

APPLICATION INSTRUCTIONS

1. Purpose

- 1.1 The purpose of this document is to establish uniform procedures for applying Vulkem® EWS in water feature applications. The techniques involved may require modifications to adjust to job-site conditions. If you have any questions regarding your application, contact your local Tremco Field Sales Representative for specific design requirements. This document will provide instructions and troubleshooting for the application of Vulkem EWS to qualify for the manufacturer's warranty.

2. Substrate Preparation

- 2.1 Investigation of the substrate should be performed to determine the type of surface preparation that will need to take place to achieve the appropriate surface profile required for the coating application. Depending on the condition of the concrete, one or more types of surface preparations may be required. Refer to ICRI's Technical Guideline No. 310.2R-2013 - Selecting and Specifying Concrete Surface Preparation for Sealers, Coatings, Polymer Overlays and Concrete Repair for best practices on selecting the appropriate method of concrete preparation. Vulkem EWS application requires a CSP 3-4.
- 2.2 For preparation of metal substrates, please follow The Society for Protective Coatings recommendations that are referenced in section 3.12.

3. Conditions for Substrates

Concrete Surfaces:

- 3.1 Concrete shall be water-cured and attain a 3000 PSI minimum compressive strength. The concrete must be below 6% moisture as measured using a Tramex CME 4 Moisture Meter prior to the coating application. Depending on concrete construction and job site location, additional concrete testing may be required. Please contact your local Tremco Sales or Technical Representative.
- 3.2 Excess moisture in the concrete can prevent the coating materials from performing as intended. To detect the presence of excess moisture, several tests may be employed:
- ASTM D4263- Standard Test Method for Indicating Moisture in Concrete by the Plastic Sheet Method
 - ASTM F2170-02 - Standard Test Method for Determining Relative Humidity in Concrete Floor Slabs
 - Calcium Chloride Test
- 3.3 All concrete surfaces must be shotblast prior to any coating application. For proper methods, refer to ICRI's Technical Guideline No. 310.2R-2013. For supplier information contact Tremco's Technical Service.
- 3.4 Concrete surface shall be properly cleaned so that the surface to receive the coating, sealant, or liquid applied flashing is free of all laitance, mold, paint, sealers, coatings, curing agents, loose particles, and other contamination or foreign matter which may interfere with the adhesion. Consult a Tremco Technical Service Representative for recommendations prior to installing materials.
- 3.5 Shrinkage cracks in the concrete surface which are 1/16" (1.5 mm) wide or greater shall be treated according to the instructions in Sections 5 and 7.

- 3.6 Structural cracks, regardless of width, shall be treated according to the instructions in Sections 5 and 7.
- 3.7 Spalled areas shall be cleaned and free of loose contaminants prior to repair. Due to the fact that jobsite conditions vary, it is recommended that you contact Tremco's Technical Service or your local Tremco Sales Representative for the best method of repair.
- 3.8 In the event of exposed reinforcing steel, it is recommended that the structural engineer of record be contacted for investigation of the condition and for the best method of repair.
- 3.9 Surfaces shall be made free of defects that may telegraph and show through the finished coating. Surfaces which are rough (fins, ridges, exposed aggregate, honeycombs, deep broom finish, etc.) shall be leveled and made smooth by applying a coat of sand-filled Tremco PUMA WC according to the instructions in Section 7.
- 3.10 All drains shall be cleaned and operative. Drains shall be recessed lower than the deck surface. Surface shall be sloped to drain and provide positive drainage. Drains should be detailed as instructed below:
- Cut a 1/4" wide x 1/4" deep (6 mm x 12 mm) keyway into the concrete surface at any point where the coating will have an exposed terminating edge- that is, any point where the coating will end in an open area subject to traffic, for example, at the end of a ramp, around drains and alongside expansion joints.
- 3.11 If the project is a restoration deck, old sealant and backing material shall be removed. The joint interface will require a thorough wire brushing, grinding, sandblasting and primer.

Metal Surfaces:

- 3.12 Follow standard SSPC-SP 10/NACE No. 2 Near White Blast Cleaning. A near-white metal blast cleaned surface, when viewed without magnification, shall be free of all visible oil, grease, dust, dirt, mill scale, rust, coating, oxides, corrosion products, and foreign matter.

4. Jobsite Materials

Recommended materials and their use are as follows:

Dymonic 100: A one-part, moisture curing, gun grade polyurethane sealant for use in precast, masonry, expansion joints, control joints and for use in forming cants.

Tremco PUMA Primer: A two-part, chemical-curing MMA primer for porous and non-porous surfaces.

Tremco PUMA BC: A two-part, chemical-curing PUMA modified coating used as an elastomeric, waterproofing membrane for Vulkem EWS.

