

# Installation Instructions

## Joint System: 1100/1150

PLEASE READ ALL INSTRUCTIONS  
BEFORE INSTALLATION

### Recommended Tools

Tape Measure, Sharp Utility Knife, Hand Miter Saw, Duct Tape, Craft Paper, Denatured Alcohol, Muriatic Acid, Clean Rags, Blunt Margin Trowels, Protective Gloves, Heat Welding Tool, landscape tamper -or- floor scraper with foot peg.

### Material Sizing

Measure joints every 5-7 [1.5m-2m] feet to ensure the opening is correct for the supplied material. Recess the material  $1/8"$  -  $1/4"$  [3mm-6mm] in the joint.

### Material Preparation

Store the materials in a dry enclosed area. Keep material off the ground and out of direct sunlight.

Cut the material ends square using a miter box. All starting and ending pieces must be square to the terminating point.

ALL intersections should be pre-formed before mixing epoxy. See fig. 3 for intersection procedures.

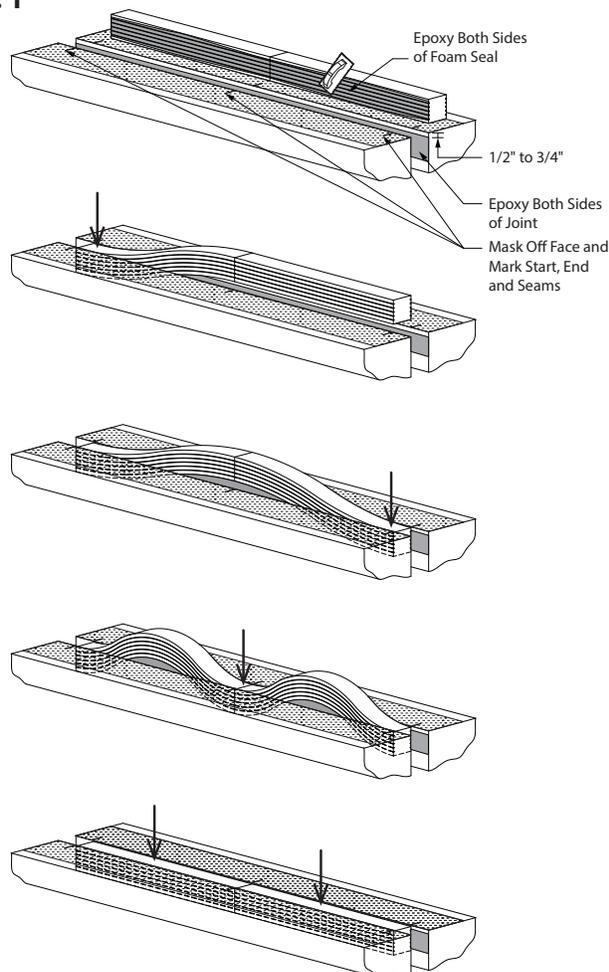
### Joint Preparation

Verify the joint is plumb and free of defects and is an appropriate surface for installation of the joint sealant. Repair spawls and pitting prior to installation. Sand blast both sides of joint as deep as the foam system requires (see details or technical data). Keep the nozzle a max distance of 2" from substrate. Use compressed air to clear any loose debris from the joint. Apply muriatic acid or alcohol to a clean cloth and wipe the joint walls to the depth of 1" [25mm] below the total depth of the seal material.

Before installation begins, apply duct tape and craft paper on both side of the expansion joint to protect the finished surface. This will also reduce clean up time.

Check the material for length, width and depth against you order. Joint depth must allow for the installed material to be recessed  $1/8"$  -  $1/4"$  [3mm-6mm] from the joint face or further depending on the expansion joint's cover plate system.

Fig. 1



### Installation - Fig. 1

1. Begin by laying out the seal next to the joint and marking the tape at the foam seal seams. When installed, the marks and seams should align.

NOTE: Foam can stretch up to 1" [25mm] every 12" [300mm] installed. If installed in a stretched manner, movement capability is dramatically reduced.

2. Mix the supplied 2 part epoxy per the instructions on container. Using a trowel or gloved hand, apply epoxy to BOTH sides of the expansion joint substrate and the grooved sides of the seal.

NOTE: When installing a continuous joint that cannot be finished, the epoxy on the substrate and foam should stop well before the end of the run to allow heat splicing when work continues.

WARNING: Do not allow the epoxy to set before installing the seal. For hot weather installs, keep the epoxy cool in an ice chest and mix the epoxy in smaller batches to increase pot life. For cold weather installs, ensure a minimum temp. of 45°F and rising.

