

WeatherBond PVC

Rib Profile Installation Guide



Safety

Worker safety is a necessity when working on steep slopes, which will be the majority of the PVC Rib Profile installations. Fall protection systems may be required to reduce the potential for slips and falls. Consult with OSHA or local bodies of government to ensure proper guidelines are followed. Proper footwear will also aid in reducing the chance of slips and falls on high-slope roofs.

Installation

1. The PVC Rib Profiles should be positioned parallel to the laps of the installed roofing system. Each field seam shall have a PVC Rib Profile positioned on top of the weld, adjacent to the edge of the top membrane but not covering the seam edge. This application will assist in hiding the seams from the viewer. The PVC Rib Profile spacing will be determined by dividing the distance between the seams into equal spacing as desired. The distance will be determined by the designer of the roof.
2. Once the rib spacing has been determined, chalk lines on the membrane to indicate each rib location and to serve as a guide to keep them straight. *Note: Test chalk to ensure that snapped lines or the color used does not permanently stain the membrane and can be washed off before using on the roof.*



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3. Position the edge of the rib flange on the chalk line. Using a hinge-type motion, keep the flange edge on the chalk line and roll the rib so a hand welder can be inserted. Tack-weld only the center of the rib every 6" while being careful not to overheat the area or weld the flange to the membrane. The initial setting on the hand gun should be at #8. *(Do not use excessive heat for this step to avoid compromising the watertight quality of the membrane.)*



4. Connecting multiple ribs is achieved by using the supplied pins. Insert a pin halfway into the end of one profile. Connect the adjoining rib by inserting the exposed end of the pin into the alignment hole. Follow the procedure for tacking the rib to the surface of the membrane as described in the previous paragraph.



5. Once the entire run of rib profiles have been tack-welded at least every 6" on center, position the automatic walk welder so it straddles the rib. Set the temperature initially at 1004°F and at a speed of 12.5 feet per minute.

6. Manually engage the drive system of the welder while inserting the nozzle under the rib flange. A second person will provide pressure to the flange using a hand roller as the rib is hot-air welded to the membrane. At the end of the run, turn the walk welder around and complete the welding process by welding the opposite flange.



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