



KEYSTONE
RV COMPANY



Superflex Roof Start Date & Installation/Repair

2642 Hackberry Drive
PO Box 2000
Goshen, IN 46527



Superflex Roof Installation Instructions

1. 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 an air hose.
2. Apply duct tape (2" minimum width) evenly onto roof and sidewall to cover sharp metal or fiberglass edges.
3. *Optional:* Apply a porous tape (masking or fiberglass mesh) 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.
4. Make sure all screw heads and surface are smooth and level throughout.
5. 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.
6. "Bed Sheet" the roof. That is, fold it in half so half of the deck is exposed.
7. Apply the water based adhesive, Alpha #8010, in a wet film thickness of 8-10 mils with a paint roller or brush to the exposed half of the roof deck. (1 gallon will cover approximately 160-200 sq. ft.)
8. Lay the roof membrane over the wet #8010 adhesive.
9. Before removing air pockets with a squeegee (a 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. 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.
10. Repeat steps 6 through 10 for remaining half of the roof. (In mass production situations the entire roof may be glued all at once.)
11. 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 be used to avoid edge splits.**
12. 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.
13. 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.**
14. Apply butyl tape to all vents and accessories on the roof to components where screws are used to penetrate roof membrane.
15. Prior to sealing the roof, make sure to have Alpha #1021 Self-Leveling Sealant (for the top of the roof) and Alpha#1010 Non-Sag Sealant (for the roof edge moldings) available. **ONLY ALPHA SUPPLIED SEALANTS CAN COME IN CONTACT WITH OUR SUPERFLEX MEMBRANE. DO NOT USE SILICONE!**
16. **Silicone will not adhere to the Superflex roof membrane.** Seal around all vents and accessories. Apply sealant to 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" bead will work for most applications.

THE SUPERFLEX ROOF INSTALLATION IS NOW COMPLETE

***See Alpha Roof Repair Part List on following page for parts reference.**

***Butyl tape provides the "Primary Seal" against water infiltration or penetration in these membrane roof assemblies. The lap sealant is a secondary seal.**

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

Superflex

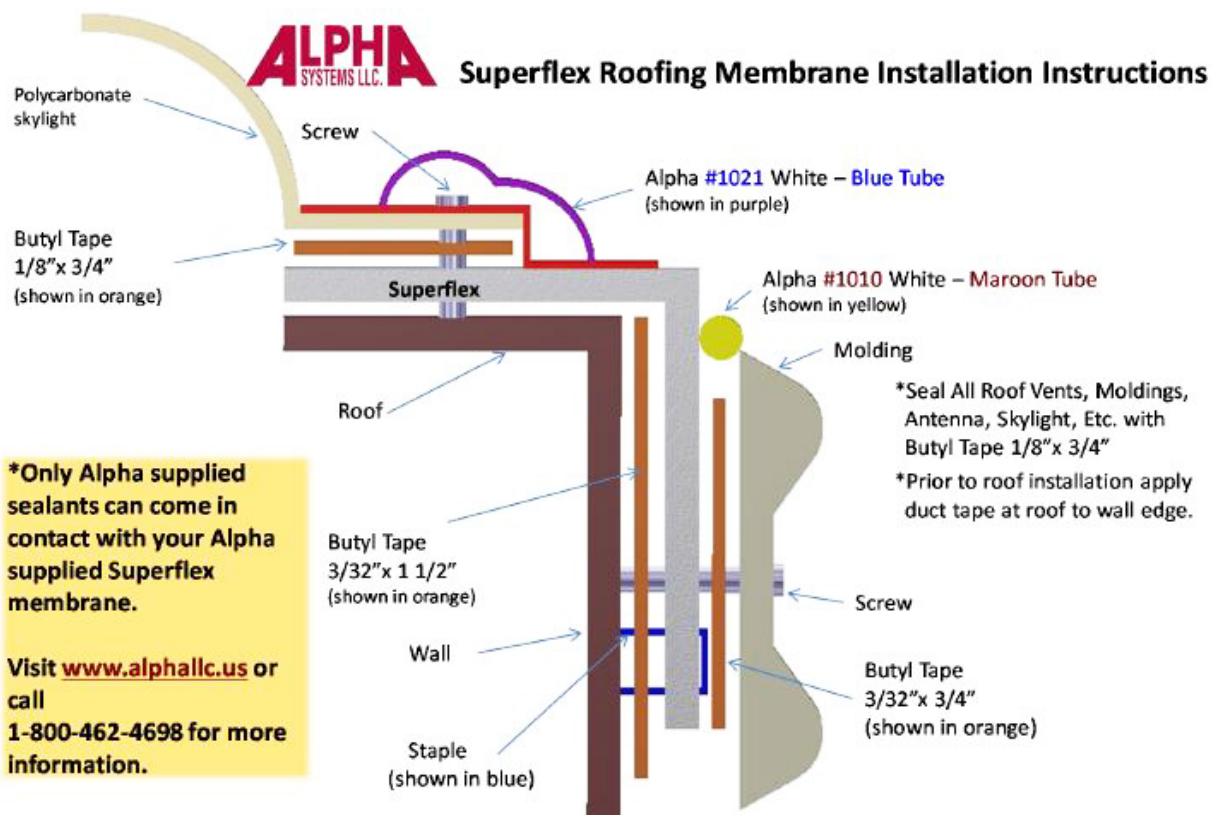
Product	OEM	Started With VIN	Ended With VIN
Aerolite	Dutchmen	EK175250	N/A
Alpine	Keystone	DE780800	N/A
Aspen Trail	Dutchmen	All	*NJ924870
Atlas	Dutchmen	All	N/A
Avalanche	Keystone	DE760634	N/A
Bullet East	Keystone	DD423383	N/A
Bullet West	Keystone	EX421041	N/A
Cameo	Crossroads	All	N/A
Carbon	Keystone	All	N/A
Coleman	Dutchmen	DT210077	*NJ934310
Cougar	Keystone	D2506542	N/A
Cruiser	Crossroads	All	N/A
Denali East	Dutchmen	DP630043	N/A
Denali West	Dutchmen	DD312850	N/A
Dutchmen East	Dutchmen	DM446129	N/A
Dutchmen West	Dutchmen	DT210083	N/A
Endurance	Dutchmen	All	N/A
Energy	Keystone	All	N/A
Fireside	Keystone	E3170000	N/A
Fuzion	Keystone	DF811230	N/A
Hampton	Crossroads	All	N/A
HC Cougar	Keystone	All	N/A
HC Montana	Keystone	FA740535	N/A
Hideout	Keystone	D7203845	N/A
Hornet	Keystone	D7203849	N/A
Infinity	Dutchmen	DC662746	N/A
Impact	Keystone	All	N/A

