

# TECHNICAL BULLETIN

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## TARGET MARKET ROOFING

BUILDING TRUST



**Subject:** SikaFast 3341 adhesive for adhering PVC to PVDF Edge Metals

**24-04**

### Application

SikaFast 3341 adhesive allows the use of **PVDF** Resin Coated Metal (Kynar) to be fabricated at the roof's edge or top of parapet walls on Sika Roofing Systems and allows the bonding of Sika's S327 membrane cover strips directly to this metal, which forms a rigid bond once cured.

To allow for normal metal movement related to thermal expansion and contraction, a flexible bond must be achieved between the metal components of any edge system prior to application of SikaFast 3341. When using SikaFast 3341, this is accomplished with 2 different metal application methods at the joints:

- 8" Metal butt plates at each metal joint and sealed with non-curing sealant
- 4" Overlap at each metal joint and sealed with non-curing sealant

### Coverage Rate Details

Coverage Rate is 60-80 LFT per each cartridge based on 2-inch-wide application. Coverage rate will vary based on tools used and application method.

### Metal Butt Plates at each Metal Joint

8" wide splice plate below the edge metal joints that is sealed to the edge metal pieces with the non-curing sealant before applying the Sika Joint Tape SA over the joints.

1. Remove the plastic protective film from metal. Clean metal thoroughly.
2. Form the moisture seal between the splice plate and metal pieces by applying beads of non-curing sealant in continuous bead at the overlapping metal.
3. Install edge metal pieces with a ¼" gap between ends centered on the butt plate and mechanically attached 4" o.c. in a staggered pattern with appropriate fasteners.
4. Apply a 3-inch wide Sika Joint Tape SA over all the joints of the metal pieces covering the joint and hold back 1- inch from the metals outside edge and roll in place with a neoprene roller.
5. Lay out the S327 membrane cover strip flashing 1/2-inch back from metal's outside edge and hot air weld all the end laps fully from front to back of the overlapping membrane. Mark the outside edge of the membrane cover strip on the metal with a sharp pen or chalk line. Hot air weld the cover strip to the primary roofing membrane.
6. Fold back the membrane cover strip and proceed with applying the SikaFast 3341 adhesive with the supplied mixing tube and application tip and follow the sharp line or chalk line (edge of membrane cover strip) on the metal. Allow to stand for 3-5 minutes before installing the membrane cover strip into the adhesive. Once membrane cover strip is installed into the adhesive, install painter's tape (Blue) centered over edge of membrane cover strip and press into leading edge of the cover strip to create a stop for the SikaFast 3341 adhesive from bleeding out past the edge of the membrane. Bond the membrane into the adhesive by rolling with a neoprene roller.
7. After adhesive has cured (1 to 2 hours), remove painter's tape.

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### Metal overlaps at each Metal joint

