

## Sarnafil® S 327-15EL

### Polymeric membrane for roof waterproofing

<b>Product Description</b>	<p>Sarnafil® S 327-15EL (thickness 1.5 mm) is a Polyester reinforced, multi-layer, synthetic roof waterproofing sheet based on premium-quality polyvinyl chloride (PVC) containing ultraviolet light stabilizers and flame retardant according to EN 13956.</p> <p>Sarnafil® S 327-15EL is a hot air weldable roof membrane formulated for direct exposure and designed to use in all global climatic conditions. Sarnafil® S 327-15EL is produced with an integral polyester scrim reinforcement for high strength used within the Sarnafast spot fastening system and Sarnabar linear mechanically fastened system.</p> <p>Sarnafil® S 327-15EL has a unique lacquer coating applied to the top of the membrane to resist staining from airborne dirt and pollutants.</p> <p>Sarnafil® S 327-15EL has no built-in stress at the time of production and has a fully encapsulated reinforcement with no risk to delamination or water-wicking. Sarnafil® S 327-15EL can be produced also in a variety of colours in smaller quantities.</p>
<b>Uses</b>	<p>Waterproofing membrane for:</p> <ul style="list-style-type: none"><li>■ Mechanically fastened roofs</li></ul>
<b>Characteristics / Advantages</b>	<ul style="list-style-type: none"><li>■ Outstanding resistance to weathering, including permanent UV irradiation</li><li>■ Excellent flexibility in cold temperatures</li><li>■ No built-in stress at the time of production</li><li>■ High dimensional stability</li><li>■ High water vapour permeability</li><li>■ Excellent weldability</li><li>■ No risk of delamination or water-wicking</li><li>■ Can be produced also in a variety of colours</li><li>■ Lacquer coated surface</li><li>■ Recyclable</li></ul>
<b>Approval / Standards</b>	<p>Sarnafil® S 327-15EL is designed and manufactured to meet most international recognised standards.</p> <ul style="list-style-type: none"><li>■ Polymeric sheets for roof waterproofing according to EN 13956, certified by notified body 1213-CPD-3917 and provided with the CE-mark.</li><li>■ Reaction to fire according to EN 13501-1.</li><li>■ External fire performance tested according to ENV 1187 and classified according to EN 13501-5: B<sub>ROOF</sub>(t1).</li><li>■ Official Quality Approvals and Agreement Certificates and approvals.</li><li>■ Monitoring and assessment by approved laboratories.</li><li>■ Quality Management system in accordance with EN ISO 9001/14001.</li></ul>



<b>Appearance / Colours</b>	Surface:	matt
	Colours:	
	Top surface:	light grey (nearest RAL 7047) lead grey (Sika colour no. 9500) copper patina (Sika colour no. 6525) window grey (nearest RAL 7040) copper brown (nearest RAL 8004) azure blue (nearest RAL 5009) traffic white (nearest RAL 9016) pearl copper metallic (nearest RAL 8029) with hammer style embossing
	Bottom surface:	dark grey
	Top surface of sheet in other colours available on request, subject to small minimum order quantities.	
<b>Packaging</b>	Sarnafil® S 327-15EL standard rolls are wrapped individually in a blue PE-foil.	
	Packing unit:	up to 27 rolls per pallet
	Roll length:	20.00 m
	Roll width:	2.00 m
	Roll weight:	72.00 kg
<b>Storage Conditions / Shelf-Life</b>	Rolls must be stored in a horizontal position on pallet and protected from direct sunlight, rain and snow. Product does not expire if correctly stored.	

