

# Installation Instructions

## Joint System: 1175

PLEASE READ ALL INSTRUCTIONS  
BEFORE INSTALLATION

### Recommended Tools

Tape Measure, Sharp Knife, Miter Saw, Blue Painters Tape, Mineral Spirits, Isopropyl Alcohol or Acetone, Clean Cloth, Blunt Putty Knife, Caulking Gun, Caulking Trowel

### Material Sizing

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

### Material Preparation

Store the material at a minimum of 68°F for at least 24 hours before the installation, regardless of the temperature at the installation site.

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

Cut the material square using a sharp knife. All starting and ending pieces must be square to the terminating point. Mineral spirits on the blade will provide a smoother cut.

### Joint Preparation

Verify the joint is clean and sound and is an appropriate surface for installation of the joint sealant. Use compressed air to clear any loose debris from the joint. Apply water or alcohol to a clean cloth and wipe the joint walls to the depth of 1" below the sealant material. 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.

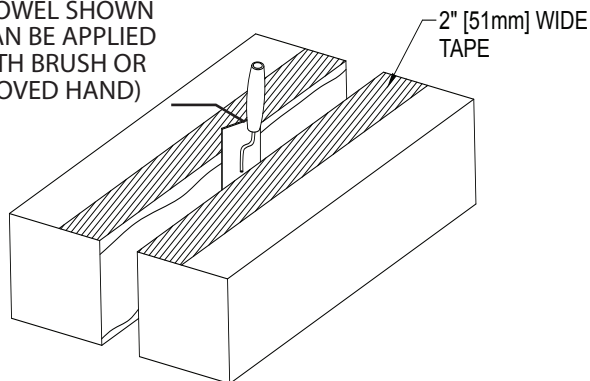
Verify that the joint is uniform. Repair any spalls prior to installation.

Apply blue painters tape to the joint face edges to prevent epoxy from contacting the deck surface.

Check the material for length, width and depth. Joint depth must allow for the installed material to be recessed 1/4" [6mm] from the joint face.

**Fig 1**

TROWEL SHOWN  
(CAN BE APPLIED  
WITH BRUSH OR  
GLOVED HAND)



### Epoxy Installation - See Figs. 1

For horizontal joints, begin installing the material on one end of the joint and work to the opposite end.

1. In a separate container mix the epoxy base and hardener at a 1:1 ratio. Verify mixing instructions as listed on the cans. Mix the material thoroughly with a low speed drill of approximately 300 rpm for 3 minutes. Pot life is 30 minutes. Only mix one kit at a time, and always mix a full kit.

**NOTE:** For every +17°F [9.5°C] epoxy cures twice as fast; while every -17°F [9.5°C] epoxy cure time doubles.

**Warning:** NEVER thin the epoxy.

**NOTE:** Epoxy will harden faster when left in the mixing pot, because of that, apply epoxy to the joint as soon as possible to slow the curing time.

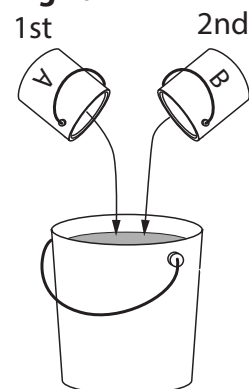
2. Apply a 1/16"-1/8" [1.5mm-3mm] coating of the epoxy mixture to both joint walls with a towel, brush or a gloved hand to a depth of the seal material plus 1/2" [13mm]. The epoxy must still be wet upon installation of the seal.

### Packaging Removal - See Fig. 2

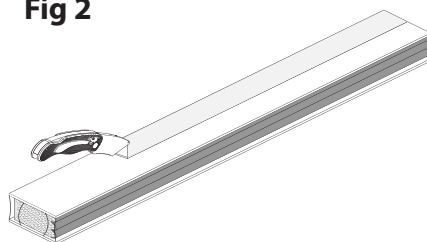
3. Cut the shrink wrap plastic packaging by cutting on the hard board along the length of the stick DO NOT cut along the silicone face. Remove hard board and inner release liner.

