



Method Statement

STARFIX AX 131

(Single Component, Elastomeric, Silicone 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 – Joint 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.
- 1.3 Roughen the surfaces, remove any laitance and expose aggregate by light scrubbing or grit-blasting.
- 1.4 Any joint filler must be checked to ensure it is tightly packed and no gaps or voids exist at the base of the sealing slot before positioning a bond breaker.
- 1.5 The use of a bond breaker is not required in expansion joints containing cellular polyethylene joint filler, backing rod (Vetoflex PBR). For contraction joints a bond breaker tape or back-up strip must be used.

2. Priming

- 2.1 Priming is not required on sound surfaces and for the adhesion of Acrylic Sealant.
- 2.2 When used on porous or highly absorbent substrates, use STAR Primer for surface preparation.

3. Application

- 3.1. Prepare **STARFIX AX 131** 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 ensure complete contact and good surface finish as follows.
- 3.5 **STARFIX AX 131** 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.

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4. Notes

- 4.1 Due to the products formulation, certain materials (e.g. copper, lead) can be affected.
- 4.2 Do not use on natural stones like marble, granite as it stains
- 4.3 Direct contact with the secondary sealing of insulating glass units and the PVB-film of safety glass must be avoided.
- 4.4 Under the influence of sunlight change in color appears.
- 4.5 When finishing with a soapy solution, make sure that remaining surfaces are not touched by this solution. This will cause the sealant not to adhere to that surface.
- 4.6 Do not use on polycarbonate.
- 4.7 Do not use in applications where continuous water immersion is possible

5. Cleaning

- 5.1 **STARFIX AX 131** 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 **STARFIX AX 131**. 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