December 2025

TECHNICAL MEMO

TARGET MARKET ROOFING & WATERPROOFING

BUILDING TRUST

Subject: Sikalastic Rapid 724 (PMMA) Flashing Install Guide

1. Product Name

Sikalastic® Rapid 724

2. Product Description

Sikalastic® Rapid 724 resin is combined with Sikalastic® Rapid Catalyst and Sikalastic® Rapid Fleece reinforcement to form a UV stable monolithic, self-flashing and self-adhering reinforced flashing membrane used in conjunction with Hydrotech® MM6125 and Hydrotech® Hot Rubberized Asphalt membranes for flashings a variety of conditions that do not allow for typically required membrane flashing termination requirements. Sikalastic® Rapid 724 resin is supplied in a 12kg (9.7 L) resealable pail. Sikalastic® Rapid 724 is available in winter grade (Sikalastic® Rapid 724 **WG**).

3. Accessories

a. **Sikalastic® Rapid Catalyst PMMA**: used as a reactive agent to initiate curing of Sikalastic® liquid resins and primers. Size: 0.1kg (3.5oz/100g), 25kg (55lbs) includes tablespoon (10g) measuring scoop. (1kg = 1000g)

b. **Sikalastic® Rapid Primer ASP:** used as a primer for Sikalastic® Rapid 724 resin and/or Sikalastic® Rapid 724 Detailer applied over concrete, masonry, wood, asphalt, and other substrates as recommended. Sikalastic® Rapid Primer ASP is combined with Sikalastic® Rapid Catalyst. Size: 10kg (9.6L) pail

c. **Sikalastic® Rapid Metal Primer:** an acrylic primer used to promote adhesion of Sikalastic resins to various metal substrates. Size: 1 gal (3.7L)

d. **Sikalastic® Rapid Fleece PMMA**: used to reinforce Sikalastic® Rapid 724 resin cold, fluid-applied, flashing membrane to improve tear strength, puncture resistance, and crack bridging capabilities while maintaining membrane uniformity. Size: width- 10”, 13.8”, 20.7” and 41.3” Length 164’

e. **Sikalastic® Rapid 724 Detailer**: a pre-reinforced resin that may be used when installing the Sikalastic® Rapid 724 flashing resin and fleece would be difficult (i.e., over bolt heads, back-to-back angles, etc.). Sikalastic® Rapid 724 Detailer is combined with Sikalastic® Rapid Catalyst PMMA. Size: 2kg (1.5L)

f. **Sikalastic® Rapid Paste**: is rapid setting paste used for horizontal and vertical leveling, patching, and repairs to substrates in non-traffic bearing applications, requires Sikalastic® Rapid Catalyst PMMA. Size: 15kg (10.6L)

g. **Sikalastic® Rapid Thixo**: a thixotropic agent that is added to the Sikalastic® Rapid 724 resin to increase resin viscosity. For use on steep slopes. Size: 1.18kg (1.0L)

h. **Sikalastic Rapid Cleaner:** used to clean surface of Sikalastic Rapid resins where tie-in or repairs may be required. Can be used to clean/remove residue of Sikalastic® Rapid PMMA resins from tools. It is also used to clean metal and non-absorbent substrates before Sikalastic® Rapid PMMA resins and primers are applied. Size: 1 or 5 gal.

i. **Sikalastic® Rapid Finish**: is an unpigmented, clear resin that **must** be mixed with a pre-measured and packaged Sikalastic Rapid Color, requires Sikalastic® Rapid Catalyst PMMA. Size: 8.5kg (8.1L)

j. **Sikalastic® Rapid Color**: is mixed with Sikalastic® Rapid Finish unpigmented resins. Size: 1.5kg. One 1.5kg is required per 8.5kg of Sikalastic® Rapid Finish

Tools:

Since Sikalastic® resins & Sikalastic® primers are generally prepared in small batches on site, it is important to have the following tools on hand.

