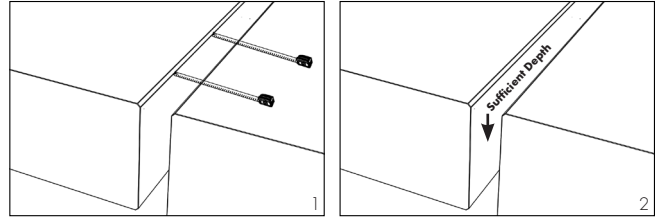


RECOMMENDED TOOLS

Tape Measure • Sharp Knife • Miter Saw • Duct Tape • Mineral Spirits • Clean Cloth
Isopropyl Alcohol • Caulking Tool • Jiffy Mixer • Margin Trowel • 2 Empty, Clean Containers

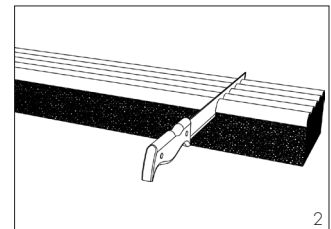
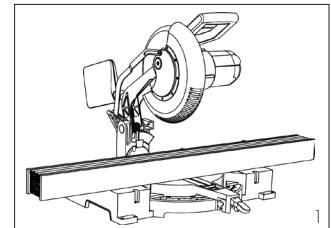
MATERIAL SIZING

- Joints must be sized every 5-7 ft (1.524-2.137 m) to ensure gap opening is uniform (1)
- Allow sufficient depth for material to be recessed 1/8"-1/4" in the joint (2)



MATERIAL PREPARATION

- 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
- Store materials in a dry, enclosed area, making sure materials are off the ground and out of direct sunlight
- 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.
- Use a miter saw to make any cuts to the material before removing the clear shrink packaging, making sure all starting and ending pieces are square to the termination point (1)
- Use a sharp knife to cut the material once the shrink packaging and wooden boards have been removed; apply mineral spirits to the knife for a smoother cut (2)
- In order to prevent expansion past the joint size, install immediately after removing shrink wrap and making final cuts

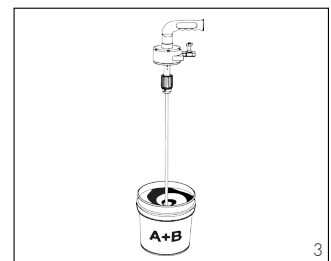
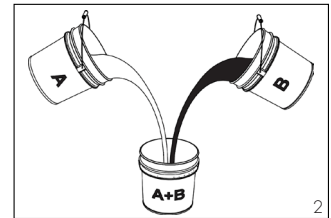
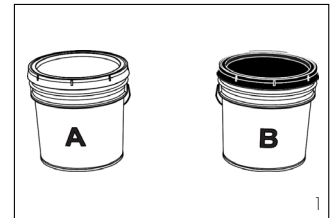


JOINT PREPARATION

- Verify that 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"
- Verify that the joint is uniform and repair any spalls prior to installation
- Apply duct tape to both edges of the substrate face to prevent the epoxy from contacting the deck surface
- Check the material for appropriate length, width, and depth
- Supplied material should be pre-compressed to a size smaller than the intended joint opening
- Joint depth must allow for the installed material to be recessed 1/4" from the substrate surface

EPOXY PREPARATION

- Mix Part A and Part B separately (1)
- Transfer the entire contents of Part A (resin) and then Part B (hardener) into a clean, empty container. Part B must ALWAYS be added to part A, and mixed in a 1:1 ratio (2)
- 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
- Transfer the mixture to another clean container to avoid any leftover residue from streaking the final mixture