4. After cutting the shrink wrap, work quickly to avoid material expanding beyond a usable size.

**Fig 1a**



**Fig 2**



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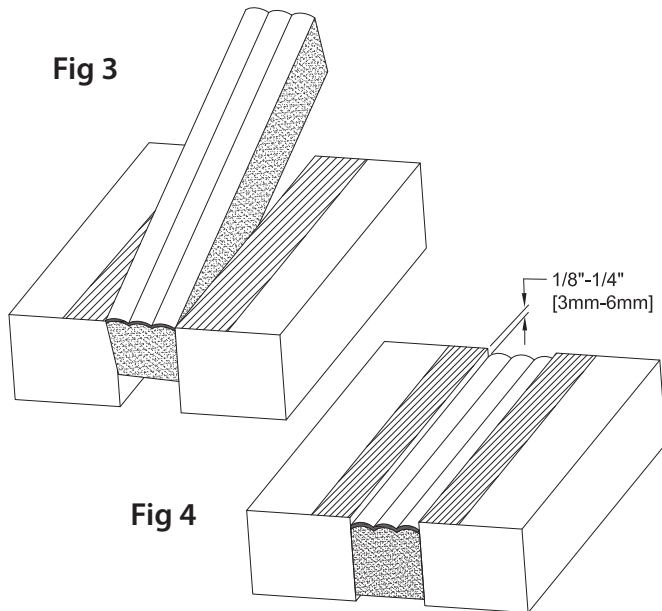
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### Seal Installation - See Figs. 3-4

5. After verifying that the epoxy on the jointing has not cured, install the foam into the joint. For installation of vertical conditions, start from the bottom and work upwards.

6. Starting from one end of the Foam Seal, insert material into the joint opening, ensure the silicone surface of the seal is facing outwards. The material should fit securely and must be installed into the substrate to the fully installed depth of seal. When the material has expanded to a secure fit, it will support itself while the epoxy cures.

7. The Foam must be installed so that the silicone faces is slightly recessed 1/4" [6mm] into the joint. **See Fig. 4**

8. If no further 1175 sticks are required, remove all excess sealant or epoxy left on the joint surface or silicone face, then remove tape from joint surface.

### Seams - See Figs. 5-6

9. Verify that the new piece of material is cut square and not at an angle to the previous material installed.

10. Apply flexible sealant to the butt end of the new piece of material.

11. After the first 1175 stick is installed to the proper depth, run a continuous bead of supplied color matched silicone along the edge of the silicone bellows. **See Fig. 5a**

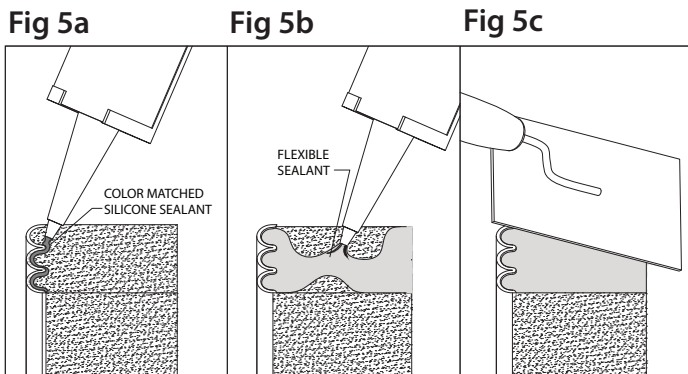
12. Apply the supplied flexible sealant on the end of the installed foam seal, ensuring to completely entomb end in sealant. **See Fig. 5b**

13. Flatten the flexible sealant to an even 1/16th [2mm] thickness. **See Fig. 5c**

14. Overlap extra material (approximately 1/2"-1") at seams and splices to ensure that the seam is in compression after installation. **See Fig. 6**

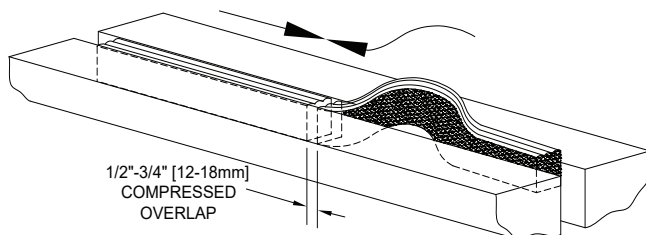
**\*Critical\***: All seams must be in compression with previous seal. Install with 1/2"-3/4" [12-18mm] compressed overlap. **See Fig. 8**

**Note**: Best practice is to lay the next piece flat over the joint, overlapping your previously installed piece, then mark the starting point. Install the far end at the mark and work back towards the previous piece.



