

LEVAJOINT WATERSTOP



DUMBBELL TYPE

LEVAJOINT Waterstop is a specially formulated polyvinyl chloride (PVC) compound manufactured from virgin materials that fulfill all properties desirable for a waterstop.

The material is tough, flexible, resilient, chemically inert, is not affected by weathering, low temperatures, or constant immersion in water. It will withstand rough treatment during installation, yet, is relatively easy to install and splice.

LEVAJOINT Waterstop is unaffected by concrete additives and most water solutions of organic chemicals.

USES

LEVAJOINT Waterstop is designed for use in any concrete structure which contains joints and is subjected to a hydrostatic load on one face of the structure.

LEVAJOINT Waterstop prevents water movement through concrete joints in water reservoirs, locks, canals, sewage treatment plants, bridges, stadiums, Basements, floor slabs, parking garages and similar structures.

COLOR: natural white, blue, or any other color upon request.

TECHNICAL DATA

LEVAJOINT Waterstop is unaffected by alkalis, acids, oxidation, sewerage and most water solutions of organic chemicals.

It is extremely resistant to abrasion, corrosion, and aging.

All technical data are subject to + or - 5% fluctuations.

We can supply any form of external or internal use waterstops according to customer's request.

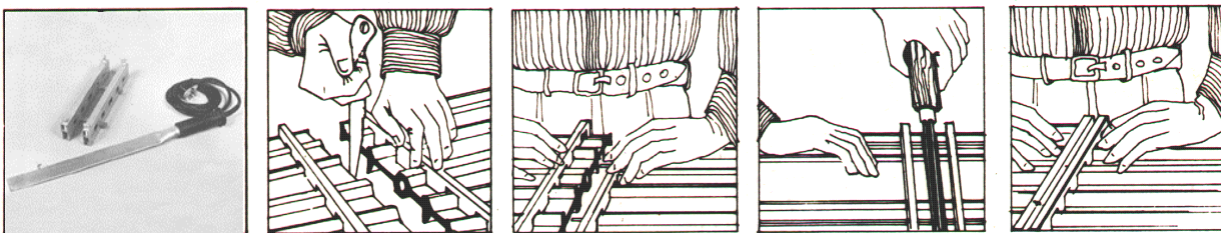
PROPERTY		NOMINAL VALUES
SPECIFIC GRAVITY		1.37
TENSILE STRENGTH	ASTM D412-87 METHOD A	2318 PSI
ULTIMATE ELONGATION	ASTM D412-87 A	285%
HARDNESS SHORE A/10		72 ± 3
STIFFNESS-IN FLEXTURE		920 PSI
TEAR RESISTANCE	ASTM D624-86 METHOD A	558 LB / INCH
MODULUS OF ELASTICITY		800 PSI
LOW TEMPERATURE BRITTLINESS	ASTM D746-79 AT - 26°C	PASSED
COLD BEND ¼" MANDREL AT - 10°C		PASSED
LOW TEMPERATURE FLEXIBILITY AT - 20°C		PASSED
LOW TEMPERATURE IMPACT AT - 20°C		PASSED
24 HOURS		0.082%
48 HOURS		0.320%

SPLICING

LEVAJOINT PVC Waterstop may be butt-spliced on the job, with an electrical splicing iron. There is no need for skilled labor to do it. Crimping, shaping, brazing or vulcanizing is not necessary. The following figures illustrate the splicing method to produce strong water-tight butt weld. Elbows tees and crosses can also be produced using this method.

A splicing iron is the recommended tool for splicing PVC Waterstops . In most instances, although a hot metal plate is still usable where an electric outlet is not available. Where the number and type of welds warrant it, the use of a hot air welding gun and vinyl welding rod is recommended. *Complete LEVAJOINT welding kits, comprising LEVAJIGS and LEVAKNIFE are available on request.*

WELDING PROCEDURE



Be sure that: The **LEVAKNIFE** is clean, plug it into the correct voltage (220V) electricity supply and let it warm up.

The ends of **LEVAJOINT** Waterstop to be welded are identical, clean them with water or a solvent without oil, and dry them.

Clamp the ends of **LEVAJOINT** to be welded in the **LEVAJIGS** and cut both ends with a sharp cutter, flush with the faces of the **LEVAJIGS**.

Open the **LEVAJIGS** and slide them back , leaving around 10mm of each end appearing , clamp the **LEVAJIGS** tightly in position , then locate the projecting bars of one jig in the holes of the other .

Place the **LEVAKNIFE** on the bars between the jigs and slide them together until the **LEVAJOINT** Waterstop ends are pressed firmly against of the **LEVAKNIFE**'s blades.

The **LEVAJOINT** should melt without burning or carbonizing.

Hold the **LEVAJIGS** firmly in position until molten PVC beads appear along both sides of the **LEVAKNIFE**.

Slide the **LEVAJIGS** back a little and remove the **LEVAKNIFE** up so that it takes as little PVC as possible with it. Join the molten ends of the **LEVAJOINT** by sliding the jigs together by exerting pressure holding the ends firmly together for around 25 seconds to allow molten PVC to fuse completely. Put the **LEVAKNIFE** off. As it is still hot, clean well the **LEVAKNIFE** preparing it for the next joint welding.

Without bending the **LEVAJOINT**, unfasten the **LEVAJIGS** and remove carefully the **LEVAJOINT** Waterstop.

When the **LEVAJOINT** becomes cold, test it by bending it several times, in order to be sure of the melting procedure success.

P.S. Where an electrical outlet is not available, the use of a hot metal blade is possible, provided this blade is heated with a clean flame.

When the required temperature is reached, the **LEVAJOINT** will melt easily when touched against the blade.

Keep attention to the blade's temperature, if it is too hot, the **LEVAJOINT** will carbonize.

HEALTH AND SAFETY

Hot weld site jointing of PVC **LEVAJOINT** Waterstops results in the liberation of hydrochloric acid fumes. Therefore, good ventilation must be provided or a suitable respirator used in closed places. In open places, such precautions are not necessary as no danger to health exists.

PRECAUTIONS

Avoid drive nails through center of waterstop when forming.

Never lap waterstop .

All joints must be sealed with a heat sealing method.

Avoid embedding center bulb in concrete. It must be positioned in the center of the joint to insure freedom of movement and proper expansion.

Catalog No.	Description	Meters/Roll	Special Length
LJ 010 PWD	Plain Web 10 cm	25	On request
LJ 014 PWD	Plain Web 14 cm	25	On request
LJ 017 PWD	Plain Web 17 cm	25	On request
LJ 010 CBD	Center Bulb 10 cm	25	On request
LJ 014 CBD	Center Bulb 14 cm	25	On request
LJ 017 CBD	Center Bulb 17 cm	25	On request



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