

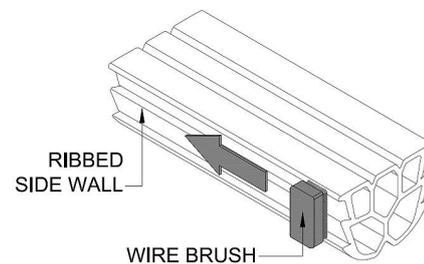
## KDS Series

Seals are delivered in either cardboard boxes or on large wooden cable reels. Store and protect seals from moisture and direct exposure to elements.

1. Read and understand complete method statement.
2. Inspect and repair all spalling / imperfections.
3. The entire length of the joint should be hard, dry, solid, straight, leveled, even, clean, clear and free from dust, dirt, grit, grime and grease.
4. Clean the expansion joint gap and edges of the joint by sand blasting or mechanical grinding. Clean the joint faces using ethanol alcohol.
5. Avoid pulling or stretching the seal during installation. Any stretching more than 3% should not be accepted as the seal will fail prematurely.
6. For large jobs, use installation machine. The machine should install the seal at the specified depth without cutting, ricking or twisting the seal.
7. Manual installing requires extra care against damages, punctures or excess stretching.
8. Select a seal that is wider than the expansion gap. Ideal width of the seal would be the one that will remain compressed of minimum 10% at the time of installation.
9. Read safety data (MSDS) of primer and adhesive before applying.

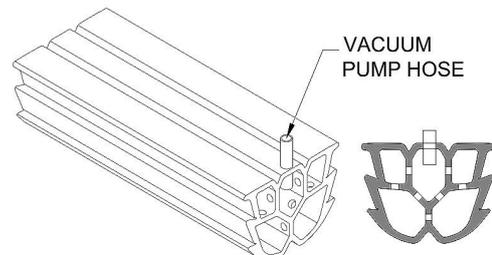
10. Create a rough surface on the ribbed sides of the seal by using a wire brush (see figure 1).
11. Apply primer to ribbed side compression seal walls using a brush and let it dry. (or follow adhesive manufacturer's instructions)

FIG. 1



12. Drill 10 to 25mm (2/5" to 1") holes near the end of compression seal using electric drill in all interior walls excluding outside wall. Make sure that all holes have clear air passage.
13. The top hole must be slightly smaller than the pump hose diameter to maintain tightness when vacuuming (see figure 2).

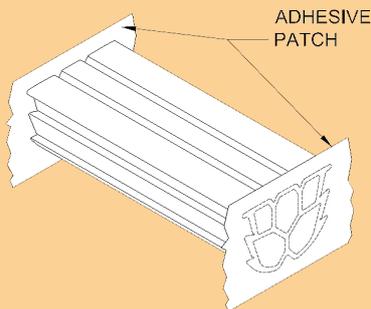
FIG. 2



## KDS Series

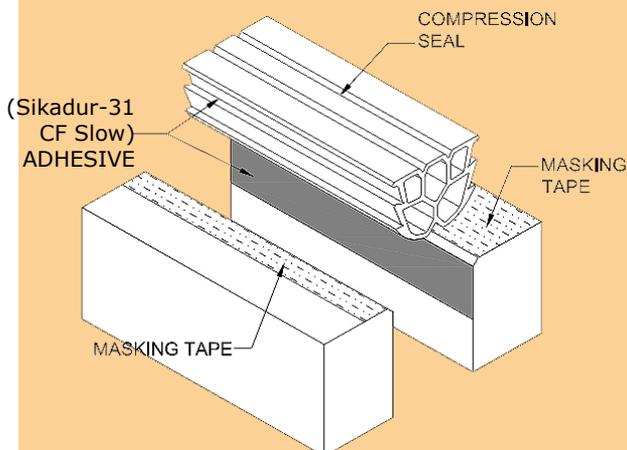
14. Completely cover both ends of the seal with duct tape, temporarily. Make sure the ends of the seal are cut perfectly square to avoid any opening or creases in seal and duct tape (see figure 3).

FIG. 3



15. Cover both the edges of the Structural joint with 2" (51mm) wide masking tape or equivalent to protect edges from adhesive spill over. Apply ( Sikadur -31 CF Slow) adhesive to both substrate walls and ribbed side walls of the compression seal. (see figure 4)

FIG. 4



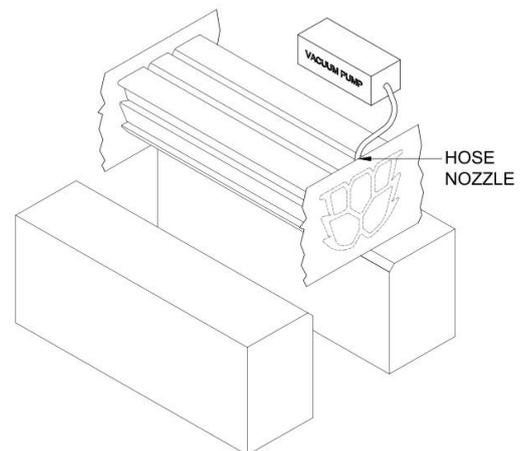
### Installation of Compression Seal without Vacuum Pump.

