



Method Statement

STARACRYSEAL DS 32-17

(Single Component, Elastomeric, Acrylic Sealant)

Rev.: A, Date: 25.06.2025



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Section A: General Considerations

Tools & Equipment

It is suggested that the following list of equipment is adopted as a minimum requirement.

Equipment Type	Equipment Description
Protective clothing	- Protective overalls - Good quality gloves and face mask - Eye Protection
Mixing equipment	N/A
Surface Preparation Equipment	- Wire Brush - Proprietary blasting equipment - Steam Cleaning Equipment - Industrial Vacuum
Application Equipment	- Bond Breaker Tape - Brush, Trowel - Extraction Gun - Power Extrusion Gun

High temperature working

It is suggested that, for temperatures above 35°C, the following guidelines are adopted as good working practice:

1. Store unmixed materials in a cool environment, avoiding exposure to direct sunlight.
2. Keep equipment cool, it is especially important to keep cool those surfaces of the equipment which will come into direct contact with the material itself.
3. Try to avoid application during the hottest times of the day, arrange temporary shading as necessary.
4. Make sufficient material, plant and labour available to ensure that application is a continuous process.

Application - points of note

STAR operates a policy to encourage the use, where possible, of approved or licensed applicators. This ensures that applications are completed satisfactorily so that the long term performance of the materials is assured.

For contractors who wish to apply the materials themselves STAR is also able to offer technical assistance and training. Either on-site or at its Training Centre in the Kingdom of Saudi Arabia.

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Section B: Application Instructions

1. Surface Preparation

- 1.1 Surfaces be dry, clean, solid, free from loose materials, oil grease, paints and free from contamination such as oil, grease, loose particles, decayed matter, moss algal growth, laitance, and all traces of mold.
- 1.2 STAR solvent can be used to clean and degrease surfaces.

2. Priming

- 2.1 Priming is not required on metal surfaces.
- 2.2 When used on porous or highly absorbent substrates, use STAR Primer for surface preparation.

3. Application

- 3.1. Prepare STARACRYSEAL DS 32-17 Cartridge, pail or drum by cutting off one end or opening the container.
- 3.2. Insert the Cartridge into the Caulking Gun or position the Power Extrusion Gun.
- 3.3. Close the Gun and fit the Nozzle to the Gun – Cut it in 45 degree angle – Position the Power Gun suitable for extrusion.
- 3.4. Extract the Sealant firmly onto the surface and Tool the sealant surface to insure complete contact and good surface finish as follows:
- 3.5. UL 181B Mastic Closure of UL 181 Flexible Air Ducts: Apply by brush, trowel or power extrusion. Uniformly brush out a 5cm

wide coat over the joint, at the nominal rate of 1 l/m².

Total coverage rate to be 1.2 – 1.6 m²/l. Allow the completed joint to dry at least 24 hours at above 21°C before pressure testing. High humidities (over 70%) and/or cooler temperatures may retard drying. Total wet film thickness to be approx. 800 mic.

3.6. Other Sealing Applications:

Apply a continuous film of Duct Sealant over all areas of the indoor or outdoor duct system where air leakage may occur. A brush may be used to work the sealant into joints and remove excess. On spiral ducts, apply a coat to the male end of the coupling prior to fitting the straight run of spiral duct over it. Brush excess sealant over the joint to complete the seal.

Screw holes and flanges should also be sealed with a coat of Duct Sealant. It may be applied to the inside or the outside of the duct.

- 3.7 STARACRYSEAL DS UL 32-17 may be applied using a wide variety of power (pressure) extrusion equipment suitable for use with water-based sealants. The sealant typically is a gel with a viscosity range of 130,000 – 160,000 cps.

4. Notes

- 4.1 Due to the products formulation, certain materials (e.g. copper, lead) can be affected.

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5. Cleaning

- 5.1 STARACRYSEAL DS 32-17 should be removed from tools, equipment and mixers with Solvent and Water prior to the initial set. Cured material can only be removed mechanically.

Section C: Approval and Variations

This method statement is offered by STAR Technology as a 'standard proposal' for the application of STARACRYSEAL DS UL 32-17. It remains the responsibility of the Engineer to determine the correct method for any given application.

Where alternative methods are to be used, these must be submitted to STAR Technology for approval, in writing, prior to commencement of any work. STAR Technology will not accept responsibility or liability for variations to the above method statement under any other condition