PVC Roofing Guide

2020 EDITION



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PVC MEMBRANES

1.0 General

1.0. GENERAL

1.1. CHEMICAL RESISTANCE

- Inadvertent exposure to foreign materials, debris and other contaminants should be addressed by proper removal and cleaning.
- The following roofing materials are incompatible with SENTINEL PVC:
 - Asphalt-based roofing and flashing products
 - Coal tar pitch
 - Un-faced extruded and expanded polystyrene.
- These incompatible materials must be eliminated or separated from direct contact.

1.2 PVC CLEANING PROCEDURES

1.2.1 SOLVENT CLEANER

GENERAL:

- Follow all safety and environmental regulations and requirements regarding the use of cleaners.
- PVC membranes may be cleaned using solvents such as methylethylketone (MEK).
- Do not pour solvent directly onto roof surface.
- Clean the area using a damp cloth soaked in solvent.
- Where necessary, use a general purpose scrubbing pad and solvent to remove contaminants. Do not use sharp tools or wire brushes.
- Allow the solvent to evaporate, or wipe the surface using a dry cloth where necessary.
- Repeat cleaning as necessary.
- Contact SOPREMA for additional information.

1.3 HOT AIR WELDING PROCEDURES

1.3.1 AUTOMATIC WELDING

GENERAL:

- Automatic hot air welding equipment is required to achieve consistent watertight membrane seam welds.
- Refer to the published operating instructions of hot air welding equipment manufacturer, and follow all applicable requirements and recommendations.





PREPARATION:

- Ensure a safe and consistent power supply is available and maintained for the welding equipment throughout the installation.
- Before welding roofing seams, ensure the area of the seams is dry, clean and free of debris or contaminants.
- Clean the PVC surfaces as necessary.
- Conduct test welds before the roofing installation to ensure equipment settings consistently produce satisfactory welded seams. Repeat test welds when the welder has been turned off or re-started, and when environmental conditions change significantly, as temperature and humidity affect the quality of welds.
 - Use clean, dry PVC cut into strips as necessary to create sample side laps to weld and test.
 - Set the welding equipment temperature and speed and adjust as necessary to achieve satisfactory welded seams. Allow the welded sample to cool.
 - Cut the welded sample into 1 to 2 inch wide test strips.
 - Peel the test strips apart at the welds.
 - A satisfactory weld is achieved when the PVC consistently and uniformly delaminates from the reinforcing fabric and minimum welded width of 1½ inches.

APPLICATION:

- Position and align the automatic welder at the lap. Ensure that the press wheel is positioned over the edge of the lap being welded and that the seam plates are not located within the welding area.
- Set the temperature and speed as determined from sample test welds.
- Insert the welding shoe 2 inches within the lap to always obtain a continuous weld (minimum 1¹/₂ inches).
- When the weld is complete and the welding shoe is disengaged, examine the welding shoe for residue.
- Ensure the welding nozzle remains clean. Remove residue accumulations from the nozzle using a wire brush.

INSPECTION:

- Carefully probe all seams and T-joints using a roundedtip probe such as a cotter pin puller. Prevent damage to the membrane during inspection.
- Repair all open seams and damage found during inspection.
- Ensure the membrane is sealed and watertight each day.

GENERAL

- When seam weld quality is suspect, inspect laps using destructive examination methods.
 - Cut 2-inch-wide weld samples across the seam
 - ${\bf 6}$ inches on either side of the weld (2-inch x 12-inch-wide strip).
 - Cut a minimum of three (3) sample welds in each suspect area.
 - Peel the test strips apart at the welds.
 - A satisfactory weld is achieved when the PVC consistently and uniformly delaminates from the reinforcing fabric.
 - Install a PVC patch of same membrane thickness over sample areas while ensuring the outer edges of the patch extend a min. of 2 inches from all sides of the cut/sample area and are hot air welded into place.

1.3.2 HAND WELDING

GENERAL:

- Hand held hot air welding equipment should be used where automatic welding equipment is not possible.
- Hand-held welding equipment should be used to weld PVC to vinyl-coated metal, small detail work, repairs and other works not accessible with automatic welding equipment.
- Refer to published operating instructions of hot air welding equipment manufacturer, and follow all applicable requirements and recommendations.

