USING A-30 TO SEAL AZ SHEET PILE INTERLOCKS

General comments -

A-30 has a pot life of approximately 2 hours once mixed. One gallon will cover about 130 -140 of interlock. Have sufficient amount of interlock prepared to accept the mixed A-30. Sheet pile must be in position and leveled prior to mixing. Sheet pile must remain in level position until A-30 cures (about 8-12 hours or longer depending on temperature).

MATERIALS ON HAND LIST:

Plastic buckets (see photo) approximately 5 gallon size for mixing -
Measuring bucket marked at 7.5 quarts (1/2 of the resin)
Measuring container marked at 0.5 quarts (1/2 of the hardener)
Drill and mixing paddle
Disposable containers for pouring A-30 into interlock (water cans, coffee cans or similar)
Insulating foam or similar to seal ends of piles (see photo for example)
Suitable gloves, clothes and equipment
Carpenters level for checking level of pile

SHEET PILE PREPARATION:

Level parallel H-Beams placed approximately 20 feet apart. (See photo)

Place sheet piles on level H-Beams and check level of sheet pile. Adjust level if necessary.

Photos are of PZ piles for an example.

IMPORTANT: Interlocks MUST be clean dry and oil free. Use wire brush (hand or electric drill) to remove any loose rust or debris. Use high pressure air to blow grit and debris from the interlock. If coated with oil, use torch to burn off oil or wipe with solvent

INTERLOCK PREPARATION:

1. Thoroughly clean interlock with wire wheel brush (or hand brush)

CLEANING INTERLOCKS WITH DRILL MOUNTED WIRE BRUSH

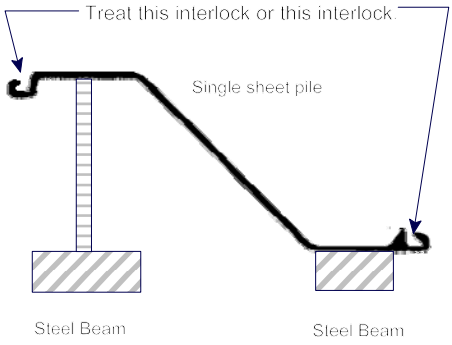
REMOVE DEBRIS BY AIR AFTER CLEANING INTERLOCKS

2. Remove grit and debris from interlock by blowing

3. If oil is present in interlock, heat to remove oil by acetylene torch

4. **Interlocks must be clean and dry**

1. **Piles do not have to be single**. If they are single, set piles in position so the socket is open and easily accessible. place two steel beams parallel and level across the beams. Weld stub on one beam to support the "up" side of the pile. The stub must be high enough to level the pile (see detail). Since the beams are level, the pile should be level.



Determine driving direction of sheet pile. Leading interlock MUST not be treated with A-30. Treat opposite interlock with A-30 following cleaning procedures

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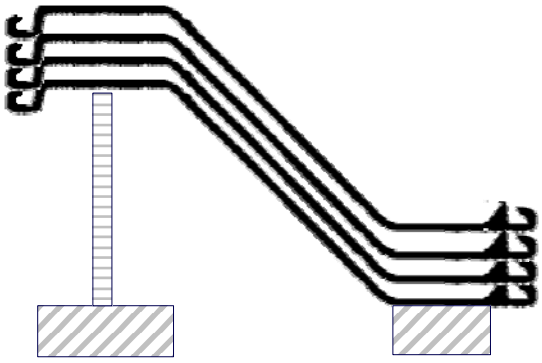


Continue placing piles on first pile - treat each pile after it has been added to the stack. Allow to cure before moving. Always protect from water.

MPORTANT - PILES MUST BE LEVEL . (this is critical - Piles must be level. The level must be maintained until the A-30 is cured.)

Remove (with grinder) any rough or sharp edges on the leading interlock (male side). The treated interlock (female side) will be driven over the male side. Any rough or sharp edges may damage the bead of A-30.

Use urethane foam, pieces of closed cell backer rod or similar material to dam ends of interlock.

MIXING:

IMPORTANT - measure carefully and mix well.

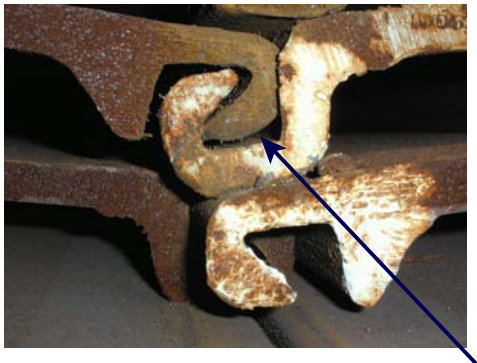
3. Measuring and Mixing - The A-30 is a two component material. Measure the **15:1** ratio (15 parts resin and 1 part hardener) carefully and mix thoroughly. Mixing is complete when the amber color is equal throughout the mixture. Two quarts of resin will require 4.25 ounces of hardener. Or another example 7.5 quarts of resin will require 0.5 quarts of hardener. If the material is not measured correctly and mixed well, it may not cure or expand as intended. Do not mix more than you can apply within 2 hours. One pail or resin and one can of hardener will yield 4 gallons. **POT LIFE is approximately 2 hours!**

APPLICATION :

Apply in the female socket (non - leading side). **IMPORTANT -** Must have correct amount in the interlock. **More is not always better!** The most efficient amount is slightly less then the measured gap when the male / female interlocks are fully extended. Determine this measurement before mixing. For example if the measured gap is 1/8", the depth of the A-30 should be slightly less than 1/8".

FILL CENTER INTERLOCK

For example only
Not AZ pile



Measure this gap when the interlock is fully extended

Apply the A-30 - use a small brush or spatula to help spread the A-30. Measure depth carefully. Determine the volume required for that length of interlock. You can treat remaining pile by calculated volume if desired however keep checking depth periodically. The correct depth of A-30 is important.

STORAGE:

Piles must remain in level position until A-30 cures (becomes firm enough that it cannot be displaced when pressed with finger tips).

After A-30 is cured (firm) the pile can be moved to a dry storage area. Protect from moisture prior to driving. If covering with plastic sheet, invert pile so condensation does not collect in the interlock. Piles can be stored for several weeks if protected from moisture and direct sunlight.

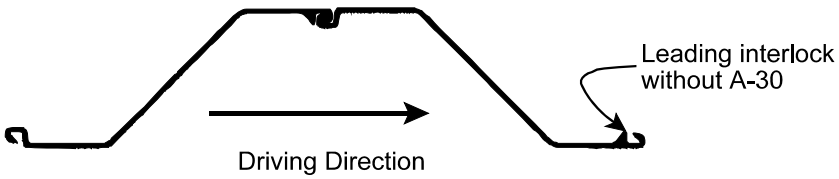
DRIVING:

To help lubricate the pile just prior to driving, use a brush dipped in soapy water and brush the interlock when the pile is being picked up to drive.

After driving has started and the pile has hit water (ground water - standing water), the pile must reach its final depth within 2 hours.

Driving Direction:

Piles must be driven with the untreated interlock leading. Drive treated interlock over untreated interlock.



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