3. To insert the foam into the joint, use a tamp or floor scraper with the blade removed. Any tool that allows you to use your legs and body weight for leverage helps. Choose an acceptable length of product which you can epoxy and install concurrently.

4. Install the beginning of the seal first, then install the end, both at the lines drawn on the tape in step one. Then return to the middle and other seams as pictured in Fig. 1, and continue to insert the rest of the seal into the joint.

WARNING: Use of sharp tools could cause damage to the foam seal material. Be careful not to tear the material in the process of compressing it into the joint.

IPC.929/Rev.8

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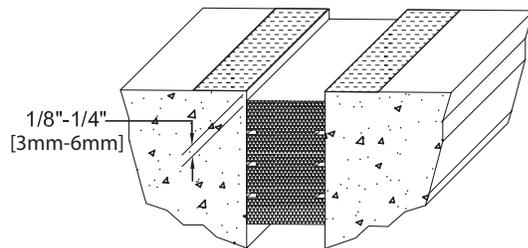
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**Fig. 2**

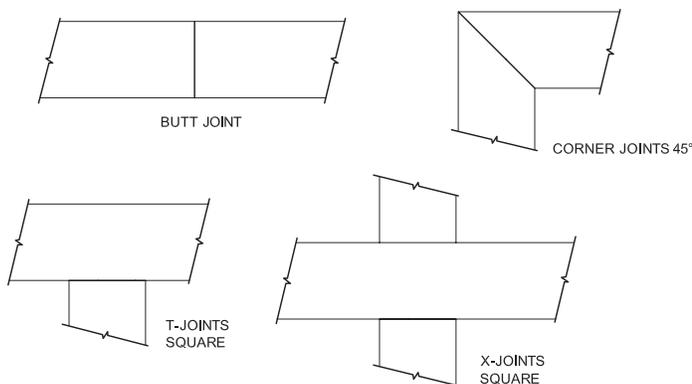


5. Continue to compress and work the material into the joint until the top surface of the seal is positioned appropriately. The standard position is set to  $1/8''-1/4''$  [3-6mm] below from the joint surface. See Fig. 2

NOTE: The Seal may need to be recessed to allow clearance for the expansion joint cover or pitched to provide drainage.

6. Remove the duct tape and craft paper from the joint surface and clean surrounding area. If epoxy has begun to cure, or cured on the finished joint surface clean using xylene and a putty knife as a scraper.

**Fig. 3**



### Epoxy Cure Time:

Gel Time = 20-40 min @ 25°C (77° F)

Initial Set Time = 2-4 hrs @ 25°C (77° F)

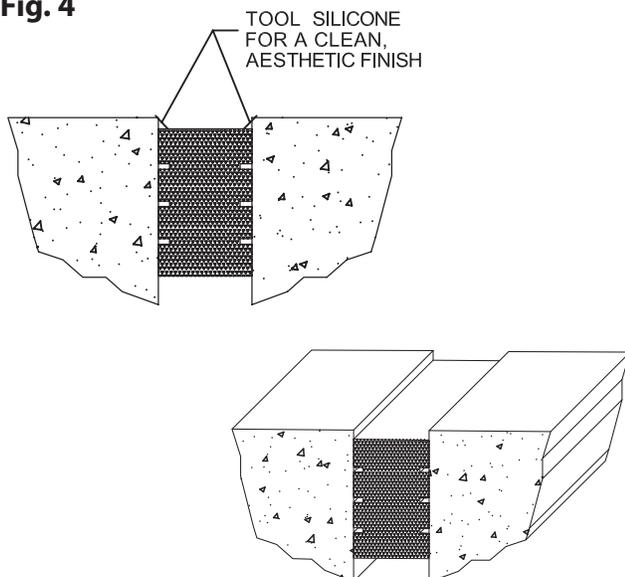
Initial Cure Time = 8-12 hrs @ 25° C (77° F)

Final Cure Time = 3 days

### Seams - Fig. 3

1. Verify that the new piece of material is cut square and not at an angle to the previous material installed.
2. Heat weld transitions using a heat welding tool, or flat iron set at 400°F [204°C]. Once iron is hot touch the foam ends to be joined to opposing faces of the iron for roughly 10 seconds.
3. Remove iron, ensure the material is aligned and immediately press and hold the foam ends together. Hold the ends in place until the splice is thoroughly adhered

**Fig. 4**



### Finish - Fig. 4 (Optional)

1. Use a caulking gun to run an even bead of silicone, installer furnished, along each edge of the joint to fill any irregularities in the substrate and create a clean, aesthetic finish.
2. Remove any excess silicone left on the surface of the material or substrate. DO NOT allow the silicone to cure before removal.

NOTE: Seal does not rely on the external fillet bead to provide a watertight seal.