Method Statement

STARBOND SB PVC

(One Component, Premium Quality, Polychloroprene Rubber & Solvent Based Contact Adhesive for the Application of PVC Waterproofing Membranes)

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	▪ Paddle Mixer ▪ Manual Mixing Tools
Surface Preparation Equipment	▪ Solvent ▪ Steam Cleaning Equipment ▪ Industrial Vacuum
Application Equipment	▪ Brush, Trowel ▪ Spatula ▪ Spray Equipment

High temperature working

It is suggested that, for temperatures above 35^{0}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.

1.3 Surfaces should be dry and within the recommended temperature range specified by the manufacturer (typically 10°C to 40°C).

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. Mix STARBOND SB PVC thoroughly by appropriate Tool – Paddle Mixer (Don't use Sticks or Boards, where splinters could contaminate the product) to assure uniform consistency.

3.2. Application:

Brush:

Use a clean paintbrush. Uniformly, apply to metal surface at approx.. 4.9 – 9.8 m2/l = 0.1 to 0.2 mm wet film. Press assembly into place, making sure complete contact is made with applied adhesive. Bond may be made within 0 to 15 minutes after observing the Open Time.

Spray:

Not applicable – Viscosity to High.

3.3. For bonded surfaces, apply adhesive to both sides if required. Adhesive should be applied with 150mm brush width in 300mm intervals.

3.4. Observe **Open Time** – Very critical, as this time defines the time the adhesive needs to form Tack.

3.5. Thereafter assembly shall be fixed using pin clips or suitable measures to prevent sagging

3.4 Bring components together carefully to avoid the introduction of air bubbles. Clamp or apply weights to ensure proper contact and bonding pressure

3.5 Maintain the assembly undisturbed during the curing period using tie cords or bands at 900mm centers until adhesive sets – 1h to touch. Dry through approx.. after 24h in standard conditions.

4. Notes

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

4.2 Check suitability before use on PVC and other surfaces.

4.3 Keep container closed when not in use to prevent solvent evaporation.

4.4 Duct glue is used to seal joints and seams of ductwork to prevent air leakage. This is important for ensuring that your HVAC system is operating efficiently and effectively. Air leakage can waste energy and reduce the comfort of your home or business.

5. Cleaning

5.1 STARBOND SB PVC should be removed from tools, equipment and mixers with Solvent 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 STARBOND SB PVC . 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