

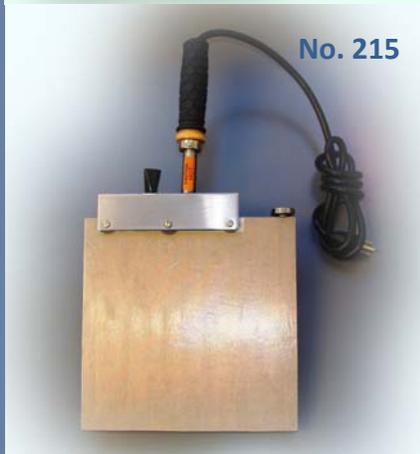
PVC Waterstop Accessories



No. 147



No. 146



No. 215



Splicing Irons

Southern Metal Splicing Irons are specifically designed for welding thermoplastic waterstops, such as PVC, TPER and Polyethylene. They are constructed of the highest quality components for superior performance and durability.

The temperature control is adjustable from 250°F to 500°F for various splicing conditions and materials. PVC waterstops require a temperature range between 350°F and 400°F. TPER and Polyethylene Waterstops are welded at a temperature between 400°F and 410°F. The No. 146 Large Iron is most versatile and is provided with a built-in thermometer for quick temperature readings. The No. 215 Iron is for extra large and retro-fit shapes.

No. 147 Small Iron 2" x 14" x 1"

No. 180 Replacement Cover for No. 147 Small Iron

No. 146 Large Iron 4½" x 14" x ¾"

No. 179 Replacement Cover for No. 146 Large Iron

No. 215 Large Iron 9" x 9" x ¾"

No. 236 Replacement Cover for No. 215 Large Iron

See the following pages for Factory Fabrications and splicing procedures

Waterstop Anchoring Methods

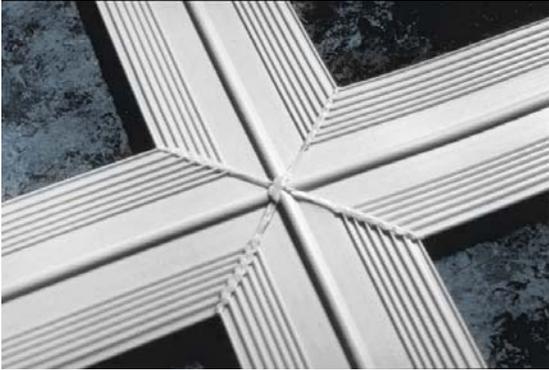
Proper positioning and anchoring of the waterstop is necessary to prevent deflection during concrete placement. Optional prepunched holes or grommets along the outer flange provide points for tethering the waterstop to adjacent reinforcing steel. Hog rings and hog ring pliers are available for performing a comparable method in the field.

3400 Tree Court Ind. Blvd. ■ St. Louis, MO 63122

Phone: 800.325-3597 ■ Fax: 636.825-6567

www.SoMetals.com

PVC Waterstop Fabrications



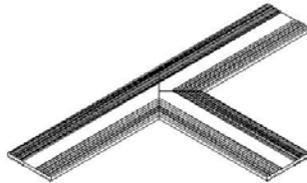
Fabrications

Southern Metal offers Factory Fabrications to accommodate transitions and intersections. Fabrications are strongly recommended and often specified to assure the continuity and integrity of the waterstop system. Ells, Tees and Crosses are available, in addition to custom fabrications to facilitate unique transitions and intersections.

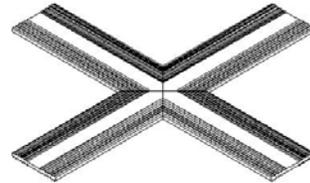
Please refer to the following configurations when ordering Factory Fabrications.



Flat Ell



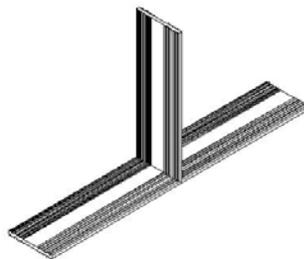
Flat Tee



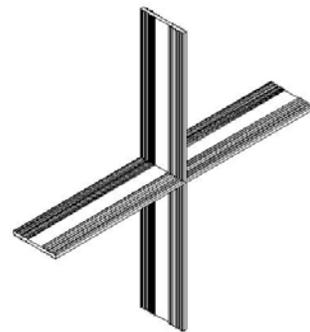
Flat Cross



Vertical Ell



Vertical Tee



Vertical Cross

3400 Tree Court Ind. Blvd. ▪ St. Louis, MO 63122

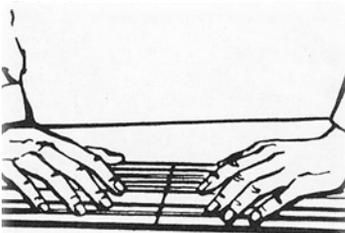
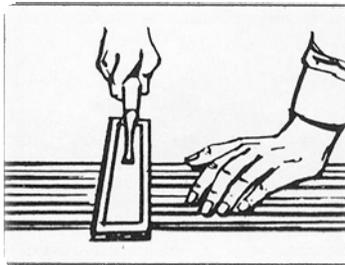
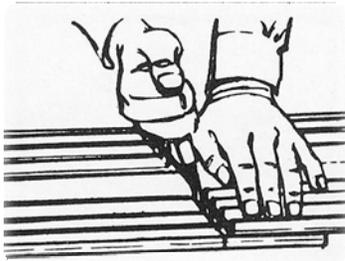
Phone: 800.325-3597 ▪ Fax: 636.825-6567

www.SoMetals.com

Waterstop Splicing Procedure

Following is the proper procedure, as recommended by Southern Metals, for field splicing PVC waterstops:

1. Provide factory fabricated corners, intersections and transitions, leaving only straight butt joint splices for the field.
2. Use a work table to create field splices. Table should be solid, have access to 110v power supply and have jigs and fixtures to aid splicing.



3. Cut ends square, using a razor knife or circular saw equipped with a carbide tipped blade (10" diameter with 40 teeth). This will ensure matching edges.
4. Preheat Teflon covered Southern Metals Splicing Iron to 360-390°.
5. Press ends of cut waterstop firmly against the preheated iron. Maintain pressure until approximately 1/8" of melted material appears at the iron surface.
6. Quickly remove Splicing Iron and hold PVC waterstop ends tightly together until they bond (approximately 60 seconds). **Note:** Water may be used to cool the material quickly. If you do not join the ends quickly, the melt bead will skin over, resulting in an inadequate bond. Do not move, bend, stretch or stress the splice before the 60 second bond time.
7. When fabricating waterstop into horizontal tees, ells or crosses, always miter the ends at an appropriate angle (typically 45-degrees) so the continuity of the ribs and/or centerbulb is maintained. This will also produce a much stronger joint. **Factory fabricated corners, intersections and transitions are strongly recommended.**

Special Safety Notation: When splicing PVC waterstop with a heated splicing iron, inhalation of the fumes may be harmful to your health. Splicing should be done only in areas with adequate ventilation.

QUALITY ASSURANCE

Waterstop splicing defects which are unacceptable include, but are not limited to the following:

1. Tensile strength less than 80% of parent section.
2. Use of adhesives, solvents or free lap joints.
3. Misalignment of centerbulb, ribs or end bulbs greater than 1/16 inch.
4. Misalignment that reduces waterstop cross-section area more than 15%.
5. Bond failure at joint, deeper than 1/16 inch or 15% of material thickness.