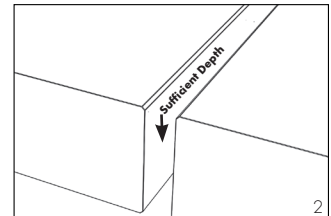
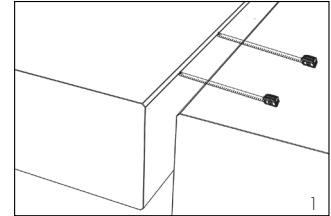


## RECOMMENDED TOOLS

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

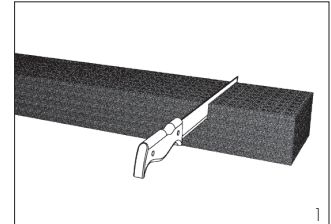
## MATERIAL SIZING

- Joints must be sized every 5-7 ft (1.524-2.137 m) to ensure gap opening is uniform (1)
- Allow sufficient depth for the material to be recessed 1/8"-1/4" into 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
- If necessary, prepare the material for heat seams
- Refer to the Seams section for further instruction on preparing the material

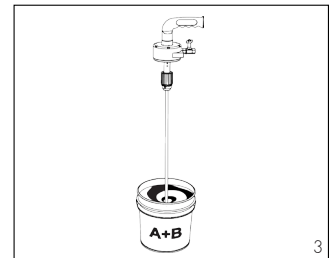
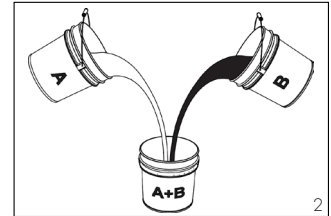
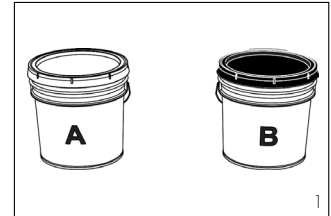


## JOINT PREPARATION

- 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 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 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

- 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

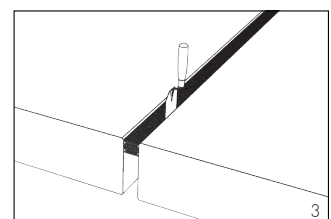
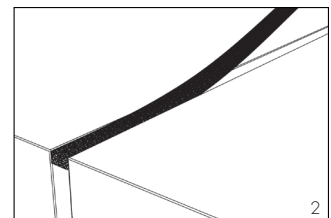
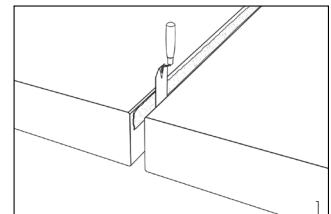


## EPOXY TIPS

- 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

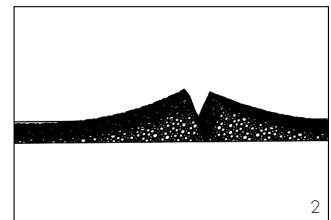
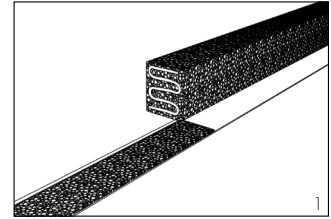
## SEALANT INSTALLATION

- When fully prepared to install, apply a 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." Also, apply a 40mils (1mm) coating of the epoxy adhesive to both sides of the material (1)
- The epoxy must still be wet upon installation; 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 2 hours. After 2 hours, the joint surface must be abraded to eliminate the amine blush that occurs during the final cure
- 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
- Begin installation at one end working to the opposite end using butt seams by inserting one side of the material approximately 1" into the joint (2)
- Verify that the material is cut square at both ends for proper seams. All pieces must be square to the termination point
- Do not excessively push or pull the material, as this will stretch the foam resulting in possible damage
- Use a blunt putty knife or your hands to compress the opposite side of the material and slide it into the joint continuing to compress and work the material into the joint until it is approximately 1/4" recessed from the substrate surface (3)



## SEAMS

- Heat Seams
  - Verify that the new piece of material is cut square and not at an angle to the previous material installed
  - Apply both ends of the seam to the welding iron
  - Once heated sufficiently, remove both ends from the welding iron and press firmly together
  - Allow to cool before mixing the epoxy adhesive
- Flexible Seal
  - Apply flexible seal to the butt end of the new piece of material (1)
  - Overlap extra material (approximately 1/2" - 1") at seams and splices to ensure that the seam is in compression after installation (2)
  - Butt seam all "T" and "+" intersections
  - Tool the supplied Flexible Seal over all seams and transitions using a small caulking tool
  - After installation, if there are any mitered joints with a hole or void, use the supplied Flexible Seal to fill and seal the joint



## FINISH

- Use the applied flexible seal to run a bead along each edge of the joint to fill any irregularities in the substrate
- Remove any excess Flexible Seal or epoxy left of the surface of the material or substrate
- Do not allow the Flexible Seal or epoxy to cure before removal

