SPECIFICATION SUPPLEMENT

E-02

EPDM Membrane Splicing and Splice Repairs
(Including VersiFleece and VersiFleece AC Membrane)

July 2025

The information contained represents guidelines to address possible requirements as part of the building specification as listed under the Quality Assurance or Performance Article. Versico recommends that the building owner retain a design professional to verify that these guidelines are appropriate.

A. **General**

1. Fully Adhered or Ballasted Roofing Systems

a. **Projects with 10, 15, 20 and 25 year Warranties – Detail VGC-2.1A**

Side Laps / End Laps: Tape splices must be a minimum of 2-1/2" wide using **3" wide field-applied Quick-Applied Seam Tape OR 3" factory-applied Quick-Applied Seam Tape (QAT)**. (**Detail VGC-2.1A**).

Splice Intersections: 'T'-Joints are to be flashed with a bead of lap sealant and 6"x6" minimum Quick-Applied 'T'-Joint Cover, (for membranes of maximum thickness of 75 mil). (**Detail VGC-2.1A**). **For membranes of thickness of 90 mil**, Apply a second layer of 12"x12" Quick Applied 'T'-Joint Cover centered over 6"x6" or 7"x9" 'T'-Joint Cover. (**Detail U-2A.1– Option 2**).

Note: A minimum 6"x6" section of Quick-Applied Uncured Flashing may be used as a 'T'-Joint cover. Quick-Applied Uncured Flashing is available in rolls of 6", 9" and 12".

b. **Projects with 30 year warranties – Detail VGC-2.1A**

OPTION 1:

Side Laps / End Laps: Tape splices may be a minimum **3" wide Factory-Applied QA Seam Tape (VersiGard QAT)**. In addition the entire field splice must be overlaid with a continuous 6" wide Quick Applied Overlayment Strip. (See **Detail VGC-2.1A -Option 1**).

Splice Intersections: Overlay the entire field splice with a continuous 6" wide Quick-Applied Overlayment Strip. Apply Lap Sealant at all Intersections between Quick-Applied Overlayment Strip. (See **VGC-2.1A -Option 1**).

OPTION 2:

Side Laps / End Laps: Tape splices may be a minimum of 5-1/2" wide using **6" wide Factory-Applied QA Seam Tape (VersiGard QAT)**. (**Detail VGC-2.1A – Option 2**).

Splice Intersections: 'T'-Joints are to be flashed with a bead of lap sealant and 6"x6" minimum Quick-Applied 'T'-Joint Cover. Apply a second layer of 12"x12" QA 'T'-Joint Cover centered over 6" x 6" QA 'T'-Joint Cover. (**Detail VGC-2.1A – Option 2**).

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Note: A minimum 6”x6” section of Quick-Applied Uncured Flashing may be used as a ‘T’-Joint cover. Quick-Applied Uncured Flashing is available in rolls of 6”, 9” and 12”.

2. VersiGard Reinforced Mechanically Attached Roofing Systems

a. **Projects with 10, 15, 20 and 25 year Warranties – Detail VGMA-2.1 and VGMA-2.2**

Side Laps: Regardless of Warranty duration, where fastening plates are placed, shall be spliced using **6” wide Factory-Applied QA Seam Tape (VersiGard QAT)** or **6” wide Field-Applied QA Seam Tape**. The splice tape shall be centered over the plates to extend approximately 2” on each side. QA Seam Tape must extend approximately 1/8” beyond the edge of the overlapping membrane. (**Detail VGMA-2.1**).

End Laps: Shall be spliced using a **3” wide QA Seam Tape** resulting in a minimum splice width of 2-1/2” for a maximum of 20 year warranties. (**Detail VGMA-2.2**).

