

## Operating Safety

- Allow only ONE PERSON to work on Splicing Iron at a time.
- Only qualified personnel should operate splicing iron.
- Keep children, bystanders, and animals, at least twenty (20) feet away from the work area.
- Do not operate under the influence of alcohol or drugs.
- Always unplug the iron when not in Use.
- Never operate under the influence of medications, drugs or alcohol.
- Iron operates at very high temperature and can burn flesh or cause ignition, even after being unplugged (until cool).
- Never, under any circumstances, alter your Splicing Iron. Altering the equipment, or using the equipment in such a way as to change its design capabilities and capacities, could result in serious or fatal injury and WILL VOID THE WARRANTY.

## Warranty

*J P Specialties, Inc. warrants this splicing iron to the original user against defective material or workmanship for a period of 90 days from the purchase date.*

## Safety Manual

Do not operate the Splicing Iron unless you read and understand the instructions and warnings in this manual. If any doubt or question arises about the correct or safe method of performing anything found in this manual contact JP Specialties, Inc.

## Personal Protection

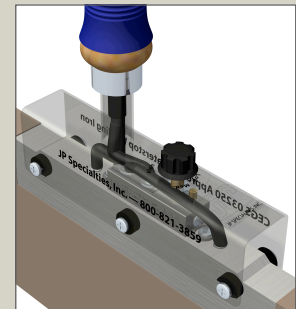
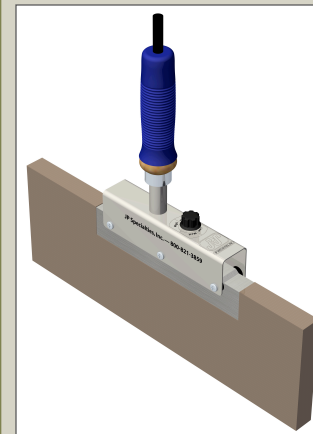
- Always wear protective gear including but not limited to:
  - ✓ Temperature resistant gloves
  - ✓ Safety goggles
  - ✓ Protective shoes/boots
  - ✓ Respirator in indoor confined spaces
- Ensure all electrical connections are in good working order prior to plugging in Splicing Iron.

## Worksite Safety

- Do not leave plugged/unplugged iron lying around the work area.
- NEVER use Splicing Iron on slippery, wet, or muddy surfaces. The location should be flat, dry, and free from any tall grass, brush, or ignitable objects.
- Welding should be done in a well ventilated area. In confined areas, a respirator should be worn as melting plastic waterstop fumes may be harmful to your health.
- NEVER use your Splicing Iron at night.

J P Specialties, Inc.

Waterstop Splicing Iron Safety Manual and Users Guide



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## Waterstop Splicing Iron Job Site Installation User Guide

Follow all of the instructions contained in this booklet to ensure a safe procedure and structurally sound waterstop welds.

### Splicing Technique:

A initial warm up time of approximately 15 minutes is required to heat up splicing iron to the required temperature. Preheat Iron up to the following:

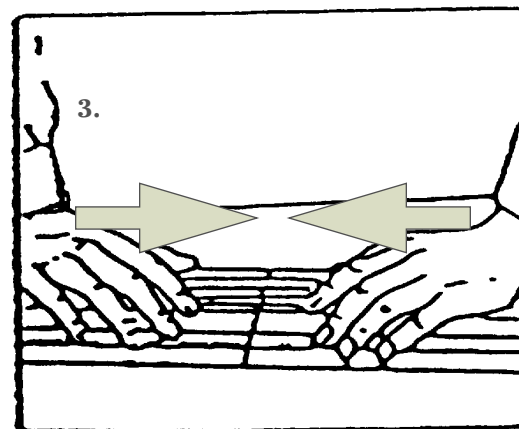
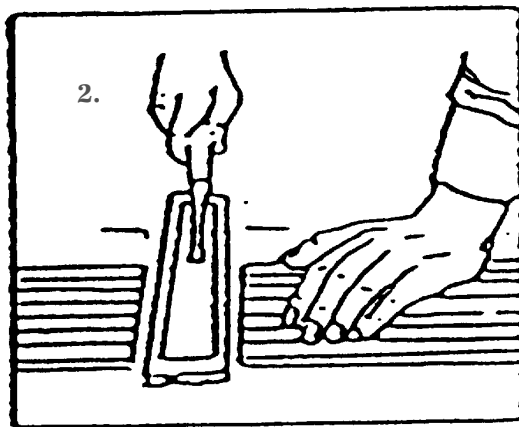
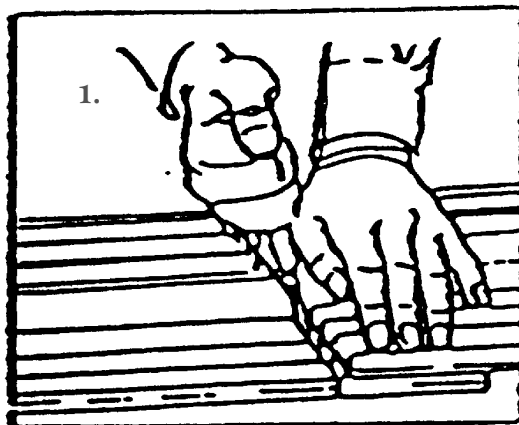
- For TPV/TPER Waterstop: 410 to 430°F
- For PVC Waterstop: 350 to 380°F

It is recommended to verify temperature using an external thermometer.

**NOTE:** The Peel and Stick Teflon® Cover is to remain on the iron during the welding process. **DO NOT REMOVE.**

**CAUTION:** Too high of a temperature will result in damage to waterstop welds, splicing iron cover, and possibly splicing iron.

1. Always cut square ends before welding waterstops. Never weld to extruded ends. Use flat work table to create field splices. Work area should be solid and have access to 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" diameters with 40 teeth) to ensure matching edges.
3. Preheat the iron to the desired temperature ranges. Place iron between butt ends. Keep waterstops in place until approximately 3/16" bead forms on each side of waterstops. Quickly remove splicing iron and gently press waterstops ends together until they bond (approximately 3 to 5 minutes or cool to touch). Cold water may be sprayed on waterstops to expedite the bond. **NOTE:** When welding TPV/TPER, if you do not join ends quickly, the melted material will skin over, resulting in an inadequate bond.



## Electrical Safety & Standards

1. Ensure appropriate electrical connections are in good working order.
2. Do not alter the tool in any way. Doing so could be a hazard and void the warranty.
3. Keep iron away from water and never operate with wet hands.
4. Do not use the Splicing Iron with a damaged cord.
5. Never use the Splicing Iron with non-regulated voltages.
6. Understand the Safety Manual and User Guide before plugging in the Splicing Iron.

### WATERSTOP SPLICING IRON TROUBLESHOOTING GUIDE

SYMPTOM	REMEDY
No Heat	<ol style="list-style-type: none"><li>1. Have qualified personnel check for correct line voltage.</li><li>2. If twist lock plug has been added, make certain all N.E.C. code has been followed and that all electrical connections are sound.</li><li>3. Ensure GFCI is closed.</li></ol>
Low Heat	<ol style="list-style-type: none"><li>1. Have qualified personnel check for correct line voltage.</li><li>2. Ensure generator has enough power for all tools in use.</li><li>3. Ensure extension cord used is less than 50 feet in length and at least 12 gauge thick.</li><li>4. If temperature has not been reached in 30 minutes contact the manufacturer.</li></ol>