



January 2, 2015

## **2001 Co. General Thermoplastic Requirements**

- Avoid ponding water with TPO, use tapered insulation or install more drains.
- Train all mechanics to use proper technique when using hand held welders for detail. Ask 2001 Co. if assistance is needed.
- Train the automatic seam robot operator to weld quality seams. The clean seam must be welded with the proper temperature, speed, and compression.
- Always do a sacrificial seam test before welding field seams at the beginning of each day and periodically throughout the day if weather conditions drastically change.
- The robot welder needs proper amperage to make quality seams. Follow equipment manufacturer's recommendations regarding cord size and length. It is recommended to have a dedicated power source for the robot welder as power surges from other equipment can affect seam quality.
- Never fold or crease the thermoplastic membrane as this can permanently damage the outer skin and allow moisture penetration at a premature date.
- Use a seam probe to press (crease) membrane down at seam step-downs.
- Use a seam probe to test all seams and repair as necessary with welded patches.
- On a BUR with gravel and gravel mat, It can be very difficult to produce a good welded seam over a roof that includes a gravel mat as it can be a very irregular surface. EPDM seam tape works better for this condition and an EPDM system should be considered.
- New PVC membranes always need an approved separator option when covering an EPDM, TPO or BUR.
- Never use seamtape products with TPO without job specific 2001 written approval.