

EternaBond OEM RV Installation Instructions: Eliminating the Variables

Surface Preparation

Cleaning: Surfaces must be free of dust, oils, and all contaminants. The mica-dust roll coating on EPDM *must* be removed; nothing will stick to it. Remove the mica-dust on EPDM, scrub the surface of TPO and PVC to remove coatings or dust and remove any oils or dust from metals or fiberglass. This is best done by scrubbing with a "Scotch Bright" type of abrasive pad then rubbing vigorously with a *clean* rag. The roof should be scrubbed, then wiped; not *just* wiped. NOTE: The contaminants will saturate the wiping rag and it should be replaced for each unit. A "hot" solvent (lacquer thinner, brake-part cleaner, EternaClean, etc.) may be used on the wiping rag for a more complete cleaning job especially on metal surfaces. Alcohol is ineffective. TPO and PVC roofs should be treated in the same manner. Spot test as changes occur in substrates or installers. A hot solvent should NOT be used on PVC or fiberglass. *If cleaning the surface is not totally effective or consistent then:*

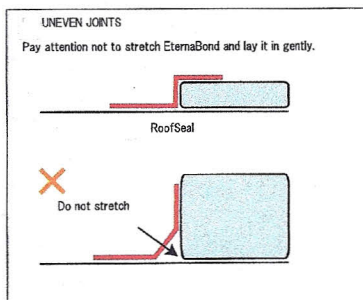
Use "EternaPrime" tape primer and surface conditioner. EternaPrime is a quick and easy, very low VOC, aerosol spray or liquid that will coat any contaminants on the substrate with the same resins used in EternaBond and assure a strong permanent bond. *Use of EternaPrime is highly recommended in manufacturing environments where contamination of the roof surface with dust and limited supervision of the installers is likely. EternaPrime will also greatly reduce problems due to variations in the roofing materials such as mica-dust amounts, oils, coating changes, etc.* Note: EternaPrime does not eliminate the need for cleaning but will mitigate the installer and substrate variables. NOT recommended for use on PVC roofing.

Spray all surfaces (especially EPDM!) with a *medium* coating of EternaPrime 1" wider than the tape target. Shake the can vigorously and often. A medium coating looks damp but dries quickly. Too heavy, it will run, too light, it will be dry and hard to see. Primer should be dry for tape application. Primer should dry in 30 seconds or less.

Applying EternaBond Tape

Keep it Warm. Tape should be at least 70° F. The warmer the tape, the better the initial adhesion. Many OEM customers use a hotbox to store EternaBond during cold weather.

Lay the Tape *gently* allowing it to conform to the surface. **IMPORTANT:** *Avoid stretching EternaBond RoofSeal tape.* Do not stand at either end of a long run and pull the tape taught to stick it down.



Rub & Roll! Lay the tape down gently and *then* go back and apply pressure at all contact points; especially all edges. For flat areas use a flat steel roller. For inside corners use a "V" roller. For corners, screws and tight areas use fingers to manipulate with pressure. EternaBond works best under pressure!

Screws and Profiles. Use extra care anywhere the tape goes over a profile that could cause a tenting action. Tenting can occur when the tape is applied over screw heads, vent flanges, etc. It is preferred to use EternaBond *under* screwheads (see attached diagram). If you *must* go over screwheads, maintain a minimum of 1" distance from the center of the screwhead to the edge of the EternaBond tape. *If there is less than 1", use of EternaPrime is required before*

installation. Less than 1/2" distance is unacceptable. Do not use a roller over screwheads; use your hands.

Corners. In tight corners, cut and fold EternaBond as if wrapping a package. Do not stretch or gather the tape!

Inspect. Perform a final inspection of the installation. Do not pull back tape immediately. Check for bonding in 60 to 90 minutes. Testing for specific applications is the responsibility of the customer.

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The user assumes responsibility for testing the suitability of any specific application and the application of these instructions.