danosa

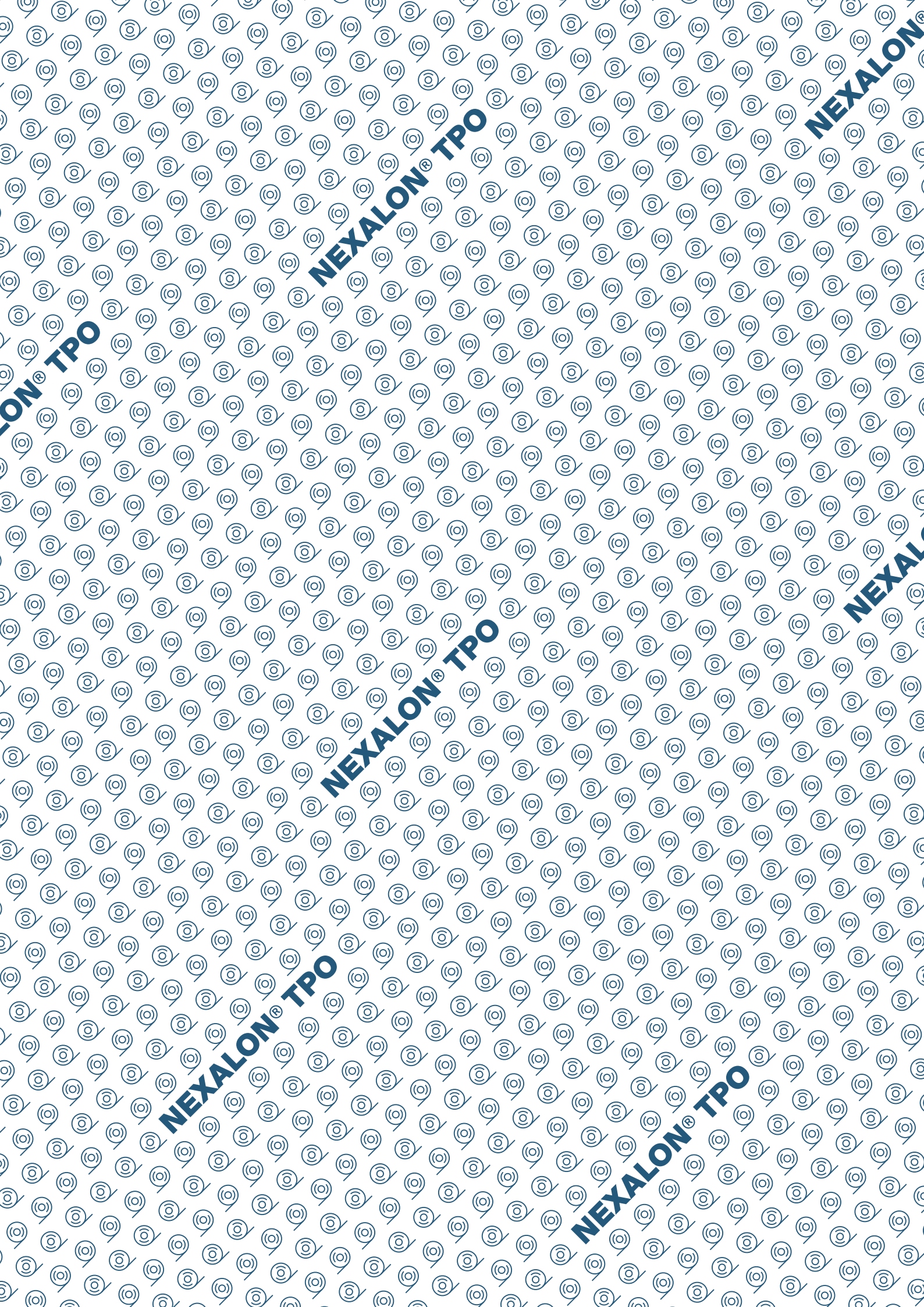
Installation manual

Deck roofing solutions

NEXALON® TPO

SYNTHETIC
WATERPROOFING




NEXALON® TPO


NEXALON® TPO

NEXALON®

ROBUSTNESS
WELDABILITY
FLEXIBILITY

The TPO that suits you.

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01
Introduction

This document outlines the installation instructions for **NEXALON® TPO**, **danosa's** range of TPO membranes, and should be used as a reference tool by the various construction professionals to ensure the proper installation of this waterproofing solution using thermoplastic polyolefin (**TPO**) synthetic membranes.

Compliance with all applicable technical standards and regulations is mandatory, including worker protection measures and safety protocols.

NEXALON® TPO is a sustainable option for roofing waterproofing, as it contains no plasticisers or chlorine, reducing the risk of releasing harmful substances into the environment. In addition, the manufacturing process incorporates the use of renewable energy, further minimising its environmental impact.



System description

The thermoplastic polyolefin (TPO) membrane waterproofing system is an advanced, versatile and highly durable solution for roof protection, specifically designed to deliver optimal performance under the most demanding weather conditions. Engineered to provide a continuous and watertight barrier, the system offers effective protection against moisture, rain, snow and extreme temperature fluctuations, helping to extend the lifespan of the roof.

The **NEXALON® TPO** membrane combines the flexibility of rubber with the mechanical strength and dimensional stability of plastic, resulting in a material that adapts exceptionally well to structural movement and thermal expansion. Its advanced formulation provides excellent resistance to ultraviolet radiation, ozone and common chemical agents typically found in industrial and urban environments, significantly reducing the risk of premature degradation.

> "This system offers effective protection against moisture, rain, snow and extreme temperature fluctuations"



Certifications

ETE 24/0749



Tools and PPE

Below is a description of the tools required and their intended use for the installation of the **NEXALON®** **TPO** system. At **danosa**, **LEISTER** tools have been approved to guarantee the correct welding of our TPO membranes.

The following tools are required for **TPO** installation:

3



› TPO nozzles

Attachments for use with hot-air welding machines. Available in various sizes, with the most common widths being 20 mm and 40 mm to ensure proper overlap. Select the most suitable nozzle depending on the specific conditions of each project.

1



› Manual hot-air welding machine

Used to manually weld overlaps between membranes by fusing the material to create a durable, watertight bond.

2



› Automatic hot-air welding machine

Also used for automatically welding overlaps between membranes. It is important to ensure the machine is properly aligned and that the wheels are moving smoothly. Make sure the air inlet is open and the nozzle is clean before use.

4



› TPO pressure rollers

Hand rollers used to apply even pressure along the membrane overlaps when using a manual hot-air welder, ensuring proper adhesion. Available in different widths to suit the unique features of each project.

5



› Welding probe

A metal tool specifically designed to check that welds have been completed correctly.

6



› Hook blade cutter

A tool designed to make cutting the membranes easier and more precise.

7



› Wire brush

Essential for cleaning nozzles and ensuring the proper operation of hot-air welding machines.

8



› Personal protective equipment (PPE)

Each worker on the roof must be properly equipped and protected in accordance with the regulations in force in the relevant country or region.

This includes gloves, helmet, safety glasses, protective footwear and a fall arrest harness connected to a certified lifeline or anchor point, where required. The use of sun cream is also recommended.

Product range



NEXALON®

danosa's NEXALON® TPO range is designed to provide advanced waterproofing solutions using TPO membranes. These membranes are engineered to deliver long-lasting, effective protection against moisture in a variety of roofing applications, ensuring watertightness in both new-build and refurbishment projects.

Composition and materials

- **Material: NEXALON® TPO** membranes are manufactured from a blend of polypropylene and ethylene-propylene, offering excellent durability and resistance.
- **Reinforcement:** Reinforced with synthetic yarn or polyester fibre to enhance dimensional stability and mechanical strength.

Advantages of using **NEXALON® TPO** membranes

- **UV and weather resistance: NEXALON® TPO** membranes are highly resistant to ultraviolet rays and harsh weather conditions, ensuring a long service life.
- **Chemical resistance:** They offer outstanding resistance to common chemicals, oils and greases, as they are free from vinyl chloride compounds.
- **Workability:** They remain flexible across a wide temperature range, making installation easier on complex surfaces and allowing for movement expansion.

Membrane range

- **NEXALON® TPO membrane**

  Reinforced with polyester mesh. Available in various thicknesses (1.2 mm, 1.5 mm, 1.8 mm, 2.0 mm). Fig. 1

- **NEXALON® TPO 1.5 NON-REINFORCED membrane**

  Membrane without reinforcement. Fig. 2



Fig. 1



Fig. 2

Accessory range

- **Outlets**

  Vertical drain outlets for downpipes, compatible with all **NEXALON® TPO** membranes. Fig. 3

- **Pipe boots**

  PVC pipe boots for penetrations, compatible with all **NEXALON® TPO** membranes. Fig. 4

- **Laminated profiles**

  Laminated sheet metal profiles used for edge terminations in waterproofing systems. Fig. 5



Fig. 5



Fig. 3



Fig. 4



Fig. 6



Fig. 7



Fig. 8

› **Preformed corners**

Factory-made external and internal corners for neat finishing of roof angles. Fig. 6

› **NEXALON® ADHESIVE**

Contact adhesive formulated from polychloroprene rubber, synthetic resins and a suitable solvent blend. Specially designed for bonding **danosa NEXALON® TPO** membranes to commonly used construction materials. Fig. 7

› **Reinforcement strips**

Linear elements used to reinforce critical areas or points subject to high mechanical stress. Fig. 8

Storage

NEXALON® TPO membranes are supplied on pallets. The following recommendations should be observed:

› Pallets must be kept horizontal in their original packaging, ensuring they are clean, undamaged and protected from direct sunlight, rain, humidity and other adverse weather conditions.