- 1-gallon graduated plastic mixing containers
- disposable paint brushes and/or small foam paint rollers
- mixing sticks
- nitrile rubber gloves
- eye protection
- scissors
- permanent markers (i.e., Sharpies)
- tape measure
- masking tape or painters' tape

3. **Limitations**:
   a. Always store the product indoors on pallets in a well-ventilated environment, at temperatures ranging from 55 °F to 80 °F (13 °C to 27 °C), away from heat, open flames, ignition sources, direct sunlight, and oxidizing agents. If storing the product temporarily outside for a very short period of time, cover it with a reflective tarp that allows for air circulation. The shelf life is approximately 12 months from the date of shipment when properly stored in its original container.
   b. Sikalastic® Rapid 724 applied flashings are to be installed when ambient and substrate temperatures are between 37° F and 95° F (3° C - 35° C).
   c. The temperature of the substrate must be at least 5 degrees higher than the dew point temperature at the time of application.
   d. In service, Sikalastic® Rapid 724 applied flashings are not to be subjected to temperatures greater than 150° F (65.5° C).

4. **Coverages** **(Coverage rates stated herein are approximate only):**
   a. Sikalastic® Rapid 724 **(coverage rates are for two coats – mil thickness approximately 100-120):**
      i. Smooth – 0.28 kg/ft² - Total per 12kg - 42ft²
      ii. Typical – 0.30 kg/ft² - Total per 12kg - 40ft²
      iii. Rough (Granulated Cap Sheet) – 0.35 kg/ft² - Total per 12kg - 34ft²
   b. Sikalastic® Rapid Primer ASP:
      i. Smooth – 0.037 kg/ft² - Total per 10kg - 269ft²
      ii. Typical – 0.048 kg/ft² - Total per 10kg – 200ft²
      iii. Rough (Granulated Cap Sheet) – 0055 kg/ft² - Total per 10kg - 179ft²

c. Sikalastic® Rapid Metal Primer:
  i. SSPC-SP3 – 0.25 gal per 100/ft² - Total per 1gal - 400ft²

d. Sikalastic® Rapid 724 Detailer:
  i. 80mils – 0.28 kg/ft² - Total per 2kg - 7ft²
  ii. 120mils – 0.40 kg/ft² - Total per 2kg – 3.5ft²

e. Sikalastic® Rapid Paste:
  i. 0.11 kg/ft²@1/8”

f. Sikalastic® Rapid Finish:
  ii. Aggregate #1 - 0.07 kg/ft² - Total per 10kg - 134ft²
  iii. Aggregate #2 - 0.06 kg/ft² - Total per 10kg - 154ft²
  iv. Smooth - 0.05 kg/ft² - Total per 10kg - 179ft²

g. Sikalastic® Rapid Color:
  i. 1 pouch per pail of resin – add to desired color shade

5. Catalyst Consumption: (0.01 kg of Sikalastic® Rapid Catalyst PMMA equals approximately 1 level tablespoon size scoop) (all mixing ratios in red are per liter)

a. Sikalastic® Rapid 724 (9.7L):
  i. Temperature range - 50 °F to 68 °F – 4% - 0.05 kg (5 tbsp/50 g)
  ii. Temperature range - 68 °F to 95 °F – 2% - 0.025 kg (2.5 tbsp/25 g)

b. Sikalastic® Rapid 724 WG (winter grade) (9.7L):
  i. Temperature range - 23 °F to 37 °F – 6% - 0.07 kg (7 tbsp/70 g)
  ii. Temperature range - 37 °F to 50 °F – 4% - 0.05 kg (5 tbsp/50 g)
  iii. Temperature range - 50 °F to 68 °F – 2% - 0.025 kg (2.5 tbsp/25 g)

c. Sikalastic® Rapid Primer ASP (9.6L):
  i. Temperature range - 32 °F to 50 °F – 6% - 0.06 kg (6 tbsp/60 g)
  ii. Temperature range - 50 °F to 68 °F – 4% - 0.04 kg (4 tbsp/40 g)
  iii. Temperature range - 68 °F to 95 °F – 2% - 0.02 kg (2 tbsp/20 g)

d. Sikalastic® Rapid 724 Detailer (1.5L):
  i. Temperature range - 32 °F to 50 °F – 6% - 0.09 kg (9 tbsp/90 g)
  ii. Temperature range - 50 °F to 68 °F – 4% - 0.06 kg (6 tbsp/60 g)
  iii. Temperature range - 68 °F to 95 °F – 2% - 0.03 kg (3 tbsp/30 g)

