

Paracoat & Paracoat HS

A detailed architectural floor plan of a building, showing various rooms, corridors, and structural elements. It is overlaid on the bottom half of the page.

Installer's Guide

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I. System Overview and Products

Siplast Paracoat

Paracoat and Paracoat HS are fast curing PMMA resin-based roof coatings. Typically applied in a single coat application, Paracoat is designed to protect existing smooth and granule-surfaced roof systems from the effects of weathering and chemical attack. Paracoat, when applied in a reinforced application, is designed to protect existing roof systems from the effects of ponding water.

Paracoat HS is used over approved Paradiene 20/30 FR or Parapro Roof Systems to achieve an Underwriters Laboratories Class A fire rating at unlimited slope.

Siplast Pro Primer R

Pro Primer R is a fast curing PMMA resin-based primer used to serve as a bleed blocker, preventing oils or asphalt in the existing roof membrane from migrating through the Paracoat and discoloring the finished Paracoat System. Pro Primer R is not used beneath Paracoat HS.

II. Personal Protection

Safety and Protection

Refer to the Safety Data Sheet (SDS) for Paracoat, Paracoat HS, Pro Primer R, and Pro Catalyst for specific PPE information. Pro Primer R and Pro Catalyst are collectively referred to as Pro Products in this guide. Paracoat, Paracoat HS, and Pro Products are flammable, and are harmful if inhaled, swallowed, or absorbed through the skin. They can cause skin, eye, and respiratory irritation, and may cause skin and respiratory sensitization.

Do not smoke, eat, or drink around Paracoat or Pro Products. Keep the products away from open flame, fire or any ignition source. Avoid breathing Paracoat

and Pro Resin vapor. Use the products with adequate ventilation or respiratory protection as needed to keep exposure below threshold limit values (TLV).

Do not ingest the products, and avoid contact with eyes, skin, and clothing. Wear suitable gloves and eye/face protection. Wash thoroughly after handling the products. Keep the products out of reach of children.

First aid information is available on Paracoat and Pro Product SDS documents and product containers.

III. Storage

Storage

Store Paracoat and Pro Products at temperatures between 32°F (0°C) and 77°F (25°C). Paracoat and Pro Products should be stored indoors in closed containers in a well-ventilated, cool, dry area away from heat, open flame, ignition sources, direct sunlight, oxidizing agents, strong acids, and strong alkalis. Resin products may auto-polymerize at temperatures greater than 140°F (40°C). The shelf life of Paracoat and Pro Products is 6 months from ship date and is noted on each pail or box. The shelf life of Paracoat and Pro Products will be reduced if the products are stored at temperatures above 77°F (25°C). Pro Catalyst is extremely heat sensitive and proper storage is important to help ensure handling safety and to maintain product quality. The reactivity/effectiveness of Pro Catalyst will decrease progressively when product

is stored under high temperature conditions. Exposure of Pro Catalyst to a temperature of 122°F (50°C) or higher can result in self-accelerating decomposition. Self accelerating decomposition is signaled by the presence of bright white smoke, and can generate temperatures in excess of 500°F (260°C), depending on the environmental conditions and quantity of catalyst present. Such temperatures can be hazardous in the presence of flammable materials. Therefore, Pro Catalyst should never be subjected to conditions that can result in self-accelerating decomposition.

Materials stored on the job site during application should be kept on a pallet in a shaded, well-ventilated area. In unshaded areas, cover Paracoat and Pro Product materials with a white, reflective tarp in a manner that allows for air circulation beneath the tarp.

IV. Materials, Tools, and Equipment for Substrate Penetration and Resin Application

Substrate Preparation

- Blower, vacuum, and broom
- Equipment for low pressure wash with mild detergent

Mixing

- Plastic tarps or polyethylene sheathing
- Variable speed drill with 1/2-inch chuck or mortar mixer (double or single auger)
- Mixing agitator
- 1-tablespoon measure (for less than full pail batches)
- Measuring cup
- Graduated mixing pails (for less than full pail batches of resin)
- Scale with 20 kg (45 lb) capacity

Application

- Masking tape
- Brushes (touch-up)
- Application rollers and frames (4", 9", & 18")
- Pro Fleece
- Stub Roller (For application of base coat in reinforced areas.)
- Pro Prep or Pro Prep M
- Disposable nitrile or butyl gloves