› Pallets should not be stacked one on top of another for extended periods, whether in storage or on site.

› Rolls must be stored in their original packaging, placed horizontally and parallel to each other (never crossed), on a flat, smooth surface.

danosa recommends consulting the product safety data sheet, which is permanently available at **www.danosa.com**, or by contacting our Technical Department (**tecnico.es@danosa.com**).

Substrate requirements and preparation

The guidelines set out in **DB HS1** of the *Spanish Technical Building Code (CTE)* and in **UNE Standard 104416:2009**, "Waterproofing roofing systems made of membranes with flexible synthetic sheets. Instructions, control, use and maintenance", or any updated equivalent, must be followed.

Waterproofing work must not be carried out when weather conditions are unfavourable, particularly during snowfall, when there is snow or ice on the roof, when it is raining, the surface is wet or in strong winds.

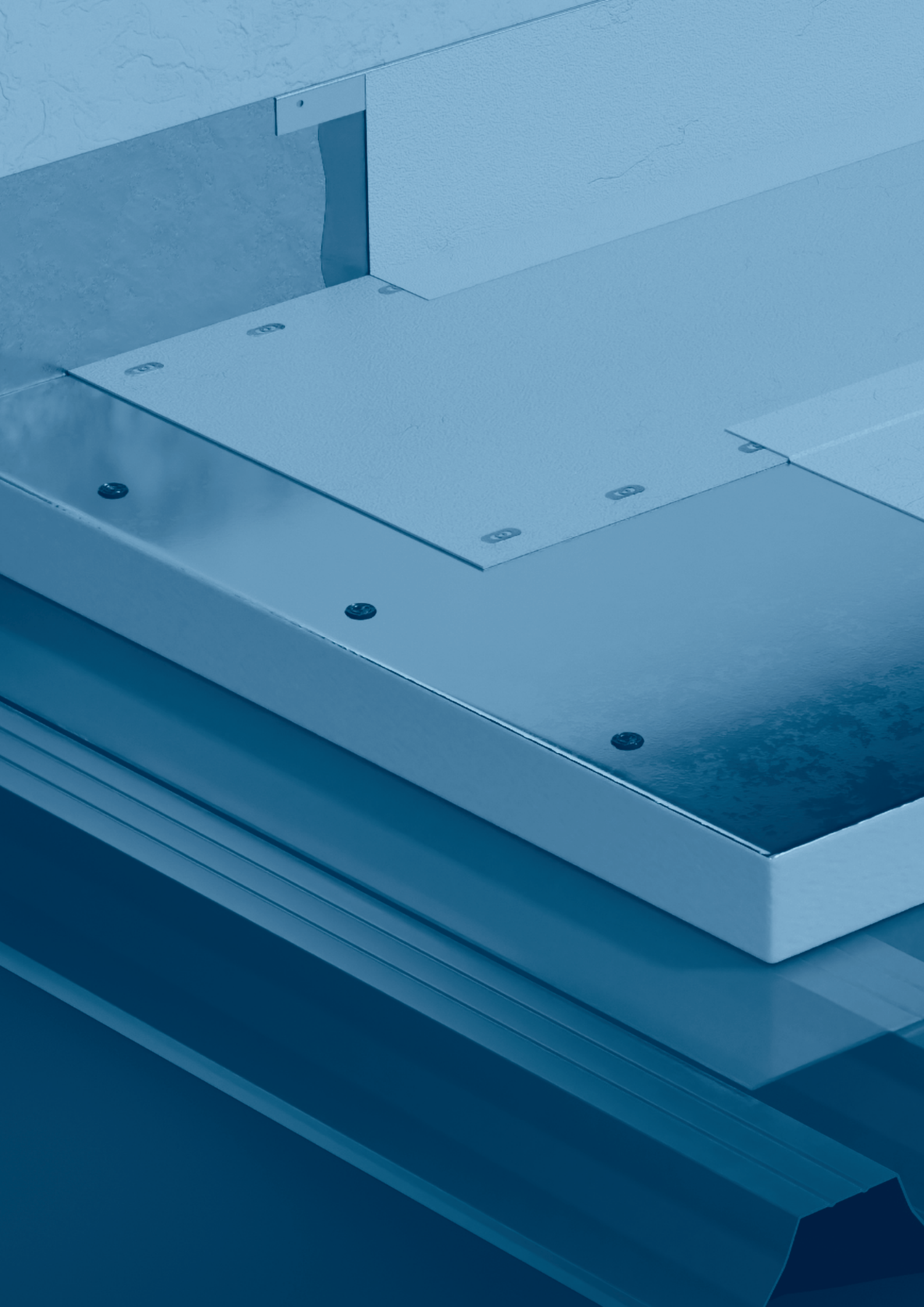
Before installing the **NEXALON® TPO** membrane, it is essential to prepare the substrate (whether concrete, timber or metal) correctly.

The substrate must be stable, uniform, smooth, clean and dry, and free of any debris or foreign objects. If installing over thermal insulation, the panels must be laid in a staggered pattern with no gaps greater than 1 mm between them.



02
Installation / Systems

Induction-welded and mechanically fixed installation systems, both designed to ensure secure placement in line with technical standards, guaranteeing the long-term durability of the waterproofing solution.



Fixing and installation

NEXALON® TPO membranes by **danosa** are mechanically fixed directly to the structural substrate to ensure stability against wind uplift. It is important to note that all fixings must penetrate the substrate: they must never be secured to any non-structural layer of the roof. They must always to fastened to the structural support.

There are two methods for fastening the membrane: mechanical fixing and induction welding.

As mentioned above, the substrate must be clean, stable and dry to prevent any cracking or displacement of the system components.

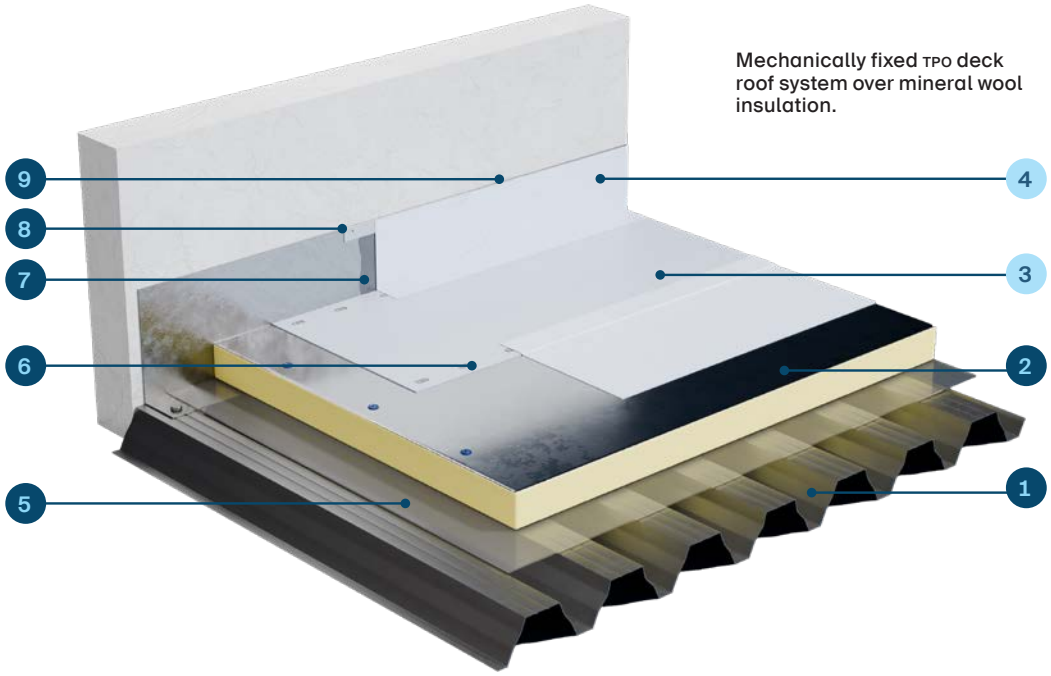
Insulation boards should be fixed to the substrate in accordance with the manufacturer's recommendations, ensuring they do not interfere with the later fixing of the **NEXALON® TPO** membrane.

Pre-installation recommendations for the **NEXALON®** membrane:

1. Before unrolling the membrane, mechanically fix the laminated profiles on both the horizontal surface (if required) and vertical parapets, ensuring a maximum spacing of 30 cm / 11.81 in between drill holes and a 5 mm / 0.197 in gap between adjacent profiles to allow for thermal expansion.
2. On vertical surfaces, the profile should be positioned so that the membrane extends at least 20 cm / 7.87 in above the finished roof level. The membrane used on the parapet must have the same characteristics as the membrane installed on the horizontal surface.
3. The joint between the vertical profile and the parapet must be sealed with an elastic, rot-proof mastic.