PREPARATION:

- Ensure an adequate and consistent power supply for welding equipment is provided and maintained at all times.
- Before welding roofing seams, ensure the area within the seams is dry, clean and free of debris and contaminants.
- Clean the PVC surfaces as necessary.
- Conduct test welds during the roofing installation to ensure equipment settings consistently achieve satisfactory welded seams.

APPLICATION:

- Insert the welding nozzle 2 inches or more within the membrane lap and heat both surfaces sufficiently to fuse the lap. A pre-weld of the lap is recommended.
- While the lap is still hot, use a silicone roller and apply sufficient pressure to ensure the two membranes are pressed and fused together.







- Consistently weld along the lap to obtain a continuous weld (minimum 1¹/₂ inches).
- Ensure the welding nozzle remains clean. Remove residue accumulations from the nozzle using a wire brush.

INSPECTION:

- Carefully probe all seams and T-joints using a roundedtip probe such as a cotter pin puller. Prevent damage to the membrane during inspection.
- Repair all open seams and damage found during inspection.
- Ensure the membrane is sealed and watertight each day.
 - When seam weld quality is suspect, inspect laps using destructive examination methods.
 - Cut 2-inches-wide weld samples across the seam 6 inches on either side of the weld (2-inch x 12-inchwide strip).
 - Cut a minimum of three (3) sample welds in each suspect area.
 - Peel the test strips apart at the welds.
 - A satisfactory weld is achieved when the PVC consistently and uniformly delaminates from the reinforcing fabric.
 - Install a PVC patch of the same membrane thickness over the sample areas while ensuring the outer edges of the patch extend a minimum of 2 inches from all sides of the cut/sample area and are hot-air weld into place.



2.0 PVC Membranes

2.0 PVC MEMBRANES

2.1 GENERAL CONSIDERATIONS

- Ensure environmental conditions are acceptable to proceed. Monitor precipitation, temperature, humidity, dew point temperature, wind, cloud cover and sun that may have an effect on materials and application.
- Conditions should remain dry, and the ambient temperature should be well above the dew point at all times during roofing application.
- Before beginning application, unroll the PVC membrane and allow it to relax.
- At the end of the field sheet where it terminates at roof edges, walls and curbs, fasten the membrane with appropriate fasteners and seam plates.
- Secure the membrane to the deck or vertical surface at the base of the upstand.
- Clean all laps as necessary before welding.
- Hot air weld all laps watertight.
- Carefully probe all seams and t-joints using a roundedtip probe such as a cotter pin puller. Prevent damage to the membrane during inspection.
- Repair all open seams and damage found during inspection.
- Ensure the membrane is sealed watertight each day.
- When seam weld quality is suspect, inspect laps using destructive examination methods.

- Cut 2 in wide weld samples across the seam 6 in on either side of the weld (2 in x 12 in wide strip).

- Cut a minimum of three (3) sample welds in each suspect area.

- Peel the test strips apart at the welds.

- A satisfactory weld is achieved when the PVC consistently and uniformly delaminates from the reinforcing fabric.

- Install a PVC patch, of same membrane thickness over the sample areas ensuring the outer edges of the patch extend a min. of 2 in. from all sides of the cut/ sample area and hot air welded into place.

- Inspect the membrane each day to ensure the membrane is adhered to the substrate.
- Each day, repair all un-adhered voids, wrinkles, open and damaged laps, and all other deficiencies before proceeding.











 Temporary night seals with compatible materials and sealants are required to seal membrane terminations watertight. Remove all temporary night seals before resuming the installation.

2.2 ADHERED PVC MEMBRANES

2.2.1 ADHERED PVC FIELD MEMBRANES

GENERAL:

- SENTINEL PVC field membranes may be adhered for new and roof recover applications.
- Adhered SENTINEL PVC field membranes are glass or polyester reinforced, 60 or 80 mils thick, and are bare or fleece-backed.
- Refer to safety data sheets and product data sheets for additional information.



DO NOT INSTALL fleece backed membranes where the fleece is wet/damp from improper storage or exposure to moisture.

