

Application Instructions

1. Purpose

- 1.1 The purpose of this document is to establish typical guidelines for installation of Willseal® Acousti-Seal. The techniques involved may require modifications to adjust to jobsite conditions. Consult your local Willseal or 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 Acousti-Seal to qualify for a manufacturer's warranty.

3. Storage

- 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
- 4.5 Check the material for appropriate length, width, and depth. Supplied material should be approximately 10% larger than the intended joint opening.
- 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

Verify that the material is cut square at both ends for proper seams; all pieces must be square to each other and to the termination points.
Tip: Apply mineral spirit to the knife for a smooth clean cut.

JOINTS Under 4"

- 5.1 When fully prepared to install, apply a 1/16" - 1/8" coating of the supplied silicone adhesive accessory to both joint walls using a 1" margin trowel to a depth of the sealant material.

- 5.2 The supplied silicone adhesive accessory must still be wet upon installation of Willseal Acousti-Seal; The working time for the supplied silicone adhesive accessory is approximately 20-30 minutes depending on the temperature.
- 5.3 If the supplied silicone adhesive accessory cures on the surface of the substrate before installation, the substrate surface must be abraded, and the supplied adhesive accessory must be reapplied.

JOINTS 4" AND UP

- 5.1 When fully prepared to install, apply a 1/16" - 1/8" coating of the epoxy mixture to both joint walls using a 1" margin trowel to a depth of the sealant material.
- 5.2 The epoxy must still be wet upon installation of Willseal Acousti-Seal; The working time for epoxy is approximately 20-30 minutes depending on the temperature.
- 5.3 If the epoxy hardens on the surface of the substrate before installation, another coat of epoxy can be applied within 2 hours. After 2 hours, the substrate surface must be abraded to eliminate the amine blush that occurs during the final cure.
- 5.4 Begin installation at the bottom of the joint and work upward
- 5.5 Do not excessively push or pull the material as this will cause it to stretch, resulting in possible damage.
- 5.6 Use a blunt putty knife or your hand to compress the opposite side of the material and slide it into the joint.
NOTE: 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.
- 5.7 Silicone coating should be flush with, but not protruding above, the substrate surface.

6. Joints, Sidewall and Finishing Work

- 6.1 Verify that the new piece of material is cut square and not at an angle to the previous piece installed
- 6.2 Apply supplied joint splice adhesive to the butt end of the new piece of material
- 6.3 Do not apply joint splice adhesive to the faces of the product that are in contact with the sidewall adhesive
- 6.4 Make sure seams are flush against each other and then push the pieces together
- 6.5 Butt seam all "T" and "+" intersections with the accessory silicone.
- 6.6 Once the joint is installed, run and tool a 1/4" bead of the supplied accessory silicone along both sides of the face of the joint along the substrate face
- 6.7 Run and tool the supplied accessory silicone over all seams and transitions to allow for a clean, aesthetic finish
- 6.8 Remove any excess adhesive material left on the surface of the material substrate; do not allow the excess adhesives to cure.

920/WACOUST-AI

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

Willseal, A Tremco Affiliate Brand

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