Reference of the construction detail of the scheme (ETA 24/0749):

1. Support
2. Thermal insulation
3. **NEXALON® TPO** membrane
4. **NEXALON® TPO** termination strip
5. Vapour barrier **DANOPOL® 250 BV**
6. Mechanical fixing
7. **NEXALON®** ADHESIVE
8. **NEXALON®** laminated profile
9. **ELASTYDAN® PU 40** elastic sealant



Mechanically fixed TPO deck roof system over mineral wool insulation.

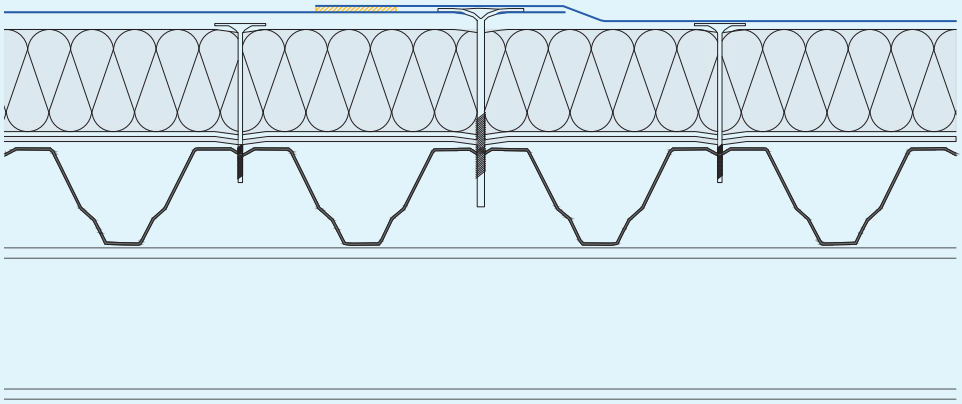
Mechanical fixing types

1. Selection of fixings

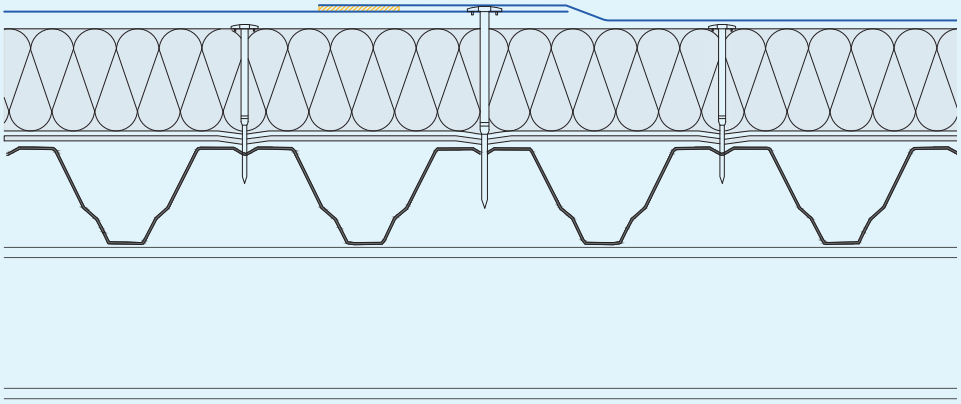
It is always recommended to use fixings approved by **danosa**.

The choice of fixing will depend on the technical specifications of each project.

› Plastic sleeve fixings:



› Metal washer fixings:





2. Fixing density

The density of fixings must follow **danosa**'s guidelines, which are based on the wind load acting on the roof. This load depends on factors such as geographical location, building height and type of substrate.

- Fixings should be placed along the edges of the membrane and at all overlaps.
- The number and layout of fixings must be determined in consultation with the fixing manufacturer, taking the project location into account.
- The spacing between fixings (typically between 15 and 25 cm / between 5.9 and 9.8 in) should follow the recommendations of the fixing manufacturer approved by **danosa**.

3. Membrane fixing: NEXALON® TPO

- The **NEXALON® TPO** membrane must be laid perpendicular to the direction of the roof's maximum slope. Membrane joints are created using thermoplastic welding with a hot-air welder.
- The rolls should be unrolled loosely over the waterproofing substrate (either thermal insulation or the existing waterproofing layer, in the case of refurbishment) starting at the lowest point of the roof slope and work perpendicular to the direction of maximum slope, forming a row of membrane.
- The minimum distance between fixings must be 12 cm / 4.72 in, and the maximum must not exceed 1 metre / 39.37 in. The maximum spacing between rows of fixings must be equal to the width of the membrane minus the edge setback of the fixing.

$$12\,\text{cm}\ (4.72\,\text{in}) \leq \mathbf{d_fij} \leq 1\,\text{m}\ (39.37\,\text{in})$$

$$\mathbf{D_max} = B - a$$

Definitions:

- **d_fij** = distance between fixings
- **D_max** = maximum distance between rows of fixings
- **B** = membrane width
- **a** = distance from the fixing to the edge of the membrane



4. Fixing inspection

- Fixings must be positioned at the specified distances to prevent membrane tearing.
- Ensure all fixings are correctly installed and secure.

Induction-welded fixing

1. Preparation of fixing plates

- Place the metal induction plates along the edges and overlaps of the membrane. The spacing between plates must comply with the recommendations of the fixing manufacturer approved by **danosa**.

2. Induction process

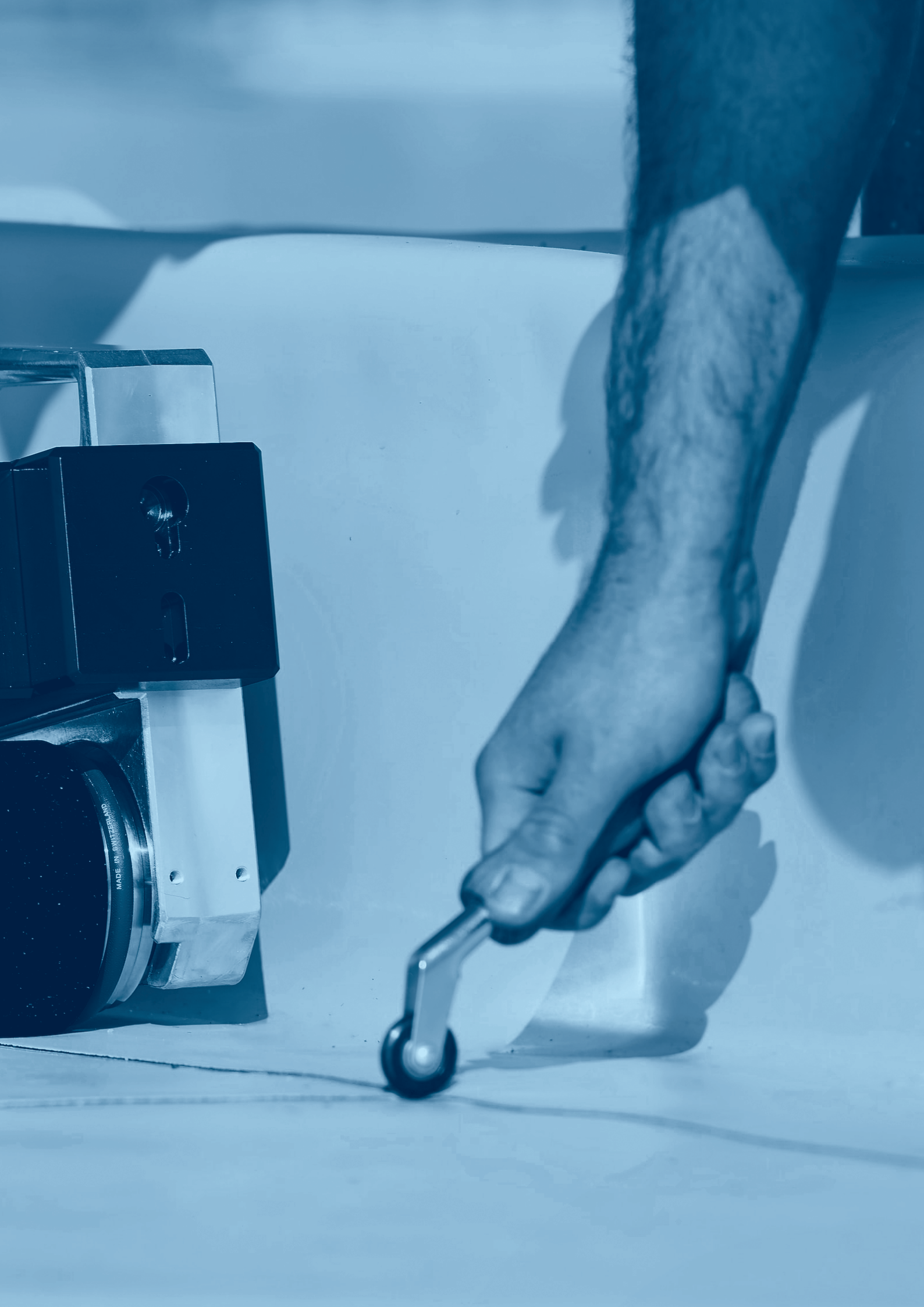
- Use the induction welding machine to bond the plates to the membrane. The machine generates an electromagnetic field that heats both the plate and the membrane, creating a strong and durable bond.
- Position the machine directly over each plate and activate the induction cycle. Keep the machine in place for the duration recommended by the manufacturer to ensure proper bonding.

