106 STRUCTURAL STEEL

AMSCOT
STRUCTURAL PRODUCTS CORP.
A World of Structural Bearings and Custom Fabricated Metal Components.
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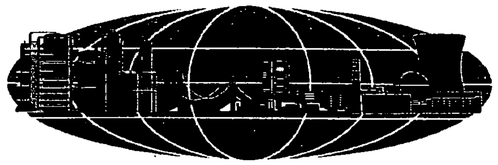

BRIDGE WATER
BRS 0149(4)

AMSCOT – "TEFLON - HOT BOND PROCEDURE"
Per AASHTO section 14.6.2 and 14.6.2.6.1

1. MATERIAL PREPARATION: (Steel to Teflon) PTFE (polytetrafluoroethylene) Filled Teflon sheet shall be chemically etched on one side. Etched face to be bonded to the prepared sandblasted Steel surface as per SSPC – 6 near white profile of the structural steel substrate plate.

2. ATTACHMENT PROCEDURE: The material shall be recessed into the structural steel plate 50% half of the TFE thickness required.

3. EPOXY: ARMSTRONG style no. A-271 Industrial two (2) part epoxy resin part A & B shall be mixed per manufactures recommendation and shall be applied with a trowel evenly on 100% of the intended prepared surface to be bonded together .

4. EPOXY BOND PROCEDURE: The steel substrate and PTFE shall be placed together in a hydraulic Temperature controlled heated press @ 180 degrees F. A constant pressure of 200PSI shall be maintained during the cure time of 15 minutes.

5. BONDED MATERIAL: Remove bonded items immediately after cure time indicated above and place on ambient Steel work station table and allow to cool for one (1) hour.

6. FINISHED PRODUCT: Once Teflon slide plate is cooled to ambient room temperatures remove any residue of epoxy along the perimeters. Secondly, polish the top Teflon surface to be free of any foreign particles prior to assembly to the mating Stainless steel element.

VTRANS
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