NOTE: Joint substrate not shown to aid in clarity only

Fig 6

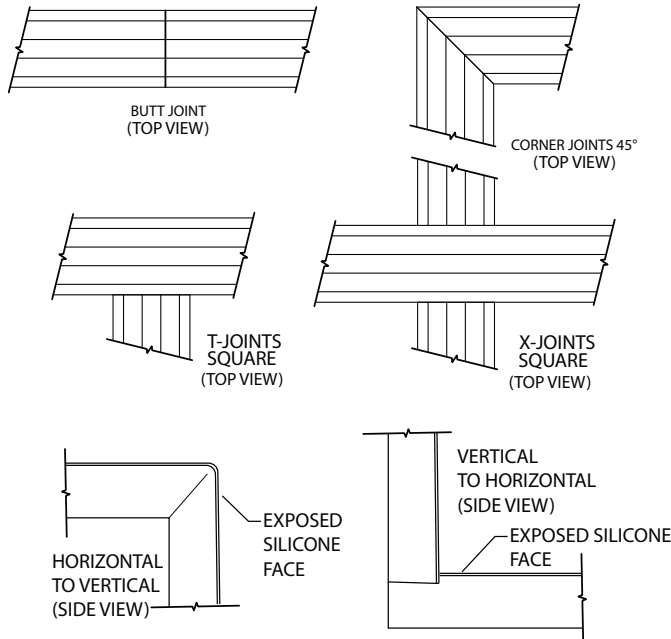


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Fig 7



### Seams - See Figs. 7

**Tip:** Apply mineral spirits to the knife for a smoother cut or heat blade with propane torch for easy cuts.

#### 15. "T" and "+" Intersections:

Install horizontal material first. Butt the vertical material up to the horizontal material following steps 1+2.

**Note:** After installation, if there are any mitered joints with a hole or a void, use the supplied silicone to fill and seal the joint.

16. Use the matching silicone to run a bead along each edge of the joint to fill any irregularities in the substrate.

**Note:** Seal does not require an external fillet bead to provide a watertight seal.

#### 17. Horizontal To Vertical Intersections:

Begin the installation at the horizontal condition. At the point of transition cut a V-notch in the back of the foam seal, making sure not to cut through the face of the seal. Fold foam seal downward, and continue installation.

#### 18. Vertical to Horizontal Intersections:

Starting at one end, cut the silicone face of the horizontal foam seal to create a matching notch for the vertical seal to seat in. Install horizontal seal, then continues installing vertical seal.

### Silicone Instructions - See Fig. 8

19. Install a bead of color matched silicone along the side and butt joints of the Foam Seal. Tool the silicone firmly into groove of the joint substrate and the silicone face to ensure a proper bond and seamless appearance. The silicone bead is only applied to the weather side of the foam.

20. **Important:** When siliconing seams at face seal, ensure bellow profile is carefully followed to allow joint to flex. See Fig. 8b

Fig 8a

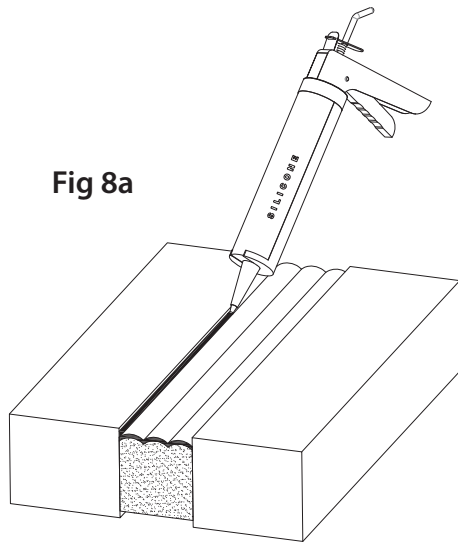
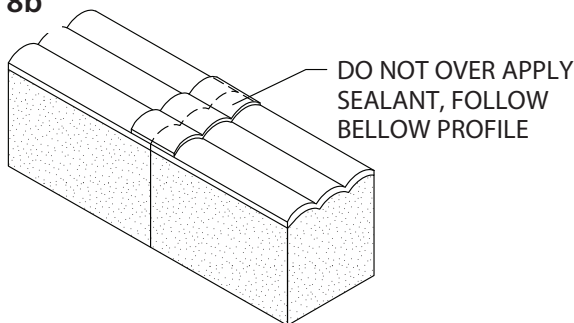


Fig 8b



NOTE: Joint substrate not shown to aid in clarity only

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