e. Sikalastic® Rapid Paste (10.6L):
  i. Temperature range - 32 °F to 50 °F – 6% - 0.08 kg (8 tbsp/80 g)
  ii. Temperature range - 50 °F to 68 °F – 4% - 0.06 kg (6 tbsp/60 g)
  v. Temperature range - 68 °F to 95 °F – 2% - 0.03 kg (3 tbsp/30 g)

g. Sikalastic® Rapid Finish (8.1L):
  vi. Temperature range - 32 °F to 50 °F – 6% - 0.06 kg (6 tbsp/60 g)
  vii. Temperature range - 50 °F to 68 °F – 4% - 0.04 kg (4 tbsp/40 g)
  viii. Temperature range - 68 °F to 95 °F – 2% - 0.02 kg (2 tbsp/20 g)

6. **Substrates:** All substrates must be free from gross irregularities, loose, unsound, or foreign material such as dirt, ice, snow, water, grease, oil, release agents, lacquers, or any other condition that would be detrimental to adhesion of the primer and/or resin to the substrate with a maximum moisture content of six (6) percent or 75% relative humidity. Substrates other than previously applied membrane and flashings materials, shall be abrasively cleaned or ground as required to provide a sound open abraded surface to provide adhesion of the membrane to substrate with a minimum bond strength of 116 psi (0.8 N/mm2). Determinations of bond strength and moisture content shall be performed periodically by the Contractor throughout the course of work. Perform adhesion test per ASTM D4541 (mechanical test) or ASTM C794 (peel test)

    a. **Concrete:** All concrete substrates and concrete repair materials must be finished to a CSP#3-#5, must be cured a minimum of 28 days in accordance with ACI-308, or as recommended by the concrete/mortar manufacturer, in order to achieve a minimum hardness of 3,500 psi (25 N/mm2) with a maximum moisture content of six (6) percent or 75% relative humidity. Concrete substrates shall be abrasively cleaned in accordance with ASTM D4259 to provide a sound substrate free from laitance with an open concrete surface. Areas of minor surface deterioration of 0.50 inch (13 mm) or greater in depth, and/or spalls, voids, bug holes and other deterioration on vertical surfaces or horizontal surfaces shall be repaired.

    b. **Masonry:** Walls shall be built with hard kiln dried brick, reinforced concrete block, or waterproof concrete block construction. Flashings must not be applied over soft or scaling brick or concrete, faulty mortar joints, or walls with broken, damaged, or leaking coping. Masonry walls must sealed to prevent moisture infiltration from behind or above.

    c. **Steel/Metal:** Clean and prepare metal surfaces to near white metal in accordance with SSPC - SP3 (power tool clean). Extend preparation a maximum of 1/8 inch (3 mm) beyond the termination of the membrane flashing materials. Once properly prepared, solvent wipe to remove any oils, debris or contaminants, let solvent completely flash off prior to placement of Sikalastic Rapid resins.

    d. **Ridged Plastics (PVC/ABS):** Ridged plastics should be lightly abraded and wiped with mineral spirits or similar products and allowed to flash off. Ridged piping, such as “smurf” tubing, Hilti block-outs, and similar type products, are not acceptable.

    e. **Plywood:** Shall be 1/2" minimum, CDX exterior grade board identified with American Plywood Association (APA) grade trademarks and shall meet the requirements of product standard PS1. Plywood panels should be installed with no gaps at panel joints. Tongue and groove plywood should be used whenever possible. After coating the exposed top face of the plywood with Sikalastic® Rapid Primer ASP, fill all voids, board joints, knot holes, cracks and fastener points with a Sikaflex 11fc or Sikalastic® Rapid Paste and strip joints with 2-inch (5cm) wide bond breaker tape followed by 6-inch (15cm) minimum wide strips of Sikalastic® Rapid Fleece PMMA and Sikalastic® Rapid 724 membrane centered over joint .**OSB not acceptable**.