## Technical Data

<b>Product Declaration</b>	EN 13956	
<b>Visible defects</b>	Pass	EN 1850-2
<b>Length</b>	20 m (- 0 % / + 5 %)	EN 1848-2
<b>Width</b>	2 m (- 0.5 % / + 1 %)	EN 1848-2
<b>Straightness</b>	≤ 30 mm	EN 1848-2
<b>Flatness</b>	≤ 10 mm	EN 1848-2
<b>Effective thickness</b>	1.5 mm (- 5 % / + 10 %)	EN 1849-2
<b>Mass per unit area</b>	1.8 kg/m <sup>2</sup> (- 5 % / + 10 %)	EN 1849-2
<b>Water tightness</b>	Pass	EN 1928
<b>Effects of liquid chemicals, including water</b>	On request	EN 1847
<b>External fire performance:</b>		ENV 1187
<b>Part 1-4</b>	B <sub>ROOF</sub> (t1) < 20°, > 20°	EN 13501-5
<b>Reaction to fire</b>	Class E	EN ISO 11925-2, classification to EN 13501-1
<b>Hail resistance:</b>		EN 13583
<b>rigid substrate</b>	≥ 22 m/s	
<b>flexible substrate</b>	≥ 30 m/s	
<b>Joint peel resistance</b>	≥ 300 N/50 mm	EN 12316-2
<b>Joint shear resistance</b>	≥ 800 N/50 mm	EN 12317-2
<b>Water vapour transmission properties</b>	μ = 15'000	EN 1931
<b>Tensile strength</b>		EN 12311-2
<b>longitudinal (md)<sup>1)</sup></b>	≥ 1100 N/50 mm	
<b>transversal (cmd)<sup>2)</sup></b>	≥ 1100 N/50 mm	
<b>Elongation,</b>		EN 12311-2
<b>longitudinal (md)<sup>1)</sup></b>	≥ 12 %	
<b>transversal (cmd)<sup>2)</sup></b>	≥ 12 %	
<b>Resistance to impact,</b>		EN 12691
<b>hard substrate</b>	≥ 600 mm	
<b>soft substrate</b>	≥ 900 mm	
<b>Resistance to static load,</b>		EN 12730
<b>soft substrate</b>	≥ 20 kg	
<b>rigid substrate</b>	≥ 20 kg	
<b>Tear strength</b>		EN 12310-2
<b>longitudinal (md)<sup>1)</sup></b>	≥ 200 N	
<b>transversal (cmd)<sup>2)</sup></b>	≥ 200 N	
<b>Dimension stability,</b>		EN 1107-2
<b>longitudinal (md)<sup>1)</sup></b>	≤  0.3  %	
<b>transversal (cmd)<sup>2)</sup></b>	≤  0.2  %	
<b>Foldability at low temperature</b>	≤ -25 °C	EN 495-5
<b>UV exposure</b>	Pass (> 5000 h)	EN 1297

<sup>1)</sup> md = machine direction

<sup>2)</sup> cmd = cross machine direction

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## System Information

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### System Structure

Wide range of accessories is available e.g. prefabricated parts, roof drains, scuppers, walkway pads and decor profiles.

The following materials are strongly recommended:

Sarnafil® G 410-15EL / S 327-15EL Sheet for detailing

Sarnafil® S 327-15EL for Coverstrips

Sarnafil® Metal Sheet

Sarnabar

S-Welding Cord

Sarna Seam Cleaner

Sarnacol® 2170 (contact adhesive)

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## Application Details

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### Substrate Quality

The substrate surface must be uniform, smooth and free of any sharp protrusions or burrs, etc.

Sarnafil® S 327-15EL must be separated from any incompatible substrates by an effective separation layer to prevent accelerated ageing. Prevent from direct contact with bitumen, tar, fat, oil, solvent containing material and direct contact to other plastic materials, e.g. expanded polystyrene (EPS) and extruded polystyrene (XPS) as this could adversely affect the product properties.

The supporting layer must be compatible to the membrane, solvent resistant, clean, dry and free of grease and dust. Metal sheets must be degreased with before adhesive is applied.

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## Application Conditions / Limits

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### Temperature

The use of Sarnafil® S 327-15EL membrane is limited to geographical locations with average monthly minimum temperatures of -50 °C.  
Permanent ambient temperature during use is limited to +50 °C.

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### Compatibility

Not compatible with direct contact to other plastics, e.g. EPS and XPS. Not resistant to tar, bitumen, oil and solvent containing materials.

