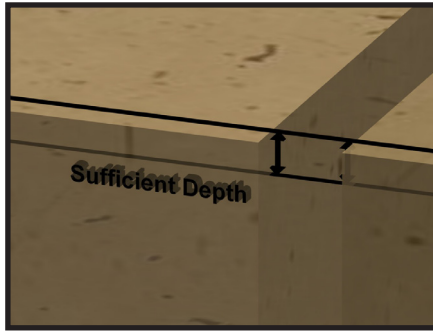
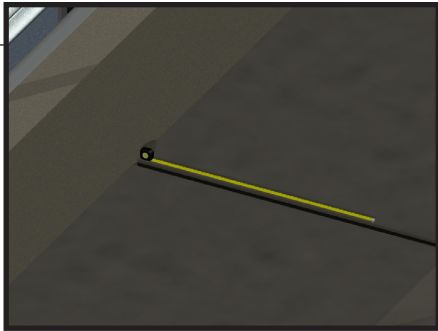


Recommended Tools

Tape Measure / Sharp Knife / Duct Tape / Mineral Spirits / Clean Cloth / Isopropyl Alcohol / Blunt Putty Knife / Caulking Gun / Caulking Trowel

Material Sizing

1. Joints must be sized every 5-7 feet (1.524-2.137 meters) to ensure gap opening is uniform and depth is sufficient for the supplied material.

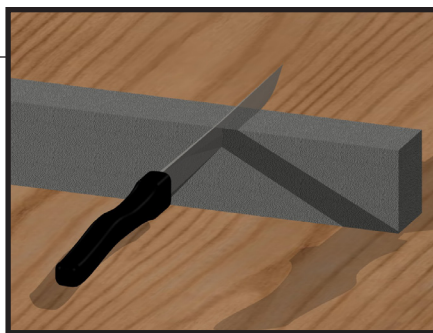


Note:

Allow sufficient depth for the material to be recessed 1/8"-1/4" into the joint.

Material Preparation

1. Store material at a minimum of 68°F (20°C) for a minimum of 24 hours prior to installation, regardless of temperature at location of installation.
2. Store materials in a dry, enclosed area. Make sure materials are off the ground and out of direct sunlight.
3. Use a sharp knife to cut the material square. All starting and ending pieces must be square to the termination point.



Tip:

Apply mineral spirits to the knife for a smoother cut.

4. Prepare material for heat seams (if necessary).

Note:

Refer to the **Seams** section for further instruction on preparing the material.

Important: These instructions are intended as recommended guidelines. Due to the variability of field conditions, selection of the proper material for the intended application and installation are the sole responsibility of the applicator. The manufacturer's published installation procedures shall be followed at all times.

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Joint Preparation

1. Verify the joint is clean, sound, and will provide an appropriate surface for installation of the joint sealant.
 - Use compressed air to clean any loose debris from the joint.
 - Apply water or alcohol to a clean cloth and wipe the joint walls to the depth of the sealant material plus 1".
2. Verify that the joint is uniform and repair any spalls prior to installation.
3. Apply duct tape to both edges of the substrate face to prevent the epoxy from contacting the deck surface.
4. Check the material for appropriate length, width, and depth.
 - Supplied material should be approximately 25% larger but never less than 16% larger than the intended joint opening or greater than 38% oversized.
 - Joint depth must allow for the installed material to be recessed while leaving sufficient space for the primary sealant and backer rod (if used).

Epoxy Preparation

1. Mix Part A and Part B separately.
2. Transfer the entire contents of Part A (resin) and then Part B (hardener) into a clean container. Mix the material thoroughly with a low speed (approximately 300 rpm) drill or jiffy mixer.
3. Mix until the black and white is evenly blended leaving no streaks of either color.
4. Transfer the mixture to another clean container to avoid any leftover residue from streaking the final mixture.

Warning:
Part B must **ALWAYS** be added to Part A, and mixed in a 1:1 ratio.

Tip:
Mix only the required amount of epoxy that will be used within a 30 minute timeframe to prevent the epoxy from curing prematurely.