***For units marked, please check catalog for current usage.**

Superflex

Product	OEM	Started With VIN	Ended With VIN
Kodiak	Dutchmen	DK171579	*PJ970296
Komfort FW	Dutchmen	DP630239	N/A
Komfort TT	Dutchmen	DD312955	N/A
Laredo	Keystone	DE602652	N/A
Longhorn	Crossroads	All	N/A
Montana	Keystone	G4701165	N/A
Outback	Keystone	DB453042	N/A
Passport East	Keystone	ET410237	N/A
Passport West	Keystone	EX410940	N/A
Raptor	Keystone	ER800025	N/A
Razorback	Dutchmen	DM446239	N/A
Redwood	Crossroads	All	N/A
Residence	Keystone	E3160000	N/A
Rubicon	Dutchmen	DM446216	N/A
Retreat	Keystone	E7260138	N/A
Springdale East	Keystone	D3102989	N/A
Springdale West	Keystone	DG103707	N/A
Sprinter	Keystone	E1530683	N/A
Summerland	Keystone	D3150909	N/A
Sunset	Crossroads	All	N/A
Sydney	Keystone	DB630265	N/A
Texan	Crossroads	All	N/A
Vantage	Keystone	All	N/A
Volente	Crossroads	All	N/A
Voltage	Dutchmen	DC662792	N/A
Yukon	Dutchmen	All	N/A
Zinger	Crossroads	All	N/A

***For units marked, please check catalog for current usage.**



Alpha Roof Installation Replacement Parts

*Indicates Parts Keystone No Longer Carries

Type	Alpha #	KRV #	Description
Roofing	SFXM400WH15	637351	Roof - Membrane - 4.08' x 15' - Superflex - White - TPO - 60 Sq Feet
Roofing	SFXM950WH45	637341	Roof - Membrane - 9.5' x 45' - Superflex - White - TPO - 427.5 Sq Feet
Roofing	SFXM400BE15	637347	Roof - Membrane - 4.0 (48") x 15' - Superflex - Beige - TPO - 60'/rl
Roofing	SFXM950BE45	637342	Roof - Membrane - 9.5' x 45' - Superflex - Beige - TPO - 427.5 Sq Feet
Roofing	SFXM408AL15	637348	Roof - Membrane - 4.08' x 15' - Superflex - Almond - TPO - 61.2 Sq Feet
Roofing	SFXM950AL45	637344	Roof - Membrane - 9.5' x 45' - Superflex - Almond - TPO - 427.5 Sq Feet
Sealant	N101001T	367536	Sealant - Lap Caulk - 1010 White - Non-Sag - Tube - Alpha - 30/Cs
Sealant	N101004T	367197	Sealant - Lap Caulk - 1010 Beige - Non-Sag - Alpha - Tube 30/Cs
Sealant	N101006T	485978	Sealant - Lap Caulk - 1010 Almond - Non-Sag - Alpha - Tube 30/Cs
Sealant	N101003T	*442994	Sealant - Lap Caulk - 1010 Gray - Non-Sag - Tube - Alpha - 30/Cs
Sealant	N101002T	385477	Sealant - Lap Caulk - 1010 Black - Non-Sag - Tube - Alpha - 30/Cs
Sealant	N102101T	238454	Sealant - Self Leveling - 1021 White Low V.O.C. - Tube - Alpha - 30/Cs
Sealant	N102104T	366398	Sealant - Self Leveling - 1021 Beige Low V.O.C. - Tube - Alpha - 30/Cs
Sealant	N511304T	*422279	Sealant - Self Leveling - Beige - 100% Solid - Alpathane - Tube 24/Cs
Sealant	N102106T	485976	Sealant - Self Leveling - 1021 Almond Low V.O.C - Tube - Alpha - 30/CS
Sealant	N102103T	442996	Sealant - Self Leveling - 1021 Gray Low V.O.C. - Tube - Alpha - 30/Cs
Adhesive	N801000G	376374	Adhesive - Roof - 8010 - 1 Gal/Can



