

APPLICATION INSTRUCTIONS

1. Purpose

1.1 The purpose of this document is to establish typical guidelines for installation of Willseal 600/600s. The techniques involved may require modifications to adjust to jobsite conditions. Consult your local Tremco Sales Representative or Tremco Technical Services for specific design requirements

2. Scope

2.1 This document will provide the necessary instructions for installation of Willseal 600/600s to qualify for a manufacturer's warranty.

3. Storage Preparation

3.1 Store materials in a dry, enclosed area, making sure materials are off the ground and out of direct sunlight
3.2 Material will expand faster when hot and slower when cold. In cold temperatures, store material in a heated area 24 hours prior to installation. In hot temperatures, store material out of direct sunlight and not in an enclosed storage container where temperatures may exceed 100°F.

4. Substrate Preparation

4.1 Verify that the joint is clean, sound, and will provide an appropriate surface for installation of the joint sealant
4.2 Use compressed air to clean any loose debris from the joint.
4.3 Apply water or alcohol to a clean cloth and wipe the joint walls to the depth of the sealant material plus 1"
4.4 Verify that the joint is uniform and repair any spalls prior to installation
4.5 Check the material for appropriate length, width, and depth
4.6 Supplied material should be pre-compressed to a size smaller than the intended joint opening
4.7 Joint depth must allow for the installed material to be recessed 1/4" from the substrate surface

5. Application Procedure

5.1 For joints supplied in a roll

5.1.1 Seal the vertical joints starting at the bottom and work up, butting each new piece into the previous.
5.1.2 If the self-adhesive backing is too sticky it can be temporarily neutralized by spraying the Willseal 600/600s with water.
5.1.3 Recess the seal 1/4" (6 mm) below the surface of the joint.

5.2 For joints supplied in a stick

5.2.1 When fully prepared to install, apply a 1/16" - 1/8" coating of the supplied adhesive accessory to the joint wall that will not have the pressure-sensitive adhesive up against it using a 1" margin trowel to a depth of the sealant material plus 1/2". Do not apply the supplied adhesive accessory to the joint wall that will be adhered to the joint with the pressure-sensitive adhesive as it will interrupt the bond.
5.2.2 The supplied adhesive accessory must still be wet upon installation of Willseal 600/600s; The working time for the supplied silicone accessory is approximately 30 minutes depending on the temperature
5.2.3 Recess the seal 1/4" (6 mm) below the surface of the joint.

6. Joints, Sidewall and Finishing Work

6.1 Willseal 600/600s will self-expand to fill the joint; its expansion time is relative to the temperature of the joint seal. After Willseal 600/600s has filled the joint, it will continue to expand until it has reached equilibrium. This process requires additional time depending on temperatures.
6.2 Recommended materials and their use are as follows. For more information on the following materials, please contact your local Tremco Sales Representative or visit our website for product specific data sheet and application instructions at www.tremcosealants.com.

Detail Sealant:

- Dymonic® 100
- Spectrem® 1
- Spectrem® 2

0919/W600/600sAI

Please refer to our website at www.tremcosealants.com for the most up-to-date Application Instructions.

Tremco Commercial Sealants & Waterproofing

3735 Green Rd
Beachwood OH 44122
216.292.5000 / 800.321.7906

1451 Jacobson Ave
Ashland OH 44805
419.289.2050 / 800.321.6357

220 Wicksteed Ave
Toronto ON M4H1G7
416.421.3300 / 800.363.3213

1445 Rue de Coulomb
Boucherville QC J4B 7L8
514.521.9555