APPLICATION:

SENTINEL S BONDING ADHESIVE:

- For use with bare-backed PVC only.
- Use a minimum 3/8 in nap, solvent resistant roller to apply adhesive. Dip the roller into the adhesive to fully coat the roller. Do not pour adhesive onto the substrate and do not allow adhesive to pool or puddle on the substrate.
- Evenly apply adhesive to clean, dry and prepared substrate while applying adhesive to the back of the bare PVC membrane.
- Prevent adhesive from contaminating the PVC lap seams to be welded.
- Apply uniform adhesive coverage as indicated on product data sheet. Appropriate coverage rate is 60 square feet/gallon (substrate and membrane) Adjust the application rate based on environmental conditions, substrate roughness and porosity.
- Allow the adhesive on both surfaces to become tacky but not wet. The adhesive should not transfer to the finger or string when touched.
- Prevent dust and debris from contaminating adhesive.
- During humid weather, and during periods when the temperature is near the dew point temperature, examine surfaces closely for condensation.
- Do not install if condensation forms on the applied adhesive surfaces. During humid conditions condensation may form on the adhesive surface due to evaporative cooling that occurs when the solvent



evaporates.

- Mate the membrane to the substrate for adhesive-to-adhesive contact.
- Apply pressure using a weighted roller or push broom to ensure complete adhesion and prevent wrinkles and air bubbles.

ICP POLYURETHANE FOAM SPATTER ADHESIVE:

- For use with fleece-backed PVC only.
- Refer to the adhesive manufacturer's published instructions.
- Spray-apply the foam adhesive to clean, dry and prepared compatible substrates. Apply from adhesive to substrate only.
- Ensure the adhesive spray pattern provides for complete membrane adhesion in accordance with adhesive manufacturer's requirements.
- Prevent adhesive over-spray from contaminating the PVC lap seams to be welded or the roof top equipment, building and vehicles near the installation.
- Examine the adhesive in accordance with adhesive manufacturer's requirements, ensure the adhesive does not dry or skin over, prior to membrane installation.
- Mate the membrane to the substrate while applying pressure using a push broom to ensure complete adhesion and prevent wrinkles and air bubbles.

2.2.2 ADHERED PVC FLASHINGS

GENERAL:

- SENTINEL PVC flashing membranes may be adhered for new and roof recover applications.
- Adhered SENTINEL PVC flashing membranes are glass or polyester reinforced, 60 or 80 mils thick, and are bare-backed.
- Refer to safety data sheets and product data sheets for additional information.

APPLICATION:

- Flashing application using SENTINEL S BONDING ADHESIVE:
 - For use with bare-backed PVC only.
 - Use a minimum 3/8 in nap, solvent resistant roller or brush to apply adhesive. Dip the roller into the adhesive to fully coat the roller.
 - Evenly apply adhesive to clean, dry and prepared substrate while applying adhesive to the back of the







bare-backed PVC membrane.

- Prevent adhesive from contaminating the PVC lap seams to be welded.
- Apply uniform adhesive coverage as indicated on product data sheet. See page 17.
- Adjust the application rate based on environmental conditions, substrate roughness and porosity.
- Allow the adhesive on both surfaces to become tacky but not wet. The adhesive should not transfer to the finger or string when touched.
- Prevent dust and debris from contaminating adhesive.
- During humid weather and during periods when the temperature is near the dew point temperature, examine surfaces closely for condensation.
- Do not install if condensation forms on the adhesive surface. During humid conditions condensation may form on the adhesive surface due to evaporative cooling that occurs when the solvent evaporates.
- Mate the membrane to the substrate for adhesiveto-adhesive contact.
- Apply pressure using a hand-held roller to ensure complete adhesion and prevent wrinkles and air bubbles.
- Install butyl water cutoff, fasten and seal the top leading edge to vertical surfaces.
- Clean laps as necessary before welding.
- Hot air weld all flashing laps.

2.3 MECHANICALLY FASTENED PVC FIELD MEMBRANES

2.3.1 FIELD MEMBRANES

GENERAL:

- SENTINEL PVC field membranes may be mechanically fastened for new and roof recover applications.
- Mechanically fastened SENTINEL PVC field membranes are polyester reinforced, 60 or 80 mils thick, and are bare-backed.

