ALH Systems Limited

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Method Statement

General

1.1 The following work shall only be carried out by specialist contractors trained by ALH System Limited and approved by the Specifying Engineer.

1.2 Obtain and understand the latest material health and safety data sheet for Series Six Primer and Series Six Encapsulant. If in doubt seek further information from ALH System Limited.

1.3 Series Six will not adhere to wet surfaces, dust, laitance, loose rust, grease, oil or other contaminants. Ensure the concrete trough, and rail are free from contamination and dry before commencing work.

Surface Preparation

Concrete Trough

The surface to which Series Six is required to give a long term effective bond must be mechanically prepared to provide a sound, dry, laitance and contamination free surface**.**

2.1 Series Six should not be applied to 'green concrete'. Concrete must be allowed to cure for 14 days prior to application.

2.2 If release oil has contaminated the concrete surface this will need removing with high pressure water or steam cleaning.

2.3 The concrete surface must be mechanically prepared to remove laitance. This can be achieved with wire brushing, scabbling or shot blasting.

2.4 Wet or damp concrete must be dried using hot air or a flame torch.

2.5 Protection must be provided where necessary to ensure the trough remains clean and dry until after the Series Six has been poured.

Steel Preparation

The steel surface (rail) must be dry and contamination free to ensure a long term effective bond.

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3.1 Oil, grease or other contaminants must be removed with high pressure water or steam cleaning or by suitable degreasing solvent.

3.2 Wet or damp rails must be dried using hot air or flame torch.

3.3 The steel surface must be mechanically prepared removing all rust and paint. This can be achieved with mechanical wire brushing or shot blasting.

Priming

Series Six primer is an active material which achieves its maximum strength as soon as it is dry, usually after 5 minutes, after 12 hours have elapsed a further coat must be applied.

4.1 Before priming check trough is clean and dry, vacuum or blow slot clean.

4.2 Apply suitable masking tape to top surface of trough.

4.3 Shake or stir well before using.

4.4 Apply Series Six primer using brush or roller to all surfaces (rail, concrete trough side and bottom) which will be in contact with the Series Six encapsulation.

Installation of Rail

5.1 Survey concrete trough for level and line and check against the design requirements and any remedial work carried out prior to starting track installation.

5.2 Using the survey information install Series Six pads and non-resilient packers as required to level rail.

5.3 The rail is then lowered into the trough onto the levelling pads and packers, check rail level against design parameters.

5.4 On satisfactory completion of 5.3 the rail will be aligned and held vertically using wedges fitted between the edge of the concrete trough and rail.

Mixing & Pouring

The pouring operation must take place within 12 hours of priming if this cannot be achieved the following procedure may be adopted. Remove all debris and water from trough. Dry the top of the concrete trough and rail if necessary. Re-prime the top 50mm-75mm of concrete trough and rail, pour immediately.

6.1 Pour base component (small can) into the hardener component (large can) allow to drain for 30 seconds.

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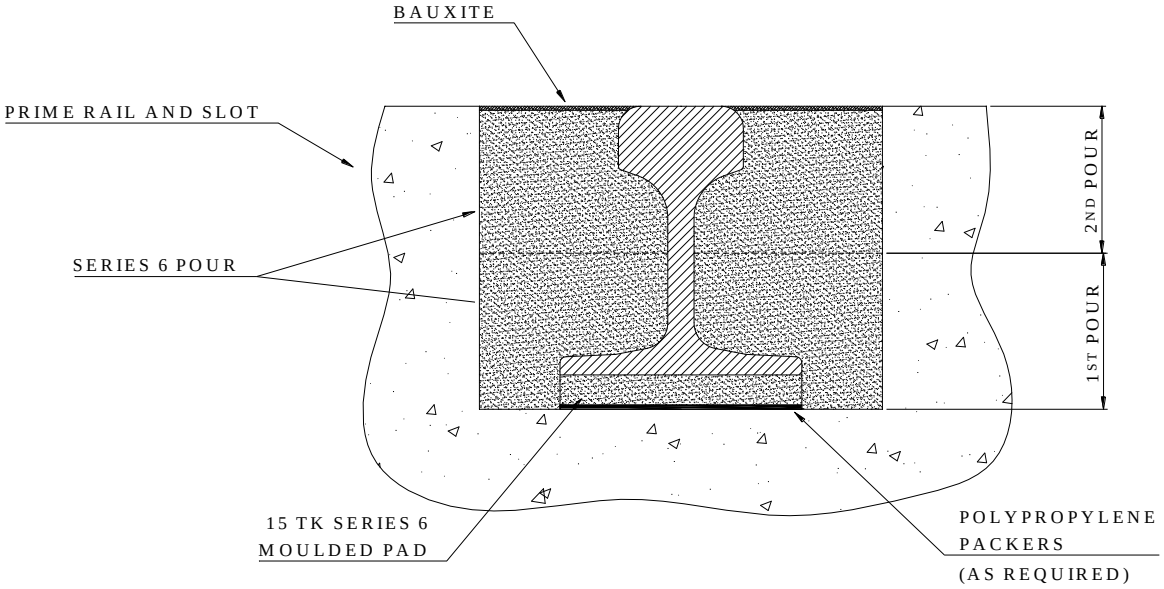
6.2 Mix using high powered electric or pneumatic drill and special ALH mixing paddle and shaft for 1 minute, time this operation.

6.3 First pour mixed material immediately starting at the lowest end of the section to be filled. Pouring must be from one side only to ensure the cavity between the bottom of the rail and trough is completely filled. Continue to pour until resin level is just below the wedges.

6.4 After 30-60 minutes when the first pour material starts to cure, check level and alignment. Remove wedges and start second pour, one side at a time until the trough is full or required height.

6.5 Sprinkle treated bauxite on to partly cured material to provide pedestrian anti slip surface.

6.6 After 15-30 minutes remove the masking tape, do not leave on for more than 30 minutes.



80 LB RAIL ENCAPSULATION