

**STRUCTURAL PLATE
SEAM SEALANT TAPE
SPECIFICATION**

A. SCOPE

This specification covers seam sealant tape used in lap joints between structural corrugated plates where gasketing is desired. Typical applications are underground culverts or tunnels passing through wet areas, conveyor tunnels or underpasses.

NOTE: Seam sealant tape **WILL NOT** make structural plate watertight.

A. GASKETING TAPE MATERIAL

A. General Description

The corrugated structural plate pipe shall be gasketed with MANUS-BOND 64A, Tremco ET-675 Elastomeric Flow Resistant Tape, or approved equal. This tape shall be a black, extruded or calendered, self-adhering, butyl elastic sealant on a release liner paper, packaged in rolls with the following initial dimensions:

EXTRUSION DIMENSIONS FOR ALL GAGES

	<u>MANUS</u>	<u>TREMCO</u>
Thickness:	1/4"	3/16"
Width:	Ribbed- N/A Flat – 4"	4" 4-1/2"

A. Physical Properties

The seam sealant tape shall have the following physical properties:

Color: Black
Base: Butyl Elastomer
Solids Content: 100%

A. APPLICATION SPECIFICATIONS

A. Experience

The erector shall have a minimum of two years successful and proven experience erecting pipe gasketed with structural plate seam sealant tape, or its approved equal.



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B. Cleaning Metal

All excess oil, grease, asphalt, dirt or other materials shall be removed from the laps of any contaminated plates by wiping with an oil-free petroleum naphtha solvent.

C. Tape Placement

Apply the unprotected surface of the seam sealant tape to the clean surface. The tape shall be centered over the bolt holes.

The tape shall be applied with the liner paper in place and rubbed out with hand pressure. The liner paper should be removed with a quick stripping motion at an angle as close to 180 degrees to the plane of the tape as possible.

Tape applied across the corrugations shall be made to follow the contours of the corrugations during application without thinning or stretching.

At triple lap points, the tape thickness shall be doubled for at least 6" on either side of the joint to provide an effective seal. When splicing tape the lap over one inch. All splices and laps are to be made next to a bolt.

D. Positioning and Securing Corrugated Plates

Bolt holes shall be pierced through the seam sealant tape with a heated spud or other sharp tool. If a heated tool is used, the temperature shall be controlled to a maximum of 275° F.

Plates shall be bolted together and all nuts to be torqued to the following levels.

MULTI-PLATE	150 - 300 Ft-lbs
Aluminum Structural Plate	90 - 115 Ft-lbs for 0.100 plate 115 – 135 Ft.-Lbs for all other plate thicknesses and components



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