



ATTACHMENT OF UNBACKED ELASTOMERIC FORM LINERS TO FORMS

Unbacked elastomeric form liners can be attached to plywood forms or CLEAN, RUST-FREE steel forms in the field by the following method. Please be advised that epoxying form liners to plywood or steel forms provides a permanent adhesion. Liners cannot be removed from the forms once the epoxy sets without damaging the liner and/or the form. Successful attachment requires that the procedure be carried out under controlled conditions. Temperature of the form, form liner, and epoxy adhesive should ideally be between 60 and 80 degrees F. Higher temperatures will accelerate the cure of the epoxy, shortening the working time. Lower temperatures will conversely retard the set time and may prevent curing entirely. Attachment should also be done out of direct sunlight. Elastomeric form liners will absorb heat from the sun and expand, creating potential buckling and delaminating problems. A constant temperature during the attachment and curing period will insure a successful attachment.

1. Position plywood (or steel form) in a horizontal position. Clean form thoroughly, removing all debris, dust, loose particles, etc.
2. Place form liner face up on form and position.
3. Roll back half the liner onto itself being careful no to bend the liner sharply.
4. Wipe form face and the back of the form liner with Methyl Ethyl Ketone (MEK), or acetone to remove any oil or grease.
5. Thoroughly mix the two-component epoxy. Mixing should be done at low speed to avoid entraining air into the mix. Follow mixing instructions on epoxy containers. Scrape the sides of the container to insure that all material is mixed homogeneously. Do not mix more epoxy than what can be applied within the pot life of the epoxy.
6. Spread a thin, uniform layer of the mixed epoxy onto the form with a 1/16" notched trowel. Special attention should be paid to the perimeter edges to insure that adequate adhesive extends to the edge. One gallon of mixed epoxy covers approximately 60 square feet of form area.
7. Roll the liner back onto the freshly applied epoxy. The liner can be shifted as needed for final edge and corner alignment.
8. Once positioned, the liner should be mechanically secured to the form to prevent movement of the liner while the epoxy cures. Appropriate length nails or screws can be used for this purpose. Furring strips secured with finishing nails work well at corners and along edges and insure that the liner has continuous contact with the plywood form.
9. Clean excess epoxy from the perimeter edges before it cures.
10. Roll back the other half of the liner and repeat the process.
11. Allow the epoxy to cure a minimum of 24 hours before handling the form and allow 48 hours before pouring concrete against the liner/form.
12. True edges of form liner and form by sanding with a 36 to 40 grit sanding belt or disc. Truing edges will enhance the seal between mating liners.

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