Tremco PUMA BC LM: A lower modulus version of Tremco PUMA BC, used as the waterproofing membrane for Vulkem EWS for service temperatures below 32° F (0° C).

Tremco PUMA BC T: A thixotropic version of Tremco PUMA BC, used for ramps, vertical rises, detailing and field applied cant beads.

Tremco PUMA BC R: A two-part, chemical-curing PUMA modified coating used as an elastomeric, waterproofing membrane for Vulkem EWS.

Tremco PUMA TC: A two-part, chemical-curing MMA coating used to lock in aggregate and provide additional chemical and UV resistance to Vulkem EWS.

Tremco PUMA TC Tintable: A tintable, two-part, chemical-curing MMA coating used to lock in aggregate and provide additional chemical and UV resistance to Vulkem EWS.

Tremco PUMA Cleaner: A one-part PUMA cleaner for all tools such as mixing paddles, squeegees, spiked rollers and spatulas. Always use this cleaner for Vulkem EWS materials. Never use any kind of solvent to clean any of your tools as this will cause contamination and inhibit cure.

Tremco PUMA Initiator: A benzoyl peroxide-based filler used to react to all components of Vulkem EWS.

Tremco PUMA Cold Weather Catalyst: Used at temperatures of 20 °F (-6 °C) and below. Please contact Tremco Technical Service for further details.

Aggregate: 0.3 to 0.6 mm (30-50 mesh)-sized silica sand for the primer application. For supplier information, contact Tremco Technical Service.

NOTE: Tremco PUMA BC will fill cracks and moving joints when applied at the recommended thickness noted in section 7; this will eliminate the need for detailing. This is the preferred method of detailing. Please note, Tremco PUMA BC is not for use in the application of expansion joints. If using the preferred method, skip section 5 and proceed to section 6.

If the project is using Dymonic 100 for cracks and moving joints, continue to section 5.

5. Detail Work – Dymonic 100

If Dymonic 100 is not being used for detail work, proceed immediately to section 6.

Note: Do not apply sealant to a frosty, damp or wet surface or when substrate temperature is below 40 °F (4 °C) or the surface temperature is above 110 °F (43 °C). Cure times as stated below are based upon standard ambient conditions of 75 °F (25 °C), 50% RH. A decrease in ambient temperature and humidity will significantly lengthen the cure time.

- 5.1 Lay a 1/4" (6 mm) diameter backer rod into the corner at the juncture of all horizontal and vertical surfaces such as curbs, wall sections, columns, or penetrations through the deck. Apply a bead of Dymonic 100 1" (2.5 cm) wide over the backer rod. Tool the sealant bead to form a 45° cant. Use sufficient pressure to force out any trapped air and to assure complete wetting of the surface. Remove excess sealant from the deck or wall joint. NOTE: Backer rod is only required for moving joints.
- 5.2 Install a backer rod, 1/8" to 1/4" (3 mm to 6 mm) diameter larger than the joint width to all prepared control joints. Set depth of backer rod to control the depth of the sealant. (Depth of sealant is measured from the top of the backer rod to the top of the concrete surface.) Proper depth of sealant is as follows:
 - 5.2a. For joints 1/4" (6.4 mm) to 1/2" (12.7 mm) wide, the depth ratio should be equal.
 - 5.2b. Joints 1/2" (12.7 mm) wide or greater should have a sealant depth of 1/2" (12.7 mm). The minimum joint size is 1/4" x 1/4" (6.4 mm x 6.4 mm).
- 5.3 All cracks and joints shall be sealed with Dymonic 100, and tooled flush with the surface. Note: Expansion joints should not be coated over. For treatment of expansion joints, contact your local Tremco Sales Representative.

- 5.4 Allow sealant to fully cure.

6. Priming Concrete Surface

- 6.1 Mix Tremco PUMA Primer for 1 to 2 min prior to the addition of Tremco PUMA Initiator.
- 6.2 Mix Tremco PUMA Primer thoroughly together with Tremco PUMA Initiator in accordance with Table 2 for 2 to 3 min.
- 6.3 Apply Tremco PUMA Primer at a minimum of 90 ft²/gal to yield 17 wet mils to the entire area to be coated. The recommended method of application is with a roller. Application below 17 wet mils will result in the primer not curing.
- 6.4 Once primer is rolled out evenly, lightly broadcast 0.3 to 0.6 mm (30-50 mesh)-size silica sand into the primer at a rate of 0.7 lb/10 ft².
- 6.5 Allow Tremco PUMA Primer a minimum of 30 min to fully cure.

7. Detail Work – PUMA Products

Contact local sales representative for expansion joint detailing.