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## Installation Instructions

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### Installation Method / Tools

Installation procedure:

According to the valid installation instructions for Sarnafil® S 327-EL types system for mechanically fastened roofs.

Fixing Method, linear fastening (Sarnabar):

Unroll the Sarnafil® S 327-15EL membrane, overlap by 80 mm, weld immediately and to fix the substructure by means of Sarnabars. The type of fastening and the distance will be advised by Sika Ltd, Sika Sarnafil. The perimeter piece ends must be secured with the Sarnafil® Sarnabar End Washer. For protection fasten a piece of Sarnafil® under bar end and plate. Leave a 10 mm clearance between bar ends. Do not fasten in hole nearest bar end. Cover the bar ends with a piece of Sarnafil® and weld. After installation the Sarnabars must immediately be made watertight with a Sarnafil® cover strip. At upstands and at all penetrations, the Sarnafil® S 327-15EL membrane must be secured with a Sarnabar. The 4 mm diameter S-Welding Cord protects the Sarnafil® S 327-15EL roof covering against tearing and peeling of by wind uplift.

Fixing Method, spot fastening (Sarnafast):

Sarnafil® S 327-15EL must always be installed at right angles to the deck direction. Sarnafil® S 327-15EL is fixed by means of the Sarnafast fasteners and barbed washers along the marked line, 35 mm from the edge of the membrane. Sarnafil® S 327-15EL is overlapped by 120 mm. The spacing of the fasteners is in accordance with the project specific calculations made by Sika Ltd, Sika Sarnafil.

Welding Method:

Overlap seams are welded by electric hot air welding equipment, such as manual hot air welding machines and pressure rollers or automatic hot air welding machines with controlled hot air temperature.

Recommended type of equipment: Leister Triac PID for manual welding  
Sarnamatic 661<sup>plus</sup> for automatic welding

Welding parameters including temperature, machine speed, air flow, pressure and machine settings must be evaluated, adapted and checked on site according to the type of equipment and the climatic situation prior to welding. The effective width of welded overlaps by hot air should be minimum 20 mm.

The seams must be mechanically tested with screw driver to ensure the integrity / completion of the weld. Any imperfections must be rectified by hot air welding.

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### Notes on Installation / Limits

Installation works must be carried out only by Registered Sarnafil Contractors.

Temperature limits for the installation of the membrane:

Substrate temperature: -30 °C min. / +60 °C max.

Ambient temperature: -20 °C min. / +60 °C max.

Installation of some ancillary products, e.g. contact adhesives / cleaners is limited to temperatures above +5 °C. Please observe information given by Product Data Sheets.

Special measures may be compulsory for installation below +5 °C ambient temperature due to safety requirements in accordance with national regulations.

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<b>Value Base</b>	All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.
<b>Local Restrictions</b>	Please note that as a result of specific local regulations the performance of this product may vary from country to country. Please consult the local Product Data Sheet for the exact description of the application fields.
<b>Ecology, Health and Safety Information</b>	The product does not fall within the EU-regulation of hazardous goods. As a result, a material safety data sheet following EU-Guideline 91/155 EWG is not needed to bring the product to the market, transport or use it. The product does not damage the environment when used as specified.
<b>Protective Measures</b>	Fresh air ventilation must be ensured, when working (welding) in closed rooms. Regulatory safety requirements must be observed.
<b>Transportation Class</b>	The product is not classified as hazardous good for transport.
<b>Disposal</b>	The material is recyclable. Any disposal must be in accordance with regulatory requirements.

All data in our product information are based on our current knowledge and experience. They do not release users from careful testing of the application and strict observation of the relevant processing regulations because of the wide range of possible influences during the application and use of our products. Legally valid assurances of specific characteristics or suitability for special purposes of application other than those provided in our documentation for the specific product cannot be inferred from our information. Any protective rights or existing laws and provisions must be followed by the recipient or processor of our products at their own responsibility. Moreover our general terms and conditions of sale and guarantee are valid.



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