

# Supercast Jointing Instructions

## Site Jointing Instructions

### EQUIPMENT REQUIRED

- Supercast jointing jig
- 110 V and 220 V, 350 W blades available
- Sharp knife
- Wire brush

### WARNINGS

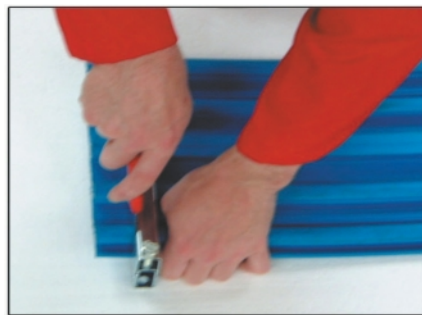
**Ensure that heater blades are earthed by the green/yellow wire, and that the wiring operation is carried out by a competent electrician.**

**Hot blade. Do not immerse blade in water/liquids.**

**Check that blade voltage matches supply voltage.**

### TRIMMING TO LENGTH

1. Carefully measure the length of water stop required and add 5 or 6 mm to each mating end to allow for melting of the compound during the heat welding process.
2. Clamp the end to be trimmed into one of the jointing jigs and cut to the required length using the side of the jig as a guide.
3. Repeat this operation for the other mating end.
4. Clamp the two ends into their respective sides of the jointing jig, with approximately 10 mm projecting and engage the guide rods.
5. Plug the welding blade and allow to warm up. Using a small off-cut of waterstop, check that the blade reaches a temperature sufficient to melt the PVC.
6. When the blade is at melt temperature, place it on edge on the guide rods of the jig between the mating ends of the waterstop and press the waterstop firmly against either face of the blade until a molten bead of PVC approx 3mm thick appears along the length of the blade. Slide the jig apart, remove the heating blade and push the waterstop back together holding under pressure for a while which allows the molten PVC to fuse together.
7. Unclamp the jigs and carefully remove the joined waterstop taking care not to flex the join until it has cooled.



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