



SEAL
ABLE

pioneers in profiles

INSTALLATION INSTRUCTION

for tunnel gaskets with contact adhesive and brush

INSTALLATION INSTRUCTIONS FOR TUNNEL GASKETS WITH CONTACT ADHESIVE AND BRUSH



NOTE

The installation procedure described here should be understood as a guideline and could vary depending on the project requirements or local conditions.

DELIVERY

All sealing profiles are delivered as corner-vulcanized gaskets tailor made for the individual segments. They are packed in skidded cartons.

PROCESSING TEMPERATURE

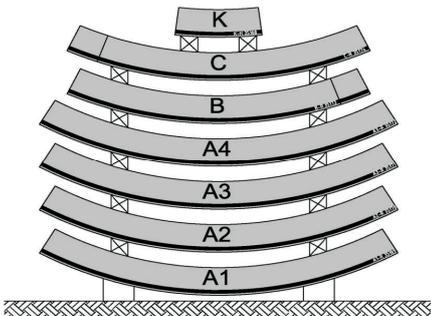
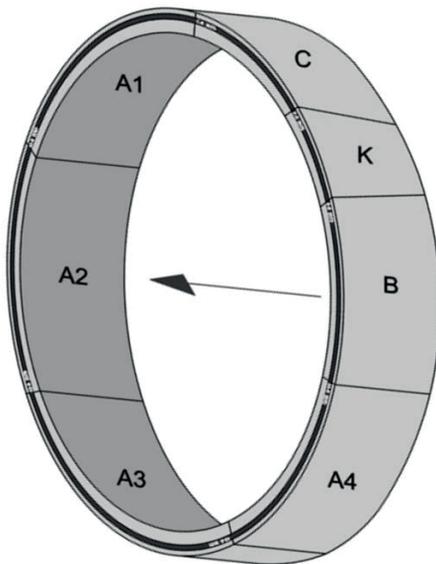
The adhesive G 3000 plus / G 3010 can be used at temperatures up to + 35° C (95° F). The adhesive pails have to be kept covered during the installation in order to avoid vaporizing of solvents and forming a skin on the surface. The adhesive has to be stirred constantly during installation. The temperature of the segment should be above + 10° C avoiding condensation.

REQUIRED MATERIALS

Adhesive G 3000 plus / G 3010



Cleaner G 3000



PREPARATION

Segments and gaskets have to be kept dry and free from dust, grease or oil residue. The adhesive should be stored at a temperature between + 15° C and + 35° C (59° F - 95° F). Avoid direct sunlight. If the adhesive is jellied due to temperatures below 15° C (41° F) it is possible to warm up the adhesive to + 20° C with a water bath (no direct heat is allowed to warm up the adhesive) to be able to work with the adhesive.

PREPARATION PRIOR TO INSTALLATION

Some hours prior to installation it is recommended to unpack and keep the gaskets in a position that the side lengths are straight and relaxed. After transportation and storage in cold conditions (winter time) the gaskets should be unpacked and stored in warm condition at least one day prior to installation. Dirty or dusty gaskets should be cleaned with SEALABLE cleaner G 3000.

INSTALLATION INSTRUCTIONS FOR TUNNEL GASKETS WITH CONTACT ADHESIVE AND BRUSH

1 | GROOVE CLEANING

The groove has to be dry and free from dust and grease or oil residue.



2 | APPLYING OF ADHESIVE



The adhesive has to be applied with a brush. It has to be applied into the groove and onto the gasket areas which have contact to the groove, especially the flanks of the gasket and groove. The adhesive should be applied equally into the groove and onto the gasket.

3 | PREPARATION GASKET INSTALLATION



The gasket has to be installed after the adhesive is “tacky”. The installation should be done by two workers. They should place themselves opposite on each of the short sides of the segment.

4 | GASKET INSTALLATION SHORT SIDE



Two workers should start with placing the corners and short gasket sides into the groove simultaneously. The process should be started with the correct positioning of the corners and pressing the gasket into the groove by hand.

5 | GASKET INSTALLATION LONG SIDE

The gasket should be placed into the groove by hand from the center towards the corners.



6 | CONTROL OF GASKET CORNERS

It is recommended controlling the correct fit of the gasket after placing the gasket into the groove. In case that the corners are not in the correct position the gasket has to be adjusted to the correct fit. The position could be adjusted by pulling off the gasket and replacing it in the correct position.



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7 | PRESS THE GASKET INTO THE GROOVE

The gasket should be pressed into the groove. This should be done simultaneously by each worker. The gasket should be placed in the correct position with the first attempt, later corrections should be avoided.



8 | FIXATION OF GASKET IN THE GROOVE

After inserting the gasket into the correct position it is important to push the gasket into the groove with a rubber mallet all around the segment, in order to provide the final bonding strength.



9 | CONTROL



During the final control each gasket corner position should be double checked. The gasket corner should be in line with the segment corner. As well the correct type of gasket and positioning of the complete gasket in the groove should be checked. After 72 hours the adhesive will achieve its final strength, after this time the adhesive bonding should be checked visually.



CONTACT

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