



**ASTEC #900 System
Metal Roof Deck
Horizontal Seams**

5/4/04

**ALL GENERAL REQUIREMENTS
AND ARCHITECTURAL DETAILS ARE
PART OF THIS SPECIFICATION**

- 1. PRESSURE WASH** to achieve a clean, dry surface free of primer and any other contaminants. Some surfaces may require multiple passes of pressure washing to ensure adhesion of the ASTEC Coating System. Treat new metal with TSP and mildew areas with bleach solution and rinse.
- 2. FASTENERS**, screws and fastening devices are first tightened or replaced so that all metal sections are firmly held and all joining sections closed. Then rusted fasteners are primed with **ASTEC B-16-71**.
- 3. RUST PRIME** all corroded surfaces. Scaling rust is first removed by scraping or by mechanical wire brush. Follow with a minimum two-coat application of **ASTEC B-16-71 Metal Primer** applied to the roof surface at an minimum average coverage rate of 300 sf/gal per coat over the rusted areas.
- 4. Apply ASTEC #4000 Surface Conditioner** at a rate of 200 sq/ft per cut gallon over entire areas of previously coated, painted, factory applied color, or surfaces with silver aluminum coatings to provide proper adhesion of the subsequent coatings.
- 5. CAULK** all exposed cracks and seams with **ASTEC #2001 Acrylic Latex Caulk**, or other 100% acrylic or urethane caulking. Optionally, in gaps and cracks 1/8" or less in width, brush in **ASTEC WPM #9 BRUSH & ROLL**.
- 6. WATERPROOF** all fasteners with **WPM #9 B&R** waterproofing membrane. **WATERPROOF** horizontal seams and flashing with 4" wide polyester cloth embedded into an 8" wide wet coat of **WPM #9 B&R**. Install and waterproof all expansion control joints. Use 4" or wider polyester

cloth strips on joints, protrusions, vents, flashings, and repair areas. In all cases, apply cloth with a brush or roller to avoid wrinkles or gaps between the material and the surface. The cloth may be cut and overlaid. For a faster dry-in **BBT**, (butyl backed tape), is an alternative to the first coat of **WPM #9 B&R** and polyester cloth. In either case all treated areas receive a second coat of **WPM #9 B&R** overlapping 2" each side at an average rate of 82sf/gal per coat. (See Notes)

- 7. INSPECT SURFACE AREA** again to be sure it is clean, dry and free of defects. The **WPM #9** membrane must be free of all moisture, dirt, dust and debris before applying the ceramic finish coats.

- 8. APPLY ASTEC #900 CERAMIC PROTECTIVE COAT** by brush, roller or sprayer over the **WPM #9** membrane covering joints, flashings, and repair areas at a rate of 74sf/gal. Apply this coat to all walkways and termination points.

- 9. APPLY ASTEC #900 CERAMIC FIRST COAT** over the entire roof surface at an average coverage rate of 148sf/gal to lower substrate surface temperature, improve the rate of curing and the quality of the finished appearance.

- 10. APPLY ASTEC #900 CERAMIC SECOND COAT** over the entire roof surface at an average rate of 148sf/gal, resulting in a final covering of no less than twelve (12) mils DFT (equal to a combined minimum coverage rate of 74sf/gal). Over seams and repair areas the final specification requirements will be an average of 45 mils DFT.

- 11. APPLY #2541 SKYLIGHT SEALER** on Skylights at the rate of 225-335 sf/gal. (Optional)



**ASTEC #900 System
Metal Roof Deck
with Horizontal Seams**

5/4/04

Notes:

1. **ASTEC WPM #10**, applied at a rate of 25 sq/ft per gallon (40 mils DFT) is an approved equal and will be accepted as an alternative to using **ASTEC WPM #9** and polyester cloth on seams. **ASTEC #101 Accelerator** may be added to **WPM #10** to enhance cure time. *(Mixing ratio is critical. See appropriate product specifications for proper use)*
2. **When Substituting ASTEC WPM #10** on horizontal seams, install stitch screws or flat head pop rivets as needed to ensure the panels are mechanically fastened tightly together.
3. **ASTEC Specification #AC-112-9** is approved for **ICC's 15 Year System Warranty** by applying a third coat of **ASTEC #900 CERAMIC COAT** over the entire roof surface at an average rate of 148sf/gal, resulting in a final covering of no less than eighteen (18) mils DFT. Over seams and repair areas the final specification requirements will be an average of 51 mils DFT