

Hydroseal FS Method Statement (High performance waterproof jointing system)

Section A : General Comments

High temperature working

It is suggested that, for temperatures above 35°C, the following guidelines are adopted as good working practice:

- (i) Unmixed materials of **Quickmast 341/341C/SB** and equipment should be stored in cool place and away from direct sunlight.
- (ii) Plan for enough material, tools and labours to avoid any stoppage during the application process.
- (iii) Avoid application through peak temperatures of the day.
- (iv) Ensure proper and adequate ventilation.

Equipment

The following equipments are required for this application:

<i>Application equipment</i>	:	<i>Slow speed mixing drill</i>
	:	<i>Mixing bucket</i>
	:	<i>Mixing paddle</i>
	:	<i>Welding machine</i>
	:	<i>Pressure roller</i>
	:	<i>Seam probe tool</i>
	:	<i>Masking tape</i>
<i>Protective clothing</i>	:	<i>Protective overalls, thick gloves, goggles and face mask</i>



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Section B : Application

1.0 Surface Preparation

- 1.1 The substrate should be dry, clean and free from laitance or any material which could affect the bond.
- 1.2 Steel substrates should be prepared by grit blasting it until a bright finish is achieved, meeting the requirements of the Swedish standard SA 2 ½.



- 1.3 Apply masking tape and cover the joint or crack.



- 1.4 The width of the total system can be calculated by adding 5 mm to each side of the joint in addition to Hydroseal FS width. Apply masking tape on the outer parameter of the total joint system.



2.0 Mixing

- 2.1 Stir the individual components of Quickmast 341/341C/SB thoroughly before mixing them together.
- 2.2 Use a slow speed drill fitted with mixing paddle to mix the two components of Quickmast 341/341C/SB for 3 minutes until a uniform and homogenous mixture is obtained.
- 2.3 Pot life of the mixed product:
 - 2.3.1 Quickmast 341 has pot life of around 1.5 hours at 25°C and 1 hour at 35°C.
 - 2.3.2 Quickmast SB is formulated to have a very fast curing rate with pot life of around 10 minutes @ 25°C.



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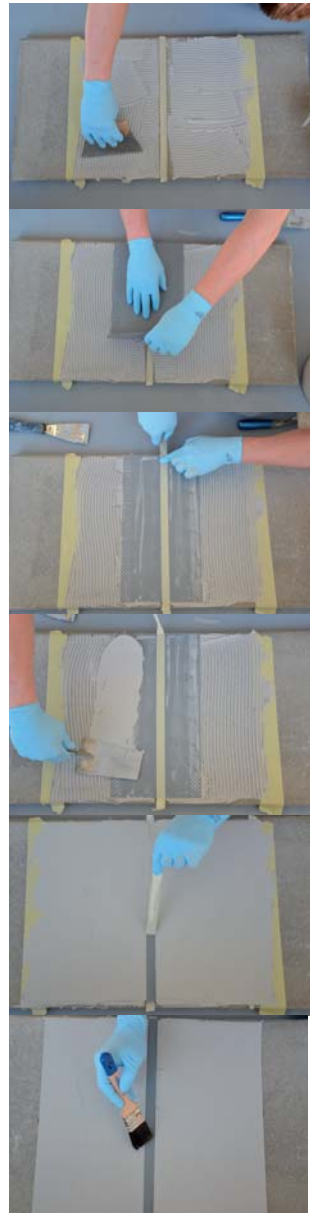
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3.0 Application

- 3.1 Clean Hydroseal FS and remove any traces of dirt or contaminations using a suitable solvent.
- 3.2 The application of Hydroseal FS should start as soon as Quickmast 341/341C/SB has been mixed and work within the pot life of the mixed material.
- 3.3 Apply the epoxy adhesive to the prepared surface on each side of the joint/crack at 1 - 2 mm thickness.
- 3.4 Position Hydroseal FS firmly into the coated surface by rolling under pressure, ensuring the epoxy adhesive is forced through edge perforation.
- 3.5 Apply masking tape to the centre of Hydroseal FS strip.
- 3.6 Apply a top coat of the epoxy adhesive over membrane width at 1 – 2 mm thick, extending surplus to approximately 20 mm outer the membrane sides.
- 3.7 Remove the masking tape from the centre of the strip as well as the outer parameters to achieve a clean finish. Allow the system to cure for 24 hours at 20°C.
- 3.8 After drying, the epoxy resin gets very hard and could create a “knife effect” on the edges. In order to avoid damages of both persons and the tape, it is suggested to smooth the edges of epoxy with a brush some minutes after removing the masking tape.



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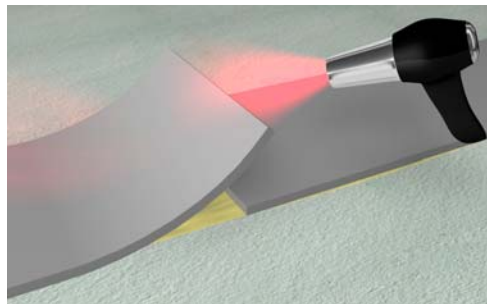
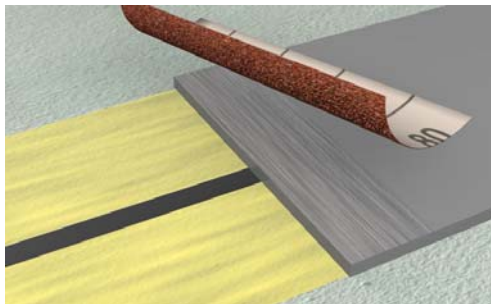
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Notes:

- For overlapping consecutive tapes it is recommended to grind the overlaps with sandpaper then fuse seams (overlapping about 10 cm or 4 inch) with a suitable hot-air-dryer. Avoid air pockets.



4.0 Cleaning

- 4.1 Tools and equipment can be cleaned with **DCP Solvent** when Quickmast 341/341C//SB is still wet. Cured material can be removed mechanically.

Section C : Approval and variations

This method statement is offered by DCP as a 'standard proposal' for the application of **Hydroseal FS**. It remains the responsibility of the Engineer to determine the correct method for any given application. Where alternative methods are to be used, these must be submitted to DCP for approval, in writing, prior to commencement of any work. DCP will not accept responsibility or liability for variations to the above method statement under any other condition.



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