Miscellaneous

- Clean cotton rags
- Infrared thermometer (required for all applications)

V. Substrate Preparation and Repair

General Substrate Preparation

All substrates must be free from gross irregularities, loose/unsound material, foreign material (such as dirt, ice, snow, water, grease, oil, paint, existing coatings), or any other condition/material that would be detrimental to the adhesion of catalyzed Pro Primer R

and/or Paracoat/Paracoat HS to the substrate. A list of substrates along with preparation guidelines appears in the following chart. **For applications where a specific substrate is not listed, please contact the Siplast Technical Department at 800-922-8800.**

Substrate	Preparatory Guidelines
Granule-surfaced SBS Membrane (including Paradiene 30 FR)	1, 2, 3
Smooth-surfaced SBS Membrane	1, 2, 3, 4
Granule-surfaced Asphaltic Cap Sheet	1, 2, 3, 4
Granule-surfaced APP Membrane	1, 2, 3, 4
Smooth-surfaced BUR Membrane	1, 2, 3, 4
Granule-surfaced APP or SBS Membranes applied in solvent-based adhesive	1, 2, 3, 4, 5

Key to Preparation Guideline

1. Paracoat and Paracoat HS are intended to offer a protective coating over a roof membrane or related substrate that is in a serviceable condition and is not intended for use as a roofing membrane itself. The existing roof system should be carefully evaluated to ensure that it will offer sound waterproofing protection. Blisters and other roof membrane or flashing defects should be removed and repaired with compatible materials. Avoid the use of solvent-based adhesives for membrane repairs.
2. The surface must be dry, clean, sound, and free from loose/foreign material such as dirt, grease, oil, paint, existing coatings or any other condition/material that would be detrimental to the adhesion of the catalyzed primer or resin. Cleaning procedures, including power brooming,

vacuuming or using a low pressure wash with a mild biodegradable detergent solution may prove helpful in removing stubborn debris. Low areas and depressions in the substrate, or any area containing excessive dirt or oils, may require repeated cleaning using the detergent solution. Allow the cleaning solution to stand for a period of time and scrub the entire surface to be cleaned vigorously and completely using a stiff-bristled broom. Before the cleansing agent dries, wash the surface with copious amounts of clean water. Allow the membrane to dry thoroughly after cleaning (normally 8 to 24 hours depending on weather conditions).

3. Pro Primer R is a bleed-blocking primer and should be used if bleed-through protection is desired. Pro Primer R is strongly recommended over newly-applied asphaltic repair materials.

4. Consider performing an adhesion or peel test if there is any question regarding adhesion of Paracoat or Pro Primer R to a specific substrate.
5. Solvent-based adhesives must be fully cured prior to application of resin products - Sheets applied in solvent-based adhesives typically require 12 months of exposure before receiving a coating.

VI. Measuring and Mixing Paracoat & Pro Resins

General Guidelines

Paracoat and Pro Primer R are fast setting and should only be catalyzed as needed. Mixing in full batches is recommended to simplify the calculation of the resin to catalyst ratio. Depending upon the resin type, resin quantity, and the substrate temperature, the amount of Pro Catalyst will vary.

Mixing Paracoat and Pro Primer R Resins

The mixing process should always be performed in a designated area that is separate from the prepared area to receive the coating. This is to prevent inadvertent spills of uncatalyzed resin materials.

Thoroughly mix the entire pail of uncatalyzed Paracoat, Paracoat HS or Pro Primer R for 2 minutes prior to pouring off into a second container when batch mixing. This will redistribute liquids/solids that may have separated during storage. Catalyze only the amount of resin that can be used within the anticipated pot life. Add pre-measured Pro Catalyst to the resin component, and stir for a full two minutes using a slow-speed mechanical agitator before applying product to the prepared substrate.

Liquid Measure of Resins

If using partial batches, a portable scale is the most accurate means for field measuring resins. When a scale is not available, liquid measure can be used for field measurement of Paracoat, Paracoat HS or Pro Primer R. Siplast offers graduated pails that make measurement of small batches easier.

