioning (heating and cooling). Metal used for exterior framing members allows greater conduction heat transfer between the outside and inside surfaces of a wall, roof or floor. In colder climates, this increased conduction can cause condensation in interior surfaces, contributing to material degradation and mold and mildew growth. Metal framing also decreases the effectiveness of insulation installed in the cavity between the metal framing due to increased three-dimensional thermal shorting effects. Higher sound transmission is another disadvantage of metal framing since sound conductivity is greater in metal than in wood. Electricians have more difficulty working with all steel framing when running holes for wiring since metal is more difficult to drill than wood, and grommets or conduits must be used to protect the wires.

U.S. Pat. No. 5,285,615 to Gilmour describes a thermal metallic building stud. However, the Gilmour member is entirely formed from metal. In Gilmour, the thermal conductivity is only partially reduced by having raised dimples on the ends contacting other building materials.

U.S. Pat. No. 3,960,637 to Ostrow describes impractical wood and metal composites. Ostrow requires each end flange have tapered channels, the end flanges being formed from extruded aluminum, molded plastic and fiberglass. Ends of the vertical web must be fit and pressed into a tapered channel. Besides the difficulty of aligning these parts together, other inherent problems exist. Extruding the channel flanges from aluminum or using molds, cuts and rolling to create the channelled plastic and fiberglass end flanges is expensive to manufacture. To stabilize the structures, Ostrow describes additional labor and manufacturing costs of gluing members together and sandwiching mounting blocks on the outsides of each channel.

Other metal and wood framing member patents of related but less significant interest include: U.S. Pat. No. 5,454,850 to Taylor; U.S. Pat. No. 5,440,848 to Deffet; U.S. Pat. No. 5,072,547 to DiFazio; U.S. Pat. No. 4,875,316 to Johnston; U.S. Pat. No. 4,301,635 to Neufeld; U.S. Pat. No. 4,274,241 to Lindal; U.S. Pat. No. 4,031,686 to Sanford; and U.S. Pat. No. 3,531,901 to Meechan.

SUMMARY OF THE INVENTION

The first object of the present invention is to provide a metal/wood composite wall stud that increases the total thermal resistance of a typical steel framed insulated wall section by some 43 percent and would eliminate interior condensation and "ghosting" for all but the coldest regions of the United States.

The second object of this invention is to provide a wood and metal composite framing combinations that achieve a resource efficient and economic construction framing member. Metal is used for its high strength, and potentially lower cost and resource efficiency through recycling. Wood is used primarily for its lower thermal conductivity and for its availability as a renewable resource, and for its workability.

The third object of this invention is to provide a wood and metal composite framing member that would be easy to manufacture.

The fourth object of this invention is to provide a wood and metal composite framing member that would be easy to manufacture.

The fifth object of this invention is to provide a wood and metal composite framing member that has low sound conductivity compared to prior art steel framing members.

The sixth object of this invention is to provide a wood and metal composite framing member that has reduced effects from flammability compared to all wood members.

The invention includes J-shaped, L-shaped, triangular shaped cross-sectional metal forms (plate legs) connected by a wood midsections, whereby the wood is fastened to the metal by machine pressing of the metal to wood, similar to the common truss plate, or by nails, staples, screws, or other mechanical fastening means, or by adhesive glue. The outward faces of the metal members are pre-formed with four longitudinal ridges such that the contact surface area to applied sheathing is reduced by about 90%.
Metal and wood composites are used to create framing members (studs and tracks, joists and bands, headers, rafters, and the like) for light-weight construction. Metal is utilized for its high strength, resistance to rot and insects, cost stability, and potentially lower cost through recycling. Wood is used primarily for its lower thermal conductivity, and availability. The metal components form the primary structure while wood, either solid or other engineered wood, provides some structure and a thermal break. The metal used can be steel of approximately 18 to approximately 22 gauge.

Metal/wood composite framing members can be used in place of conventional wood framing members such as: 2x4 and 2x6 wall studs, and 2x8, 2x10, 2x12 and other dimensions of roof rafters, floor joists and headers. The novel framing members can be used to replace conventional light-gauge steel framing to reduce thermal transmittance and sound transmission.

