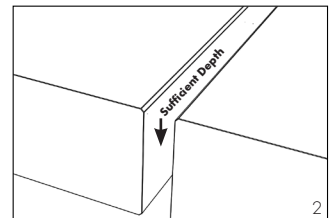
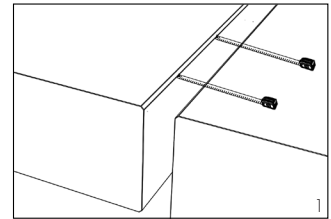


## RECOMMENDED TOOLS

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

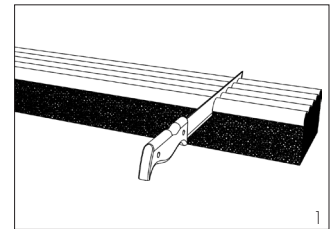
## MATERIAL SIZING

- 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 1/4" 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
- Use a sharp knife to cut the material square. All starting and ending pieces must be square to termination point (1)
- Apply mineral spirits to the knife for a smoother cut
- Refer to the Seams section for further instruction on preparing the material

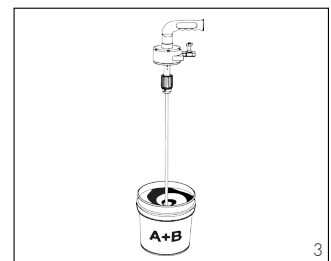
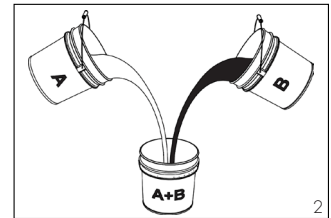
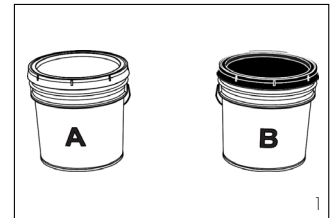


## JOINT PREPARATION

- 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 blue painters tape to both edges of the joint surface to prevent the silicone from contacting the substrate surface
- Check the material for appropriate length, width, and depth
  - Supplied material should be approximately 25% larger but never less than 12% larger 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

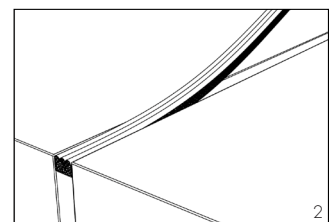
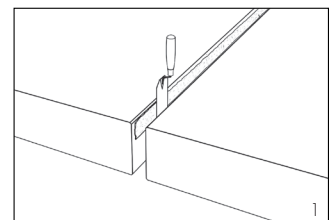


## EPOXY TIPS

- 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

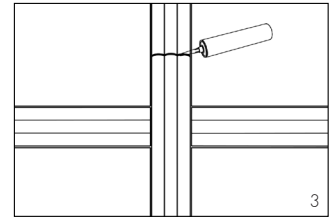
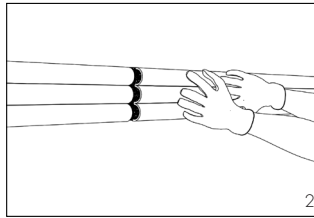
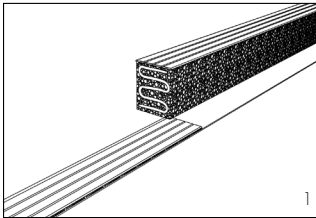
## SEALANT INSTALLATION

- 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" (1)
- Begin installation at one end of the joint and work to the opposite end using butt seams (2)
- The epoxy must still be wet upon installation of Willseal Color Coreséal H; The working time for epoxy is approximately 30 minutes depending on the temperature
- 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
- Verify that the material is cut square at both ends for proper seams; all pieces must be square to the termination point



**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
- Make sure seams are flush against each other and then push the pieces together (2)
- 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 silicone over seams and intersections (3)
- 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**

- Use the supplied silicone to run a bead along each edge of the joint to fill any irregularities in the substrate (optional)
- To ensure an aesthetic finish, verify that the silicone adhesive matches the color on the face of the joint sealant material
- The material does not rely on the external fillet bead to provide a watertight seal
- Evenly spread the silicone on exposed seams to allow for a clean, aesthetic finish
- Remove any excess silicone left on the surface of the material or substrate. Do not allow the silicone to cure before removal
- Remove the blue painters tape from the joint surface