Resin Type	Density	Liquid Measure
Pro Primer R	1.0 kilogram per liter	1.0 liter per kilogram
Paracoat + Paracoat HS	1.4 kilogram per liter	0.72 liter per kilogram

The Tablespoon Method

If using less than full container batches and a portable scale is not available, a level 1-tablespoon measure using a standard culinary-type measuring spoon can be used for calculating catalyst quantities per kg of resin.

Pro Catalyst Mixing Ratios & Measurements

The amount of Pro Catalyst added to Paracoat, Paracoat HS or Pro Primer R is based upon the weight (or associated volume) of the resin used, and will be determined based upon the temperature of the substrate as measured using an infrared thermometer immediately preceding application of the batch. Pro Catalyst Liquid is packaged in 2.5 kg (10 cup) containers. Whenever possible, full-pail quantities of resin should be used; this will allow full-cup quantities of Pro Catalyst Liquid for catalyzation. See the chart on page 4 for mixing ratios. The amount of Pro Catalyst added to Paracoat, Paracoat HS, or Pro Primer R should never be less than that published in the Pro Catalyst mixing charts.

Pot Life and Curing Times

Paracoat and Pro Primer R resins should have a temperature of less than 77°F (25°C) at the time of mixing to maximize pot life. Pot life will be reduced significantly if mixed at higher resin temperatures. If resin mixed with Pro Catalyst at the proper rate for the specific substrate temperature does not offer sufficient pot life, the temperature of the resin itself may be too high.

All catalyzed resins must be fully cured within one hour of installation. If a catalyzed resin has not cured within one hour, the products have not been mixed properly, the products have been misapplied, or both. This will necessitate removal of the materials and application of new product.

Mass and Volume Data for Pro Catalyst Liquid

Pro Catalyst Liquid - net contents per unit			
2.5 kilograms	2.25 liters	2250 milliliters	10 cups (approximately)

Pro Catalyst Liquid Mixing Charts

Pro Catalyst Liquid Mixing Chart Pro Primer R						
Resin Quantity	Pro Catalyst Liquid Ambient Temperature 59°F to 95°F (15°C to 35°C)		Pro Catalyst Liquid Ambient Temperature 41°F to 59°F (5°C to 15°C)		Pro Catalyst Liquid Ambient Temperature 32°F to 41°F (0°C to 5°C)	
	tablespoons	cups	tablespoons	cups	tablespoons	cups
1 kg (1 liter)	2	n/a	4	n/a	6	n/a
10 kg (10 liters)	n/a	1	n/a	2	n/a	3

Pro Catalyst Liquid Mixing Chart Paracoat & Paracoat HS						
Resin Quantity	Pro Catalyst Liquid Substrate Temperature 59°F to 104°F (15°C to 40°C)		Pro Catalyst Liquid Substrate Temperature 41°F to 59°F (5°C to 15°C)		Pro Catalyst Liquid Substrate Temperature 32°F to 41°F (0°C to 5°C)	
	tablespoons	cups	tablespoons	cups	tablespoons	cups
1 kg (0.72 liter)	2	n/a	4	n/a	6	n/a
10 kg (7.2 liters)	n/a	1	n/a	2	n/a	3
20 kg (14.3 liters)	n/a	2	n/a	4	n/a	6

VII. Pro Primer R Application

General Application Guidelines

Pro Primer R is used as a bleed blocker and prevents oils from migrating through the Paracoat and discoloring the finished Paracoat System. Pro Primer R is not used beneath Paracoat HS. Pro Primer R is recommended for use over smooth surfaced SBS systems, bitumen bleedout on existing approved roof systems, and systems that have significant granule loss where bleed-through of asphaltic oils is a concern.

Pro Primer R may be applied when the ambient and substrate temperature are between 32°F (0°C) and 95°F (35°C), provided the substrate is clean, dry, and prepared as outlined on page 2. The substrate should be shaded prior to and during application, as necessary, to keep the substrate temperature within the acceptable range. **An infrared thermometer should be used regularly to monitor substrate temperatures during application of resins. Application of product over substrates that have a temperature exceeding published maximums can affect curing of the resin, and ultimately, the integrity of the Paracoat System. Siplast recommends that crews keep a log of substrate temperatures per batch of resin applied and these records should be maintained.**

Pro Primer R is applied with a conventional roller and can be overlaid with Paracoat after the primer has set (cured), generally a minimum of 45 minutes following application. If work is interrupted for more than 12 hours, or the cured primer surface becomes dirty or contaminated from exposure to the elements, thoroughly clean the in-place primer with Pro Prep. Pro Prep should be allowed a minimum of 20 minutes of drying time after application before continuing with application of a subsequent layer of resin. Following the drying time, the next layer of resin should be completed within 1 hour.

