

Edge Sealing Kit

Application Note and Mixing Instructions

Attention has been made with regards to the duration of time it takes to seal the edges of Clock Spring installations, due to the consistency of the adhesive. In order to expedite the process, ClockSpring|NRI has investigated the addition of a thickening agent to the adhesive. Thickening the adhesive permits the installer to ensure the edges are properly sealed, as well as decrease the amount of time spent on the process.

Fumed silica, a well-known thickening agent used for a variety of applications, was determined to be the best substance to be added to the adhesive. The improved consistency found with the addition of fumed silica, as well as the absence of structural changes in the adhesive, have been verified with 1000 hour test in saturated conditions.



Procedure

Obtain and record the ambient and pipe surface temperatures. Use the highest temperature obtained to determine appropriate ratio of activator needed for adhesive.

Tables are provided here for reference. Thoroughly mix the adhesive for at least two minutes before adding any of the activator. Add the blue colored activator and mix until the mixture is uniform in color and without streaks. Mix for approximately 2-3 minutes. Note that the working time has begun once the activator is mixed.

Approximate		Edge Sealing Adhesive Kit with pre-measured Fumed Silica				Installation Temperature	
Cure Time Hours	Working Time Minutes	Activatory Quantity (grams)				°F	°C
		2400	1700	1200			
1.5 - 1	35	380	275	190		32	0
1.5 - 1	35	330	240	170		50	10
1.5 - 1	30	300	240	150		70	21
1.5 - 1	30	225	165	115		80	27
1 - 0.5	25	225	160	115		90	32
1 - 0.5	20	225	160	115		100	38
1 - 0.5	15	225	160	115		110	43
1 - 0.5	15	225	160	115		120	49

The consistency of the adhesive is significantly thicker and will conform to the edges of the Clock Spring with limited runoff. Using the 3-inch (76 mm) putty knife, apply adhesive sealing both edges of the Clock Spring repair sleeve. Please note that the working time of the mixture will be between 35 and 15 minutes.