



**ECONO COPPER DRAIN TPO  
ECONO ALUMINUM DRAIN TPO  
INSTALLATION INSTRUCTIONS**

1. Cut an appropriate sized hole in the roof deck for the drain stem.
2. Remove all debris or materials that may prevent the drain flange from laying flush on the deck.
3. Place the drain stem into the receiving pipe and lower drain to deck. The flange must lay flush on deck.
4. Secure the drain to the deck using a minimum of 4 broad-head fasteners.

**Before installing TPO membrane, refer to the manufacturer's instructions.**

5. The TPO Direct Weld™ coated flange and TPO membrane must be clean before heat welding.
6. Make certain that the TPO membrane reaches the edge of drain bowl but does not go into the drain bowl.
7. Heat weld TPO membrane to TPO Direct Weld™ coated flange. Do not weld the membrane into the drain bowl.
8. Apply TPO roofing membrane to the drain flange according to the manufacturer's instructions.
9. Adhere to installation requirements as determined by the regulatory authorities for your region.