



KEYSTONE
RV COMPANY



Alphaply Roof Start Date & Installation Instruction

2642 Hackberry Drive
PO Box 2000 Goshen,
IN 46527

Revised 5/9/2023

Alphaply

Product	OEM	Start Serial #	Start Date
Astoria	Dutchmen	MM916616	4/19/2021
Alpine	Keystone	N/A	N/A
Arcadia	Keystone	ML550406	5/26/2021
Aspen Trail - Plt 815	Dutchmen	M8925099	6/2/2021
Aspen Trail - Plt 803	Dutchmen	N/A	N/A
Aspen Trail - Plt 922	Dutchmen	N/A	N/A
Atlas	Dutchmen	MM960665	4/28/2021
Avalanche	Keystone	N/A	N/A
Bullet	Keystone	ND434307	4/19/2022
Cameo	Crossroads	P9310135	3/22/2023
Carbon	Keystone	KR805437	5/01/2019
Coleman	Dutchmen	N/A	N/A
Colorado	Dutchmen	M8950485	6/1/2021
Cougar - Plt 2	Keystone	L2508777	3/16/2020
Cougar - Plt 31	Keystone	LV509082	3/23/2020
Cougar - Plt 901	Keystone	MC500914	6/09/2020
Cruiser	Crossroads	N/A	N/A
Fuzion	Keystone	KF810917	3/05/2019
Hampton	Crossroads	P9330295	3/13/2023
HC Montana	Keystone	N/A	N/A
Hideout - Plt 7	Keystone	L7246205	1/27/2020
Hideout - Plt 57	Keystone	N/A	N/A
Hideout - Plt 903	Keystone	N/A	N/A
Impact	Keystone	KF815488	3/05/2019
Kodiak	Dutchmen	N/A	N/A
Longhorn	Crossroads	N/A	N/A
Montana	Keystone	N/A	N/A
Outback	Keystone	MB454565	4/22/2021
Passport	Keystone	ND415443	4/19/2022
Raptor	Keystone	LR800090	4/30/2019
Redwood	Crossroads	P9340105	4/3/2023
Residence	Keystone	N/A	N/A
Retreat	Keystone	N/A	N/A
Springdale	Keystone	M3111945	5/25/2021
Sprinter	Keystone	N/A	N/A
Sunset	Crossroads	N/A	N/A
Texan	Crossroads	N/A	N/A
Volante	Crossroads	N/A	N/A
Voltage	Dutchmen	MZ990221	8/19/2020
Yukon	Dutchmen	MZ980188	8/19/2020
Zinger	Crossroads	N/A	N/A