RECOMMENDED ROOF REPAIR METHOD FOR ALPHA SYSTEMS SUPERFLEX MEMBRANE

Use of 6" Cover Strip Along Width of Roof

1. Remove all necessary roof edge moldings attached to the area where the membrane will be seamed.
2. Evaluate existing roof decking. If decking is soft, please replace. See Alpha SuperFlex Installation Instructions on apply adhesive to decking with the replacement membrane. Butt this new piece of SuperFlex roofing directly next to unaltered adhered, existing SuperFlex roof membrane.
3. Thoroughly clean the area to be seamed with a household cleaner such as Spic-n-Span™ or Simple Green™. Do not pour the cleaner directly onto the roof, but onto a separate rag. Clean thoroughly and wipe off any oxidation build up.
4. After cleaning, apply Alpha's Primer (SPC-3)* to a scratch pad. Use the scratch pad to apply the primer to the SuperFlex roof membrane, 3.5 inches on each side of the seam. The membrane should be clean and slightly tacky before applying the patch.
5. Alpha's Cover Strip is approximately 6" wide. Roll the tape out along the entire width of the roof. To ensure adequate length, cut Cover Strip so both edges overhang over the side of the side of the unit. Starting at one end of the unit, remove the release paper from the underside of the patch. Use hand pressure to position the patch in place as the release paper is removed. Once the release paper has been removed from the entire patch, use a hand roller to fully adhere the patch. Work out any air bubbles using the hand roller.
6. Use butyl tape underneath the roof edge moldings to help prevent water penetration. Reapply roof edge moldings.
7. Apply a generous bead (1/2" in diameter) of Alpha Systems 1010 Non-Sag along both edges of the Cover Strip.

THE SUPERFLEX ROOF REPAIR IS NOW COMPLETE

*See Alpha Roof Repair Part List on following page for parts reference.

FOR FUTURE MAINTENANCE: During routine cleaning (3-4 times a year), all caulk and sealants should be inspected for voids or cracking. If the caulk is cracking, pull up any loose caulk. Do not use any tools that could puncture the SuperFlex roof membrane. If the caulk is still adhered to the roof, simply apply a generous amount of Alpha Systems #1010 Sealant on top of the existing caulk.



RECOMMENDED ROOF REPAIR METHOD FOR ALPHA SYSTEMS SUPERFLEX MEMBRANE (CONT.)

Alpha Roof Repair Parts List (Using 6" Cover Strip)

*Indicates Parts Keystone No Longer Carries

Type	Alpha #	KRV #	Description
Cover Strip	SFXCS15	498963	Cover Strip w/Adhesive - .50 (6") x 15' - White
Cover Strip	SFXCS	498958	Cover Strip w/Adhesive - .50 (6") x 100' - White
Cover Strip	SFXCS15	*498964	Cover Strip w/Adhesive - .50 (6") x 15' - Beige
Cover Strip	SFXCS	*498961	Cover Strip w/Adhesive - .50 (6") x 100' - Beige
Cover Strip	SFXCS15	*498965	Cover Strip w/Adhesive - .50 (6") x 15' - Gray
Cover Strip	SFXCS	*498962	Cover Strip w/Adhesive - .50 (6") x 100' - Gray
Cover Strip	SFXCS15	N/A	Cover Strip w/Adhesive - .50 (6") x 15' - Almond
Cover Strip	SFXCS	N/A	Cover Strip w/Adhesive - .50 (6") x 100' - Almond
Sealant	#1010	367536	Self Leveling - White - Non Sag - Tube
Sealant	#1010	367197	Self Leveling - Beige - Non Sag - Tube
Sealant	#1010	442994	Self Leveling - Gray - Non Sag - Tube
Sealant	#1010	485978	Self Leveling - Almond - Non Sag - Tube
Sealant	#1010	385477	Self Leveling - Black - Non Sag - Tube
Primer	SPC-3	498966	Roof - Primer - For Cover Strip Adhesive - 1 Pint

Superflex 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.



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.