Pro Primer R Pot Life

The pot life of Pro Primer R is approximately 15 minutes when the catalyzed liquid is at 68°F (20°C). Pot life will be reduced if the resin is at higher temperatures. Pot life can be maximized by storing product under controlled conditions and ensuring that the temperature of the resin is below 77°F (25°C) at the time of mixing.

Pro Primer R – Consumption & Typical Coverage Rates over Smooth Substrates

Minimum Consumption (smooth substrates):

3.7 kg/sq (0.037 kg/sf) (0.4 kg/m²).

Typical Coverage (10-kg pail): 270 square feet

Pro Primer R – Consumption & Typical Coverage Rates over #11 Granule-Surfaced Systems

Minimum Consumption (granule surfaces):

5.5 kg/sq (0.055 kg/sf) (0.6 kg/m²).

Typical Coverage (10-kg pail): 160 - 180 square feet

Note that rough or uneven substrates may require a heavier application. The typical consumption rates above are gross values and do not include waste factors, including product required for roller saturation or residue in less than empty pails.

Pro Primer R Set (cure) Times

Minimum set (cure) times noted below are approximate, and may vary depending on ambient and

surface temperatures. The information below is based on laboratory conditions, and is intended for use as a guideline only. Actual set (cure) times should be established in the field, based upon actual field conditions.

Rain Proof at 68°F (20°C): 25 minutes

Ready for Paracoat at 68°F (20°C): 45 minutes

Please note that Pro Primer R must be fully cured within one hour of installation. If catalyzed resin has not cured within one hour, the primer has not been mixed properly, the primer has been misapplied, or both. This will necessitate complete removal of the primer and application of a new primer layer.

VIII. Pro Fleece

Pro Fleece

Pro Fleece is the reinforcement layer used in a reinforced Paracoat System.

Pro Fleece Sizes

Pro Fleece is available in three widths: 12-inch (315 mm), 25-inch (630 mm), and 41-inch (1050 mm).

IX. Paracoat & Paracoat HS Application

General Application Guidelines

Paracoat Roof Coating, when catalyzed, is applied over qualified and prepared existing smooth and granule-surfaced roof systems for protection against the effects of weathering, and chemical attack. Paracoat, when applied in a reinforced application, is designed to protect existing roof systems from the effects of ponding water. Paracoat HS Roof Coating, when catalyzed and applied over an approved Paradiene 20/30 FR Roof System, achieves an Underwriters Laboratories Class A fire rating at unlimited slope. Paracoat HS should not be used in areas that pond water.

Paracoat and Paracoat HS may be applied when the ambient temperature is between 32°F (0°C) and 95°F (35°C) and the substrate temperature is between 32°F (0°C) and 104°F (40°C), provided the substrate is clean, dry, and prepared as outlined on page 2. The substrate should be shaded prior to and during application, as necessary, to keep the substrate temperature within the acceptable range. ***An infrared thermometer should be used regularly to monitor substrate temperatures during application of resins. Application of product over substrates that have a temperature exceeding published maximums can affect curing of the resin, and ultimately, the integrity of the Paracoat System. Siplast recommends that crews keep a log of substrate temperatures per batch of resin applied and these records should be maintained.***

An even, generous layer of Paracoat or Paracoat HS Coating is applied to the qualified and prepared substrate with an 18", 1/2-inch nap roller. A 9", 1/2-inch nap roller can be used for tight areas or for cutting in perimeters or penetrations. Work the coating puddle parallel to the lengths and side laps of the underlying sheets to ensure proper coverage over the laps. Crosshatch the coating as a finishing step to eliminate bare spots, remove air bubbles, and prevent pooling at side laps. Change roller covers regularly to ensure that the coating used to saturate the cover is not catalyzed to the point that it will affect even application of product. ***Stage work to ensure that continuous areas can be coated in a continuous application of Paracoat to ensure that a monolithic aesthetic can be generated.***