APPLICATION:

- Starting at the low point of the roof, lay out the membrane to ensure the plies are installed perpendicular to the roof slope, shingled to prevent back-water laps.
- Remove all wrinkles from the sheet, but do not overstretch the membrane too tight during installation.
- Ensure 6 in side-lap and end-lap widths are maintained.
- Starting at one end of the sheet, install the mechanical fasteners within the 6 in side lap Avoid installing plates

welding area of the lap. Locate the center of the seam plates 2 in from the edge of the sheet. Refer to the fastener line printed 2 in from the edge of the sheet.

- When fasteners require repositioning, ensure the repositioned plate is not located in the weld area of the laps.
- Ensure fastener spacing meets the specified wind uplift resistance requirements.
- Do not over-drive fasteners. Install fasteners as necessary to firmly set the fastener and seam plate tight against the sheet. Prevent wrinkles from forming in the sheet as the fasteners are installed.
- At the end of the sheet where it terminates at roof edges, walls and curbs, fasten the perimeter of the membrane with appropriate fasteners and seam plates to the deck or vertical surface at the base of the upstand.
- Clean laps as necessary before welding seams.
- Hot-air weld all laps. Do not tack weld membrane prior to using automatic welder at side laps.
- When rows of fasteners are installed through the membrane at perimeter and corner enhancements, weld a minimum 8 in wide sealing strip over the fasteners to seal the fasteners watertight.



2.4 DETAILS

2.4.1 PVC FIELD MEMBRANE DETAILS4



Figure 2.4.1a PVC Field Membrane At Wall/Curb With Horizontal Perimeter Fastening



Figure 2.4.1b PVC Field Membrane At Wall/Curb With Vertical Perimeter Fastening



Figure 2.4.1c PVC Field Membrane At Gravel Stop With Vinyl Coated Metal Fascia



Figure 2.4.1d PVC Field Membrane At Gravel Stop With Sheet Metal Fascia



Figure 2.4.1e PVC Field Membrane At Drip Edge



Figure 2.4.1f PVC Field Membrane At Roof Drain



Figure 2.4.1g PVC Field Membrane At Penetration With Field Fabricated Pipe Flashing



2.4.2 ADHERED PVC FLASHING MEMBRANE DETAILS

Figure 2.4.2a Adhered PVC Flashing Membrane At Field Fabricated Inside Corner



Figure 2.4.2b Adhered PVC Flashing Membrane At Prefabricated Inside Corner



2.4.2 ADHERED PVC FLASHING MEMBRANE DETAILS

Figure 2.4.2c Adhered PVC Flashing Membrane At Molded Outside Corner



Figure 2.4.2d Adhered PVC Flasing Membrane At Prefabricated Outside Corner

3.0 PMMA/PMA LIQUID-APPLIED FLASHING FOR PVC ROOFING

3.0 PMMA/PMA LIQUID-APPLIED FLASHING FOR PVC Roofing

3.1 GENERAL CONSIDERATIONS

- ALSAN RS 230 or 260 LO Flash liquid applied, reinforced flashing systems are an acceptable alternate to PVC flashing membranes to form waterproof flashings for roof transitions, terminations and penetrations.
- ALSAN RS liquid applied flashing systems may be used with adhered PVC membranes. Contact SOPREMA for use with mechanically fastened.
- Refer to ALSAN RS detail drawings, product data sheets, safety data sheets and published guidelines for additional installation, storage and handling requirements.

PREPARATION:

- Ensure all substrates are sound, dry clean and free of dust, debris, and adhesives.
- PVC membrane preparation:
 - Ensure the PVC field membrane is fastened to the substrate at all membrane terminations before liquid applied flashing is installed.
 - Install a welded PVC cover-strip over fasteners where applicable. Ensure cover-strip is welded with a minimum 1-1/2 in weld, with no loose ends or open laps.
 - Ensure PVC membrane and substrates are dry, clean and free of asphalt and all bitumen-based products.
 Do not allow bare-backed PVC to come in contact with asphalt or bitumen-based products.
 - Lightly abrade the PVC membrane surface using a scouring pad only where liquid applied flashing is to be applied.
 - Wipe the PVC membrane surface clean using ALSAN RS Cleaner, and allow to fully dry.
- Metal substrate preparation:
 - Sand, grind, blast or otherwise abrade approved metal surfaces to near-white finish and wipe clean with ALSAN RS Cleaner.
- Concrete and masonry substrate preparation:
 - Substrates should be smooth and free of spalls, voids, blow holes and loose materials.
 - Use mechanical scarifying, grinding or blasting methods where necessary to provide a smooth, open surface free of laitance. The surface profile should meet ICRI 3,4 or 5.