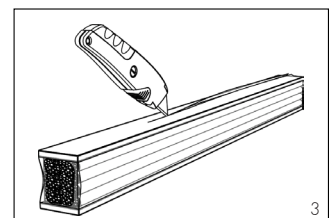
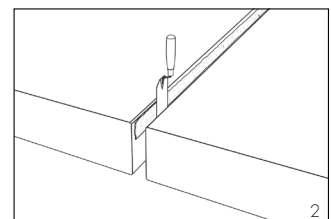
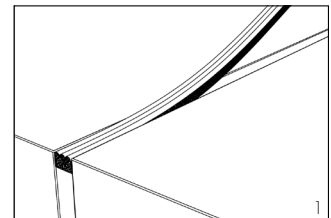


EPOXY TIPS

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

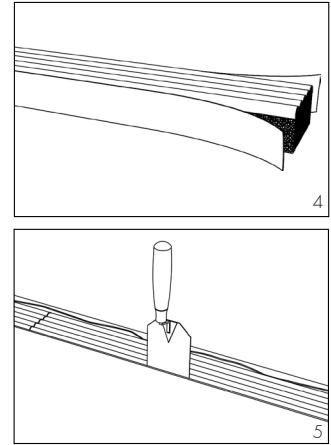
SEALANT INSTALLATION

- Begin installation at one end of the joint and work to the opposite end using butt seams (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 plus 1/2"
- The epoxy must still be wet upon installation of Willseal 250; The working time for epoxy is approximately 30 minutes depending on the temperature (2)
- 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
- Cut the shrink packaging along the edge of the masonite strapping (3)
- Verify that the material is cut square at both ends for proper seams; all pieces must be square to the termination point
- Pay attention to the direction of insertion marked on the packaging
- Be prepared to install the material immediately once the packaging is removed to prevent the material from expanding past the joint width



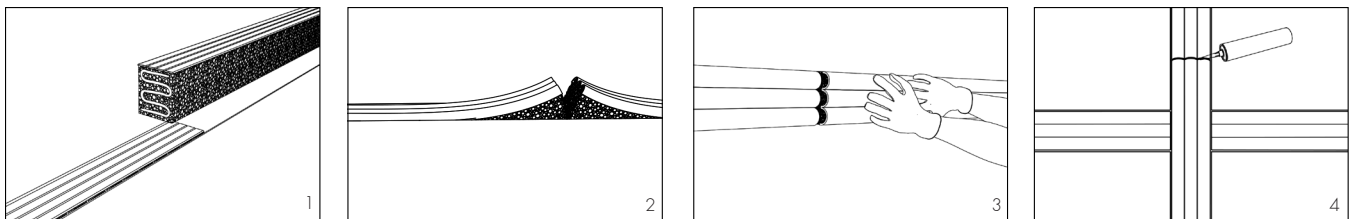
SEALANT INSTALLATION (CONTINUED)

- Remove the release liner on both sides of the Willseal 250 (4)
- Make sure not to pull, twist or stretch the material in the process of installation to avoid tearing the release liner
- Initially, position Willseal 250 1/8" above the deck surface. Once the material is partially expanded in the joint, it can then be installed to 1/4" below the surface of the joint using a putty knife or margin trowel (5)
 - Wedges can be used to aid in installation
 - Remove wedges once the material begins to expand and before the epoxy cures



SEAMS

- Verify that the new piece of material is cut square and not at an angle to the previous piece installed
- Apply flexible seal to the butt end of the new piece of material (1)
 - Do not apply flexible seal to the faces of the product that are in contact with the epoxy
- Overlap extra material (approximately 1/2" - 1") at seams and splices to ensure that the seam is in compression after installation (2)
- Make sure seams are flush against each other and then push the pieces together (3)
- Butt seam all "T" and "+" intersections
 - If there are any mitred joints with a hole or void, use the supplied flexible seal to fill and seal the joint
- Apply flexible seal over seams and intersections (4)
- If crew size permits and two lengths of material can be prepared, the ends to be seamed can be held above the deck surface and the mitred pieces can be pushed down into the joint together



FINISH

- Remove duct tape
- Remove any excess flexible seal or epoxy left on the surface of the material substrate
 - Do not allow the excess flexible seal or epoxy to cure