3. Fixing verification

- Once the plates have been installed, check that each one is fully bonded to the membrane. Ensure there are no displacements or unbonded areas.

03
Welding

TPO membranes are joined using hot-air welding, which produces homogeneous, high-strength seams without the need for adhesives. This method ensures watertightness, long-term durability and a uniform finish across the entire system.


MADE IN SWITZERLAND

Manual / automatic welding



Preparation before welding

NEXALON® TPO membranes are factory-ready for installation. However, if the membrane has been exposed or has come into contact with other materials, it must be checked to ensure it is clean and free from dirt or contaminants.

Preparation of the hot-air welding machine: It is essential that the nozzles are clean and that the air outlet is uniform to maintain a consistent airflow during welding.

Temperature: Settings should follow the manufacturer's recommendations for the welding equipment, though they may need to be adjusted based on the ambient conditions of each project.

Test welding: Strongly recommended before starting work on any site to ensure that the machine is functioning correctly and has reached the appropriate temperature.

- After any significant weather change.
- Before beginning morning welding.
- Before beginning afternoon welding.

Manual welding

1. Before beginning manual welding, set the machine to the correct temperature. Adjustments must be made to ensure a strong weld. [1]
2. Manual welds should be carried out in two phases, as described below.
3. Using a pressure roller in your other hand, apply firm pressure on the upper membrane at the overlap while hot air is directed into the seam.



1. The effectiveness of this process will depend on the weather conditions, such as temperature and humidity.



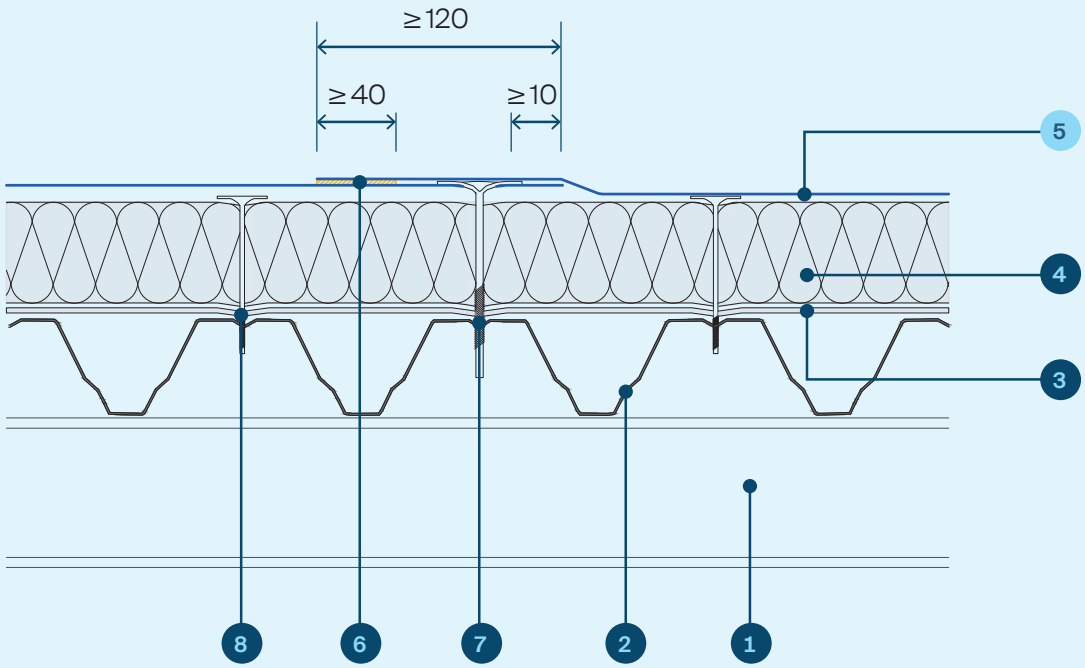
Automatic welding

1. As with manual welding, you must adjust the **temperature and travel speed of the machine** according to the manufacturer's recommendations and the environmental conditions.
2. Make sure all components, including the nozzles, are clean and in good working order before starting.

Overlaps

1. If overlaps are welded manually, the process must be done in several steps:
   - Start by spot welding the overlap every 50 cm / 19,69 in approximately.
   - Once the membrane is fixed in place with spot welds, proceed to weld the full overlap between the membranes.
2. Overlaps must be at least **120 mm** / **4.72 in** wide to cover the mechanical fixing. The welded area between the lower and upper membrane must be a minimum of **40 mm** / **1.57 in** wide. Immediately after welding, the seam must be pressed with a roller to ensure a homogeneous bond.
3. Mechanical fixings should be placed in the longitudinal overlap, which will then be covered by the next membrane in the row (on the higher part of the roof slope). The distance from the edge of the washer to the edge of the membrane must be at least **10 mm** / **0.39 in**.
4. Position the roll for the next row and weld the overlap at the location of the fixings. Membranes should be laid in such a way that no transverse overlap in one row aligns with overlaps in adjacent rows.
5. Mechanically fix the opposite edge of the next membrane roll following the same principles outlined above.

