



# Vi-Pro® EPDM SYSTEM

## Installation Manual

### Installation

We make every effort to ensure that the information provided in this document is current and accurate. However, errors, misprints, inaccuracies, omissions or other errors may sometimes occur despite our best efforts. Vi-PRO EPDM does not warrant that the content of this document including, without limitation, product-/installation descriptions or photographs and illustrations, is accurate or complete. With five alternative application methods there is a suitable Vi-PRO EPDM solution to every facade or window construction and every type of substrate.

### Substrate

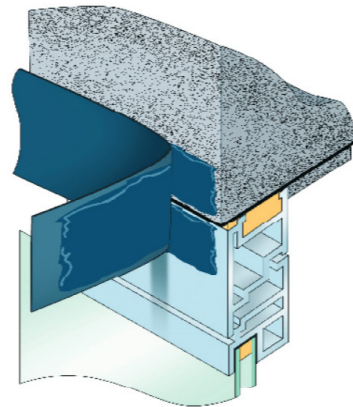
Surfaces to be bonded have to be clean and dry. If any oil based products are present these has to be washed away with Vi-Pro Cleaning Wash 907 before applying the Vi-Pro EPDM Membrane. On porous substrate like for instance concrete and light weight concrete the substrate must be primed before application. Priming is done with Vi-Pro EPDM Primer 908 alternatively Vi-Pro Contact Adhesive 904 that has been thinned with 10% Vi-Pro Cleaning Wash 907. When using contact adhesive on porous substrate we recommend the Vi-Pro Contact Adhesive 904 as primer and that the surface shall be stroked twice. It is important that the applied primer is left to dry before bringing on the adhesive.

Vi-Pro	Product type	Areas of use	Suitable substrates or surfaces
<b>Paste Adhesive 903</b>	Polymer based high viscosity adhesive with low solvent content. Colour: black	One-side adhering of EPDM and Butyl to substrates. By using Vi-Pro Paste Adhesive 903 the position of the strip can be adjusted, where Vi-Pro EPDM Contact Adhesive 904.	Ridge PVC, Aluminium, Steel, Galvanised steel, Glass, Acrylic glass, Concrete, Light weight concrete, Lead, Wood, Bitumen, EPDM, Butyl
<b>Contact Adhesive 904</b>	Polymer based contact adhesive containing inflammable solvents. Colour: black	Two-side adhering of EPDM and Butyl to substrates. Can also be used to splice EPDM or Butyl surfaces together, in combination with Vi-Pro Neutral Sealant.	Ridge PVC, Aluminium, Steel, Galvanised steel, Glass, Bitumen (not APP), Concrete, Light weight concrete, Wood, EPDM, Butyl
<b>Neutral Silicone</b>	Silicone based sealant with low solvent content. Colour: black	Sealing of overlap seams, details and corners in all Vi-Pro EPDM Systems.	PVC, PE, Aluminium, Steel, Galvanised steel, Glass, Acrylic glass, EPDM, Butyl
<b>Primer 908</b>	Solvent based primer, contains polymer. Highly inflammable. Colour: black	Treatment of absorbing or porous substrates before applying Vi-Pro EPDM Butyl Layer/Butyl Strips.	Concrete, Light weight concrete, Stone, Perlite, Mineral boards.
<b>Cleaning Wash 907</b>	Naphtha (Petroleum), hydrogen processed light. Highly inflammable. Colour: Black	Used on metal and Vi-Pro EPDM surfaces that are to accept adhesives which have been contaminated by oil-based products or excess dirt (note: on both mating surfaces in the case of Vi-Pro EPDM surfaces).	Hard PVC, Aluminium, Steel, Galvanised steel, Acrylic glass, Concrete, Light weight concrete, Lead, Wood, Bitumen, EPDM, Butyl

**Note:** Vi-Pro Contact Adhesive 904 and Vi-Pro Cleaning Wash 907 might discolour Hard PVC (uPVC) if these are combined.

## Vi-Pro EPDM Membrane with Vi-Pro Contact Adhesive 904

Vi-Pro Contact Adhesive 904 must be applied to both the mating surfaces that are to be bonded together. Stir the adhesive carefully before use and apply with solvent resistant brush or roller. Allow both surfaces to flash off until touch dry. Bond together and apply pressure using a silicone or steel rubber roller. Make sure that the strip is applied without building in tension and stress to the splice. On really porous substrate where it is obvious that the adhesive vanishes into the material, the substrate shall be primed with Vi-Pro Contact Adhesive 904 and left to dry before once more applying adhesive to bond the Vi-Pro EPDM Membrane.



We recommend that the bonding surface should be 10 cm wide or absolute minimum 5 cm. This gives an approximated consumption of 30-50 g/m depending on substrate. If the width of the bonding surface is less than 5 cm an additional mechanic fixation must be applied.

Seams between Vi-Pro EPDM Membrane must have a minimum overlap of 100 mm, bonded together with Vi-Pro Contact Adhesive 904.

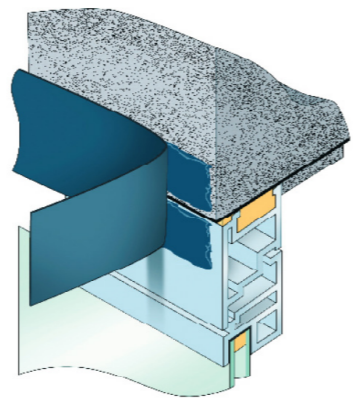
**Note:** Vi-Pro Contact Adhesive 904 must not be applied in temperatures below 5°C.