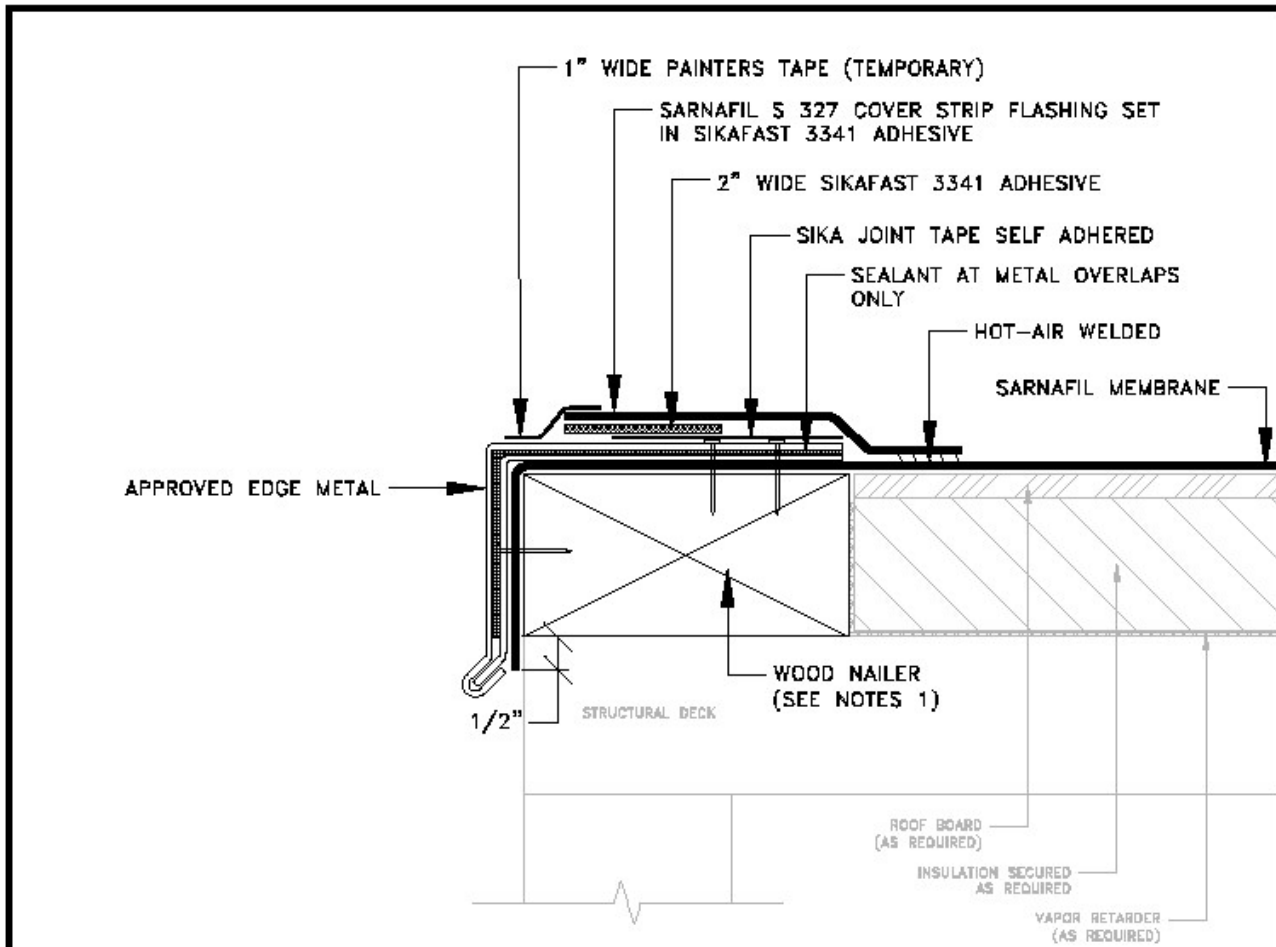
4" overlap at metal joints that is sealed with the non-curing sealant before applying the Sika Joint Tape SA over the joints.

1. Remove the plastic protective film from metal. Clean metal thoroughly.
2. Form the moisture seal between the overlapping metal pieces by applying beads of non-curing sealant in continuous bead as shown and mechanically attached 4" o.c. in a staggered pattern with specified fasteners.
3. Apply 3-inch wide Sika Joint Tape SA over all the joints of the metal pieces covering the joint and hold back 1-inch inch back from the metals outside edge and roll in place with a neoprene roller.
4. Lay out the S327 membrane cover strip flashing 1/2-inch back from metal's edge and hot air weld all the end laps fully from front to back of the overlapping membrane. Mark the outside edge of the membrane cover strip on the metal with a sharpy pen or chalk line. Hot air weld the cover strip to the primary roofing membrane.
5. Fold back the membrane cover strip and proceed with applying the SikaFast 3341 adhesive with the supplied mixing tube and application tip and follow the sharpy line or chalk line (edge of membrane cover strip) on the metal. Allow to stand for 3-5 minutes before installing the PVC cover strip into the adhesive. Once membrane cover strip is installed into the adhesive, install painter's tape (Blue) centered over edge of membrane cover strip and press into leading edge of the cover strip to create a stop for the SikaFast 3341 adhesive from bleeding out past the edge of the membrane. Bond the membrane into the adhesive by rolling with a neoprene roller.
6. After adhesive has cured (1 to 2 hours), remove painter's tape.

#### Notes:

- 1 static mixing tube and 1 applicator tip can be used with 3 to 5 cartridges of SikaFast 3341 adhesive. Weather, ambient temperature, and application thickness will factor into how fast the adhesive starts to cure (typically within 30 minutes). Static mixing tubes and applicator tips can only be used during the same day application.
- SikaFast 3341 Adhesive is dispensed with 490 ml 10:1 Applicator Gun (manual or battery)
- Recommended Applicator Gun: <https://www.perigeedirect.com/products/albion-2-part-dispensers-for-400ml-490ml-385ml-415ml-cartridges-1-1-2-1-4-1-or-10-1-mix-ratios-manual-pneumatic-18v-battery?variant=42332017950974>
- Warranted to a maximum of 20 years.