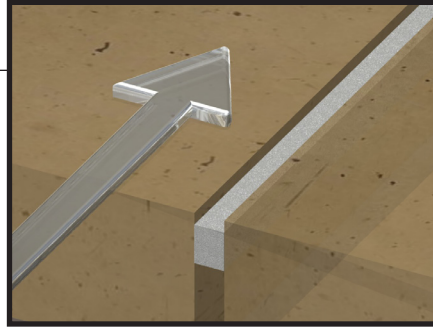
Epoxy Tips:

- The epoxy will not cure when the temperature is below 40°F.
- For every +17°F, the epoxy cures twice as fast.
- For every -17°F, the epoxy takes twice as long to cure.
- Greater volume = less time to cure
- Smaller volume = more time to cure
- A technique to increase the pot life of the epoxy is to split up the mixed material into smaller units.

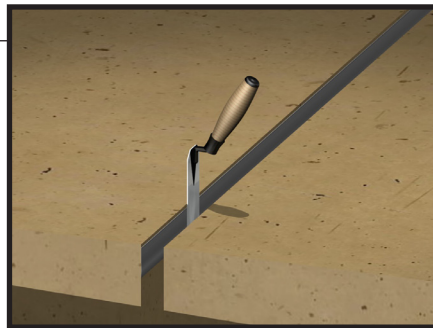
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Sealant Installation

1. Begin installation at one end of the joint and work to the opposite end using butt seams.



2. When fully prepared to install, apply a 40mils (1mm) coating of the epoxy mixture to both joint walls using a 1" margin trowel to a depth of the sealant material plus 1/2".
 - The epoxy must still be wet upon installation of HS; The working time for epoxy is approximately 30 minutes depending on the temperature.
 - If the epoxy hardens on the surface of the substrate prior to installation, another coat of epoxy can be applied within 8 hours. After 8 hours, the joint surface must be abraded to eliminate the amine blush that occurs during the final cure.



Note:

When a continuous joint cannot be finished, the epoxy on the substrate should stop at the last stick installed and epoxy should not be applied to the end of the installed material until the next piece of material is ready to be installed.

3. Verify that the material is cut square at both ends for proper seams. All pieces must be square to the termination point.
4. Apply a 40mils (1mm) coating of the epoxy adhesive to both sides of the material.

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Sealant Installation (Cont.)

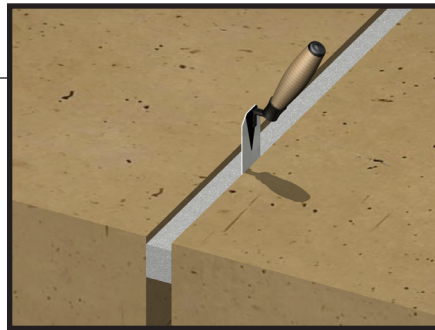
5. Begin installing the material by inserting one side of the HS B approximately 1" into the joint.



Note:

Do not excessively push or pull the material, as this will stretch the foam resulting in possible damage.

6. Use a blunt putty knife or your hand to compress the opposite side of the material and slide it into the joint.



Warning:

Use of sharp tools could cause damage to the joint sealant material. Be careful not to tear the material in the process of compressing it into the joint.

7. Continue to compress and work the material into the joint until the material is approximately 1/4" back from the substrate surface.

Seams

Heat Seams

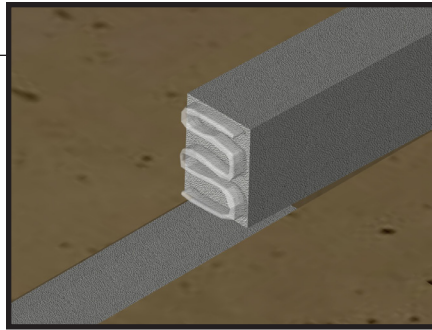
1. Verify that the new piece of material is cut square and not at an angle to the previous material installed.
2. Apply both ends of the seam to the welding iron.
3. Once heated sufficiently, remove both ends from the welding iron and press firmly together.
4. Allow to cool before mixing the epoxy adhesive.

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Seams (Cont.)

Flexible Seal

- ① Apply flexible seal to the butt end of the new piece of material.
- ② Overlap extra material (approximately 1/2"-1") at seams and splices to ensure that the seam is in compression after installation.



Note:
After installation, if there are any mitered joints with a hole or void, use the supplied Flexible Seal to fill and seal the joint.

- ③ Butt seam all "T" and "+" intersections.
- ④ Tool the supplied Flexible Seal over all seams and transitions using a small caulking tool.

Finish

- ① Use the supplied Flexible Seal to run a bead along each edge of the joint to fill any irregularities in the substrate.
- ② Remove any excess Flexible Seal or epoxy left on the surface of the material or substrate.

Warning:
Do **NOT** allow the Flexible Seal or epoxy to cure before removal.



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