BY ALPHA SYSTEMS INSTALLATION INSTRUCTIONS

1. AlphaPly is a roof system where some component areas need to be primed. Primer #4110 must be applied and completely dry prior to butyl tape being applied. **DO NOT PRIME** polycarbonate, ASA, PVC, Fiberglass and clean metal. Sealant will not adhere to some components without primer. Contact your Alpha representative for components needing primed and submit any new roof components to Alpha Systems for testing. Primed components must be dry and free of debris prior to sealant being applied.
2. Route all necessary vent and accessory openings. Sand all wood decking openings, seams and edges to a smooth surface. Blow debris off roof (wood decking) with air hose.
3. Apply duct tape or Mylar backed tape (non-porous, 2" minimum width) evenly onto roof and sidewall to cover sharp metal or fiberglass edge.
4. *Optional:* Apply Alpha QCT290 tape or a porous tape (masking, seam tape or fiberglass mesh tape) to seam the decking where butted together. This will help hide decking seams and give the finished roof a smoother appearance while strengthening the joint.
5. Make sure all screw heads and surfaces are smooth and level throughout.
6. Place roof membrane on top of unit. Cut the roof sheet to fit roof length with an excess of at least 6" front and rear. Square as required.
7. "Bed Sheet" the roof. That is, fold it in half so half of the deck is exposed.
8. Apply water-based adhesive, #8019/8021/8010 or 8011, in a wet film thickness of 8-15 mils with a paint roller or brush to the exposed half of the roof deck. (1 gal. will cover approximately 160-200 sq ft.)
9. Lay the roof membrane over the wet #8019/8021/8010 or 8011 adhesive. Adhesive will change color if open time is missed.
10. Before removing air pockets with a squeegee (gray neoprene head will not streak), the membrane must be lifted and pulled taut from each of the four corners of the roof. The membrane needs to be adjusted both in width (side to side) and length (front to rear) to ensure the roof is as flat as possible before the squeegee process.
11. Remove all air pockets with a squeegee; press firmly working from the center outward toward the edges. All wrinkles must be removed at this point for a quality installation. The roof will tighten and conform as the adhesive cures.
12. Repeat steps 6 through 10 for remaining half of roof. (In mass production situations, the entire roof may be glued all at once.)
13. Using a utility knife "x" cut all roof openings. Make sure you round all 90-degree corners to eliminate the possibility of running cuts. Surplus material can be stapled inside the vent openings. Let surplus material drape over the side of the unit for perimeter finishing. **The roof edges can be sharp – IT IS REQUIRED that duct tape or Mylar backed tape be used to avoid edge splits.**
14. Apply butyl tape to the backside of the roof-edge molding. (Size of butyl will depend on unit design) Then while holding the bar, draw surplus material tight with a downward pull. Attach the drip edge bar, working outward from the center of the unit. When fully installed, use a utility knife to cut surplus material from below the bar.
15. Assemble and attach roof molding where the roof membrane meets the front and rear end caps. **Remember the roof molding must be secured to a cross member.**
16. Apply butyl tape to all vents and accessories on the roof. Q-130 1/8" x 3/4" is recommended for all roof top components where screws are used to penetrate roof membrane.
17. Prior to sealing the roof, make sure to have Alpha #5121 self-leveling (for the top of the roof) and #5160 non-sag sealant (top of the roof-edge molding) available. **ONLY ALPHA SUPPLIED SEALANTS CAN COME IN CONTACT WITH YOUR ALPHAPLY MEMBRANE. DO NOT USE SILICONE!** Silicone will not adhere to the AlphaPly roof membrane. Seal around all vents and accessories as well as all visible screw heads. Both edges of the front and rear roof molding must also be sealed. There is **no need** to spread the sealant as you are applying it. A minimum 3/8" x 1" bead will work for most applications.

YOUR ALPHAPLY INSTALLATION IS NOW COMPLETE!

*Butyl tape provides the "Primary Seal" against water infiltration or penetration - the lap sealant is a secondary seal.

*Do not allow **solvents/primer** to come in contact with the roof membrane.

*Butyl tape must be compressed 30% to 40% to perform correctly.

www.alphallic.us

TOLL FREE 1-800-462-4698

Replacement Parts List

Vendor #	Description	Keystone #
N801000G	Adhesive - Roof - 8010 - 1 Gal/Can	376374
N411000G	Sealant - Primer - Superflex - Gallon	472602
Q13018*34	Butyl - Tape - 1/8" x 3/4" x 30' - Q130 - 20/Case	620483
N512101T	Sealant - Self Leveling - 5121 Alphathane 100% - White - Tube	639155
N516001ST	Sealant - Lap Caulk - 5160 White - Non-Sag - Tube - Alphathane	639157
N411000Q	Sealant - Primer - Superflex - Quart	669675
APM400WH15	Roof - Membrane - 4.0' x 15' - Alphaply - White - TPO - 60/Sf/RI	679824
APM950WH45	Roof - Membrane - 9.5' x 45' - Alphaply - White - TPO - 427.50 Sf/RI	679920

AlphaPly Cleaning Procedures For Gray Or Black Stains

The recommended cleaning procedure for the removal of stains is as follows:

Cleaning Procedure: Removes gray and black stains.

Materials required: Soft brass bristle brush, small paint brush, bleach, clean rag, hose or power washer.

- 1.) Brush on bleach 3-5 mills with small paint brush to the designated areas.
- 2.) Let bleach sit for 10 minutes.
- 3.) Take a soft brass bristle brush and scrub vigorously to clean stained areas.
- 4.) To achieve maximum effect wipe scrubbed area with a clean rag, then hose off or power wash the same area to rinse remaining residue.
- 5.) The cleaning procedure is now complete.

