



Waterstop Job Site Installation Guide

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NOTE: It is highly recommended that you use a JP Specialties, Inc. ST-10® Waterstop Splicing Machine. The following directions are for welding WITHOUT an ST-10. The ST-10 will greatly enhance the quality of the welds and reduce welding time.

The following is the proper procedure, as recommended by JP Specialties, Inc., for field splicing nonmetallic waterstops.

1. Provide shop made fabricated waterstop ells, tees, crosses and transitions, leaving only straight butt joint splices for the field. Always cut ends square before welding waterstop. Never weld to extruded end. Use a work table to create field splices. Table should be solid, have access to 115 volt power supply, and have jigs and fixtures to aid splicing.
2. Cut ends square using a razor knife, or circular saw equipped with a carbide tipped blade (10" diameter with 40 teeth) to ensure matching edges.
3. Preheat Teflon covered splicing iron (JP214 or JP414) to 350-380°F for PVC or 410 to 430°F for TPER / TPV or PE. It is recommended that you verify the temperature with a digital thermometer.
4. Place iron between butt ends. Keep waterstop in place until approximately 3/16" bead forms on each side of waterstop. Quickly remove splicing iron and hold waterstop ends together until they bond (approximately 3 to 5 minutes or cool to the touch). Cold water may be sprayed on waterstop to expedite the bond. Do not move, bend, stretch or stress the splice before the recommended bond time. When welding TPER / TPV, if you do not join the ends quickly, the melted material will skin over, resulting in an inadequate bond.

