

# APPLICATION INSTRUCTIONS

## 101CR Inset Reflecting Road Studs and Hot Melt Adhesive

### Adhesive

Generally termed “Hot Melt” type, as it requires heating in order to liquefy for application. Supplied in blocks, it has an indefinite storage life in cool dry conditions.

**‘READ HEALTH AND SAFETY NOTES CAREFULLY BEFORE HEATING COMMENCES.’**

### Heating – Initial and ongoing.

It is advisable to break the block into smaller pieces for more efficient heating. Using suitable equipment (see note 7) capable of achieving and maintaining required temperature, the adhesive is heated to 170 – 190 degrees Centigrade. This is the optimum temperature for both adhesion and application properties. Lower temperatures will reduce adhesion and make it more difficult to handle. Higher temperatures, especially maintained for longer periods, may damage properties and could lead to combustion.

### Cutting the surface and installing the stud

Cut the surface to match the bottom contour of the stud. A single plunge cut using a suitable purpose built piece of equipment, is required.

- Using a stud as a gauge, inspect each cut for proper fit.
- The cut should have approx 2-3mm clearance (side to side movement).
- All four levelling lugs must be in contact with the road surface.
- The leading edges of the casting must lie below the road surface.
- The saw cut must be dry and free from dust, dirt or any other material that may adversely affect the adhesive bond.
- Pour the adhesive into the two outer grooves and the central ‘scalloped’. Fill to within approximately 12 – 15mm of the road surface. Immediately place the casting into the cut making certain that no adhesive flows back over the reflective faces or the plate immediately in front of them.
- Subject to ambient temperature, the studs should be allowed to set for between ? min. and 2mins, before exposure to traffic.

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### NOTES

1. In view of the temperatures involved when handling the adhesive, normal protection measures should be taken during heating and application, ie. suitable gloves, clothing etc should be worn.  
  
If skin is splashed with hot adhesive, it should be treated immediately with copious quantities of cold water. Preferably immersed.
2. Care should be taken to avoid any contact between hot adhesive and water.
- 3 UNDER NO CIRCUMSTANCES SHOULD THE ADHESIVE EXCEED 200 DEGREES CENTIGRADE. Heating above the recommended 170 –190 degrees C for prolonged periods may affect properties and heating above 200 degrees C may lead to combustion.
4. 1kg of adhesive is sufficient for 1-2 101 studs depending on road surface texture.
5. Technical assistance is available for demonstration of the application technique if required.
6. The information contained in this document is given in good faith and is believed to be true and accurate. However, no guarantee of results are implied, as conditions of use are beyond our control.
7. Application equipment. We are able to offer advice on suitable machinery or recommend specialist equipment manufacturers.
- 8 Tropicalised Hot Melt Adhesive is available for use in areas where higher ambient and/or surface temperatures prevail.
9. Roadcraft Fleming Hot Melt Road Stud Systems meet the requirements of EN1463-1: 1998 and have been accepted by the DTLR, The Welsh Assembly, The Scottish Executive and The D.O.E. Northern Ireland for use on all types of roads.  
  
Substitution of any of the system components is not only illegal, but will breach any contractual agreements with the Specifier.
10. If studs are installed in unfavourable conditions, optimum performance cannot be expected. ie ensure that application instructions are adhered to for best results and use only Roadcraft Fleming supplied components.