Note: This drawing is for your records. Contractors should complete repairs by the end of each work day.

When the roof has multiple levels, inspect one level at a time.

For larger roof levels, break into smaller sections to eliminate confusion.

NOTE: PVC PRESSURE-SENSITIVE COVER STRIP PRODUCT MUST BE USED IN CONJUNCTION WITH STEP 1 ACTIVATOR (BLUE IN COLOR) AND STEP 2 PRIMER.

Heat Welding Procedures:

Temperature setting for automatic welder:
PVC = 114°F

All welds are a minimum 1½" wide, regardless of warranty duration.
Bleed-outs should be present on edges of reinforced PVC membrane.

Minimum requirements for test welds: Perform a test weld at the start of work each morning and afternoon by using like material over the same substrate. WeatherBond does not require the use of destructive testing.
Once cooled, peel the test sample apart to examine delamination of the membrane from the scrim reinforcement.

Welding Troubleshooting Checklist:

- Temperature and/or speed of welder
- Outside temperature (humidity and time of day)
- Heat transfer over insulation plates
  - Cold welds/voids can be found were seams cross over plates
  - Cord size and length from source
- Generator size and wattage
  - Minimum 6500-watt generator for 1 automatic welder
  - Minimum 3000-watt generator for 2 hand welders
- Regular service/maintenance for welder
- Cleanliness of membrane
  - Proper cleaning materials/ags
  - PVC/KEE HP Membrane Cleaner on PVC & KEE HP systems
  - Scotch Brite Pad in conjunction with PVC/KEE HP Membrane Cleaner required on membranes exposed to sun for longer than 7 days
- Cleanliness of automatic welder/hand welder nozzle
- Check all start and stop points thoroughly

All seams must be probed prior to final inspection of the roofing system. Voids in the membrane must be repaired by the end of each work day.

Please consult WeatherBond’s Specification Supplement (section T-01-11) for more information about welding procedures, generator usage, and general troubleshooting.

If you need assistance, it’s only one call away.

Important Information:
Sales Representative phone number:
Distributor phone number(s):

As a reminder, this guide is meant to help with details commonly seen in the field. Not all details are included in this guide. WeatherBond contractors are encouraged to call with any questions.

For assistance, please call 1-866-471-5125 and ask for the Technical Department.

Guide for Inspecting Your System

This guide will illustrate and provide a basic understanding of some common details.

Below is a simple roof drawing with penetrations included. It shows a recommended path to follow when inspecting a completed roof.

PVC/KEE HP (Thermoplastic) Rooftop Guide

Inspection Checklist

Step 1: Inspect the perimeter.
Update the roof plan to show the location of all curbs, penetrations, drains, etc. Focus on securement and termination. Mark deficiencies on the roof plan as they are found.

Step 2: Inspect all seams on the roof level.
Focus on plate placement and proper seaming.

Step 3: Inspect all curbs, penetrations, drains, etc.
Focus on one detail at a time, confirming proper seaming, termination, and flashing minimums.

Step 4: Finally, walk across the roof, update areas in need of repair, and perform a general check of the system.
**Common Details**

**WBPC-1.2 Heat Weldable Drip Edge Fascia**
1. Is wood nailer wider than metal flange?
2. Is wood nailer flush with insulation?
3. A continuous, minimum 22-gauge metal and the metal must be fastened 6" OC using ring shank nails.
   a. Install according to SNSMA ES-9 requirements.
4. Membrane covered post nailer heads a minimum of 2 ½" is minimum 1½" weld present on the metal flange? Is bleed-out present?
5. Wood nailer must be properly secured/anchored (refer to FM 1-48).
6. Maximum ½" gap between joints in metal overlaid with 2 layers of Non-Reinforced Flashing (first 1" wide, second 6" wide).
7. Membrane weld onto coated metal: minimum 1½" hot air weld past fasteners heads is required.

**WBPC-1.3 WeatherBond PVC PS Cover Strip for Standard Drip Edge**
1. Is the Cover Strip placed out to the edge of the metal?
2. Is Step 1 Activator extending out from the primer only on the PVC membrane?
3. Is the Activator and Primer on the PS Cover Strip in all areas of overlap?
4. Is Step 1 Activator extending out from the primer only on the PVC membrane?
5. If Termination Bar is used, follow WBPC-12.4, 5.
6. Is Water Cut-Off Mastic present?

**WBPC-2.0/AC-2.2 Membrane Splice**
1. Are all flashings properly adhered?
2. Present at all fixed access points, HVAC units that are regularly serviced, and concentrated walk areas?
3. Is securedment present?
4. Appropriate fastening rate for required warranty? No more than 12" OC.
5. Is PVC Inside Corners or PVC Outside Corners. Note: PVC accessory corners are not universal.
6. Is 1½" weld present on deck flange?
7. Securement is required on mechanically fastened systems. Not required on fully adhered systems.
8. On fully adhered systems, pockets larger than 18" in diameter must have plates and fasteners.