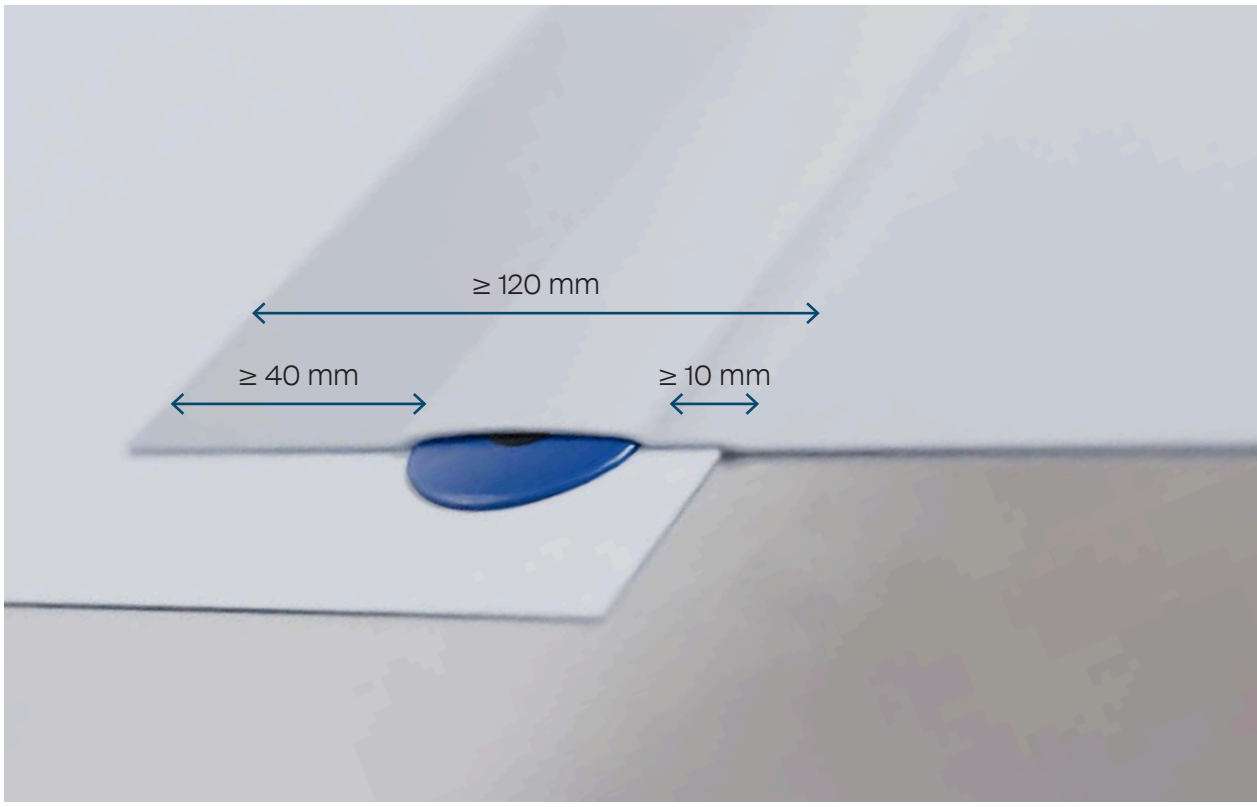
Measurements in mm



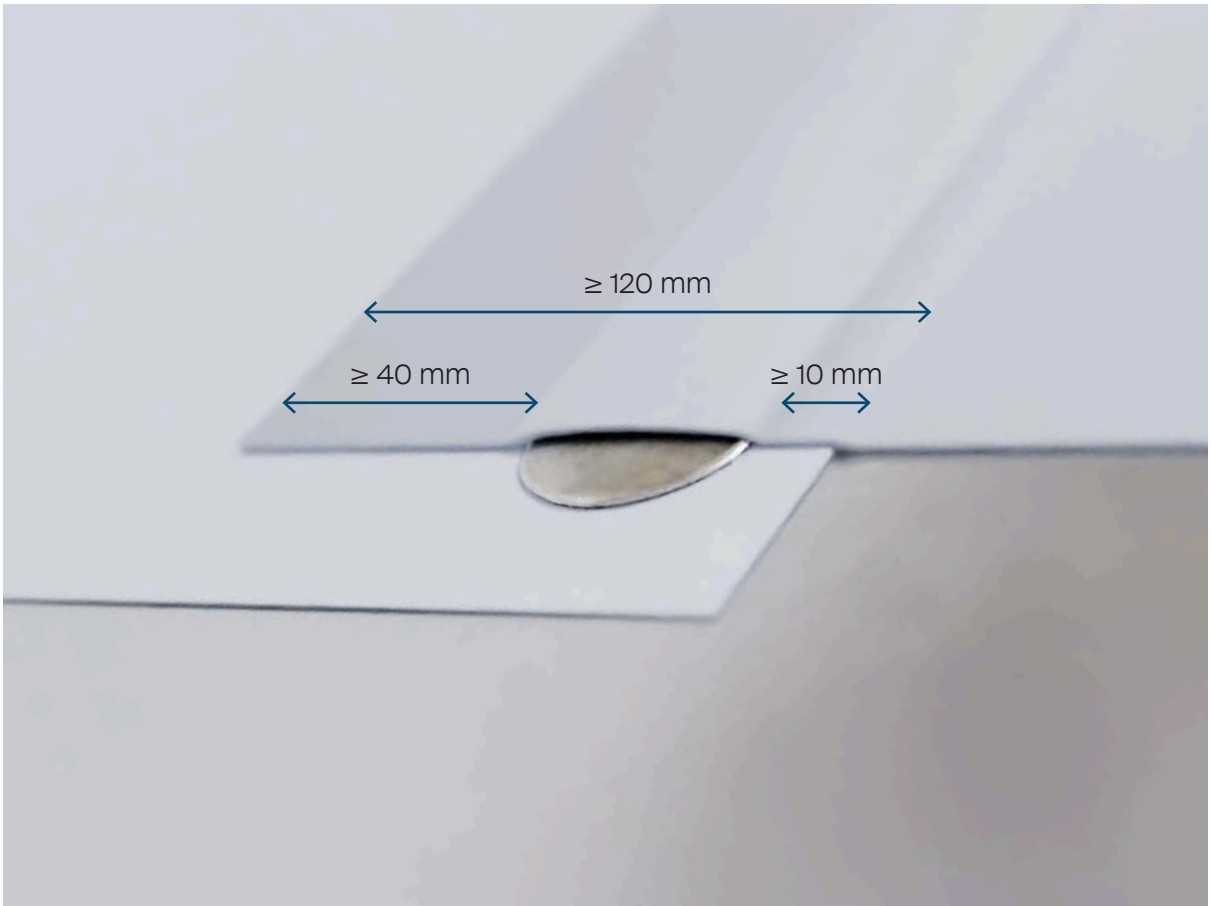
Reference of the construction detail of the scheme (ETA 24/0749):

1. Rigid substrate
2. Profiled metal sheet
3. Vapour barrier: **DANOPOL® 250 BV**
4. Thermal insulation
5. **NEXALON® TPO** synthetic waterproofing membrane with polyester reinforcement
6. Thermoplastic welding
7. Mechanical fixing of waterproofing membrane
8. Mechanical fixing of insulation

› Overlap with plastic sleeve fixings



› Overlap with fixing bar

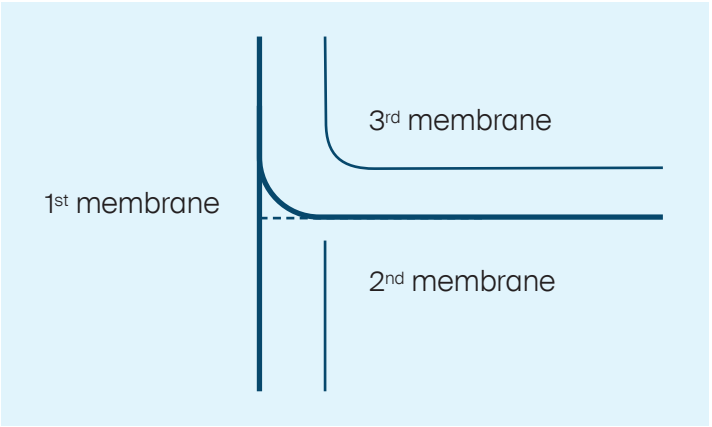


T-joint

A T-joint occurs where three separate membrane sheets overlap, forming a T-shaped intersection.

It is essential to ensure that the first two membranes are correctly installed.

Once this is confirmed, proceed with welding the third membrane following the previously described guidelines.



T-join between three membranes.



At the point of intersection, all corners must be rounded to improve wind resistance and minimise the risk of water infiltration over time.

Once complete, perform a weld integrity test.

Weld inspection

After all welds are complete and the material has sufficiently cooled, all joints between membranes must be inspected.

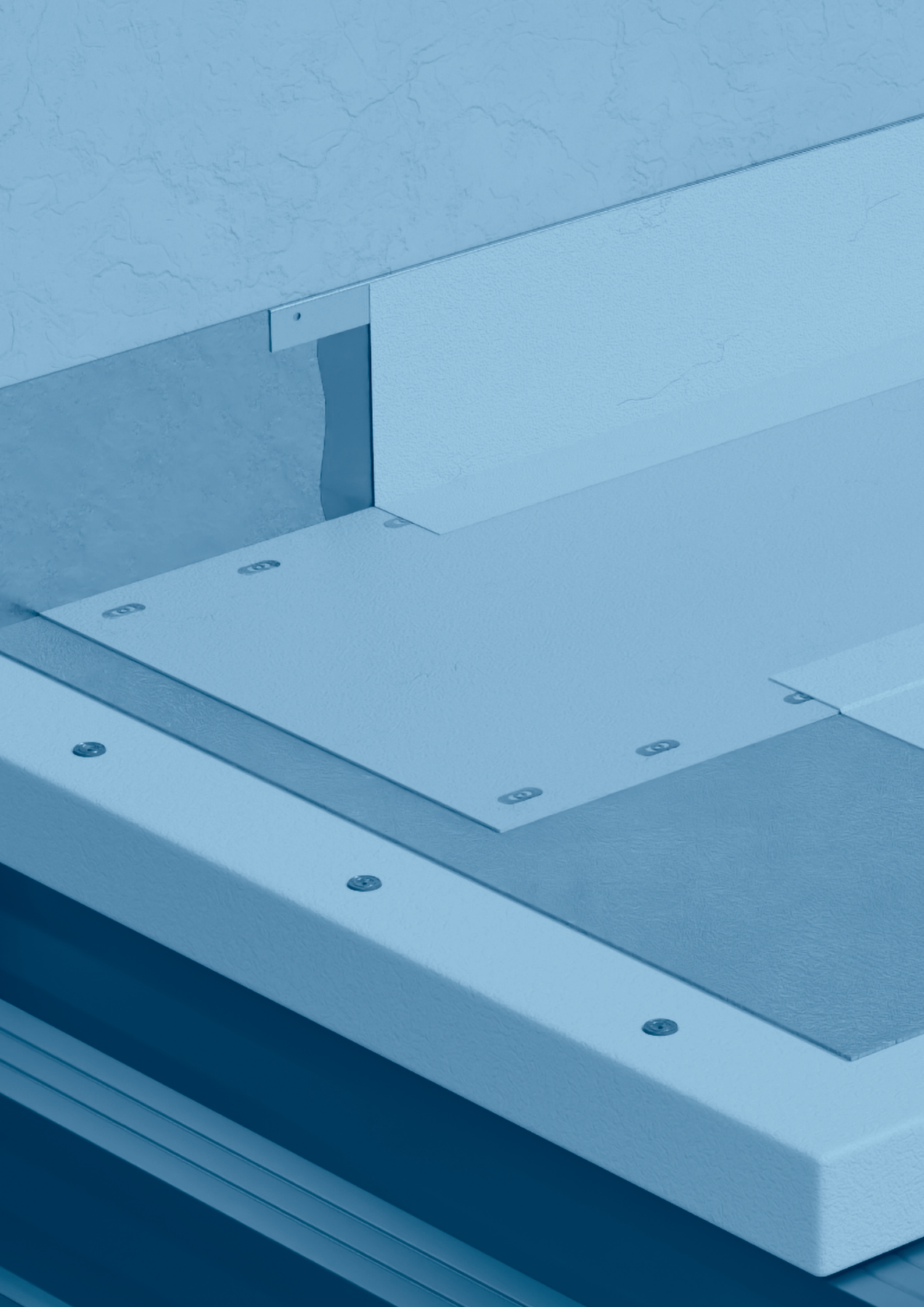
To verify the joints, a physical inspection shall be carried out using a welding probe..

This probe must not penetrate the welded overlap. If it does, this indicates an improper weld, and the joint must be redone.



04
Critical points

Critical points such as junctions, corners, outlets and joints require special attention to ensure the continuity and watertightness of the system. These areas must be carefully reinforced and sealed to offer maximum protection against leaks and long-term deterioration.



Perimeter / roof parapets

At junctions between the roof and vertical elements (such as parapets or penetrations), the membrane must rise at least 20 cm / 7.87 in above the finished roof level, or higher if required. This ensures that the top edge of the membrane remains elevated, protecting against water ingress caused by splashing, accumulated snow or similar conditions. To improve the aesthetic finish in these areas, **NEXALON® ADHESIVE** may be used to bond the membrane to the vertical surface.