** Procedure may need to be done more than once to achieve desired look.



CLEANING AND MAINTAINING YOUR ALPHA SYSTEMS ROOF MEMBRANE

Proper care and maintenance of the Alpha Systems roof membrane is critical to sustain years of trouble-free performance. Normal maintenance is simple, easy and requires no special materials. The Alpha roof membrane is quite inert and will resist weathering well; nor does it require the periodic application of products to protect it from ultra-violet light or ozone. In fact, these products can often cause damage to the roof membrane.

Periodic cleaning (*three to four times per year*) is the primary maintenance required. Alpha Systems recommends using a non-abrasive household cleaner, such as dish soap, and a medium-bristled scrub brush. Do not use any harsh or highly abrasive products during routine cleaning. When finished cleaning, remember to thoroughly rinse the roof and sidewalls in order to remove any soap residue and to prevent streaking.

CARE SHOULD BE EXERCISED WHEN WORKING ON TOP OF YOUR UNIT! THE ROOF MAY BECOME SLIPPERY WHEN WET. DO NOT USE ACETONE, OR ANY OTHER PRODUCTS CONTAINING PETROLEUM DISTILLATES, ON THE ALPHA SYSTEMS ROOF MEMBRANE. USE OF THESE PRODUCTS WILL DAMAGE THE MEMBRANE.

Periodic inspection of the roof, during cleaning, is highly recommended. Check the membrane for signs of damage. If damage does occur, the membrane can most often be patched (refer to the Care and Repair Instructions).

While inspecting the roof, it is also important to check the lap sealant used in all termination areas. Inspect the existing sealant around all accessories and fasteners for signs of cracking or voids. If additional sealant is needed, **ONLY ALPHA BRAND SEALANTS CAN COME IN CONTACT WITH ALPHA ROOF MEMBRANE.**

If you have an Alpha **Superflex** membrane use Alpha's #1021 and/or #1010 sealant. If you have an Alpha **AlphaPly** membrane use Alpha's #5121 and/or #5160 sealant.



Explaining Air Pockets and Swelling in the Alpha Systems Roofing Membrane

Reasons Air pockets can appear under a roof membrane -

- The most common reason is the air pockets were not pushed/squeegeed out during installation of the membrane.
- For air pockets where the membrane rolls over the edge of the unit; we do ask the installers not to stretch the material during installation to allow for expansion and contraction of the membrane. For this reason, a manufacturer may intentionally leave the membrane slightly loose along the edge of the unit during installation to avoid a stress point in that area.
- Air pockets can become more or less noticeable due to weather conditions, temperature and humidity. Trapped moisture air will expand when the sun warms the roof and air pockets will occur along the seams in the boards. Often the membrane will contract back in to position in the evening when the roof cools back down.
- Air bubbles can also occur at the seam of the roof decking due to the flexing and twisting that occurs during transit, as well as during times of natural expansion and contraction of the wood underlayment.

Air pockets do mean there is room for expansion and contraction, therefore lessening the chance of stress crack later. These are not considered defects in the roofing and will not affect the performance of the membrane.

Swelling may also occur in a newer unit around any of the components on the roof that have been sealed, or a unit that has had new sealant applied. This is due to the solvents in the sealant interacting with the membrane material. This swelling is not abnormal and will recede with time as the solvents cure out of the sealant.

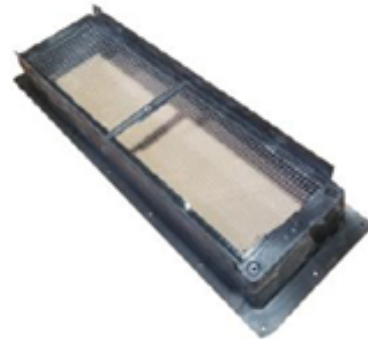
Alpha System's ensures that any of the fore described conditions will not impact the effectiveness of the Alpha System's Roof Membrane in protecting your unit. Please be reassured that your Alpha Roof membrane will NOT come loose due the air pockets that have been described here, your Alpha Roof membrane will remain securely attached to your unit.

Sincerely,

Alpha Systems, LLC.



Primed





Non-Primed

