
1. PURPOSE

- 1.1 The purpose of this document is to establish typical guidelines for installation of Willseal® PF100. The techniques involved may require modifications to adjust to jobsite conditions. Consult your local Willseal or Tremco Sales Representative or Tremco Technical Services for specific design requirements.
- 1.2 Willseal PF100 is used as an external primary weathertight seal in prefabricated construction applications like modular, panelization, tilt up and other off-site construction methods. It is a market leading solution that delivers easy, safe, rapid, and reliable joint seals. PF100 is designed for use in vertical applications only.

2. SCOPE

- 2.1 This document will provide the necessary instructions for installation of Willseal PF100 to qualify for a manufacturer's warranty.

3. APPROVED SEALANTS

- 3.1 Recommended materials for use with Willseal PF100:
 - a. Spectrem 1
 - b. Spectrem 2
 - c. Spectrem 800
- 3.2 Follow recommended sealant dimension guidelines on sealant manufacturers Data Sheet.

4. AVAILABILITY

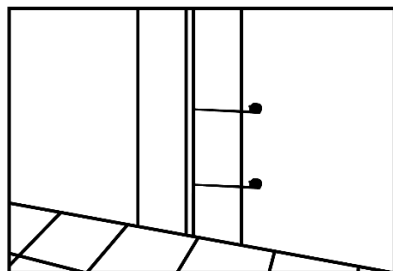
- 4.1 Willseal PF100 is available in joint sizes from ½" to 2" (1.3 to 5 cm) wide in 6.5 ft (1.8 m) stick lengths, from your authorized Tremco distributor, or any Tremco or Willseal Sales Representative. Both pre-notched and prefabricated 4-way connection points are available upon request. For more information contact Customer Service by phone at 800-274-2813 or by email at custserv@willseal.com.

5. STORAGE

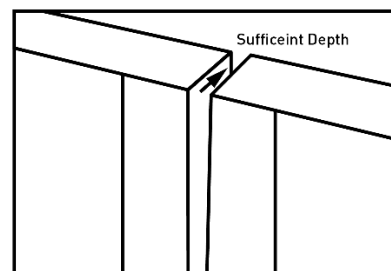
- 5.1 Store materials in a dry, enclosed area, making sure materials are off the ground and out of direct sunlight.
- 5.2 Material will expand faster when hot and slower when cold. In cold temperatures, store material in a heated area 24 hours prior to installation. In hot temperatures, store material out of direct sunlight and not in an enclosed storage container where temperatures may exceed 100 °F (38 °C).

6. MATERIAL SIZING

- 6.1 Joints must be sized every 5 to 7 ft (1.5 to 2.1 m) to ensure gap opening is uniform. See Ref 1.
- 6.2 Allow sufficient depth to recess the foam material a minimum ¼" (3-6 mm) into the joint. See Ref 2.



Ref 1 – Measure gap opening every 5 to 7 ft (1.5 to 2.1 m).



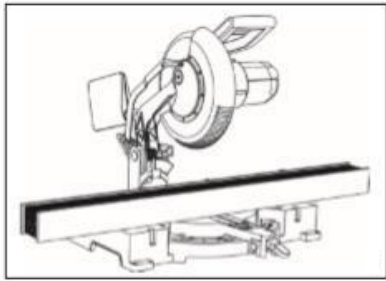
Ref 2 – Ensure depth for ¼ in. foam recess minimum.

7. MATERIAL PREPARATION

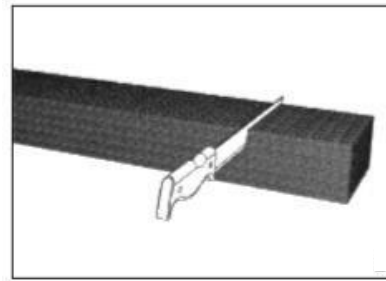
- 7.1 Store material at a minimum of 68 °F (20 °C) for a minimum of 24 hours prior to installation, regardless of temperature at location of installation.

7.2 Cutting Material

- a. Use a miter saw to make any cuts to the material before removing the clear shrink packaging. All starting and ending pieces must be square to the termination point. See Ref 3.
- b. Use a sharp foam knife to make any cuts after the clear shrink packaging has been removed. See Ref 4.



Ref 3 – Measure then cut before removing shrink wrap.



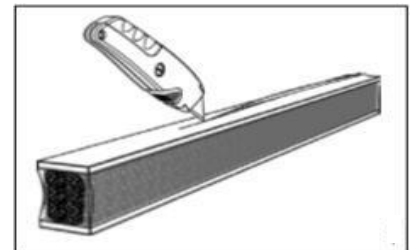
Ref 4 – Cutting with foam knife after shrink wrap removed.

