

SAMPLE PAGE: Q-Seal Preparation

Planning and preparation are necessary to allow continuous sealing operations. Managing tile surface temperature plays a pivotal role in maintaining a steady process.



Surface Temperature

The surface temperature of tile and liners is critical to successful sealant bonding. The QS 250 will heat each tray of tile to a predetermined temperature setting. If the tile entering the QS 250 is extremely cold, excessive pre-heat times will decrease production. To minimize this, product to be sealed should be staged in an area where the tile will achieve a surface temperature of at least 65°F. Tile is dense and may require several hours to warm to room temperature after being moved from a cold location.



Sealant Temperature

Each sealant component is heated in the pressure vessels to a temperature of 105°F using heating bands around the outside surface of the pressure vessels. To improve heat transfer, air operated agitators are installed inside each pressure vessel.

Depending upon the sealant's storage temperature, this heating process may take several hours and should begin well before operation (e.g. the evening before for daytime sealing operations). Full pressure pots provide enough sealer for 12 to 15 hours of continuous operation. In this case, refilling the pots and restarting the agitator and heaters at the end of each day will ensure that they are ready for the following day.

For operations expected to exceed 15 continuous hours, secondary pressure vessels should be employed to minimize changeover time between tanks.

Filling Pressure Vessels with Q-Seal

Each type of sealant has its own pressure vessel. The installation team will set up the tanks initially, after which tanks will need refilling as sealant is consumed. Scales beneath each tank feature a digital display showing the weight of material in each tank. Weight is also continuously monitored by the QS 250, which will alert the operator before reaching a low level point (approximately 12 to 15 hours of operation per full tank).



Remember when refilling sealant tanks that the Q-Seal must be processed at an elevated temperature. Refilling during a shift may impose several hours of wait time while the sealant reaches operating temperature. Tanks should be refilled at the end of each shift to minimize this condition, or a secondary set of heating elements may be employed to elevate the temperature of unopened containers of Q-Seal.

TIP If using band heaters on unopened containers monitor the temperature every 20 minutes until it reaches the optimum 95°F (35°C). **Do not let the temperature exceed 105°F (40°C).**

Following a prolonged shutdown, flush the spray valves, material lines, and pressure vessels with solvent before starting production. Allow the sealer sufficient time to heat up to operating temperature.

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