



# ASTEC® Re-Ply™ Roof System for METAL ROOFS

*Application Specification # AC-2014-MR-15©  
(15 Year Material & Labor Warranty)*

## PART I - GENERAL

### 1.01 DESCRIPTION

- A. This guideline specification includes the installation of the fluid applied ASTEC® Re-Ply™ System. The process effectively repairs defects in the aged roof and renews the weathered surface to extend the useful life of the roofing system.
- B. Work included is labor, materials, equipment and accessories and related services to complete the application in accordance with guidelines and details as approved by ASTEC® Re-Ply™.
- C. This guideline does not specifically outline application procedures for preparation and finishing of roof drains, vents, ductwork, flashings, parapet walls or sheet metal work. This scope of work shall be submitted by the contractor prior to the commencement of work and shall be performed utilizing published trade related practices.

### 1.02 QUALITY ASSURANCE

- A. Manufacturer Qualifications: ASTEC® Re-Ply™ will furnish upon request, certification the material meets the physical properties stated in this guideline.
- B. Contractor Qualifications: All work to be completed must be done by an ASTEC® Re-Ply™ preferred applicator.
- C. No deviation from this guideline will be accepted without prior written approval of ASTEC® Re-Ply™.

### 1.03 SUBMITTALS

- A. All projects requiring ASTEC Re-Ply System Turn Key Warranties must be submitted prior to commencement of work.
- B. Consult MSDS and Product Data Guideline for each product used before beginning work. MSDS and product Specifications for each product are available at either [www.icc-astec.com](http://www.icc-astec.com) or from an ICC representative.

### 1.04 PRODUCT DELIVERY, STORAGE, AND HANDLING

- A. Deliver MSDS for each product specified. Consult MSDS and Product Data Guideline for each product used before beginning work.
- B. Containers are to be labeled with manufacturer's name, product name, description and identification.
- C. **Deliver** material in original, unopened packages and containers.
- D. Store materials in a dry area above 40° and protect from water and direct sunlight.
- E. Any materials damaged in handling or storage must **NOT** be used.

### 1.05 JOB CONDITIONS (CAUTIONS AND WARNINGS)

- A. All **NEW** mechanical equipment, vents, skylights, etc., should be in place before the roof restoration system is installed.
- B. Coatings should be protected from traffic and other abuse until completely cured and installation is complete.
- C. Application of coatings with spray equipment may require some masking and possible erection of wind screens to prevent over-spray and drift damage. Protect surfaces of unrelated areas from coatings and over-spray possibility.



#### 1.05 Job Conditions cont.

- D. Application shall proceed **on** dry, clean surfaces only. In planning work consider environment and weather related conditions such as frost, mist, dew, condensation, humidity, and temperature. Temperature should be above 50°F. and rising, and stay above 40°F. long enough for initial cure to occur, moisture should not be imminent.
- E. A wet surface or a surface that is not thoroughly cured can be very slippery. All work environments should comply with current OSHA regulations.

#### 1.06 WARRANTY

- A. ASTEC® Re-Ply™ Roofing Systems warrants that materials provided are free from defects in manufacturing and will replace any material found to be defective.
- B. All ASTEC® Re-Ply™ Turn Key Warranty Systems must be installed by an authorized and trained contractor. Contact ASTEC® Re-Ply™ Representative or Technical Department for details regarding new and renewable warranty program.

## PART 2 – PRODUCTS

- A. The components of the coating system are to be products of ASTEC® Re-Ply™ or products approved as compatible and/or approved equal.
- B. Physical Properties of Cured Roofing System: Testing of the coating system shall be done using guidelines under ASTM-D6083, “Standard Specification for Liquid Applied Acrylic Coating Used In Roofing”.

#### 2.01 ASTEC® RE-PLY™ #4000 SURFACE CONDITIONER (REQUIRED IN CHALKY SURFACE CONDITIONS)

- A. See Data Sheet

#### 2.02 ASTEC® RE-PLY™ B 16-71 RUST PRIMER (REQUIRED IN CORROSION CONDITIONS)

- A. See Data Sheet

#### 2.03 ASTEC® RE-PLY™ WPM #9

- A. See Data Sheet

#### 2.04 ASTEC® RE-PLY™ WPM #9 BRUSH & ROLL GRADE

- A. See Data Sheet

#### 2.05 ASTEC® RE-PLY™ WPM #10

- A. See Data Sheet

#### 2.06 ASTEC® RE-PLY™ #900 CERAMIC COATING

- A. See Data Sheet

#### 2.07 ASTEC® RE-PLY™ #2000 FINISH COATING

- A. See Data Sheet



## 2.08 REINFORCING FABRIC

- A. See Data Sheet

## 2.09 BUTYL-BACKED TAPE

- A. See Data Sheet

## 2.10 RELATED MATERIALS

- A. Caulks, adhesives, thinners, primers, flashing materials and products of a similar nature shall be approved by the manufacturer of the ASTEC® Re-Ply™ System prior to use. All accepted materials should be applied in accordance with its manufacturer's specification and recommendations.

**NOTE:** See Product Data Guidelines for additional information and detailed instruction on each product.

## PART 3 - APPLICATION

### 3.01 SUBSTRATE INSPECTION

- A. An acceptable substrate shall be provided to receive the ASTEC® RE-PLY™ metal roof coating system.
- B. The roof surface must be clean, dry and over-all structurally sound.
- C. Inspect the metal roof surface for loose fasteners, seam separation, repair areas (including asphalt and silicone and acrylic caulking) and chalking. Inspect flashing details, seams, patches, expansion joints, terminations, and transitions. Determine which areas may not be watertight or structurally sound and in need of repair or replacement.
- D. If a structurally sound, stable, well secured, surface cannot be ensured the roof is not acceptable to receive the Astec® Re- Ply™ Metal Roof System.

