

HYDRO-STOP® PVC WATERSTOP SITE JOINING GUIDELINES

Following is the recommended procedure for site joining **Hydro-Stop® PVC Waterstop**. On-site welding is a relatively simple exercise using **CJSA Heat Welding Equipment** comprising of a Welding Jig and Welding Iron. Refer to **CJSA Hydro-Stop® PVC Waterstop Welding Equipment** brochure.

1. The number of joins in **Hydro-Stop® PVC Waterstop** shall be the minimum practical. Straight splices can be carried out in the field but all intersections shall be factory produced and supplied by **CJSA**.
2. Preheat Welding Iron until the desired welding temperature is achieved, which is approximately 190°C-200°C.
3. Place the ends of the **Hydro-Stop® PVC Waterstop** through the adjustable Welding Jig and clamp down using the assembly screws, cut both ends off square with a sharp knife or fine tooth saw. **(Refer Fig. 1)**
4. Loosen the clamps and slide back **Hydro-Stop® PVC Waterstop** allowing approximately 10-15mm of waterstop to protrude from both ends, then clamp the Welding Jig down tightly in position with the screws. At this stage when the Welding Jig slides together, the ends should meet squarely, and the profiles are to match up. If the **Hydro-Stop® PVC Waterstop** is not square to each other, or the profiles do not meet up, loosen the clamps on the Welding Jig and adjust the waterstop until the ends meet up perfectly, then tighten up the clamps ready for welding. **(Refer Fig. 2)**
5. Slide the two halves of the Welding Jig apart and position the pre-heated Welding Iron on top of the bars between the **Hydro-Stop® PVC Waterstop** ends. Slide the two waterstop end sections back together until they press against the sides of the Welding Iron and maintain the pressure in this position until a bead of molten PVC, approximately 4mm-5mm thick, appears along the length of the Welding Iron. The PVC must melt without charring or burning. **(Refer Fig. 3)**
6. Slide the Welding Jig apart, remove the Welding Iron vertically and then slide the two halves of the profile back together holding under pressure for approximately 45 seconds to 60 seconds, allowing the molten PVC to fuse together. **(Refer Fig. 4)**
7. Unclamp the Welding Jigs and carefully remove the joined **Hydro-Stop® PVC Waterstop** taking care not to flex the join until it is cool (approximately 5 minutes).

Note: Welding should only be carried out in areas with adequate ventilation, if welding in confined locations, it is considered necessary to provide forced ventilation or a suitable respirator. Care must be taken not to heat the PVC to the point of charring as harmful fumes may be released. Safety Data Sheet (SDS) available upon request.

