



Waterstop Splicing Field Guide

Following is the proper procedure for field splicing of nonmetallic waterstop. BoMetals highly recommends that all intersections be factory fabricated and that only straight butt joints be attempted in the field.

Equipment:

You will need a Teflon covered waterstop splicing iron (part # SI-414 Splicing Iron), a sturdy heat resistant work surface (part # ST-10 Field Splicing Machine), access to 115 VAC power, circular saw with carbide tipped blade, framing square, and miscellaneous jigs and fixtures to aid splicing.

Caution: When splicing PVC waterstop, inhalation of the fumes may be harmful to your health. Splicing should be done in only in well-ventilated areas.

Splicing:

1. Preheat splicing iron to 350°F-380°F for PVC or 390°F-410°F for TPER. Preheat iron for at least 30 minutes to assure even temperature.
2. Layout and cut the ends square using carbide tipped circular saw. Ends must be cut square and cleaned of debris to assure proper alignment and bond strength.
3. Dry Fit joint to check fin and bulb alignment before welding. Repeat step 2 if necessary.
4. Place iron between butt ends of the waterstop. Apply light and even pressure to the waterstop in the direction of the iron. Insure that the butt ends are heated evenly across the waterstop profile. A slot in the work surface would be helpful in allowing the iron to protrude below the bottom of the waterstop profile. Keep the waterstop in place and pressure applied until a 3/16" bead forms around the entire outside edge of the waterstop profile on both butt ends. Caution: Iron and plastics are hot. Take precaution to avoid burns. Do not hold the waterstop in contact with the iron so long that it begins to darken and burn. Burnt material will contaminate the joint and cause possible joint failure.
5. Remove iron and **immediately** join the butt ends together with light and even pressure. Care must be taken to align the profiles and maintain the continuity of the bulbs and ribs. Hold in place for approximately 3 minutes or until the bond is cooled enough to hold together. Do not bend, stretch, or stress the joint for approximately 10 minutes or until it has cooled to room temperature. Failure to join the ends quickly or premature stress can result in a poor weld and joint failure.
6. Wipe the iron clean with a clean dry cloth to remove any molten material. Burnt material will contaminate future joints and cause possible failures. Caution: Iron and plastics are hot. Take precaution to avoid burns.
7. Contact BoMetals Inc. 1-800-862-4835 with any questions or for assistance.