8. SUBSTRATE PREPARATION

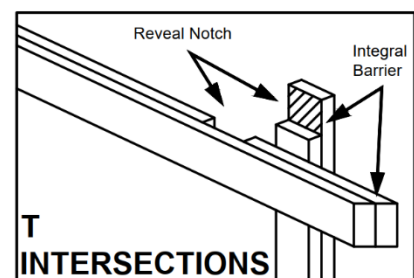
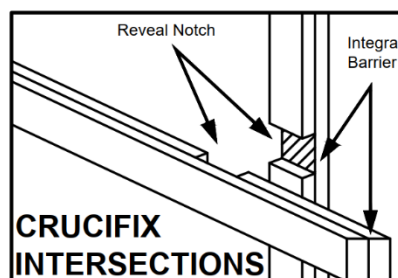
- 8.1 Verify that the joint is clean, sound, and will provide an appropriate surface for installation of the joint sealant.
- 8.2 Use compressed air to clean any loose debris from the joint.
- 8.3 Apply alcohol to a clean cloth and wipe the joint walls to the depth of the sealant material plus 1 inch.
- 8.4 Verify that the joint is uniform and repair any damages or irregularities prior to installation.
- 8.5 Check the material for appropriate length, width, and depth.
- 8.6 Supplied material should be pre-compressed to a size smaller than the intended joint opening.
- 8.7 Joint depth must allow for the installed material to be recessed 1/4" from the substrate surface.

9. APPLICATION PROCEDURE

- 9.1 When fully prepared to install, cut/slit the shrink packaging along the edge of the masonite strapping. See Ref 5.
- 9.2 Be prepared to install material immediately once the packaging is removed to prevent the material from expanding past the joint width.
- 9.3 Material will expand faster when hot and slower when cold. In cold temperatures, store the material in a heated area 24 hours prior to installation. In hot temperatures, store the material out of direct sunlight and not in an enclosed storage container where temperatures may exceed 100 °F (38 °C).
- 9.4 Verify that the material is cut square at both ends for proper seams; all pieces must be square to the termination point.
 - a. For all Crucifix and/or T-Intersection, a reveal notch must be cut to expose the integral barrier, taking care not to damage it. See Ref 6.
 - b. In these areas, the integral barriers of adjacent sticks must be bonded together with the supplied accessory sealant. The silicone splice adhesive must be wet applied at joints and 4-ways over all parts of foam in contact with the other parts of foam, to complete the seal. The splice adhesive must be across the entire adjoining face to ensure proper continuance through splices.



Ref 5 – Removing shrink wrap by carefully slitting shrink wrap along masonite.



Ref 6 – Example of a Crucifix Intersection and T-Intersection.

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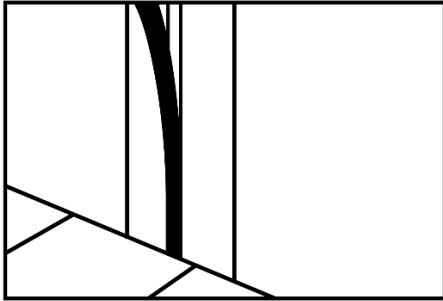
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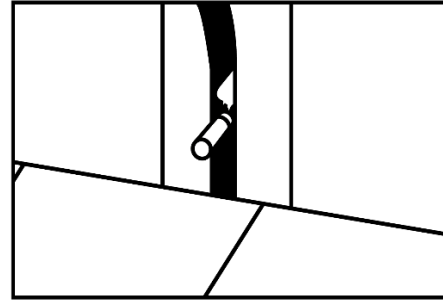
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- 9.5 Remove the release liner from the stick.
- 9.6 For joints that run horizontal, begin installing the material at one side of the joint (either side) and continue to install the material working towards the opposite end. For vertical joints, begin installation at the bottom of the joint and work upward. Sequence will depend on how prefabricated units are being installed. See Ref 7.
- 9.7 The installed sticks will assist in supporting the subsequent sticks until the material fully expands.
- 9.8 Pay attention to the direction of insertion marked on the packaging.



Ref 7 – Begin installation of foam at bottom of joint.



Ref 8 – Use of a dull tool to assist in achieving 1/4" recess.

- 9.9 Recess joint 1/4" from the substrate surface. See Ref 8. Allow 72 hours for full expansion and material equalization. Expansion and equalization rates are affected by temperature. Material will expand faster when hot and slower when cold.

10. MAINTENANCE

- 10.1 Follow Recommended Maintenance Procedures document for vertical applications on tremcosealants.com.

11. LIMITATIONS

- 11.1 Avoid contact of the Willseal PF100 with hydrocarbon solvents and corrosive chemicals. Willseal PF100 cannot be used as a primary seal where standing or ponding water will occur. Do not apply to damp, contaminated, or frost covered surfaces. Single wall applications must be installed within 30 minutes. Contact your local Tremco or Willseal Technical Sales Representative for questions.

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