- Refer to ASTM D4259 and D5295 for surface preparation guidance.



- Other approved substrates: Contact SOPREMA and refer to ALSAN RS installation instructions for other approved substrates and priming requirements.
- Conduct adhesion/peel tests by applying ALSAN RS PRIMER and liquid-applied membrane where necessary to ensure satisfactory adhesion is achieved.

APPLICATION:

- Prime substrates where required.
- ALSAN RS 276 and ALSAN RS 222 PRIMER
 - Refer to product data sheets and safety data sheets, as well as ALSAN RS installation instructions.
 - Using a slow-speed mechanical agitator, stir the entire container thoroughly.
 - Mix primer resin and catalyst for approximately two minutes using a clean spiral agitator on slow speed or stir stick until evenly mixed. Do not aerate. Mix only the amount of primer that can be used within the application time.
 - Apply the appropriate specified primer to dry, compatible substrates as required to enhance adhesion of new specified waterproofing and flashing materials.
 - Apply primer using a brush or roller at the rate indicated on the technical data sheet. Do not allow heavy accumulations of primer.
 - Allow primer to fully cure before membrane application.

ALSAN RS METAL PRIMER

- Refer to technical data sheets and safety data sheets as well as ALSAN RS installation instructions.
- Using a slow-speed mechanical agitator, stir the entire container thoroughly.
- Apply primer using a brush or roller at the rate indicated on the technical data sheet.
- ALSAN RS membranes and flashing membranes should be installed to the primed surface within 24 hours of primer application.
- Pre-cut ALSAN RS FLEECE polyester reinforcement to fit roof terminations, transitions, and penetrations. Cut reinforcement to ensure a minimum 2 inch overlap of fleece at side laps and end laps. Ensure the liquidapplied flashing membrane is fully reinforced.





- Apply the base coat of catalyzed ALSAN RS FLASH resin onto the substrate using a brush or roller, working the liquid resin into the surface for complete coverage and full adhesion.
- Immediately apply the ALSAN RS FLEECE reinforcement into the wet base coat of resin. Using a brush or roller, work the ALSAN FLEECE reinforcement into the wet resin while applying the second coat of catalyzed ALSAN RS FLASH resin to fully saturate the fleece. Extend the ALSAN RS FLASHING resin a maximum of 1/4 inch beyond the reinforcement.

INSPECTION:

- As project conditions vary, monitor changing conditions, adjust primer and membrane application methods as necessary to achieve the desired results.
- Refer to ALSAN RS installation instructions for additional guidance.



3.2 DETAILS

3.2.1 ALSAN RS details



Figure 3.2.1a ALSAN RS Wall/Curb Flashing On PVC Membrane With Horizontal Perimeter Fastening



Figure 3.2.1b ALSAN RS Roof Drain Flashing On PVC Membrane With Horizontal Perimeter Fastening



Figure 3.2.1c ALSAN RS Penetration Flashing On PVC Membrane With Horizontal Perimeter Fastening

4.0 MISCELLANEOUS

4.0 MISCELLANEOUS

4.1 PVC HOT-AIR WELDED SIDE AND END LAP PREPARATION

GENERAL:

 All SENTINEL PVC membranes require a continuous hot-air welded seam (minimum 11/2 inch) at all side and end laps.

PREPARATION:

- Ensure all substrates and bottom surfaces of barebacked membranes are dry and free of debris.
- Clean laps as necessary.