In areas that may hold ponding water, the Paracoat System should be reinforced using Pro Fleece. An even, generous layer of catalyzed Paracoat Roof Coating is applied to the qualified and prepared substrate with an 18", 1/2-inch nap roller or an approved stub roller. Pro Fleece is immediately worked into the wet, catalyzed Paracoat Roof Coating using an approved roller to fully embed the fleece in the resin and remove trapped air. At side and end laps, Pro Fleece must be overlapped a minimum of 2 inches (50 mm). An additional coat of catalyzed Paracoat Roof Coating must be placed between all layers of overlapping fleece. An even top coat of catalyzed Paracoat Roof Coating is then applied immediately following embedment of the fleece to ensure full saturation of

the fleece reinforcement.

For tie-ins or laps over an existing layer of cured Paracoat or Paracoat HS Coating that has been in place for more than 12 hours, or a cured coating surface that has become dirty or contaminated from exposure to the elements, thoroughly clean the in-place coating with Pro Prep. Pro Prep should be allowed a minimum of 20 minutes of drying time after application before continuing with application of a subsequent layer of resin. Following the drying time, the next layer of Paracoat should be completed within 1 hour.

Paracoat Products' Pot Life

The pot life of Paracoat is approximately 15 minutes when the catalyzed liquid is at 68°F (20°C). Pot life will be reduced if the coating is at higher temperatures. Pot life can be maximized by storing the coating under controlled conditions and ensuring that the temperature of the Paracoat product is below 77°F (25°C) at the time of mixing.

Paracoat and Paracoat HS Set (cure) Times

Minimum set (cure) times noted below are approximate, and may vary depending on ambient and surface temperatures. The information below is based on laboratory conditions, and is intended for use as a guideline only. Actual set (cure) times should be established in the field, based upon actual field conditions.

Rain Proof at 68°F (20°C): 25 minutes

Stress Resistant at 68°F (20°C): 2 hours

Note that Paracoat products must be fully cured within 1 hour of installation. If a catalyzed resin has not cured within 1 hour, Paracoat products have not been mixed properly, have been misapplied, or both. This will necessitate removal in its entirety and application of new product.

X. Product Consumption and Coverage Tables

Product	Minimum Consumption		
	kilogram/square foot	kilogram/square	kilogram/square meter
Pro Primer R (smooth)	0.037 kg/sf	3.7 kg/sq	0.4 kg/m ²
Pro Primer R (granule)	0.055 kg/sf	5.5 kg/sq	0.6 kg/m ²
Paracoat (over smooth) (*minimum)	0.08 kg/sf	8 kg/sq	0.85 kg/m ²
Paracoat Reinforced (over smooth)			
Total	0.31 kg/sf	31 kg/sq	3.3 kg/m ²
Base Coat	0.19 kg/sf	19 kg/sq	2 kg/m ²
Top Coat	0.12 kg/sf	12 kg/sq	1.3 kg/m ²
Paracoat (over granule) (*minimum)	0.09 kg/sf	9 kg/sq	1 kg/m ²
Paracoat Reinforced (over granule)			
Total	0.4 kg/sf	40 kg/sq	4.3 kg/m ²
Base Coat	0.28 kg/sf	28 kg/sq	3 kg/m ²
Top Coat	0.12 kg/sf	12 kg/sq	1.3 kg/m ²
Paracoat HS (over Paradiene 20/30 FR)	0.168	16.8 kg/sf	1.8 kg/m ²
Paracoat HS (over Parapro)	0.168	16.8 kg/sf	1.8 kg/m ²

* Note that rough or uneven substrates will require a heavier application. Net coverage will decrease if more than one roller cover per pail is used.