Defects, Patching and Sloping

- 7.1 Mix Tremco PUMA WC for 1 to 2 min prior to the addition of the silica sand.
- 7.2 Begin with 10 lb of sand for every gallon of Tremco PUMA WC. Additional sand can be added if a thicker consistency is desired.
- 7.3 Once Tremco PUMA WC and the sand are blended together, combine this mixture with the Tremco PUMA Initiator in accordance with Table 2 and mix thoroughly for 2 to 3 min. Amount of Tremco PUMA Initiator is dependent on ambient temperature. Please note the Vulkem Initiator addition is based in the ratio of Initiator to Tremco PUMA WC, not Initiator to Tremco PUMA WC with silica sand. Please see Table 2 for addition amounts.
- 7.4 For uneven spots and other defects in the surface, such as pitting or cratering, a thicker mix of Tremco PUMA WC and sand may be required. Trowel the material to create an even surface with the concrete.
- 7.5 Allow Tremco PUMA WC with sand mixture to cure a minimum of 45 min before proceeding to base coat application.

Horizontal to Vertical Transition

Note: Proceed to 7.9 if horizontal to vertical transitions were treated with Dymonic 100.

- 7.6 Mix the Tremco PUMA BC T for 2 to 3 min prior to the addition of the Tremco PUMA Initiator. Ensure that Tremco PUMA BC T is thoroughly mixed together with the Tremco PUMA Initiator in accordance with Table 2 for 2 to 3 min.
- 7.7 Apply a cant of Tremco PUMA BC T 1" (2.5 cm) wide at the juncture of all horizontal and vertical surfaces (such as curbs, wall sections, columns or penetrations through the deck). Tool Tremco PUMA BC T to form a 45° cant. Use sufficient pressure to force out any trapped air and to assure complete wetting of the surface. Remove excess material from the deck or wall surface.
- 7.8 Apply a strip of tape (masking tape or duct tape) to the vertical sections, 2 to 3" above the Tremco PUMA BC T or Dymonic 100 cant to provide a neat termination of Tremco PUMA BC R.
- 7.9 Apply Tremco PUMA Primer over the Tremco PUMA BC T or Dymonic 100 cant before applying coating.

- 7.10 For penetrations, apply Tremco PUMA Primer over the cant, up the penetration to 1" below the top of the projected overburden. Allow primer to cure.
- 7.11 Following the primer application, mix Tremco PUMA BC R. Mix in Tremco PUMA Initiator in accordance with Table 2.
- 7.12 Apply the Tremco PUMA BC R mixture using a medium-nap roller to achieve a minimum thickness of 40 mils over the primed penetration, over the cant, and extended minimum of 12 inches onto the horizontal plane. Spiked rollers are not required for change in plane.
- 7.13 Apply Tremco PUMA Primer over the Tremco PUMA BC R before coating over.

8. Base Coat Application

Note: In environmental conditions where large temperature swings exist, such as Northern US and Canada, Tremco PUMA BC LM can be used in lieu of Tremco PUMA BC.

Vertical Surfaces:

- 8.1 Mix Tremco PUMA BC R for 2 to 3 min prior to the addition of Tremco PUMA Initiator. Note: The application of PUMA BC R to the vertical surfaces of the structure is the first step in applying base coat.
- 8.2 Tremco PUMA BC R is thoroughly mixed together with the Tremco PUMA Initiator in accordance with Table 2 for 2 to 3 min. Amount of Tremco PUMA Initiator is dependent on the ambient temperature. Please see Table 2 for addition amounts.
- 8.3 Apply the Tremco PUMA BC R at 40 ft²/gal to yield 40 wet mils (1.0 mm) thick to the vertical surfaces of the structure. The recommended method is a medium nap roller.
- 8.4 Allow a minimum of 45 min to cure.
- 8.5 Apply a second coat of Tremco PUMA BC R at 40 ft²/gal to yield a thickness of 40 wet mils (1.0 mm) on the vertical surfaces of the structure as per 8.1 - 8.2.
- 8.6 Allow a minimum of 45 min to cure.

Horizontal Surfaces:

- 8.7 Mix Tremco PUMA BC or BC LM for 1 to 2 min prior to the addition of Tremco PUMA Initiator. Note: The application of PUMA BC or BC LM to the horizontal surfaces of the structure is the second step in applying base coat.
- 8.8 Tremco PUMA BC or Tremco PUMA BC LM is thoroughly mixed together with the Tremco PUMA Initiator in accordance with Table 2 for 2 to 3 min. Amount of Tremco PUMA Initiator is dependent on the ambient temperature. Please see Table 2 for addition amounts.
- 8.9 Apply Tremco PUMA BC or Tremco PUMA BC LM at 20 ft²/gal to yield 80 wet mils (2.0 mm) thick to the entire area. The recommended method is a metal notched rake.
- 8.10 Spike roll Tremco PUMA BC or Tremco PUMA BC LM immediately to release all air bubbles from the coating.
- 8.11 Allow Tremco PUMA BC, Tremco PUMA BC LM, or Tremco PUMA BC R a minimum of 45 min to cure.

