

## **FLEX PVC ROOF RIB ASSEMBLY** **INSTALLATION GUIDELINE**

The following is an installation guideline to be used for the installation of the Flex PVC Roof Rib Assembly. The Flex PVC Roof Rib Assembly can be installed over Flex PVC Fleece Back or Smooth Back Membranes. The Flex PVC membrane must be adhered and 60 mils or thicker.

Before installation of the Flex PVC Roof Rib Assembly, ensure that the Flex PVC Roofing System is installed in accordance to current Flex specifications and details. For best results, the Flex field membrane is to be installed parallel to the roof structure slope or "strapped" method.

### **Flex Roof Rib Installation**

1. Prepare the surface of the Flex Roofing System by cleaning the top surface of the membrane to remove any residual dirt and debris.
2. The Flex PVC Roof Ribs should be positioned parallel to the laps of the Flex Roofing System. Each field seam shall have a Flex PVC Roof Rib positioned on top of the weld but not covering the seam edge.
3. Determine the spacing of the Flex PVC Roof Rib Profile. Flex Detail 7.10, Flex SSM Rib Spacing provides the spacing of 3 different layouts. The layouts are generally determined by the designer of the roof.
4. Chalk lines on the roof membrane to assist in keeping the rib straight and properly spaced.
5. Place the ribs along the lay lines and join ribs together by inserting the provided pins into the alignment holes of each section and pushing together. To reduce separation of the connected rib pieces, use a hand welder to create a tack weld between the two ends of the rib.
6. Hold rib flat and against the field membrane. Tack weld the edge of the rib flange on the opposite side of the flange where the nozzle of the automatic welder will be inserted. Tack welds should be done every 2 to 3 feet to ensure proper alignment. Tack welds are performed by the hot air welding method using a hand hot air welder and a silicon roller. Note: Do not tack weld the entire width of the flange. This will disrupt the automatic welder.
7. Prepare the automatic welder by installing the Flex Rib Profile Wheel Kit on the automatic welder. Test weld a piece of the Flex Rib to a scrap piece of membrane to ensure the automatic welder is running properly.
8. Once an entire run of the Flex Rib has been tack welded in place, position the automatic welder over the first rib of the run. The automatic welder should be positioned so that the nozzle of the welder will be inserted under the opposite side of the rib flange that was tack welded.
9. Weld the Flex Rib using the automatic welder keeping the Flex Rib in a straight line.
10. Using a hand welder, hot air weld the ends of the adjoining Flex Rib together. The Flex Rib splice joints and exposed ends can be detailed by hot air welding small pieces of the same colored membrane over the joints or ends.