Splice Intersections: ’T’-Joints are to be flashed with a bead of lap sealant and 6”x6” QA ‘T’-Joint Cover. (**Detail VGMA-2.1**).

b. **Projects with 30 year Warranties – Detail VGMA-2.1A and VGMA-2.2**

Side Laps: Where fastening plates are placed, shall be spliced using **6” wide Factory-Applied QA Seam Tape (QAT) OR 6” wide Field-Applied QA Seam Tape**. The splice tape shall be centered over the plates to extend approximately 2” on each side. QA Seam Tape must extend approximately 1/8” beyond the edge of the overlapping membrane. (**Detail VGMA-2.1A**).

End Laps: Shall be spliced using **6” wide Factory-Applied QA Seam Tape (QAT) OR 6” wide Field-Applied QA Seam Tape** resulting in a minimum splice of 5-1/2” wide for a maximum of 30 year warranties. (**Detail VGMA-2.2**).

Splice Intersections: ’T’-Joints are to be flashed with a bead of lap sealant and 6”x6” QA ‘T’-Joint Cover. Apply a second layer of 12”x12” QA ‘T’-Joint Cover centered over 6”x6” QA ‘T’-Joint Cover. (**Detail VGMA-2.4**)

3. VersiFleece AC EPDM Mechanically Attached

a. **Projects with 10, 15 and 20 year Warranties - Detail AC-MA1**

Side Laps, the tape splices may be a minimum of 5-1/2” wide using 6” wide **Field-Applied QA Seam Tape OR 6” Factory-Applied QA Seam Tape (VersiGard QAT)**. (**Detail AC-MA1**).

End Laps: A minimum of 6” wide Quick Applied cured Coverstrip or Quick Applied Overlayment Strip shall be used at all end laps and shall be centered over the leading edge (butt edge) of the splice. (**Detail AC-MA1**).

Splice Intersections: All intersections between the Quick Applied Coverstrip and side laps shall be overlaid by a 6”x6” minimum Quick Applied ‘T’-Joint cover with a bead of Lap Sealant. (**Detail AC-MA1**).

Note: A minimum 6”x6” section of Quick-Applied Uncured Flashing may be used as a ‘T’-Joint cover. Quick-Applied Uncured Flashing is available in rolls of 6”, 9” and 12”.

B. **Splicing Procedures**

1. **Set the Membrane** – Overlap the EPDM membrane a minimum 2 1/2“or 5 1/2” (63 or 138 mm) to coincide with the QA Seam Tape width. Stagger factory seams on dusted EPDM to avoid a double thickness of membrane. For sheets without a pre-printed set mark, place a set mark 1/8” to 1/2” (3-13 mm) beyond the leading edge of the top membrane when field applying QA Seam Tape. Locate field splices outside of drain sumps. The pre-marked line on the membrane edge can also be used as a guide for positioning splice tape.

   Note: Refer to Step 5 for position of membrane with Factory-Applied Tape.

2. **Clean the Splice Area** - The entire membrane surface where QA Seam Tape will be applied must be clean and free of any residual mica dust or dirt. QA Seam Tape will not adhere to dusted or dirty surfaces.

   a. Remove loose mica dust on dusted EPDM by brooming or wiping with a clean, dry rag or HP Splice Wipe. Pay particular attention to removing mica dust at any factory seam step-offs.

   b. Clean the splice areas with Weathered Membrane Cleaner. This allows for roller application of the primer which improves productivity and decreases potential over drying of the primer. This process is required on membrane that has been exposed for a number of weeks. Change HP Splice Wipes often to ensure mica dust is removed. Permeation-resistant gloves meeting ANSI/ISEA 105-2005 are required for hand protection when cleaners or primers are being used. Allow the Weathered Membrane Cleaner to flash-off before applying primer.

   CAUTION: Using rags or Splice Wipes that are saturated with mica dust only serve to move the dust from one area to another.

