

1. Clean - interlocks **MUST** be clean. Use wire brush to remove any loose rust or debris.
2. Make sure the piles are level. If you are going to treat just a portion of the pile, use a small bead of sealant, urethane foam or something to dam the portion. Use a dam every few feet if the pile has a curvature to it. **The piles must remain level** during the curing process. Sequence the application so the A-30 in treated piles will have cured before moving.
3. Measuring and Mixing - The A-30 is a two component material. **IMPORTANT** measure the 15:1 ratio carefully and mix thoroughly. The material may not cure due to incomplete mixing. Don't mix more than you can use. 2 quarts of resin will require 4.25 ounces of hardener. Or another example 7.5 quarts of resin will require 0.5 quarts of hardener. **POT LIFE is approximately 2 hours!**



4. Protection - Keep interlocks dry before driving. Piles may be stored for several weeks if kept dry.
5. Driving - **Piles must be driven to their final depth within 2 hours of hitting ground water or any water.**
6. Brushing with a little soapy water just prior to driving may help the interlocks slide together easier.

**OCM, Inc.**

1120 Peterson Road, Grayslake, IL 60030

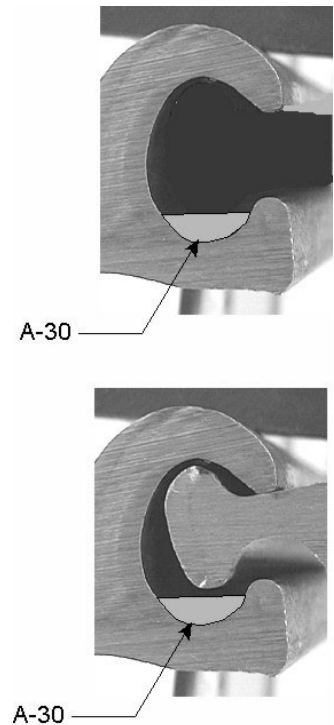
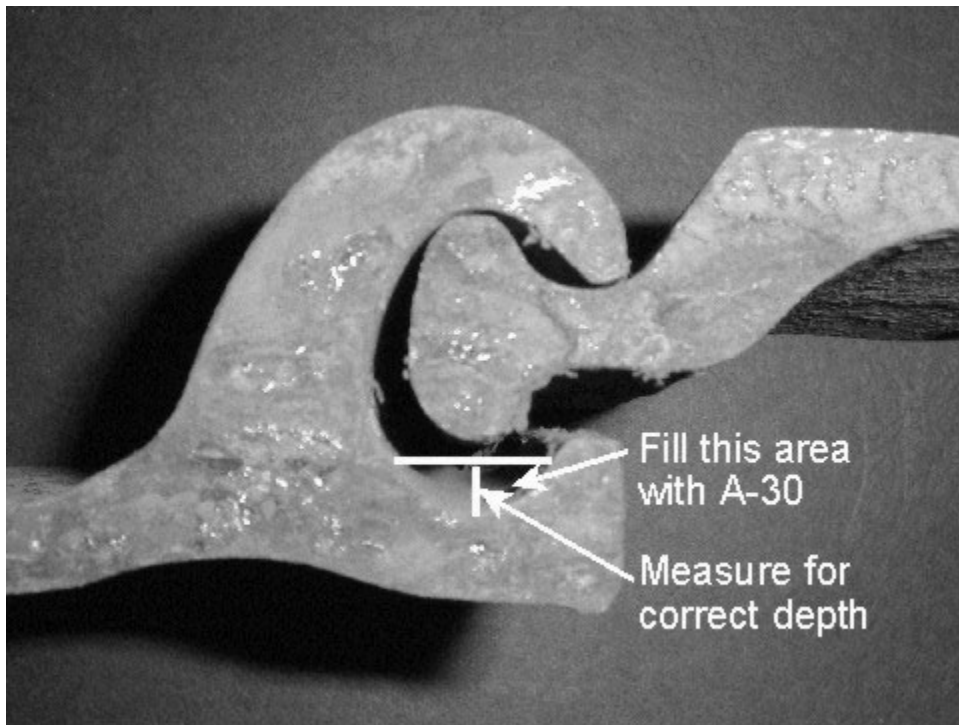
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**Materials on hand list:**

- Plastic buckets (see photo) approximately 4 gallon size for mixing -
- Measuring bucket marked at 7.5 quarts (1/2 of the resin - or appropriate measure for quantity needed).
- Measuring container marked at 0.5 quarts (1/2 of the hardener - or appropriate measure for quantity needed).
- Drill and mixing paddle
- Containers for pouring A-30 into interlock ( Coffee cans, plastic containers or dispensers work the best)
- Insulating foam, backer rod, sealant or similar to seal ends of piles (see photo for example)
- Tool for checking depth of A-30 in the interlock (see photo)
- Disposable paint stirring sticks to scrape remaining resin into mixing container
- Suitable gloves and clothes (A-30 is difficult to remove from clothing)
- Carpenters level for checking level of pile (should be fairly long level)

Apply in the socket as shown in the following photos. **IMPORTANT** - Must have correct amount in the interlock. **More is not always better!** The most efficient amount in the side interlock of paired piles is about 1/8". Field conditions indicate 1/16" to 1/8" is the best thickness for most effective sealing and driving conditions. Pile must be level. If pile is not level from end to end, place small P-201 dams at 5~10 foot intervals to help control thickness of A-30 bead.