APPLICATION:

- Hot-air welders shall be used to seal all membrane lap seams.
- Position the membrane so that it overlaps the adjacent membrane at the required side lap width. Ensure the laps are clean, dry, and free of adhesive and foreign material.
- Weld the laps using an automatic welding machine or hand welder to maintain a 11/2 inch uniform and continuous weld.
- At end laps of bare-backed PVC, dog-ear and round all corners. Extend a minimum of 3 inches beyond the adjacent roll.
- Adhered fleece-backed membrane end laps shall be butted together and a 6 inch membrane cover strip shall be welded over the butted joint.
- SENTINEL T-JOINT PATCHES shall be hot-air welded to the membrane at all T-joint intersections. Chamfer the welding seam prior to installing SENTINEL T-JOINT PATCHES using an edging tool or by heating the edge and rolling.

INSPECTION:

- Carefully probe all seams and T-joints using a roundedtip probe such as a cotter pin puller. Prevent damage to the membrane during inspection.
- Repair all open seams and damage found during inspection.
- Ensure the membrane is sealed and watertight each day.
- When seam weld quality is suspect, inspect laps using destructive examination methods.









- Cut 2-inch-wide weld samples across the seam 6 inches on either side of the weld (2-inch × 12-inch-wide strip).
- Cut a minimum of three (3) sample welds in each suspect area.
- Peel the test strips apart at the welds.
- A satisfactory weld is produced when the PVC consistently and uniformly delaminates from the reinforcing fabric.
- Inspect the membrane each day to ensure the membrane is properly fastened to the substrate.
- Each day, repair all voids, wrinkles, open and damaged laps, and all other deficiencies before proceeding.
- Temporary night seals are required to seal membrane terminations watertight. Remove all temporary night seals before resuming the installation.





Figure 4.1a Bare-backed PVC Field Membrane Side And End Laps



Figure 4.1b Fleece-backed PVC Field Membrane Side And End Laps

4.2 PVC ACCESSORIES

GENERAL:

 Refer to the Technical Data Sheets and Safety Data Sheets for additional product information.



ACCESSORIES CHART					
PRODUCTS	APPLICATION				
SENTINEL MOLDED OUTSIDE CORNERS*	Injection-molded, unreinforced flashings used to flash outside corners				
SENTINEL MOLDED INSIDE CORNERS*	Injection-molded, unreinforced flashings used to flash inside corners				
SENTINEL PVC PREFABRICATED OUTSIDE CORNERS*	Prefabricated fiberglass-reinforced flashings used to flash outside corners				
SENTINEL PVC PREFABRICATED INSIDE CORNERS*	Prefabricated fiberglass-reinforced flashings used to flash inside corners				
SENTINEL PVC MOLDED UNIVERSAL CORNERS	Injection-molded, unreinforced flashings used to flash irregular details				
SENTINEL T-JOINT PATCHES*	Round, polyester-reinforced patches used to seal intersections of three or more layers of PVC membrane				
SENTINEL PVC PIPE FLASHINGS*	Fiberglass reinforced prefabricated PVC pipe flashings used to flash round penetrations				
SENTINEL PVC BOOT Flashing	Factory fabricated fiberglass-reinforced flashing used to seal protrusions				
BUTYL SEALANT	100 percent solids, water cut-off, gun-grade butyl sealant used to seal between PVC membrane and approved substrates				
BUTYL TAPE	100 percent solids, water cut-off sealant tape approved for sealing between PVC membrane and substrate.				
FOIL TAPE BOND BREAKER	Bond breaker tape, nominal 2-inch-wide, adhesive-backed: • Applied to vinyl-coated metal edge detail joints prior to stripping-in with PVC flashing membranes • Applied to pipes and other flashing substrates to cover incompatible materials, such as asphalt				

INNOVATION SINCE 1908

SOPREMA has developed around the idea that the quality, durability and reliability of materials must match builders' ambitions and expectations. For more than 100 years, SOPREMA has been using its expertise to develop a variety of high-end products that meet or exceed all the requirements of the construction field.

ROOFS WALLS FOUNDATIONS PARKING DECKS BRIDGES ADDITIONAL EXPERTISE











WATERPROOFING

ATION

VEGETATIVE SOUNDPROOFING SOLUTIONS

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SOPREMA is an international manufacturer specializing in the production of waterproofing and insulation products, as well as vegetative and soundproofing solutions, for the building and civil engineering sectors.

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