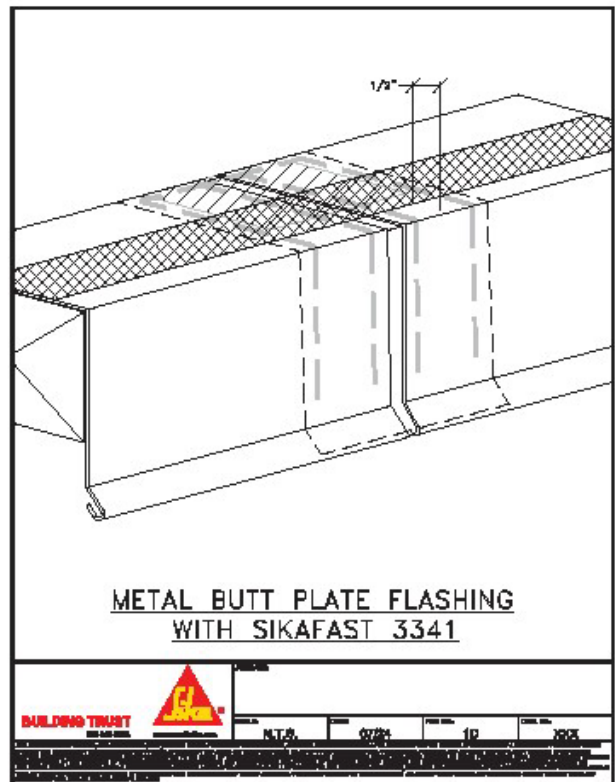
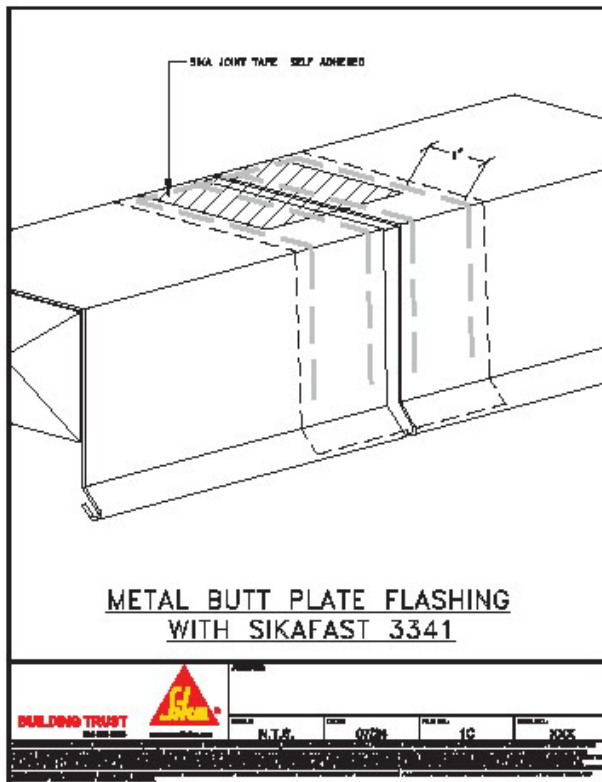
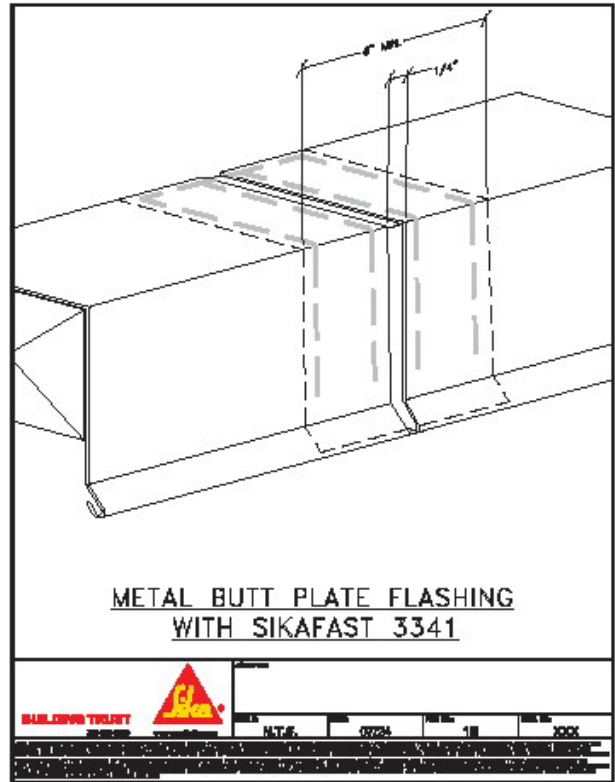
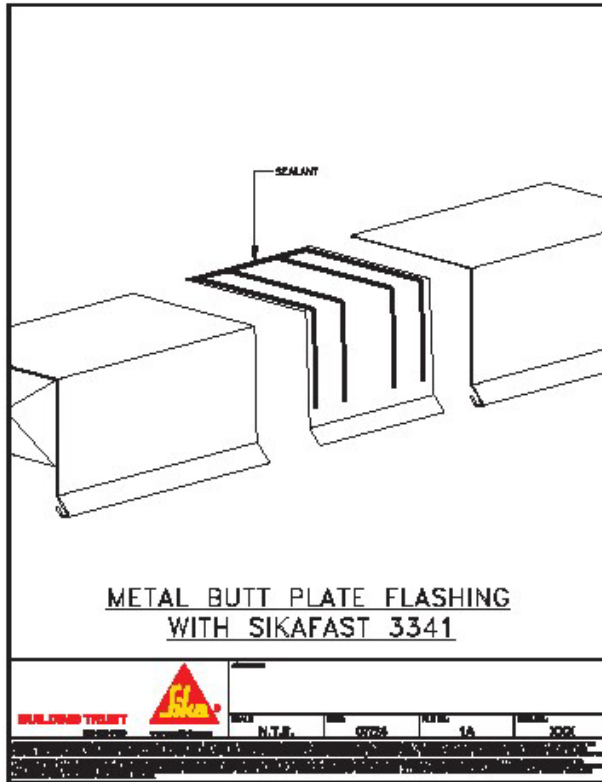


