

TECHNICAL BULLETIN

Connection of Rhepanol hfk/Rhepanol hsg to the Rhepanol fk self-sealing edge

Even after the product change from Rhepanol fk self-sealing edge to the hot-air-weldable roofing membrane Rhepanol hfk, the reparability of existing Rhepanol fk self-sealing edge roof surfaces remains fully intact.

The following illustrated step-by-step guide provides detailed instructions on how to professionally connect Rhepanol hfk / Rhepanol hsg to existing Rhepanol fk self-sealing edge membranes, ensuring a durable and functional connection.

Required Tools / Materials

- ✓ Quickscriber handle / Quickscriber pad, or alternatively a brush
- ✓ Disposable gloves
- ✓ Cleaning tissues
- ✓ Rhepanol solvent welding agent (Rhepanol-Quellschweißmittel)
- ✓ Rhepanol h-seam cleaner (Rhepanol h-Nahtreiniger)
- ✓ hsg connecting strip for Rhepanol hfk
- ✓ Handheld welding tool with steel brush, scissor, FDT Teflon pressure roller and, if necessary, a FDT metal pressure roller (narrow)
- ✓ (Root brush/scrubber for cleaning the roof surface)



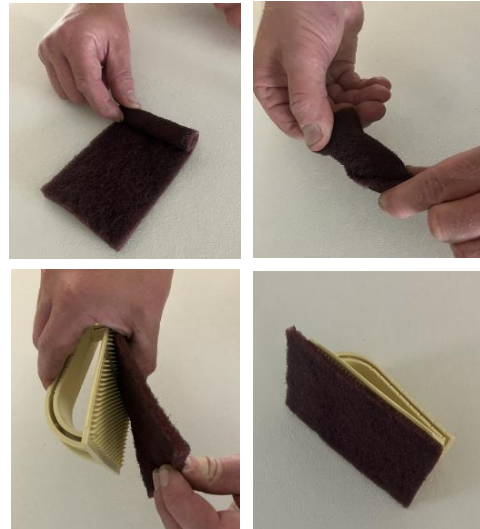
Cleaning

Thoroughly clean the old Rhepanol fk self-sealing edge roofing membrane at the joint area using water and a brush (scrubber) to remove dirt and debris. For heavy soiling, we recommend using an angle grinder with a scrubbing disc (e.g. a fan disc).



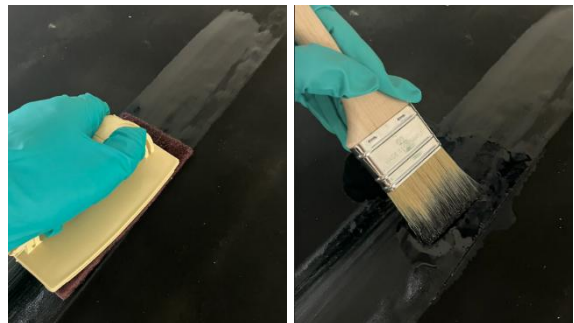
Refreshing of the old roof waterproofing Rhepanol fk self-sealing edge

The old roofing membrane should preferably be refreshed/cleaned using the Quickscriber pad (alternatively, a brush may be used). The pad is applied to the Quickscriber handle by rolling, twisting and pulling it.



After moistening the scrubber pad with Rhepanol solvent welding agent, the surface of the Rhepanol fk roofing membrane is lightly abraded using vigorous back-and-forth motions, thereby refreshing it. The cleaned area must be allowed to air dry thoroughly (at least 1 hour).

When using a brush, apply the Rhepanol solvent welding agent to the roofing membrane using circular motions. Here, too, the cleaned area must be allowed to air dry for at least 1 hour.



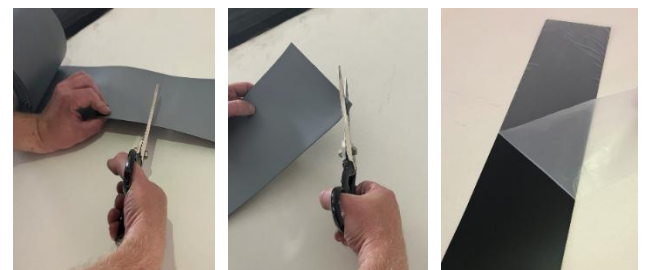
Surface inspection

You can tell if the roofing membrane is properly prepared for welding by pressing your finger against the freshly cleaned surface. When you lift your finger, slight threads should form.



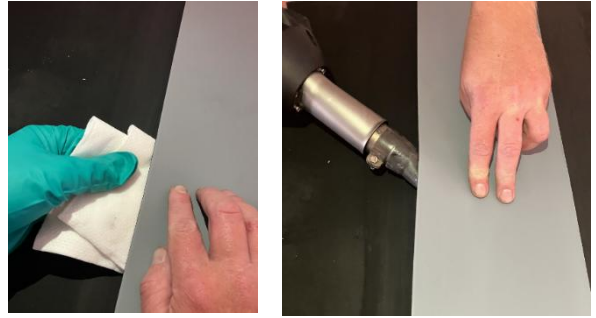
Repair Cut-to-Size Piece

In the next step, the Rhepanol hfk membrane or Rhepanol hsg connecting strips to be welded on, is cut to size and laid in place. Corners are rounded off. The backing film strip on the reverse side of the connecting strip is peeled off.



Pre-treatment

The Rhepanol hfk membrane or the Rhepanol hsg connecting strips to be welded is now pre-cleaned in the seam area using Rhepanol h-seam cleaner, and the membranes are attached in the middle.



Transitions and Capillaries

Any existing transitions, such as those resulting from welding overlap joints, are marked. These areas must later be planed down using a hot-air welding tool so that the joint can be made free of capillaries.



Hot-air welding

When using the handheld welding tool, we recommend a welding temperature of 500 °C. For the automatic welding machine, set the default settings to 520°C and a feed rate of 2.5 m, and adjust these as needed based on the operating conditions.



Capillary /Joint Formation

Smooth out any existing joints as described above. To do this, heat the joint of the overlapping roofing membrane and use the nozzle of the handheld welding tool to pull the material downwards. Alternatively, the joint can be heated and the transition smoothed out using the FDT Teflon pressure roller.



Seam Welding

After cleaning, allowing sufficient time for the surface to dry, tack-welding the area to be welded, and planing the seam, the final step involves welding the adjacent membrane or the Rhepanol hsg connecting strip using a handheld welding tool and a Teflon pressure roller. Alternatively, an automatic welding machine can be used.



Final Inspection

The completely welded Rhepanol hfk membrane or the Rhepanolh sg connecting strip can be inspected after 24 hours using a suitable seam tester. This is not possible immediately after welding, as the freshly welded seam is too soft due to the Rhepanol solvent welding agent and does not yet have sufficient strength. The solvents must first diffuse out to achieve proper strength.



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