3. **Apply HP-250 or Low-VOC Primer**

   a. **Dusted Membrane** - After removing the loose mica as noted above, Roller-apply the primer to the membrane with a 3/8” (9mm) medium nap paint roller achieving a thin and even coat that is uniform in color and free of streaks or heavy spots. Confirm that primer is applied into any factory seam step-offs.

   b. **Pre-Kleened™ Membrane or membrane cleaned with Weathered Membrane Cleaner** - Roller-apply the primer to the membrane with a 3/8” (9mm) medium nap paint roller achieving a thin and even coat that is uniform in color and free of streaks or heavy spots. Confirm that primer is applied into any factory seam step-offs.

   c. Allow the primer to flash-off until it does not transfer to a dry finger touch. Do not allow the primer to over dry.

   d. Install QA Seam Tape shortly after the primer flashes off to maximize bond strength and minimize potential dust contamination.

      CAUTION: Due to solvent flash-off, condensation may form on freshly applied primer when the ambient temperature is near the dew point. If condensation develops, the application of primer and QA Seam Tape must be discontinued since proper adhesion will not be achieved. Allow the primer surface to dry and apply a thin freshener coat of primer to the previously coated surface and apply QA Seam Tape when conditions allow. Do not stir LVOC Primer.

4. **Field Applied QA Seam Tape**

   a. **Unroll** approximately 3' (1m) of QA Seam Tape aligning the tape with the set marks. Use firm and even hand pressure to press the tape down to the bottom sheet along the length of the splice. Overlap tape roll ends 1”. A continuous piece of QA Seam Tape must be used at all factory seams and field splice intersections. In warm, sunny weather, keep QA Seam Tape rolls in their box in a shaded area until ready to use.

   b. Rolling the installed QA Seam Tape with a 2"-wide hand roller will reduce the frequency of air blisters in the completed field seam. Crease the QA Seam Tape into any factory seam step-off with the edge of the hand roller.

c. Allow the top sheet to fall freely onto the poly backing. Ensure that a minimum of 1⁄8" to a maximum of 1/2" of tape extends beyond the top membrane edge. Trim membrane if necessary.

d. Pull the poly backing off at a 45 degree angle and use firm hand pressure across the splice towards the outside splice edge mating the top sheet onto the QA Seam Tape.

e. Immediately roll across the splice with a 2" (50 mm) wide hand roller applying positive pressure. Use the edge of the hand roller to crease the top membrane into any factory seam step-off.

Note: At any QA Seam Tape overlap, apply a 5⁄16" (8 mm) diameter bead of Lap Sealant 1/2" (12 mm) in all directions from the overlap.

5. **Factory Applied QA Seam Tape (VersiGard QAT)**

a. Overlap the Factory Applied Tape membrane a minimum 3" or 6" (75 or 150 mm) to coincide with the QA Seam Tape width. Stagger factory seams on dusted EPDM to avoid a double thickness of membrane.

b. Pull the poly backing off at a 45 degree angle and use firm hand pressure across the splice towards the outside splice edge mating the top sheet onto the primed area of the bottom sheet.

c. Immediately roll across the splice with a 2" (50 mm) wide hand roller applying positive pressure. Use the edge of the hand roller to crease the top membrane into any factory seam step-off.

6. **Install T-Joint Covers** - At all field splice intersections, follow the cleaning and priming steps listed above and then apply a 5⁄16" diameter (8 mm) bead of Lap Sealant 1/2" (12 mm) in each direction from the membrane intersection according to **Detail VGC-2.1A**. Then install a 6" x 6" Qucik Applied T-Joint Cover. For 25 and 30 year warranties and all 90-mil membranes apply a 12" x 12" Quick Applied T-Joint Cover centered over the 6" x 6" QA T-Joint Cover according to **Detail VGC-2.2**.

7. **Apply Lap Sealant** - Apply Lap Sealant at cut edges of reinforced membrane, splice tape overlaps and Quick Applied T-Joint Covers. Lap Sealant may be applied immediately following the completion of a splice. Feather the Lap Sealant with the specially formed plastic Lap Sealant Tool so the high point or crown is centered over the splice edge. Plastic Lap Sealant Tools are provided in cartons of Quick Applied Uncured EPDM Flashing and cardboard tools are on the top of the Lap Sealant cartons.