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**On Site Job Photos**



Place piles on parallel level H-beams.



Paired PZ piles.



“Ball” of PZ piles.

Grind off any rough edges of the ball before driving.  
Rough edges could gouge A-30 from the socket.



Socket of PZ piles.

Right: Piles leveled and ready for cleaning  
before application of A-30





On Site Job Photos continued



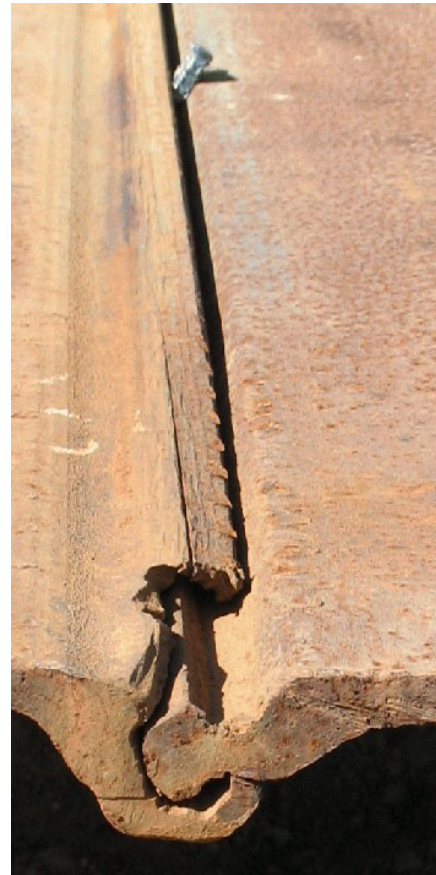
Cleaning socket with wire brush.  
**IMPORTANT**—Socket must be clean, dry,  
free from oils and any loose rust or debris.



Remove any loose debris by compressed air.



Plug ends with urethane foam in spray can,  
backer rod or bead of chalk



Open paired center interlock by wedging a 1/4"  
spacer in the interlock. This is best done while  
placing the pile on the H-beam. The crane or  
loader can raise the center to accept the wedge.



Prepare a small tool for measuring the correct depth of the A-30. A small allen wrench marked with a chisel and painted at the 1/8" mark works the best. This is easy to slip into the interlock and easy to see the depth of the A-30. The maximum amount should be about 1/8". Field conditions indicate 1/16" to 1/8" is the best thickness for most effective sealing and driving conditions. Pile must be level. If pile is not level from end to end, place small P-201 dams at 5~10 foot intervals to help control thickness of A-30 bead.

**IMPORTANT**—The pile must remain level until the A-30 is cured (approximately 8 hours).



A small plastic "squeeze" bottle works best for applying A-30 to the outer interlock.

#### **IMPORTANT**

Measuring and mixing is **CRITICAL!** The ratio is 1 part of hardener to 15 parts of resin. For example—2 quarts (64 oz) will require 4.2 oz of hardener. Mix thoroughly. Don't mix more than can be applied within 2 hours.

Two (2) quarts of A-30 will treat approximately 100-110 ft. of the outer interlock. The center interlock will require more.

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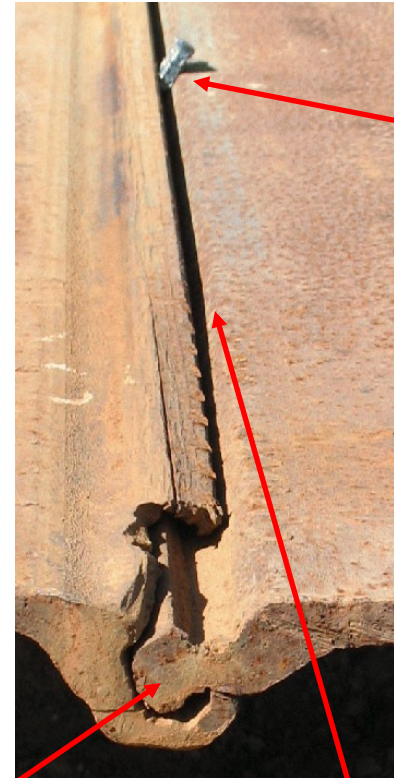
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Applying A-30 to the Center Interlock



Wedge

Plug end with urethane foam in a can.

Fill this area with A-30. A-30 will migrate to the bottom of the socket.

One (1) gallon of A-30 will treat approximately 100 feet when the center interlock is filled as shown.

One half (1/2) gallon will treat approximately 100 feet of outer interlock.

**1.5 gallons of A-30 will treat one hundred (100) feet of paired sheet pile (100 feet of center and 100 feet of outer socket) OR an average of 130~140 feet of interlock per gallon when considering center and outer interlock together.**

This is an estimate and should be used as a guide only.

A-30 is a non-returnable item. Order short and add to your order after actual amount needed is determined by field use.

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