For the execution of these connections, the membrane may be fixed by. :

- TYPE A laminated profile, fixed to the vertical surface. Fig. 1
- Spot fixings on the horizontal surface. Fig. 2

Fig 1.: Fixing with laminated TYPE A profile



Fig 2.: Fixing with plastic sleeve



1. Intermediate fixing on the parapet

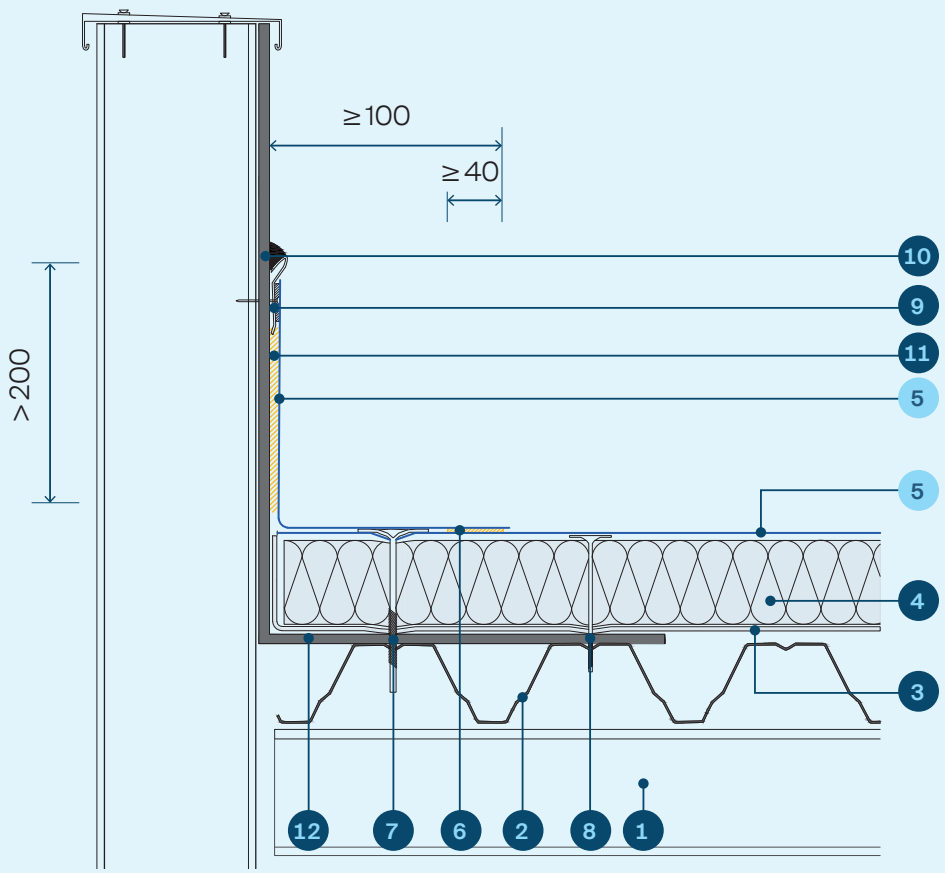
› If the height of the vertical parapet exceeds 50 cm / 19.69 in, an intermediate fixing must be installed. The fixing method will depend on the material composition of the parapet.

› When the parapet exceeds this height, the membrane must be either adhered using **NEXALON® ADHESIVE**, mechanically fixed (if the material permits), or secured with a laminated sheet metal profile.

2. Final fixing of the **NEXALON® TPO** membrane on the parapet

› The final fixing of the membrane is carried out after installing a TYPE B laminated profile, ensuring watertightness at the junction.

Measurements in mm



Reference of the construction detail of the scheme (ETA 24/0749):

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2. Profiled metal sheet
3. Vapour barrier: **DANOPOL® 250 BV**
4. Thermal insulation
5. **NEXALON® TPO** synthetic waterproofing membrane with polyester reinforcement
6. Thermoplastic welding
7. Mechanical fixing of waterproofing membrane
8. Mechanical fixing of insulation
9. **NEXALON® B** laminated profile
10. Elastic sealant **ELASTYDAN® PU 40** GREY
11. **NEXALON®** ADHESIVE
12. Metal profile

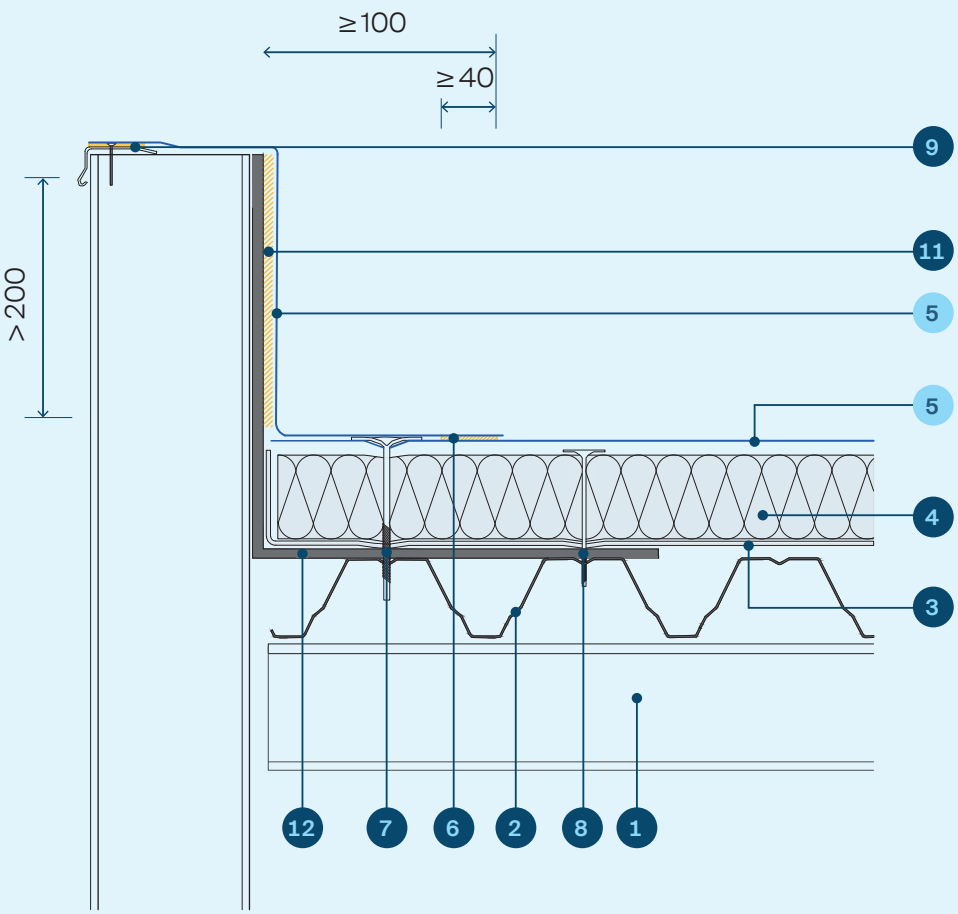
3. Parapet coping

A TYPE C laminated profile with drip edge is installed along the entire top edge of the parapet to allow welding of the membrane and to create a fully watertight seal.

When the parapet height does not exceed 20 cm / 7.87 in, or if there is no perimeter parapet, the connection to these elements or to the edge of the slab can be made using an angled laminated metal profile – TYPE C laminated profile (drip-edge termination angle) – that projects over the exterior face of the wall, acting as a drip edge.

This profile should be fixed to the parapet via its horizontal flange, which must be at least 6 cm / 2.36 in wide, using anchors spaced no more than 25 cm / 9.84 in apart. The membrane is then welded to the laminated metal profile so that the screw heads remain concealed.

Measurements in mm



Reference of the construction detail of the scheme (ETA 24/0749):

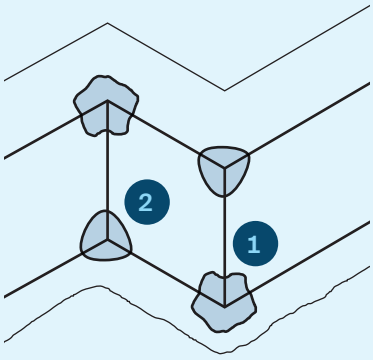
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4. Thermal insulation
5. **NEXALON® TPO** synthetic waterproofing membrane with polyester reinforcement
6. Thermoplastic welding
7. Mechanical fixing of waterproofing membrane
8. Mechanical fixing of insulation
9. **NEXALON®** laminated profile
10. **ELASTYDAN® PU 40** elastic sealant
11. **NEXALON®** ADHESIVE
12. Metal profile

Corners

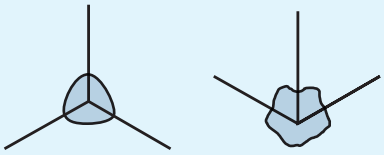
For corner junctions, it is always recommended to use prefabricated corner pieces from **danosa**. These should be welded using a hot-air gun with a 20 mm / 0.79 in nozzle to ensure the junction is completely watertight.

Special attention must be paid to corners, as they are critical points on the roof and must be properly executed.