Further objects and advantages of this invention will be apparent from the following detailed description of a presently preferred embodiment which is illustrated schematically in the accompanying drawings.

BRIEF DESCRIPTION OF THE FIGURES

FIG. 1A is a perspective isometric view of a first preferred embodiment metal/wood stud.

FIG. 1B is a cross-sectional view of the embodiment of FIG. 1A along arrow AA.

FIG. 2A is a perspective isometric view of a second preferred embodiment metal/wood stud.

FIG. 2B is a cross-sectional view of the embodiment of FIG. 2A along arrow BB.

FIG. 3A is a perspective isometric view of a third preferred embodiment metal/wood stud.

FIG. 3B is a cross-sectional view of the embodiment of FIG. 3A along arrow CC.

FIG. 4A is a perspective isometric view of a fourth preferred embodiment metal/wood joist, rafter and header.

FIG. 4B is a cross-sectional view of the embodiment of FIG. 4A along arrow DD.

FIG. 5A is a top perspective view of a fifth embodiment track for metal/wood stud systems.

FIG. 5B is a bottom perspective view of the embodiment of FIG. 5A along arrow EL.

FIG. 5C is a cross-sectional view of the embodiment of FIG. 5B along arrow EE.

FIG. 6A is a perspective view of a sixth preferred embodiment metal/wood stud.

FIG. 6B is a cross-sectional view of the embodiment of FIG. 6A along arrow FF.

FIG. 7 cross-sectional view a framing system utilizing the embodiments of FIGS. 1A-6B.

DESCRIPTION OF THE PREFERRED EMBODIMENT

Before explaining the disclosed embodiment of the present invention in detail it is to be understood that the invention is not limited in its application to the details of the particular arrangement shown since the invention is capable of other embodiments. Also, the terminology used herein is for the purpose of description and not of limitation.

The preferred method of calculating thermal transmittance for building assemblies with integral steel is the zone method published by the American Society of Heating Refrigeration and Air-Conditioning Engineers (ASHRAE). A recent study by the National Association of Home Builders Research Center and Oak Ridge National Laboratory verified the usefulness of the zone method for calculating thermal transmittance for light gauge steel walls.

Thermal transmittance calculations were completed using the zone method for the metal/wood stud invention embodiments. Table 1 shows a comparison of thermal transmittance (given as total R-value) for nine wall configurations. The first wall listed is a conventional 2x4 wood frame wall with ½" plywood sheathing and R-11 fiberglass cavity insulation. The total wall R-value is 13.2 hr-F-ft²/Btu. the second and third walls listed are conventional metal stud walls, one with ½" plywood sheathing (R-7.9) and the other with ½" extruded polystyrene sheathing (R-11.4). With conventional metal studs, high resistivity insulated sheathing is necessary to limit the large loss of total thermal resistance when low resistivity sheathings are used. In some cases, it is not desirable to use the non-structural insulated sheathing, such as when brick ties are needed, or when higher racking resistance is needed.

In comparison, the metal/wood stud walls corresponding to those described in the subject invention has a 43 percent greater total R-value than the conventional stud wall when using plywood sheathing. Thermal performance of the metal/wood stud wall with plywood sheathing is nearly the same as the conventional wall with ½" extruded polystyrene (XPS insulated sheathing). Where non-structural sheathing is acceptable, fiber board sheathing, which is much less expensive than plywood, further increases the total R-value of the metal/wood stud wall.