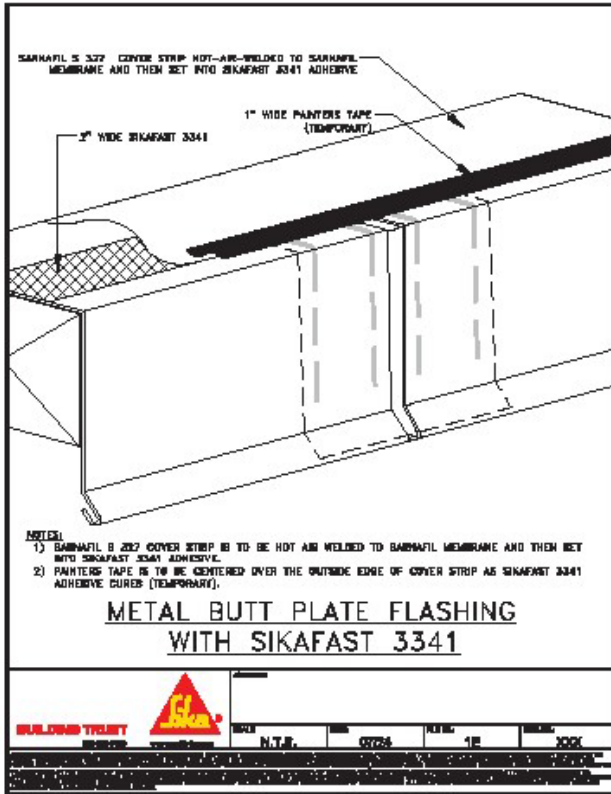
**NOTES:**

- 1) NEW OR EXISTING WOOD NAILERS SHALL BE ATTACHED ACCORDING TO THE D.O.R., LOCAL CODE, OR INSURANCE REQUIREMENTS, WHICHEVER IS MORE STRINGENT. NAILER HEIGHT TO MATCH TOP SURFACE TO WHICH MEMBRANE IS TO BE APPLIED.
- 2) SARNAFIL S 327 COVER STRIP IS TO BE HOT AIR WELDED TO SARNAFIL MEMBRANE AND THEN SET INTO SIKAFAST 3341 ADHESIVE.
- 3) PAINTERS TAPE IS TO BE CENTERED OVER THE OUTSIDE EDGE OF COVER STRIP AS SIKAFAST 3341 ADHESIVE CURES (TEMPORARY).

## METAL FLASHING WITH SIKAFAST 3341

 <b>BUILDING TRUST</b> 781-828-5400 <a href="http://www.sikainfl.com">www.sikainfl.com</a>	JOB NAME:		
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**Metal Overlap Flashing at each Metal Joint:**