8. **Cold Weather Requirements –** installation when temperatures fall below 40°F (4°C)

a. Hot boxes for jobsite storage must be provided to maintain a minimum QA Seam Tape temperature of 40°F (4°C).

b. Heat the primed area of the bottom membrane as the QA Seam Tape or Factory Applied QA Seam Tape (VersiGard QAT) is installed and pressed into place.

c. Field applied QA Seam Tape must be rolled with a 2" (50 mm) wide hand roller prior to removal of the release liner when temperatures fall below 40°F (4°C).

d. Prior to rolling the splice area with a 2" (50 mm) wide hand roller, apply heat to the topside of the membrane with a hot-air gun. The heated surface should be warm to the touch.

C. **Lap Sealant Application**

1. **Lap Sealant is required at the following locations:**

a. Splice tape overlaps.

b. Beneath 6" x 6" T-Joint Covers and around the outer edge.

c. Where joints in metal edgings intersect with VersiGard Quick Applied Cured Cover Strip.

d. Around all edges of Quick Applied Uncured Flashing, Corners, and Pockets.

e. Cut edges of reinforced membrane.

2. **Procedures**

a. Dusted EPDM must be cleaned 1” (25 mm) on either side of the splice edge using Weathered Membrane Cleaner or EPDM Primer and HP Splice Wipes or a clean cloth.

Note: Weathered Membrane Cleaner is not required when using Kleen EPDM unless accumulated dirt is present.

b. Apply a 5/16” bead of Lap Sealant centered over the splice edge. Coverage rate is 22 lineal feet per tube.

c. Feather the Lap Sealant with the specially formed Lap Seal Tool so the high point or crown is centered over the splice edge. Clean the feathering tool occasionally for consistent crowning of Lap Sealant.

d. Application of Lap Sealant **should be completed each day** to avoid extra cleaning of accumulated dirt.

D. **Splice Repairs**

1. **General**

a. Prior to initiating repairs, the membrane must be cleaned to remove field dirt and other contaminants. Using a scrub brush, scrub the splice areas with warm water and a low-sudsing soap (Spic and Span, Tide, Lestoil). Rinse with clean water and allow to dry prior to applying Weathered Membrane Cleaner or Versico EPDM Primer as required.

b. Versico’s Weathered Membrane Cleaner can be used to prepare membrane exposed to the weather prior to applying Versico EPDM Primer. Using a HP Splice Wipe or natural fiber rag (cotton) with Weathered Membrane Cleaner, scrub the area in a circular motion. Continue cleaning until the surface is a consistent matte black color without streaking.

2. **Repairs of Cuts and Tears (Surface Splice)**

Repairs to cuts and tears in the membrane must be accomplished by splicing a membrane section over the affected area.

a. Select a repair membrane, which is the same material as that to be repaired.

b. Extend the repair membrane section at least 3" in every direction from the cut or tear. Round the corners of the repair membrane prior to splicing. Clean the membrane to remove field dirt and other contaminants as outlined above.

c. Apply Versico EPDM Primer to the splice areas. Install Quick Applied Cured Cover Strip or Cured Membrane and QA Seam Tape and then hand roll the splice areas. Apply T-Joint Covers at splice intersections. Lap Sealant is applied at flashing and tape overlaps in accordance with standard procedures.

3. **Repair of improperly installed Tape Splices**

a. Improperly installed tape splices include, but are not limited to, fishmouths at field splices, lack of or improper use of Primer, condensation formation on Primer or incorrect tape placement, etc.

b. **If fish mouths are present in the field splice**, the fish mouth must be cut by removing the top layer of membrane prior to overlaying the splice. The flashing overlay **must** be supported by the bottom layer of cured membrane.

c. Clean the splice area with Weathered Membrane Cleaner. Apply EPDM Primer on both sides extending past the width of the new flashing overlay to be installed.

d. Overlay the defective splice area with a bead of lap sealant overlaid with a minimum 6" wide VersiGard Quick Applied Uncured EPDM Flashing, Cover Strip or Overlayment Strip centered over the edge of the splice. If using Quick Applied Uncured EPDM Flashing, apply Lap Sealant around the outer edge and feather accordingly.

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