

## RECTANGULAR BOX GUTTER SYSTEM

### JOINTING INSTRUCTIONS

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#### INTRODUCTION

Rectangular box gutter with internal union joints sealed with low modulus silicone sealant and secured with bolts, nuts and washers. To provide a permanent seal within the manufacturing tolerances of the material, the construction tolerances of the building, and able to withstand the cyclic thermal movement associated with climatic conditions.

#### JOINT DESIGN

Internal union/butt strap 100mm wide across joint with 16x8 slots longitudinally located appropriate to the girth of the gutter. Dimpled spacers pressed into the joint 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:

- 1.1 Treat surfaces to be sealed by generously spraying with Loctite 7063 cleaner.
- 1.2 Wipe surfaces whilst still wet with a clean lint free cloth to ensure that heavy contamination is removed.
- 1.3 Spray surfaces again, preferably with surfaces in a vertical position to allow run-off of the cleaner.
- 1.4 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: Sealcreate PLA, Febseal, Dow Corning, and Sika. Sealant should not be applied in temperatures below 5 degrees Celsius.
3. Apply sealant in 6mm diameter continuous beads around the full girth of the gutter. Particular attention should be given to the surrounding bolt holes.
4. Set gutters 3mm apart (to allow for thermal movement) and insert the union clip.
5. Secure bolts using 29mm diameter neoprene backed washer and nuts (provided by Guttermaster) commencing with the sole/base, progressing to the front and back.
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 OVER TIGHTEN.
7. Smear sealant around exposed threads of bolts.
8. Remove excess sealant.
9. Allow 24 hours for partial cure.