16. Insert the compression seal slightly recessed into the structural gap starting from one end and working towards the other end.
17. Allow adhesive to cure as specified by adhesive manufacturer.

### Installation of Compression Seal with Vacuum Pump.

18. Apply (Sikadur - 31 CF Slow) adhesive to both substrate walls and ribbed side walls of the seal.
19. Lay loose the compression seal over structural gap, insert vacuum pump hose nozzle into the compression seal and start suction until the seal can be easily pushed into the gap (see figure 5).

FIG. 5



20. After complete installation, immediately clean before the adhesive starts curing, the visible surface of seal and structural gap, make sure adhesive is filled flush to top surface of the seal and slightly recessed on the substrate. Remove all the tapes and clean adhesive off of joint surface.

## KDS Series

**NOTE:**

If installation could not be completed in one session, leave approx. 24" (600mm) of seal and structural gap free of adhesive for next session.

**Transition / Connections / Splicing.**

21. To ensure that the seam is in compression after installation, leave an extra 2/5" – 4/5" (10-20mm) approx. material at seams.
22. Before applying the Splice Sealant use a wire brush (see fig.9) to create a rough surface on the seal at the edge. This will ensure that the seal surface and splice Sealant have a good bond.
23. Install Splice foam or any other locally available backer rods in ends of cell opening at this point.
24. Apply Splice Sealant at both faces to the end of seal (follow manufactured instruction). Place the seal into the joint to align the alignment of corresponding cells, ensure that there is no gap between ends of the seals.
25. For "T" and "X" transition / Intersection, install the horizontal first and joint the vertical up to the horizontal material. (see fig 6-10)

**Recommend Splice Sealer:**

1. Rema Tip Top SC2000
2. Aron Alpha Type 241
3. General Purpose Super Glue

**Recommend for Installation:**

1. (Sikadur - 31 CF Slow)
2. Rema Tip Top SC2000

FIG. 6

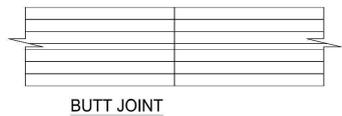


FIG. 7

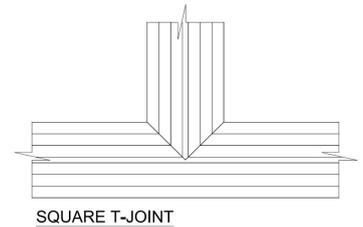


FIG. 8

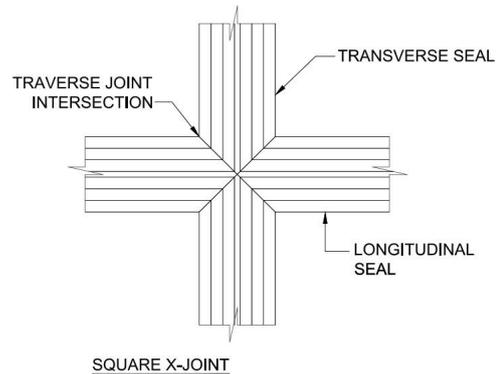


FIG. 9

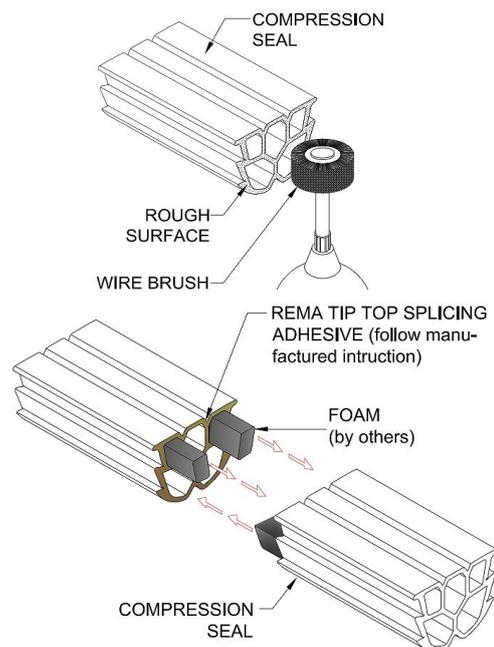


FIG. 10