    f. **Wall/Roof Boards (:** Boards shall be a minimum ½” and solidly secured to substrate/framing. Gypsum, fiberglass, and paper-faced based boards **are not** acceptable. Wall/Roof boards must be a cement type board and classified for use

in roofing/waterproofing applications.*(consult Sika-Hydrotech technical).* After coating the exposed top face of the acceptable roof boards with Sikalastic® Rapid Primer ASP, fill all voids, board joints, knot holes, cracks, and fastener points with a Sikaflex 11fc or Sikalastic® Rapid Paste and strip joints with 2-inch (5cm) wide bond breaker tape followed by 6-inch (15cm) minimum wide strips of Sikalastic® Rapid Fleece PMMA and Sikalastic® Rapid 724 membrane centered over joint**.** Boards cannot be used in buried applications. ***See Hydrotech's Tech Bulletin #7 - Wall Construction & Approved Sheathing Options***

g. **Rubberized Asphalt and related Flashings:** Hydrotech® MM6125 and Hydrotech® Hot Rubberized Asphalt with the appropriate corner reinforcement or appropriate flashings shall be completely installed before the Sikalastic® Rapid 724 cold liquid-applied flashing is applied. The Hydrotech® MM6125 and Hydrotech® Hot Rubberized Asphalt or related flashing shall be extended vertically up onto the penetration, curb, or parapet a minimum of 4 inches or as directed by Sika-Hydrotech's technical department. All loose granules, dust and dirt shall be removed from the surface of the membrane or flashing by appropriate means based on the flashing installed and without damage to the installed flashing.

7. **Application:**
   a. **Sikalastic® Rapid Primer ASP**

      Asphalt (Hot Rubber)/Concrete/Wood/HydroFlex-MB

      i. Thoroughly mix the entire container of Sikalastic® Rapid Primer ASP resin for 2 minutes before each use, before adding catalyst, and prior to pouring off primer resin into a second container (i.e., plastic paint bucket/pail) for batch mixing.
      ii. Catalyze only the amount of material that can be used within 10-15 minutes.
      iii. Add pre-measured catalyst to the primer resin component (see #6)), stir for 2 minutes using a slow-speed mechanical agitator (200-400 rpms) or stirring stick. The amount of catalyst added is based on the weight of the resin used and the anticipated ambient conditions. Pot life approximately 20 minutes.
      iv. After mixing, apply the catalyzed primer resin to the clean and prepared substrate at the required consumption (see #5) using appropriate 3/8 " nap rollers or brushes. The resin should be spread evenly onto the surface.
      v. The clean and fully cured primer can be coated with resin after a minimum of approximately 30-45 minutes (dry to the touch) up to a maximum of 6-months.

   b. **Sikalastic® Rapid Metal Primer**

      i. Clean and prepare metal to near-white metal in accordance with The Society for Protective Coatings formerly the Steel Structures Painting Council (SSPC) standard SP3 Power Tool Cleaning to a point maximum ⅛ in (3 mm) beyond the termination of Sikalastic® Rapid components and wipe with xylene or similar product to remove oils, debris, or contaminants.
      ii. Thoroughly mix primer resin approximately 2-3 minutes using a mixing stick or slow-speed(200 to 400 rpm) mechanical mixer with spiral.
      iii. Apply evenly to metal surface, care should be taken as not to spread too thin or allow puddling.
      iv. Sikalastic® Rapid Metal Primer should be covered once cured, maximum exposure time – 24hrs

v. See attached tech memo dated - July 7, 2025, for alternative methods as needed.

c. Sikalastic® Rapid Paste

i. Thoroughly mix the entire container of Sikalastic® Rapid Paste for 2 minutes before each use, before adding catalyst, and prior to pouring off primer resin into a second container (i.e., plastic paint bucket/pail) for batch mixing.
ii. Catalyze only the amount of material that can be used within 15-20 minutes.
iii. Add pre-measured catalyst to the primer resin component (see #6)), stir for 2-minutes using a slow-speed mechanical agitator. The amount of catalyst added is based on the weight of the resin used and the anticipated ambient conditions. Pot life approximately 20-30 minutes.
iv. For leveling and smoothing applications **(maximum 1/8" per lift),** spread and plane the repair mortar with a flat blade squeegee and trowel to achieve a flat surface.
v. For patching and repairs, fill cavities with repair mortar and trowel to achieve a flat surface.
vi. Maximum 1/8" per lift, second lift can be added after paste has cured.