If it is not possible to install a prefabricated corner piece, the junction may be formed using **NEXALON® TPO 1.5 NON-REINFORCED** membrane.

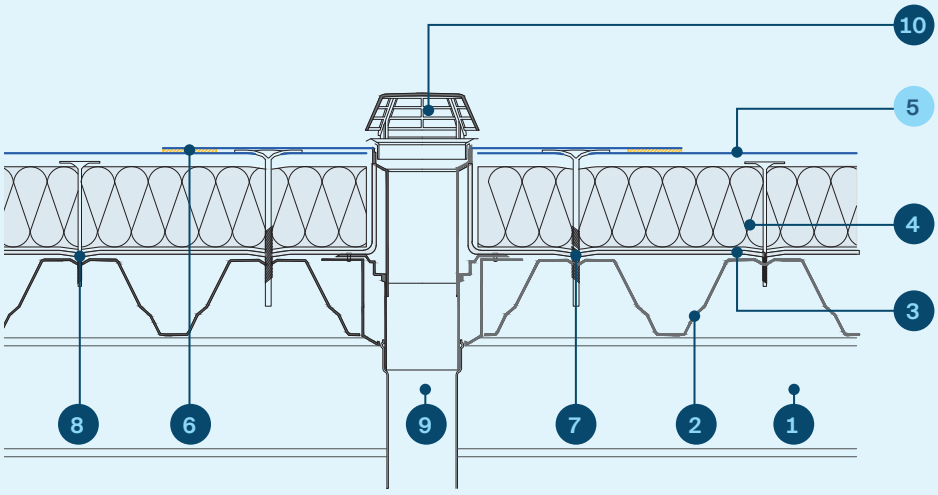


1. Corner reinforcement
2. Nook reinforcement



Nook TPO Corner TPO

Outlets



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6. Thermoplastic welding
7. Mechanical fixing of waterproofing membrane
8. Mechanical fixing of insulation
9. **NEXALON® DRAIN OUTLET:** vertical roof outlet
10. Gravel guard for outlet

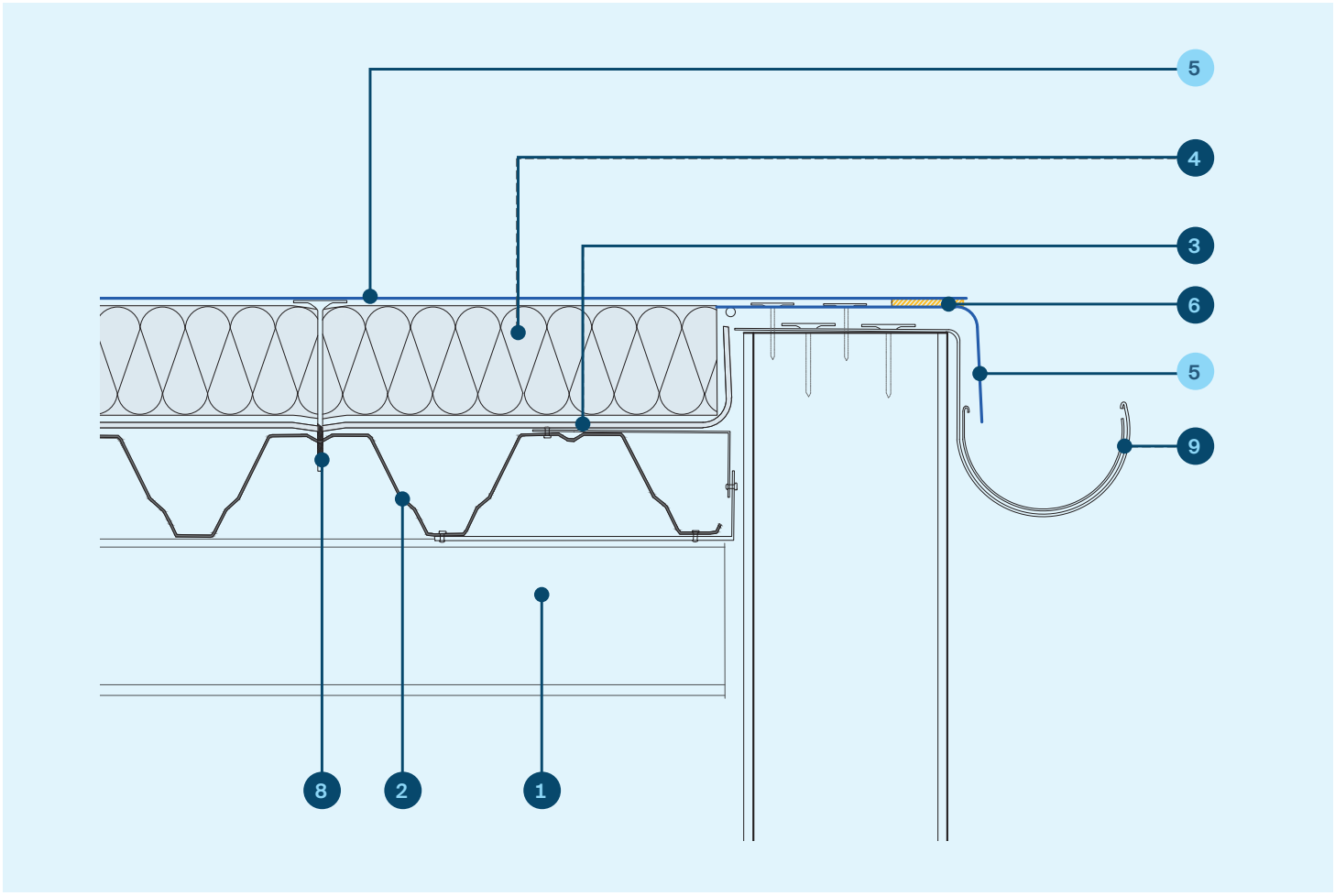
It is always recommended to use prefabricated **danosa** outlets for these types of solutions, as they ensure reliable welding and watertightness at the roof finish points.

If a prefabricated corner piece cannot be used, the junction can also be formed using **NEXALON® TPO 1.5 NON-REINFORCED** membrane.

With other systems specified in the project, provided they ensure watertight integration with the roof's waterproofing membrane.

Gutters

A TYPE C laminated profile with drip edge is installed along the entire top edge of the gutter to allow welding of the membrane and to create a fully watertight seal.

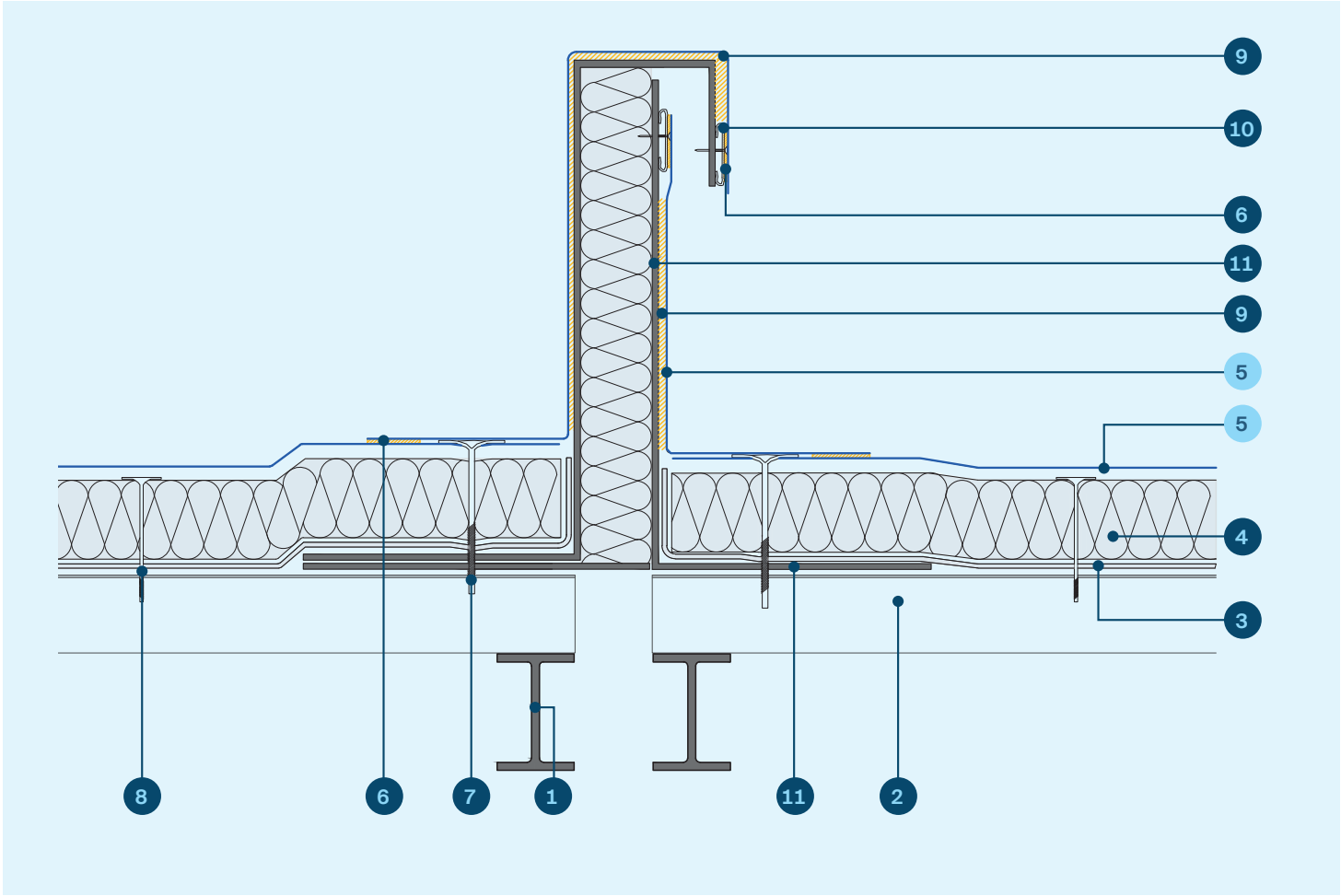


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6. Thermoplastic welding
7. Mechanical fixing of waterproofing membrane
8. Mechanical fixing of insulation
9. Metal gutter

Structural joints

The structural joint shall be properly prepared, ensuring that the substrate is clean and stable. The specific waterproofing system shall be installed over the joint, allowing free movement between the structural elements. The membrane shall be welded to the designated profiles or anchoring strips, ensuring a continuous and watertight seal along the entire length of the joint.