Product	Unit	Typical Coverage	
		Square	Square Meters
Pro Primer R (over smooth)	10-kg pail	2.7 sq	25 m ²
Pro Primer R (over granule)	10-kg pail	1.8 sq	16.6 m ²
Paracoat (over smooth)	10-kg pail	2.3 sq	21.4 m ²
Paracoat Reinforced (over smooth)	20-kg pail	0.64 sq	5.9 m ²
Paracoat (over granule) *	20-kg pail	1.75 - 2.06 sq	16.2 - 19.1 m ²
Paracoat Reinforced (over granule)	20-kg pail	0.5 sq	4.6 m ²
Paracoat HS (over Paradiene 20/30 FR)	20-kg pail	1.1 sq	10.2 m ²
Paracoat HS (over Parapro)	20-kg pail	1.1 sq	10.2 m ²

*Coverage of 206 square feet per pail of Paracoat over a granule-surfaced membrane is under ideal conditions over a roof that is not weathered. Crazed and weathered roof surfaces will require a significantly heavier application. Net coverage will decrease if more than one roller cover per pail is used, since an 18" roller cover requires approximately 1.5 kg of resin for saturation.

Note that the above consumption and coverage rates are gross values and do not include waste factors, including product required for roller saturation or residue in less than empty pails. The above coverage rates for Paracoat and Paracoat HS include the coating required to saturate a single 18" roller cover per pail (1.5 kg) but do not include waste factors such as residue in less than empty pails.

Waste Factors

Roller Cover Saturation (avg. loss per cover in kg)			
Resin Type	4" Cover	9" Cover	18" Cover
Pro Primer R	0.1 kg	0.55 kg	1.1 kg
Paracoat and Paracoat HS	0.1 kg	0.75 kg	1.5 kg

XI. Application Images



1. Mixing/Catalyzing

Set up a designated area for mixing and work over a sacrificial sheet or tarp. Avoid spillage of uncatalyzed resin over areas to be primed or coated. Mix product for a minimum of 2 minutes when batch mixing or catalyzing. A timer should be used for this purpose.



2. Monitor Substrate Temperature

Measure substrate temperature at regular intervals using an infrared thermometer and maintain a log of values.



3. Preparation/Cleaning

Sweep areas to remove loose debris. Use a low-pressure wash with mild detergent to remove stubborn deposits. Scrub with a soft bristle broom to dislodge debris if necessary. Rinse with copious amounts of water to remove debris/detergent residue and allow to dry thoroughly.



4. Priming (Paracoat applications only)

If bleed-through is a concern, apply Pro Primer R over the prepared substrate at a minimum rate of 3.7 kg/sq over smooth substrates and 5.5 kg/sq over granule-surfaced substrates plus a waste factor. The Pro Primer R will be ready for application of Paracoat in approximately 45 minutes.



5. Gridding

Grid the area to be coated by marking off the surface area that will correspond to the batch size to be applied. Take into account waste or overage factors such as the amount of resin required to saturate roller covers.



6. Tie-in to Existing Coating

Prepare the in-place coating to receive the tie-in by wiping with Pro Prep. Allow the Pro Prep to dry for 20 minutes before application of Paracoat.



7. Pour

Pour resin over the gridded area, ensuring that the proper amount is evenly distributed. See page 6 for application rates.



8. Paracoat Application #1

Using an 18", 1/2-inch nap roller, evenly spread the Paracoat or Paracoat HS over the prepared substrate. If applying product over existing roll products, the coating should be distributed parallel to the sheets.



9. Paracoat Application #2

Crosshatch the previously applied product to evenly distribute the coating and finish the application. Change roller covers regularly. Allow the coating to cure for 2 hours prior to exposure to foot traffic.



10. Reinforced Paracoat Application #1

Apply a base coat of catalyzed Paracoat using an approved stub or conventional roller.



11. Reinforced Paracoat Application #2

Embed a layer of Pro Fleece into the wet Paracoat Resin.



12. Reinforced Paracoat Application #3

Use an approved roller to embed the fleece in the resin and remove trapped air. Lap fleece layers a minimum of 2 inches, and apply an additional coat of catalyzed Paracoat Resin between layers of overlapping fleece.



13. Reinforced Paracoat Application #4

Apply a top coat of catalyzed Paracoat Resin using an approved roller immediately following embedment of the Pro Fleece to ensure full saturation of the fleece.

**Siplast**

1000 Rochelle Blvd.
Irving, Texas 75062
469-995-2200
Facsimile: 469-995-2205

Customer Service in
North America:
Toll Free 1-800-922-8800

www.siplast.com

In Canada:
201 Bewicke Ave., Suite 208
Vancouver, BC,
Canada V7M 3M7
604-929-7687



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