



BluSeal Waterstop Welding

PROCEDURE

WATERSTOP WELDING PROCEDURE

EQUIPMENT REQUIRED

- Jointing jig
- Welding blade
- Sharp knife
- Wire brush

WARNINGS

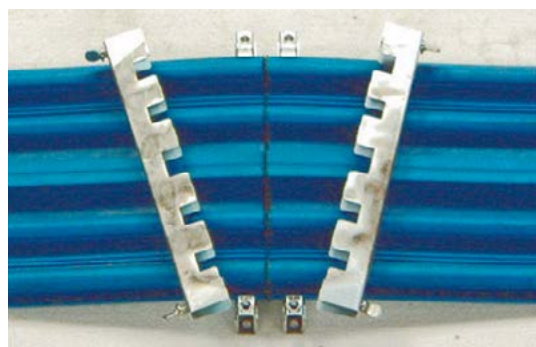
Ensure heater blades meet all local statutory safety requirements.

Hot blade. Do not immerse blade in water/liquids.

Check that blade voltage matches supply voltage.

PROCEDURE

- 1 Carefully measure the length of waterstop required and add 5 or 6 mm to each mating end to allow for melting of the compound during the heat welding process.
- 2 Clamp the end to be trimmed into one of the jointing jigs and cut to the required length using the side of the jig as a guide.
- 3 Repeat this operation for the other mating end.
- 4 Clamp the two ends into their respective sides of the jointing jig, with approximately 10mm projecting and engage the guide rods.
- 5 Plug the welding blade and allow to warm up. Using a small offcut of waterstop, check that the blade reaches a temperature sufficient to melt the PVC.
- 6 When the blade is at melt temperature, place it on edge on the guide rods of the jig between the mating ends of the waterstop and press the waterstop firmly against either face of the blade until a molten bead of PVC approx 3mm thick appears along the length of the blade. Slide the jig apart, remove the heating blade and push the waterstop back together holding under pressure for a while which allows the molten PVC to fuse together.
- 7 Unclamp the jigs and carefully remove the joined waterstop taking care not to flex the join until it has cooled.
- 8 Clean residue off heater blades using a wire brush after each weld.
- 9 Ensure welding blade is fully cooled prior to storage.



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