Reference of the construction detail of the scheme (ETA 24/0749):

1. Rigid substrate
2. Profiled metal sheet
3. Vapour barrier: **DANOPOL® 250 BV**
4. Thermal insulation
5. **NEXALON® TPO** synthetic waterproofing membrane with polyester reinforcement
6. Thermoplastic welding
7. Mechanical fixing of waterproofing membrane
8. Mechanical fixing of insulation
9. **NEXALON®** ADHESIVE
10. **NEXALON®** laminated profile
11. Metal profile

05 Recommendations / Annexes

This section provides additional guidelines to optimise the installation and long-term performance of the system.



Use and functioning

- **NEXALON® TPO** membranes must be used exclusively for their intended purpose.
- No chemical products should be discharged directly onto the waterproofing membrane.

Key considerations: Maintenance

To ensure the proper maintenance of the roof, the **danosa** Maintenance Plan shall be consulted, as it details the recommended inspections and the actions required to preserve the durability and performance of the waterproofing system.

Maintenance and care

Maintenance tasks, along with their required frequency, are detailed in Table 6.1. Any detected defects must be promptly corrected.

- Perform visual inspections at least once per year.
- Inspect the roof after severe weather events, such as storms or hail, to detect any damage.

The maintenance operations described in table 6.1 of CTE HS1 are included. →

Table: **Maintenance tasks**

	Task	Frequency
Walls	Check correct function of gutters and downpipes on **partially sealed walls**	1 year [1]
	Check that the ventilation openings in the cavity of partially sealed walls are not obstructed	1 year
	Inspect condition of internal **waterproofing**	1 year
Floors	Check cleanliness of **drainage** and waste networks	1 year [2]
	Clean inspection chambers	1 year [2]
	Check the condition of the sump pumps, including any backup units, if their installation was required to ensure proper **drainage**	1 year
	Check for signs of water ingress through cracks or fissures	1 year
Façades	Inspect the condition of the surface finish: look for possible cracks, detachment, damp patches or staining	3 years
	Inspect condition of critical points	3 years
	Check for cracks, warping or deformation in **main wall leaf**	5 years
	Inspect cleanliness of **joints** and cavity ventilation openings	10 years
Roofs	Clean drainage components (outlets, gutters, overflows) and check function	1 year [1]
	Relevel or reposition gravel ballast	1 year
	Inspect condition of protective layer or roof covering	3 years
	Inspect condition of critical points	3 years

1. Additional inspections should be carried out after major storms.

2. To be done annually at the end of summer.

Regular cleaning

- Clean the surface of the **NEXALON® TPO** membrane to remove dust, debris, leaves and dirt.
- Use a solution of water and neutral detergent, avoiding aggressive chemicals that could damage the membrane.
- Rinse thoroughly with clean water to remove any detergent residue.

Immediate repairs

- Repair any damage, punctures or tears as soon as they are detected.
- Use only **danosa**-approved repair materials and techniques to ensure compatibility and performance.



Inspection of joints and welds

- Check that all joints and welds are secure and fully adhered.
- Repair or reinforce any areas showing signs of separation or deterioration.

Damage prevention

- Avoid unnecessary foot traffic over the **NEXALON® TPO** membrane. Where access is required, use temporary protective walkways.
- Keep sharp tools and objects away from the membrane to avoid accidental damage.



Drainage management

- Ensure that all drains and gutters are free of blockages to prevent standing water.
- Inspect and clean all drainage elements regularly.

Detailed documentation

- Maintain a detailed log of all inspections, cleaning and repair activities.
- Include photographs and notes of any repaired areas for future reference and tracking.

Special conditions

- In areas exposed to extreme weather conditions, consider additional inspections and maintenance.
- Adapt the maintenance plan according to **danosa's** specific recommendations, based on the local environment and intended use of **NEXALON® TPO** membranes.

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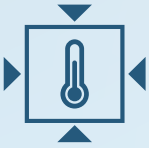
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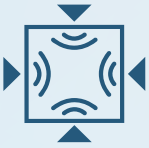
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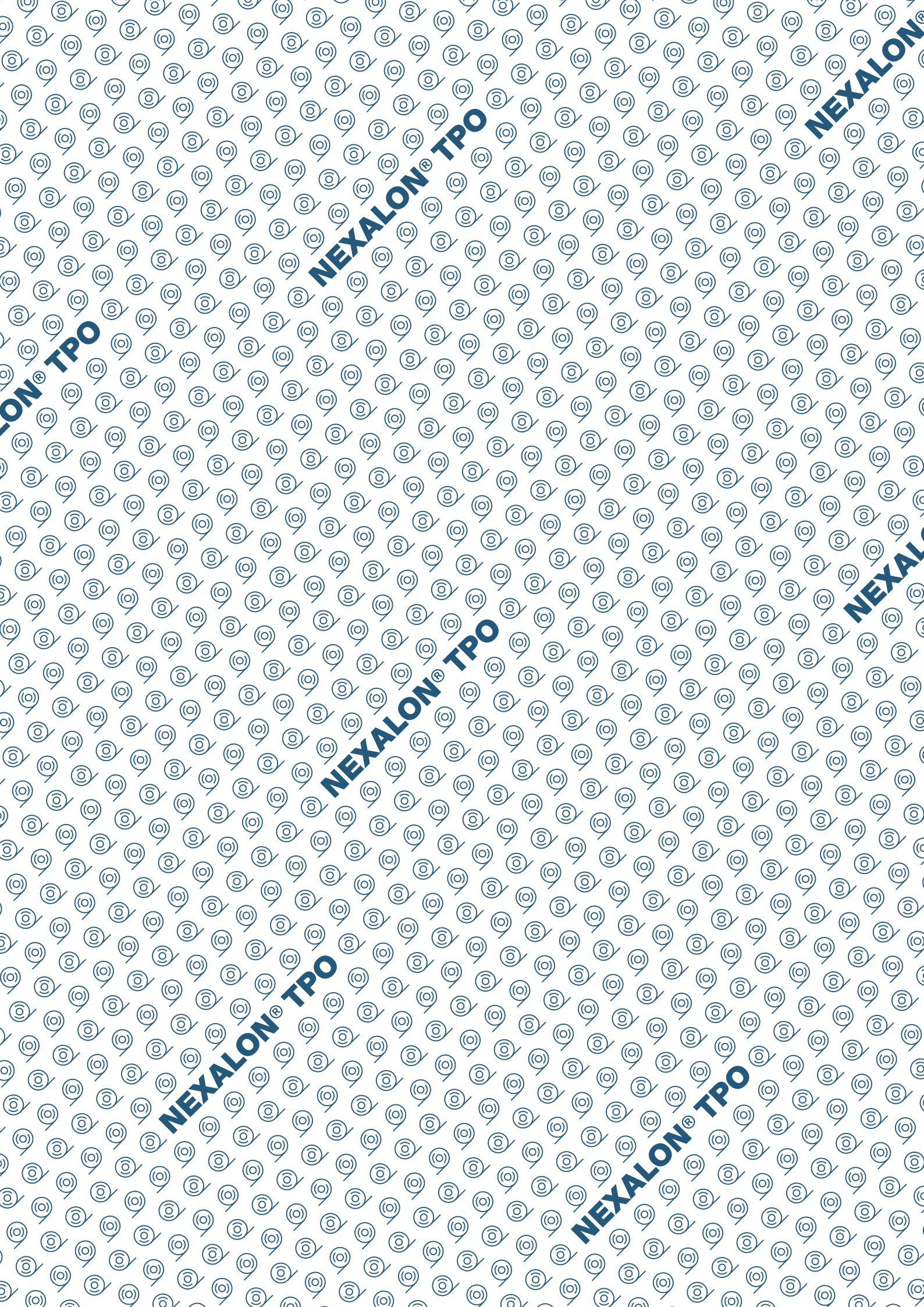
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Danosa Technical Office

For further information or technical assistance, please contact our Technical Office via our website **www.danosa.com**, or by emailing **tecnico.es@danosa.com**.

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