



**CUSTOM SPLICES:** An important factor in the water tightness of any waterstop is the reliability of splices. With BoMetals fittings, you are guaranteed greater strength and efficiency with ease of field installation. The following factory made splices are available.

**FIELD FABRICATIONS:** Following is the proper procedure for the field splicing nonmetallic waterstops.

1. Provide shop made fabricated waterstop ells, tees, and transitions leaving only straight butt joint for the field.
2. Use a work table to create field splices. Tables should be solid, have access to 115 volt power supply, and have jigs and fixtures to aid splicing.
3. 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.
4. Preheat Teflon covered splicing iron to 350- 380 F for PVC or 390-410 F for TPER.
5. 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 bend, stretch or stress the splice before the recommended bond time. When welding TPER, if you do not join the ends quickly, the melted material will skin over, resulting in an inadequate bond.
6. When fabricating watertop into horizontal tees, ells or crosses always miter the ends at a 45-degree angle so the continuity of the ribs and/ or center bulb is maintained. This will also produce a much stronger joint.

**SPECIALTY SAFETY NOTATION:** When splicing PVC waterstop, inhalation of the fumes may be harmful to your health. Splicing should be done only in areas with adequate ventilation.