TABLE 1

<table>
<thead>
<tr>
<th>Description</th>
<th>Stud Size Inch</th>
<th>Stud Spacing O.C. Inch</th>
<th>Cavity Insulation</th>
<th>Exterior Sheathing</th>
<th>Total R-Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Conventional stud,*</td>
<td>1.625 x 3.625</td>
<td>24</td>
<td>R-11 ½&quot; plywood</td>
<td>7.9</td>
<td></td>
</tr>
<tr>
<td>2. Conventional metal stud,*</td>
<td>1.625 x 3.625</td>
<td>24</td>
<td>R-11 ½&quot; XPS</td>
<td>11.4</td>
<td></td>
</tr>
<tr>
<td>3. Novel metal/wood stud,</td>
<td>1.5 x 3.5</td>
<td>24</td>
<td>R-11 ½&quot; plywood</td>
<td>11.3</td>
<td></td>
</tr>
<tr>
<td>4. Novel metal/wood stud</td>
<td>1.5 x 3.5</td>
<td>24</td>
<td>R-13 ½&quot; plywood</td>
<td>12.8</td>
<td></td>
</tr>
<tr>
<td>5. Novel metal/wood stud</td>
<td>1.5 x 3.5</td>
<td>24</td>
<td>R-15 ½&quot; plywood</td>
<td>14.2</td>
<td></td>
</tr>
<tr>
<td>6. Novel metal/wood stud</td>
<td>1.5 x 3.5</td>
<td>24</td>
<td>R-15 ½&quot; fiber board</td>
<td>12.1</td>
<td></td>
</tr>
<tr>
<td>7. Novel metal/wood stud</td>
<td>1.5 x 3.5</td>
<td>24</td>
<td>R-15 ½&quot; fiber board</td>
<td>13.6</td>
<td></td>
</tr>
<tr>
<td>8. Novel metal/wood stud</td>
<td>1.5 x 3.5</td>
<td>24</td>
<td>R-15 ½&quot; fiber board</td>
<td>15.0</td>
<td></td>
</tr>
</tbody>
</table>
Summary calculation results compared the allowable axial load for stud elements subjected to combined loading with axial and bending components. The three elements analyzed were a conventional 2x4 wood, a conventional 20 gauge steel stud, and the present invention metal/wood composite stud. All elements were 8' tall, and spaced 16' O.C. Wind (transverse) load at 110 mph. Table 2 shows that the metal/wood composite section can support 54% more weight than the metal stud, and 250% more weight than the wood stud. This gives the opportunity for further cost optimization by increasing the spacing which would reduce the number of studs required, or for reducing the amount of steel used in the composite section.

**TABLE 2**

<table>
<thead>
<tr>
<th>Description</th>
<th>Stud Size</th>
<th>Stud Spacing</th>
<th>Cavity Insulation</th>
<th>Exterior Sheathing</th>
<th>Total Load</th>
<th>R-Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Allowable Axial</td>
<td>2 x 4 Wood Stud</td>
<td>3.5&quot; 20 Gauge</td>
<td>Metal Stud</td>
<td>Composite Section</td>
<td>551 lb</td>
<td>804 lb</td>
</tr>
<tr>
<td>8' tall stud</td>
<td>16&quot; O.C.</td>
<td>0.75&quot;</td>
<td>1.125 inches</td>
<td>1.1625 inches</td>
<td>1 inch</td>
<td>0.75</td>
</tr>
</tbody>
</table>

FIG. 1A is a perspective isometric view of a first preferred embodiment metal/wood stud 100. FIG. 1B is a cross-sectional view of the embodiment 100 of FIG. 1A along arrow AA. Referring to FIGS. 1A-1B, embodiment 100 includes metal forms 110, 120 such as but not limited to 20 gauge steel that has been cold-formed into a cross-sectional channel J-shape. Each form 110, 120 includes steel web portions 112, 122 that have staggered rows of raised V-shaped grooves 117, 127 running longitudinally along the exterior of the flanges 116, 126. Flange returns 118, 128 are perpendicular to flanges 116, 126. Teeth 115, 125 can be hydraulically pressed adjacent the top and bottom rear side 152 of central web board 150. Central web board 150 can be solid wood, OSB, plywood and the like, having a thickness of approximately ½ an inch. Alternatively, web portions 112, 122 of forms 110, 120 can be fastened to the central web board 150 by nails, screws, staples and the like. Metal web portions 112, 122, 118, 128 can be fastened to the central web board 150 by nails, screws, staples and the like. Metal web portions 112, 122, 118, 128 can have a height, B1 of approximately 1.1625 inches, flanges 114, 124 can have a width, B2 of approximately 1.5 inches, flange returns 116, 126 can have a height, B3 of approximately 0.925 inches and inner web portions 112, 122 can have a height, B4 of approximately 1 inch. A finished metal/wood stud 200 can have the remaining dimensions and spacings similar to the embodiment 100 previously described, except height, B5 can be approximately 5.5 to approximately 7.25 inches.

