

EXTRUDED MOULDED ALUMINIUM GUTTER JOINTING INSTRUCTIONS

IS MG1

INTRODUCTION

Extruded aluminium gutter with snap-fit internal union clip joints, sealed with low modulus silicone sealant, secured with aluminium bolts, nuts and washers. To provide a permanent seal within the manufacturing tolerances of the aluminium, the construction tolerances of the building, and be able to withstand the cyclic thermal movement associated with climatic conditions.

JOINT DESIGN

Internal union 100mm wide across joint with 13 x 8mm slot longitudinally located in sole. Spacers incorporated into the joint to provide a permanent 2 –2.5mm space between gutter and union to maintain a bed of sealant if the bolts are over-tightened.

ASSEMBLY

1. It is essential that prior to sealing both surfaces of the gutter joint are clean and free from oils, grease and debris. Guttermaster recommends the use of Loctite 7063 Cleaner and Degreaser. The following instructions should be followed:

Treat surfaces to be sealed by generously spraying with Loctite 7063 cleaner.

Wipe surfaces while still wet with a clean lint free cloth to ensure that heavy contamination is removed.

Spray surfaces again, preferably with surfaces in a vertical position to allow run-off of the cleaner.

Allow the solvent time to evaporate until the surfaces are completely dry.
2. To ensure adhesion and elasticity only low modulus neutral cure silicone to BS5889 (type A) is suitable. Always follow the sealant manufacturers' recommendations. The following brands are recommended: Sealocrete PLA, Febseal, Dow Corning, Sika. Sealant should not be applied at temperatures below 5deg C.
3. Apply sealant in 6mm diameter continuous beads around the full girth of the gutter. Particular attention should be given the area surrounding the bolt holes.
4. Set gutters 3mm apart (to allow thermal movement) and insert the union clip.
5. Secure aluminium bolts using 29mm diameter neoprene backed washer and nuts (provided by Guttermaster).
6. Tighten bolts sufficiently to squeeze excess sealant from the joint. The spacers in the joint will offer resistance when the bolts are tight enough – **DO NOT OVERTIGHTEN.**
7. Smear sealant around exposed threads of bolts.
8. Remove excess sealant.
9. Allow 24 hours for partial cure.

If you require assistance, please contact our
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