d. Sikalastic® Rapid 724 Detailer

i. Thoroughly mix the entire container of Sikalastic® Rapid 724 Detailer for 2 minutes before each use, before adding catalyst, and prior to pouring off primer resin into a second container (i.e., plastic paint bucket/pail) for batch mixing.
ii. Catalyze only the amount of material that can be used within 15-20 minutes.
iii. Add pre-measured catalyst to the primer resin component (see #6)), stir for 2-minutes using a slow-speed mechanical agitator or stirring stick. The amount of catalyst added is based on the weight of the resin used and the anticipated ambient conditions. Pot life approximately 20-30 minutes.
iv. After mixing, apply the catalyzed resin in a single coat (approximately 80-120 mils) to primed or cleaned substrate at the required consumption (see #5) using brushes or a putty knife.
v. If different color is required, apply a catalyzed resin topcoat (approximately 30 mils) at the required consumption (see #5) using appropriate 3/8 " nap rollers or brushes.
vi. Sikalastic® Rapid 724 Detailer will cure to rainproof in 30-60 minutes with a fully cured in 3-6 hours

e. Sikalastic® Rapid 724

i. Thoroughly mix the entire container of Sikalastic® Rapid 724 for 2 minutes before each use, before adding catalyst, and prior to pouring off primer resin into a second container (i.e., plastic paint bucket/pail) for batch mixing.
ii. Catalyze only the amount of material that can be used within 15-20 minutes.
iii. Add pre-measured catalyst to the primer resin component (see #6)), stir for 2-minutes using a slow-speed mechanical agitator or stirring stick. The amount of catalyst added is based on the weight of the resin used and the anticipated ambient conditions. Pot life approximately 20-30 minutes.

iv. After mixing, apply the catalyzed resin basecoat (approximately 60 mils) to primed or cleaned substrate at the required consumption (see #5) using appropriate 3/8 “ nap rollers or brushes.

v. Roll Sikalastic® Rapid Fleece PMMA reinforcement directly into the resin, avoiding any folds and wrinkles. Use a roller to lightly work the resin into the fleece, saturating from the bottom up. Note the **fleece should be fully saturated**, with no white spots showing. White spots are indications of unsaturated fleece or lack of adhesion

vi. Apply the catalyzed resin topcoat (approximately 40 mils) at the required consumption (see #5) using appropriate 3/8 “ nap rollers or brushes.

vii. Sikalastic® Rapid 724 will cure to rainproof in 30-60 minutes with a fully cured in 3-6 hours

f. Sikalastic Rapid Finish- Color Coat

i. Thoroughly mix the entire container of Sikalastic Rapid Finish with Sikalastic Rapid Color pack for 2-5 minutes until uniform and streak free color is achieved.

ii. Add pre-measured catalyst resin component (see #7), stir for 2-minutes using a slow-speed mechanical agitator. The amount of catalyst added is based on the weight of the resin used and the anticipated ambient conditions. Pot life approximately 20-30 minutes. **Catalyze only the amount of material that can be used within 15-20 minutes.**

iii. After mixing, apply the catalyzed resin (approximately 25-30 mils) to cleaned substrate at the required consumption (see #6) using appropriate 3/8 “ nap rollers or notched squeegee.

iv. Sikalastic Rapid Finish will cure to rainproof in 30-45 minutes with a fully cured in 3-6 hours.

8. Notes:

a. If work is interrupted for more than 12 hours, reactivate the transition area with Mineral Spirits or an eco-friendly bio-based solvent. Allow a minimum of 20 minutes of evaporation time after application and overcoated within 60 minutes of application, surface should be dry to the touch.

b. Review all Sikalastic® Rapid SDS sheets prior to commencement of work

c. Materials should be stored in a cool dry environment.

d. Cured Sikalastic® Rapid components may be disposed of in standard landfills. Before disposal, thoroughly mix all leftover components, mixing buckets, and/or empty cans with residual product residue with Sikalastic® Rapid Catalyst PMMA and allow time to fully harden. Sikalastic® Rapid materials and debris must be managed as required in individual product SDS and in accordance with local, state, and federal regulations.

e. Protect finished application from all other contractors and activities during and after completion. Any damage to the system must be repaired as required or recommended by Sika-Hydrotech.