

Southern Metal & Plastic Products offers both SBR and Neoprene Waterstops, which are formulated to meet the Corps of Engineers Specification CRD-C-513.

RUBBER WATERSTOP PHYSICAL PROPERTIES			
Property	Test Method	SBR	Neoprene
Tensile strength (psi min.)	ASTM D 412	2,500	2,500
Tensile strength @ 300% modulus (psi min.)	ASTM D 412	1,150	1,150
Ultimate elongation (% min.)	ASTM D 412	450	450
Durometer, Shore A	ASTM D 2240	65 ±5	65 ±5
Water Absorption, 7 day @ 70°C (max % weight change)	ASTM D 471	5	15
Compression Set, 22 hr@70°C (max % of original deflection)	ASTM D 395	30	30
Accelerated Aging, 96 hr@70°C (min % of tensile strength before aging)	ASTM D 573	80	80
(min % of elongation before aging)		80	80
Ozone resistance, 7 days @ 50PPHM @ 38°C, 20% elongation	ASTM D 1149	No Cracks	No Cracks

## RUBBER FITTINGS



Rubber Waterstops require factory fittings for all splices, intersections and changes in direction. Southern offers a variety of fittings for both SBR and Neoprene to accomplish on site fabricating of Rubber Waterstop. Please call for information about Southern's fittings and adhesive kits.

Procedure for **Cold Bond Junctions of Rubber Waterstop** is on the following page.

<b>SBR No.902</b>	<b>1.30 lbs/ft.</b>
<b>Neoprene No.918</b>	<b>1.51 lbs/ft.</b>
<b>SBR No.903</b>	<b>1.90 lbs/ft.</b>
<b>Neoprene No.919</b>	<b>2.20 lbs/ft.</b>
<b>SBR No.904</b>	<b>1.05 lbs/ft.</b>
<b>Neoprene No.920</b>	<b>1.22 lbs/ft.</b>
<b>SBR No.906</b>	<b>2.50 lbs/ft.</b>
<b>Neoprene No.921</b>	<b>2.90 lbs/ft.</b>

## PROCEDURE FOR COLD BOND JUNCTIONS OF RUBBER WATERSTOP SBR OR NEOPRENE

- Waterstop
- Junction Fitting
- Sharp knife or carbide tipped saw blade
- #80 Medium Grit abrasive paper or wire brush
- Southern Metal's High Performance Contact Adhesive
- Clean cloth
- Denatured Alcohol
- Paint brush
- Wooden blocks
- Adjustable "C" clamps

### Procedure:

1. Cut waterstop ends straight and true using sharp knife or saw blade.
2. Clean and roughen the ends of the waterstop using abrasive paper and or wire brush at least four inches (100mm) from the end. Repeat process on the inside of the fitting for the full depth of the fitting.
3. Clean the roughen surfaces using the clean cloth and Denatured Alcohol. Let dry.
4. Using the paint brush, apply a thin coat of the Southern Metal's Adhesive to all surfaces to be bonded (waterstop and inside of fitting) and let dry.
5. Reapply a thin coat of adhesive to all surfaces, as the adhesive becomes tacky, insert the end of the waterstop into the fitting. Be sure to insert to the full depth of the fitting and hand press together.
6. Clamp all bonded areas using the wood blocks the width and length of the bonded areas. Secure blocks with "C" clamps and let set for 2 hours.
7. Do not pull or stress bond for at least 24 hours.
8. Bonds will reach maximum strength in approxately 14 days.

### HIGH PERFORMANCE CONTACT ADHESIVE

This adhesive is for the purpose of bonding rubber waterstop materials and the necessary fittings at junctions and intersections. After material preparation, the adhesive is thinly applied to the surface of the waterstop and the interior of the fitting. A second thin coat is applied after the first coat has dried and just prior to joining the two sections. The waterstop is inserted into the fitting and clamped firmly for a minimum of two hours.



- Packaging:** Available in one quart or one gallon kits
- Coverage:** Yield is dependent on the size of the waterstop and type of fittings. Yield ranges between 65 and 200 fittings per gallon.
- Description:** Polychloroprene base, "contact" adhesive
- Color:** Gray-green
- Viscosity:** 225 cps
- Application:** Brush

**SOUTHERN**  
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