Viton® Hot Splice Installation Instructions

Tools & Materials Needed:

- One (1) empty gallon sized container
- Viton® Stock (included with Splice Kit)
- MEK (methyl ethyl ketone)
- Methanol
- Two (2) ¼" steel plates; 6" wide x belt width plus 2"
- Minimum of four (4) "C" clamps
- Heating iron; capable of continuous 250°F to 275°F temp
- Release paper; slightly larger than steel plates
- Paint brush
- Scrap pieces of insulation; slightly larger than steel plates
- Needle nose pliers
- Small side grinder with 80 grit paper

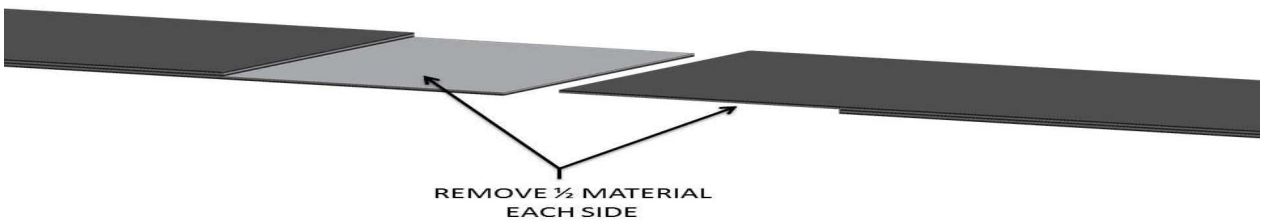
Preparation:

Mix four (4) pounds of Viton Stock, 1/3 gallon MEK with 3/4 quarters pint Methanol in a gallon sized container. This makes one (1) gallon of cement. Scale to fit needs of number of splices (Example 1/8 will be okay for doing one (1) splice with a belt width of 24"+/-)

Directions:

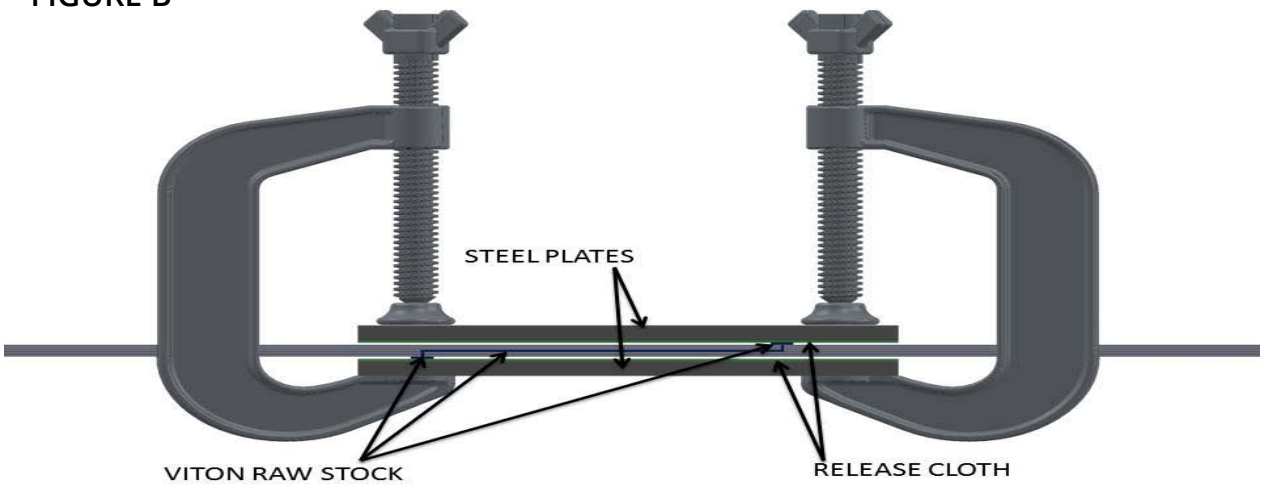
1. Leave 2' to 3' ft of each end of the expansion joint unbolted for ease of splicing.
2. Prepare one end for the step splice by removing 1/2 the material 4" back from the edge of the belt on one side of one end of the joint. See Figure A.
3. Repeat the same process to the other end of the joint, but this time remove the material on the opposite side. See Figure A.

FIGURE A



4. Clean both surfaces thoroughly with MEK. It is very important to clean the ground areas and to remove all traces of dust and grit before continuing.
5. Paint each four (4) inch ground area with a thick coat of the prepared Viton cement, allow to dry.
6. Cut a strip of Viton stock five (5) inches wide and apply a coat of cement to each side, allow to dry.
7. Apply one (1) more coat of cement to splice areas and Viton stock strip. When cement is tacky to the touch, center the 5" strip in between ends of joint, making sure joint is pulled taut before overlapping. (The edges of the joint may be stapled with industrial staples to keep the joint from coming undone.) Place a strip of uncured Viton over each splice seam.
8. Next, place one 6" wide steel plate behind the splice and the other plate on top of the splice. Insert a piece of release paper between the plates and the uncured splice stock. Secure with numerous "C" clamps. See Figure B.

FIGURE B



9. Place the scrap insulation on the back side of the Splice, against the steel plate. This will reduce heat loss. Place the heating iron directly on the top plate and secure with bailing wire, rope, or if the iron will stay put by itself, which is fine.
10. Place another piece of scrap insulation over the iron to also minimize heat loss.
11. Vulcanize the splice at 250°F to 275°F for 1 ½ to 2 hours. If outside temperature is near freezing, an additional 15 to 20 minutes may be required. It is important to continually monitor the iron's temperature as Viton will not cure correctly if temperature is too high, or too low.
12. After curing is complete, carefully remove heating iron, "C" clamps, and steel plates. Allow the splice to cool to ambient temperature before continuing.
13. Finish by bolting expansion joint.