FIG. 3A is a perspective isometric view of a third preferred embodiment metal/wood stud 300. FIG. 3B is a cross-sectional view of the embodiment 300 of FIG. 3A along arrow CC. Referring to FIGS. 3A-3B, embodiment 300 includes metal forms 310, 320 such as but not limited to 20 gauge steel that has been roll pressed into a cross-sectional channel right-triangular-shape. Each form 310, 320 includes outer web portions 312, 322 that have staggered rows of cut-out portions 313, 323 which are of a pressed tooth type triangular shape. Outer web portions 312, 322 are perpendicular to flanges 314, 324 which include approximately 4 rows of raised V-shaped grooves 315, 325 running longitudinally along their exterior surface. Flange returns 316, 326 are approximately 45 degrees to flanges 314, 324, and are connected to inner web portions 318, 328 each having staggered rows of cut-out portions 319, 329 which also are of the pressed tooth type triangular shape. Teeth 313, 319 and 323, 329 can be firmly pressed adjacent the top and bottom of central web board 350. Central web board 350 can be solid wood, OSB, plywood and the like, having a thickness of approximately ½ an inch. Alternatively, web portions 312, 318, 322, 328 can be fastened to the central web board 350 by nails, screws, staples and the like. Outer web portions 312, 322 can have a height, B1 of approximately 1.1625 inches, flanges 314, 324 can have a width, B2 of approximately 1.5 inches, flange returns 316, 326 can have a height, B3 of approximately 0.925 inches and inner web portions 312, 322 can have a height, B4 of approximately 1 inch. A finished metal/wood stud 300 can have the remaining dimensions and spacings similar to the embodiment 100 previously described, except height, B5 can be approximately 5.5 to approximately 7.25 inches.

**TABLE 1-continued**

<table>
<thead>
<tr>
<th>Description</th>
<th>Stud Size</th>
<th>Stud Spacing</th>
<th>Cavity Insulation</th>
<th>Exterior Sheathing</th>
<th>Total R-Value</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Structural calculation results compared the allowable axial load for stud elements subjected to combined loading with axial and bending components.</strong></td>
<td>200</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Summary calculation results compared the allowable axial load for stud elements subjected to combined loading with axial and bending components. The three elements analyzed were a conventional 2x4 wood, a conventional 20 gauge steel stud, and the present invention metal/wood composite stud. All elements were 8' tall, and spaced 16' O.C. Wind (transverse) load at 110 mph. Table 2 shows that the metal/wood composite section can support 54% more weight than the metal stud, and 250% more weight than the wood stud. This gives the opportunity for further cost optimization by increasing the spacing which would reduce the number of studs required, or for reducing the amount of steel used in the composite section.</strong></td>
<td>200</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
Form 610 further includes an upright leg 614 having a length F2 of approximately 1.3 inches, perpendicular to a third leg 616, having a length F3 of approximately 1.25 inches, which abuts against and overlaps top end 652 of centerboard 650. Lower metal form 620 has a metal web portion 622 having tooth shaped triangular cut-outs 623 which are pressed into upper end sides of wood center board 650, and a continuous extended plate 624. The continuous width F4 of metal plate 622, 624 is approximately 1.75 inches, with plate 624 extending a length F5 of approximately 0.75 inches from the lower end 654 of center-web-board 650, having thickness of approximately 0.5 inches. A finished embodiment 600 can have a width F6 and length L3 similar to embodiment 400.