### 3.02 SURFACE PREPARATION & CLEANING

- A. Fasteners, screws and fastening devices are first tightened or replaced so that all metal sections are firmly held and all joining sections closed.
- B. Pressure wash to achieve a clean, dry surface free of dirt, debris or other contaminants. Some surfaces may require additional passes of pressure washing to ensure adhesion of the Astec® Re-Ply™ Metal Roof System.
- C. Previously coated surfaces, including aluminum silver flake coatings, may require the application of ASTEC #4000 Surface Conditioner prior to the ASTEC® Re-Ply™ coating application. ASTEC® #4000 Surface Conditioner must be applied at a rate of 200-250 square feet per cut gallon and dry 1-2 hours prior to the application of other coatings.

### 3.03 COATING APPLICATIONS

- A. Prime all corroded surfaces. Scaling rust is first removed by scraping or by mechanical wire brush. Follow with a minimum two-coat application of B-16-71 Metal Primer applied to the roof surface at a minimum average coverage rate of 300 square feet per gallon per coat in rusted areas resulting in a Dry Film Thickness (DFT) of 6mils.
- B. Waterproof all fasteners with WPM #9 B & R waterproofing membrane, forming a watertight seal completely around the fastener.
- C. Waterproof horizontal seams with 4" wide reinforcing fabric embedded into an 8" wide wet coat of WPM#9 B&R. Use 4" or wider reinforcing fabric with WPM #9 B&R on joints, protrusions, vents & flashings. In all cases apply reinforcing fabric with a brush or roller to avoid wrinkles or gaps between the material and the surface. The fabric may be cut and overlaid. 4" BBT (butyl backed tape) is an alternative to the first coat of WPM #9 B&R and reinforcing fabric. In either case, all treated areas receive a second coat of WPM#9 B&R overlapping 2" each side at an average rate of 82 square feet per gallon per coat resulting in a DFT of 12 mils. BBT and reinforcing fabric must be coated on the same day with WPM #9 B&R.



### 3.03 Coating Applications cont.

D. Waterproof vertical seams with 2" wide reinforcing fabric embedded in a 4" wide wet coat of WPM #9 B&R spread along the seams. Cover cloth with a second coat of WPM #9 B&R overlapping 1" on each side at an average rate of 82 square feet per gallon per coat resulting in a DFT of 12 mils. For standing vertical seams see notes below.

\*2" BBT (butyl backed tape) is an alternative to the first coat of WPM #9 B&R and reinforcing fabric. In either case, all treated areas receive a second coat of WPM#9 B&R overlapping 2" each side at an average rate of 82 square feet per gallon per coat resulting in a DFT of 12 mils. BBT and reinforcing fabric must be coated on the same day with WPM #9 B&R. An alternative use of WPM#10 fibered waterproof membrane is available.

E. Using commercial airless spray equipment, spray apply 2 coats of Re-Ply™ #900 Ceramic coat or ASTEC® Re-Ply™ #2000 Finish over the entire roof at an average coverage rate of 100 square feet per gallon per coat. Second coat should be sprayed in an opposite direction to ensure that both sides of the corrugation are uniformly covered, resulting in a final coverage of no less than 18 mils DFT (equal to a combined coverage rate of 50 square feet per gallon)

## PROTECTION AND CLEAN-UP PROTECTION

- A. The roof system and all components must be protected from all other trades at the job site.
- B. All damage to the system must be repaired to comply with ASTEC™ Re-Ply® guidelines prior to final inspection for warranty approval. The cost of all related repairs will be the sole responsibility of the trades and/or subcontractors responsible for the damages.

## CLEAN-UP

- A. Site clean up is the responsibility of the contractor.
- B. All debris, containers, materials, equipment, and protection materials must be removed from the premises and properly disposed of. All work and storage areas must be in an undamaged and acceptable condition upon completion of clean up.

## DETAIL WORK

- A. The purpose of this specification is to act as a guideline and is not intended to extensively describe preparation procedures, scope of work to drains, ductwork, skylights, flashings, parapets, copings, scuppers, etc. This work should be the result of consultation with contractors, manufacturer's representatives and end-users prior to commencement of the project and shall be performed using standard and acceptable trade practices.

## NOTES

1. Heavy rust will require more B-16-71. Consult your ICC Representative.
2. Standing seam Roofs do not require application to vertical seams. Please consult with your ICC Representative for more information.
3. Skylights may require the application of ASTEC® RE-PLY™ METAL ROOF SYSTEM Re-Ply #2541 Skylight sealer. See product specifications for Skylight Sealer.
4. ASTEC® RE-PLY™ METAL ROOF SYSTEM Re-Ply #2000 Finish MUST BE APPLIED in the States of Florida, Georgia, Alabama, South Carolina, Mississippi, and Louisiana
5. Tinting of any ASTEC products must be approved by ICC. Failure to do so may invalidate manufacturer backed warranties.
6. Renewable Warranty Process - follow guidelines for substrate inspection and surface preparation/cleaning found in section 3.01 & 3.02 that are applicable to the existing warranted system. Upon completion of the inspection and surface preparation follow guidelines found in "Coatings Application" Section 3.03 E. Consult your ICC Representative for additional information.



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