**WBPC-5.1 Curb Flashing**
1. Is it 1½" hot air weld past plates and fasteners present? Bleed-out present?
2. Is membrane properly terminated at the top of the curb?
   a. Is counter-flashing used? If so, was it fastened with neoprene washers 12" OC?
3. Is Water Cut-Off Mastic present?
4. Membrane securedment at inside angle changes?
5. Are outside corners complete?
6. On 60-⅛ and thicker membranes, have factory-fabricated T-Joint Covers been installed?
7. WBPC-9 Termination Bars
   a. Is Water Cut-Off Mastic present?
   b. Do not wrap Termination Bar around corners. Apply on hard, smooth surfaces only: not for use on exposed wood.
   c. WBPC-9.5 for additional requirements if Termination Bar is used at 0½ panel joints.
   d. Water Cut-Off Mastic must be installed at approximately 10' per tube.

**WBPC-6.1 Drain Details**
1. Are drain bolts or clamps in place to provide constant compression?
2. Hole in membrane must be larger than drain hole itself: minimum ½" from attachment points of clamping ring.
3. WBPC-5.1 Curb Flashing
   a. Is Water Cut-Off Mastic present between the cleaned drain bowl and the membrane?
4. Is the drain properly terminated at the top of the curb?
5. Is membrane properly terminated at the top of the curb?
6. Is 1½" hot air weld past fasteners heads is required.

**WBPC-8 Pipes/Single Penetrations**
- **Pre-molded Pipe Flashing**
  1. If it is a flat surface? Note: flanges cannot be overlapped.
  2. Cut in pipe below at rib 16in.
  3. Are Water Cut-Off Mastic and clamping ring present at top of boot?
- **Field-fabricated Pipe Flashing**
  1. Are two wraps present?
     a. Base wrap goes up pipe ½" minimum?
     b. Top wrap overlaps base wrap 1" with a 1½" minimum splice on the vertical overlap?
     c. Are Water Cut-Off Mastic and clamping ring present at top of field fabrication?
     d. Fully adhered systems: Securement is required at penetrations greater than 18" in diameter. Mechanically fastened roofing systems: Securement is required at all penetrations.

**WBPC-10 Parapet/Curb Angle Change**
1. Is membrane securement present at the angle change?
2. Plates and fasteners 6"-9" away from Inside/Outside Corner?
3. Are plates and fasteners a minimum of 12" OC? Note: 6½" OC must be used when warranty wind speed is greater than 90 mph. See WAN 1-24.1, 5.
4. Pig ear fold in field-fabricated inside corner?
   a. Is membrane properly terminated at the top of the curb?
   b. Is Water Cut-Off Mastic present?
   c. Membrane covered past nailer heads a minimum of 2" is minimum 1½" weld present on the metal flange? Is bleed-out present?

**WBPC-11 Molded Sealant Pockets**
1. Field-fabricated Pipe Flashing
   a. Check usage of Walkway Rolls.
2. Metal scupper box must have a continuous flange with rounded corners.
3. Is wood nailer present underneath metal?
4. Is Water Cut-Off Mastic present underneath metal?
5. Sealant by others required on outside of scupper where the scupper meets the outside wall.

**WBPC-12 Parapet/Curb Angle Change**
1. Is securement present?
   a. Appropriate fastening rate for required warranty? No more than 12" OC.
   b. 6" OC for warranty wind speeds greater than 50 mph.
2. Are all flashings properly adhered?
   a. Wall flashing securement is required if termination height is greater than 4'. See Detail WBPC-12.4, 5.
3. When seam is present at angle change, there must be a 1½" weld?
   a. If 1½" weld is not achieved, overlay using PVC Non-Reinforced Flashing with a minimum 1½" splice in all directions around the splice.
   b. How is membrane terminated?
   c. See Detail WBPC-9.
4. WBPC-15 Inside/Outside Corner
   a. Is membrane securement present at the angle change?
   b. Plates and fasteners 6 ½" away from Inside/Outside Corner?
   c. Are plates and fasteners a minimum of 12" OC? Note: 6½" OC must be used when warranty wind speed is greater than 90 mph. See WBPC-12 Details.
   d. Field-fabricated Pipe Flashing
      a. Is membrane properly terminated at the top of the curb?
      b. Is Water Cut-Off Mastic present?
      c. Membrane covered past nailer heads a minimum of 2" is minimum 1½" weld present on the metal flange? Is bleed-out present?

**WBPC-16.1 Molded Sealant Pockets**
1. Is wood nailer present underneath metal?
2. Is water cut-off mastic present underneath metal?
3. Sealant by others required on outside of scupper where the scupper meets the outside wall.

**WBPC-18 Metal Scupper**
1. Scuppers can be flashed using PVC coated metal (WBPC-12.1) or PVC Pressure-Sensitive Cover Strip (WBPC-18.6).
2. Metal scupper box must have a continuous flange with rounded corners.
3. Is wood nailer present underneath metal?
4. Is water cut-off mastic present underneath metal?
5. Sealant by others required on outside of scupper where the scupper meets the outside wall.

**WBRC-24.0 Sleepers/Wood Blocking**
1. Are slip sheets present underneath to prevent damage to new membrane?
2. Check usage of Walkway Rolls.
   a. Present at all fixed access points, HVAC units that are regularly serviced, and concentrated walk areas?
3. A-27 Insulation Fastening
   a. Is insulation fastened in accordance with current specifications and details?
   b. Has proper fastener penetration been achieved?
   c. Reduced fastening patterns are allowed on 22-gauge or heavier steel, concrete, minimum 1½" wood, and minimum ½" ply-wood decks only.