FIG. 7 is a cross-sectional view a framing system 700 utilizing the embodiments of FIGS. 1A–6B. Embodiment 700 can be a two story building having a metal/wood bottom track 500 attached at floor 702 by conventional fasteners such as nails, screws, bolts and the like. Vertically oriented metal/wood studs 100/200/300 can be attached to floor and ceiling tracks 500 by steel framing screws 715 and the like. A metal/wood band 600 attaches first floor ceiling track 500 to metal/wood floor joist 400 and subfloor 710, which has conventional steel framing flathead type screws 716 and the like. The second floor has a similar arrangement with rafters 400 attached at conventional angles to upper metal/wood top track 500.

A cost of a metal/wood composite stud such as those described in the previous embodiment 100 is estimated to be $4.24. The lowest cost of conventional 20 gauge steel studs is $2.52 each, however, to obtain the same thermal performance, an insulated sheathing is required which raises the cost to $4.55 per stud. The metal/wood framing member’s invention is directly cost effective compared to the conventional metal stud. In addition, structural calculations show that the metal/wood stud configuration can support 54% more weight at the same 8’ wall height, 16” O.C. spacing, and 110 mph wind load. This give opportunity for further cost optimization by increasing the spacing which would reduce the number of studs required. For example, a 2000 square foot house framed 16” O.C. will have about 168 conventional steel exterior wall studs, the same house framed 24” O.C. with the stronger metal/wood composite exterior wall studs will use only 107 studs. With 61 fewer exterior wall studs required, the builder can save about $270.

While the invention has been described, disclosed, illustrated, and shown in various terms of certain embodiments or modifications which it has presumed in practice, the scope of the invention is not intended to be, nor should it be deemed to be, limited thereby and such other modifications or embodiments as may be suggested by the teachings herein are particularly reserved especially as they fall within the breathed and scope of the claims here appended. For the claims, the invention will be described as having all metal portions including the forms to be referred to as flanges, and all mid wood portions will be referred to as wood web members.

I claim:

1. A stud-track member formed from mixed composite materials which is used for residential and light commercial construction, the stud-track member comprises:

   a substantially elongated web member having a first long side, a second long side opposite the first long side, a top end and a bottom end, a first face and a second face opposite the first face, the web member formed from a first material;

   a first L-shaped form connected to the first long side of the web member, the first L-shaped form having a flange...
space apart from the first long side of the web member, and a web portion adapted to connect the flange to the first face of the web member, and a second L-shaped form connected to the second long side of the web member, the second L-shaped form having a flange spaced apart from the second long side of the web member, and a web portion adapted to connect the flange to the first face of the web member, the first L-shaped form and the second L-shaped form are formed from a second material, so that the first material and the second material are dissimilar from one another, wherein the stud-track member has increased thermal resistance over single metal stud-track members and greater axial load capability over single wood stud-track members, and which reduces interior condensation and ghosting.

2. The stud-track member of claim 1, wherein the first material of the web member is formed from wood, and the second material of the first L-shaped form and the second L-shaped form are both formed from metal.

3. The stud-track member of claim 1, wherein the connecting web portion of each of the L-shaped forms have a height greater than a thickness of the web member.

4. The stud-track member of claim 1, wherein the flanges of both the first L-shaped form and the second L-shaped form each extend in an identical direction from the web member.

5. A stud-track member formed from mixed composite materials which is used for residential and light commercial construction, the stud-track member comprises:

a substantially elongated web member having a first long side, a second long side opposite the first long side, a top end and a bottom end, a first face and a second face opposite the first face the web member formed from wood;

a first L-shaped form connected to the first long side of the web member, the first L-shaped form having a flange spaced apart from the first long side of the web member, and a web portion adapted to connect the flange to the first face of the web member, the connecting web portion of the first L-shaped form has a height greater than a thickness of the web member, and a second L-shaped form connected to the second long side of the web member, the second L-shaped form having a flange spaced apart from the second long side of the web member, and a web portion adapted to connect the flange to the first face of the web member, the connecting web portion of the second L-shaped form each extend in an identical direction from the web member, wherein the stud-track member has increased thermal resistance over single metal stud-track members and greater axial load capability over single wood stud-track members, and which reduces interior condensation and ghosting.