

WIL-KEY CONCRETE LOCK (WILLOCK)

INSTALLATION PROCEDURE

Attachment of WILLOCK to Formwork

WILLOCK is attached to the inside face of the formwork with finishing nails prior to concrete pouring. The nails must be 25mm or shorter. The nails must be driven flush with the back of the **WILLOCK** to allow for easy removal when formworks are removed.

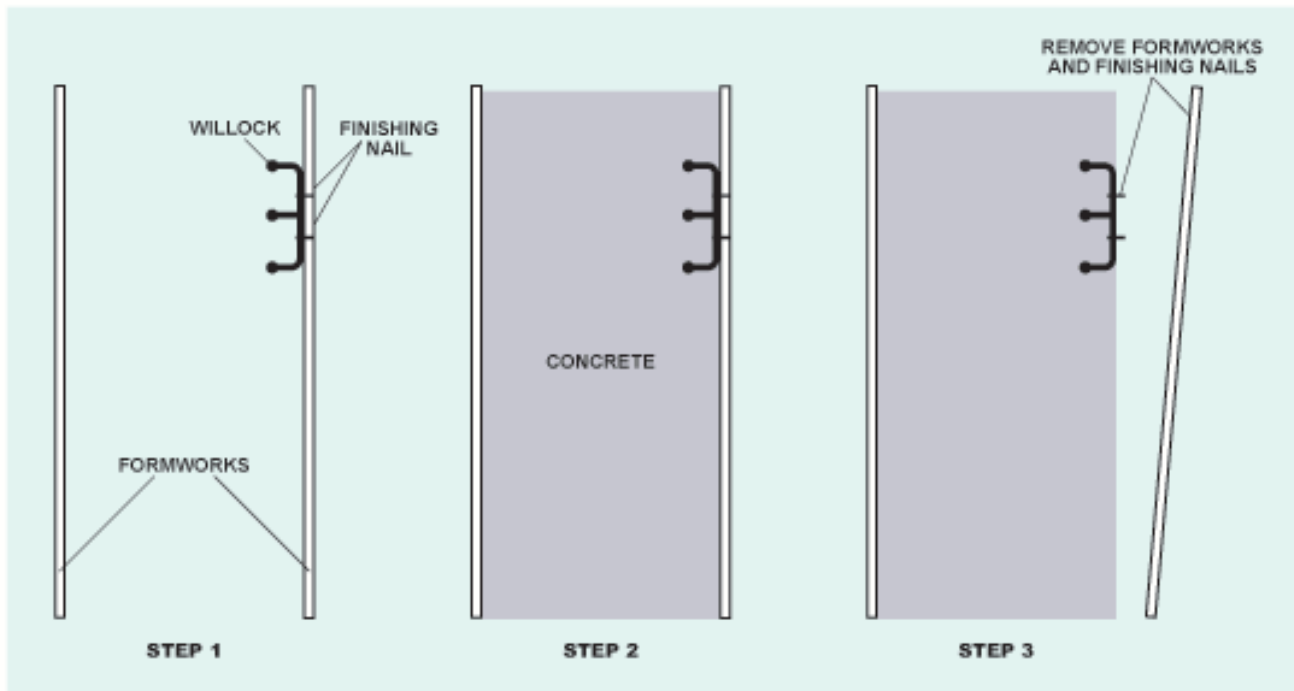
The concrete surrounding the **WILLOCK** should be vibrated to ensure that there are no void spaces (honeycomb) in the concrete adjacent to the **WILLOCK**.

After the concrete has set and formworks are removed, the finishing nails can be removed by pulling out with the help of pliers. If concrete gets between the **WILLOCK** and the formwork, the concrete should be chipped away to reveal the face of the **WILLOCK**. Any sharp edges concrete that are created by the chipping must be beveled to prevent possible cutting or puncturing of the liner.

Welding of WILLOCK

Wil-Key International has developed butt fusion welding equipment (Model WK-BF400) specially for the welding of Concrete Locks. The Concrete Lock welding procedures are as follow:

1. Cut the ends of the **WILLOCK** to be welded. These cut ends should be smooth with no nicks or gouges in the surfaces.
2. Clean ends and remove dirt, water, grease and other foreign materials.
3. Insert clean and pre-heated welding heater plate between ends and bring the ends firmly in contact with the heater plate while achieving an even melt pattern over the cut faces of the **WILLOCK**. Allow ends to heat and soften until a melt bead of approximately 3mm appears.
4. Remove the heater plate from the two pieces of **WILLOCK** and bring the melted ends together. Apply enough pressure to produce a 3mm rollback bead.
5. Allow the joint to cool.



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