9. Top Coat Application

- 9.1 Mix Tremco PUMA TC for 1 to 2 min prior to the addition of Tremco PUMA Initiator.

- 9.2 Thoroughly mix Tremco PUMA TC together with the Tremco PUMA Initiator in accordance with Table 2. Amount of Tremco PUMA Initiator is dependent on the ambient temperature. Please see Table 2 for addition amounts.
- 9.3 Apply Tremco PUMA TC at 20 mils (80 ft²/gal). The recommended method of application is with a roller.
- 9.4 Allow Tremco PUMA TC a minimum of 1 hr to cure.

If using a field tintable clear top coat, please follow the below directions.

- 9.5 Add up to 3 Universal Color Pak to one 6 gallon pail of Tremco PUMA TC Tintable and mix for 1 to 2 minutes prior to the addition of the Tremco PUMA Initiator. Mix the Tremco PUMA TC and initiator in accordance with Table 2 for 2 to 3 min.
- 9.6 Apply the Tremco PUMA TC Tintable at 80 ft²/gal to yield 20 wet mils (0.51 mm) thick to the entire area. The recommended method of application is with a medium nap roller.
- 9.7 Allow the Tremco PUMA TC Tintable a minimum of 1 hr to cure.

10. Clean Up

- 10.1 Clean all adjacent areas to remove any stains or spills with Tremco PUMA Cleaner.
- 10.2 Clean tools or equipment with Tremco PUMA Cleaner.
- 10.3 Clean hands by soaking in hot, soapy water then brush with a stiff bristle brush.

11. Material Usage Guidelines

The Following is a guide to determine material usage:

Dymonic 100: For a 1" (25 mm) cant bead over a 1/4" (6 mm) backer rod, 1 case of sealant for every 48 lf (14.6 M) is required.

Tremco PUMA Primer: When applied at 90 ft²/gal (2.21 M²/L) will yield a mil thickness of 17 wet mils.

Tremco PUMA BC, BC LM, or BC R: When applied at 20 ft²/gal (0.49 M²/L) will yield a mil thickness of 80 wet mils.

Tremco PUMA TC: When applied at 80 ft²/gal (1.96 M²/L) will yield a mil thickness of 20 wet mils.

Aggregate: Apply silica sand at a rate of 0.7 lb/10 ft² immediately after the Tremco PUMA Primer application.

12. Troubleshooting

- 12.1 This section describes common industry application issues when certain environmental conditions exist. Below are some commonly seen issues and remedies. If any of these should occur, it is always recommended you contact your local Tremco Sales Representative or Tremco's Technical Service.
- 12.2 Tremco requires that any possible recoating job be reviewed and approved by your Sales and/or Technical Representative prior to installation.
- 12.3 When a deck contains too much moisture, the excess moisture may change into a vapor which then condenses at the concrete-membrane

interface before the coating has cured, which will cause blisters or bubbles, which, in turn, will interfere with proper adhesion. If this should occur the blisters/bubbles can be cut out, allowing the moisture to escape. After moisture has escaped and the surface is dry, the area can be repaired.

- 12.4 If the coating is applied in very hot ambient temperatures, the air in the small spaces between the concrete particles increases in volume and forms blisters. Contact Tremco's Technical Service should this occur.
- 12.5 Tremco PUMA products should only be applied when the UV index is less than 7 and substrate temperatures below 115°F.

Table 1: Quick Reference Application Chart

Layer	Product	Wet Mil	Cure Time	Square Feet Per Gallon
Primer	Tremco PUMA Primer	17	30 min	90
Base Coat (Horizontal)	Tremco PUMA BC R	80	45 min	20
Base Coat (Vertical)	Tremco PUMA BC or BC LM	80	45 min	20
Top Coat	Tremco PUMA TC	20	1 hr	80

Table 2: Temperature Chart

Temperature °F	Temperature °C	Grams or ounces/gallon
68 to 95	20 to 35	75 g or 2.75 oz of initiator/gal resin
50 to 68	10 to 20	150 g or 5.5 oz of initiator/gal resin
32 to 50	0 to 10	300 g or 11 oz of initiator/gal resin
14 to 32*	-10 to 0*	450 g or 16.5 oz of initiator/gal resin

*Below 14°F (-10°C), please contact Tremco Technical Service for further details. Minimum 75g of initiator per gallon required.

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Please refer to our website at www.tremcosealants.com for the most up-to-date Product Data Sheets.



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