**Warning:** Vi-Pro Contact Adhesive 904 is highly flammable. Keep away from open fire.

The solvent in Vi-Pro Contact Adhesive 904 are harmful to polystyrene foam and similar products.

## Vi-Pro EPDM Membrane with Vi-Pro Paste Adhesive 903

Vi-Pro Paste Adhesive 903 is applied on substrate with standard type of hand or electric gun or putty spade. Apply the paste in 2-3 beads to the substrate. Wait a couple of minutes before fixing the Vi-Pro EPDM membrane into the paste. Spread the paste or apply the Vi-Pro EPDM membrane directly over the beads so that a 1 mm thick layer of adhesive is covering a width of approx 100 mm. Apply pressure using a silicone or steel roller. When adhering vertically the paste shall be applied and pressed until a 1 mm bead is visible outside the membrane edge, to seal the splice.



Make sure that the strip is applied without building in tension and stress to the splice.

Seams between Vi-Pro EPDM strips must have a minimum overlap of 100 mm, bonded together with Vi-Pro Paste Adhesive 903. The paste shall be applied and pressed until a 1 mm bead is visible outside the membrane edge, to seal the splice.

**Note:** Paste Adhesive 3300 must not be applied in temperatures below 5°C.

**Warning:** Paste Adhesive 3300 is flammable. Avoid open flames.

## Vi-Pro EPDM Membrane Butyl Layer/ Vi-Pro EPDM Membrane Butyl Strips

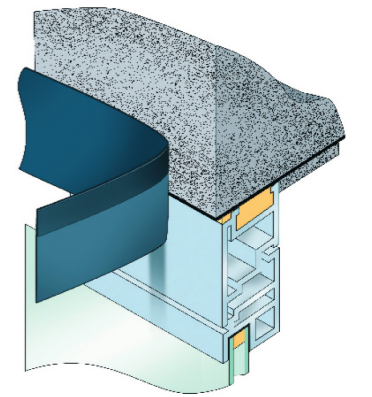
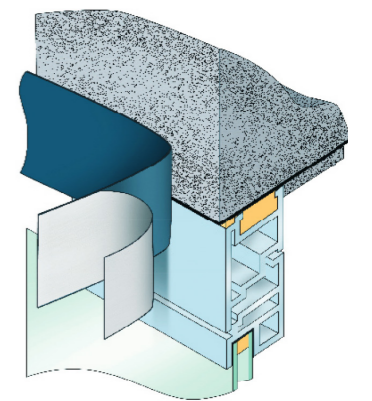
Vi-Pro EPDM Membrane Butyl Layer is a scrim reinforced composite EPDM rubber sheet coated with sticky Butyl that makes the sheet adhere to most available construction material.

Vi-Pro EPDM Membrane Butyl Strips is a composite EPDM rubber sheet partly coated with sticky Butyl that makes the sheet adhere to most available construction material. Tear of the protective foil and press the Vi-Pro EPDM Membrane Butyl Layer/ Vi-Pro EPDM Membrane Butyl Strips. Use a silicone or steel roller to apply pressure and get a good bonding between Vi-Pro EPDM Membrane Butyl Layer/ Vi-Pro EPDM Membrane Butyl Strips. Make sure that the strip is applied without building in tension and stress to the splice.

Vi-Pro EPDM Membrane Butyl Layer/ Vi-Pro EPDM Membrane Butyl Strips must be mechanically secured at the top to avoid sliding.

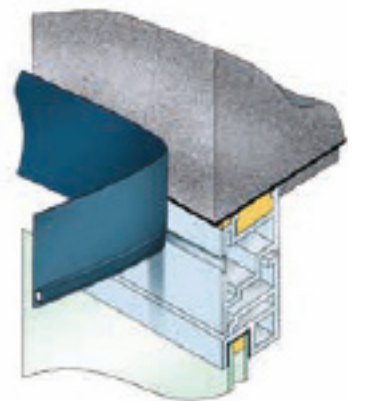
Seams between Vi-Pro EPDM Membrane Butyl Layer/ Vi-Pro EPDM Membrane Butyl Strips shall be done with Vi-Pro Contact Adhesive 904 or Vi-Pro Paste Adhesive 903.

**Note:** Vi-Pro EPDM Membrane Butyl Layer and Vi-Pro EPDM Membrane Butyl Strips must not be applied in temperatures below 5°C.



## Vi-Pro EPDM Membrane Click with Vi-Pro Paste Adhesive 903

Vi-Pro EPDM Membrane Click is an EPDM strip with an EPDM profile attached on one side. During installation the profile shall be firmly pressed into the mounting spline. It is possible to use silicon as anti friction agent for easier mantling. The side on the strip without profile must be glued to the substrate with Vi-Pro Contact Adhesive 904 or Vi-Pro Paste Adhesive 903. The area that shall be glued must be free from silicone to gain sufficient adhesion. Make sure that the strip is applied without building in tension and stress to the splice.



## Technical guidance

Proventuss technicians would gladly respond to every question or uncertainty regarding our Vi-Pro EPDM system.

## General information

All information in this installation instruction is based on our practical experience throughout the years as well as laboratory evaluations. Nevertheless, we cannot assume any responsibility for its use, the circumstance under which the products are stored, handled and used being beyond our control.

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