

## Hydrostop AB Method Statement (PVC Waterstops)

### Section A : General Comments

#### Equipment

The following equipments are required for this application:

<i>Application equipment</i>	:	240V electrically heated welding blade
	:	Sharp knife
	:	Wire brush
<i>Protective clothing</i>	:	<i>Protective overalls, thick gloves, goggles and face mask</i>

### Section B : Application

#### 1.0 Method of Installation

##### 1.1 Centrally fixed Hydrostop AB:

1.1.1. Hydrostop AB "Centrally fixed" should be fixed in split stop-end shutter and tied by wires to the reinforcement through the eyelets in the edge flanges.

##### 1.2 Externally fixed Hydrostop AB:

1.2.1 Hydrostop AB "Externally fixed (rear-guard)" should be fixed before concreting to the concrete blinding and vertical shutters through the edge flanges.

#### 2.0 Site Welding

The key to a leak free waterstop network is correct onsite jointing. Hydrostop AB is made of thermoplastic PVC, and can be easily welded using suitable heating processes, such as welding knife or heated welding blade.

- 2.1 To trim the waterstop, carefully measure the required length and add 5 - 6 mm to each mating end, which will melt during the heat welding process.
- 2.2 Cut the mating ends neat and straight at both sides with a sharp knife.
- 2.3 Plug in the welding blade and allow it to warm up. Using a small offcut from the Hydrostop AB, check that the blade reached a temperature sufficient to melt the waterstop.
- 2.4 When the blades temperature is adjusted, place it between the mating ends of the waterstop and press the waterstop firmly against the blade.
- 2.5 Hydrostop AB will start to melt when in contact with the blade. Maintain the pressure against the blade until a 5 mm bead of molten PVC has formed on both sides all around the section.

Lift away the blade with an upwards motion will avoiding too much displacement of the molten PVC bead.



Without delay, while the PVC is still molten, press the two mating ends together and hold firmly for 20 seconds or so until the joint has cooled and solidified.

- 2.6 Carefully allow the waterstop to cool thoroughly. Do not flex the joint until it cools down after the joint has solidified inspect for imperfections.

### 3.0 Safety caution

- 3.1 Hot welding of PVC will generate acidic hydrogen chloride fumes, jointing should take place in a well-ventilated area, or while wearing oxygen mask. Avoid breathing fumes. Wear a proper mask

### Section C : Approval and variations

This method statement is offered by DCP as a 'standard proposal' for the application of **Hydrostop AB**. 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.