

# Sealtite 50N

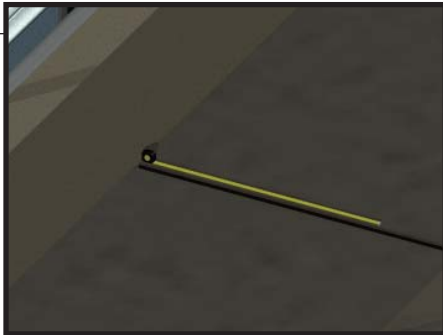
## Installation Instructions

### Recommended Tools

Tape Measure / Sharp Knife / Miter Saw / Duct Tape / Mineral Spirits / Clean Cloth / Isopropyl Alcohol / Caulking Tool / Jiffy Mixer / Margin Trowel  
2 Empty, Clean Containers

### Material Sizing

1. Joints must be sized every 5-7 feet (1.524-2.137 meters) to ensure gap opening is uniform and depth is sufficient for the supplied material.



**Note:**

Allow sufficient depth for the material to be recessed 1/8"-1/4" in the joint.

### Material Preparation

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.

**Tip:**

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.

2. Store materials in a dry, enclosed area. Make sure materials are off the ground and out of direct sunlight.

**Note:**

Refer to the **SEAMS** section for further instruction on preparing the material for proper seam installation.

3. Use a miter saw to make any cuts to the Sealtite 50N™ before removing the clear shrink packaging. All starting and ending pieces must be square to the termination point.



**Warning:**

Install the material directly after removing the shrink packaging to ensure the material does not expand past the joint opening.

**Tip:**

Apply mineral spirits to the knife for a smoother cut.

4. Use a sharp knife to make any cuts after the clear shrink packaging and wooden boards have been removed.

Important: These instructions are intended as recommended guidelines. Due to the variability of field conditions, selection of the proper material for the intended application and installation are the sole responsibility of the applicator. The manufacturer's published installation procedures shall be followed at all times.

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### Joint Preparation

1. 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".
2. Verify that the joint is uniform and repair any spalls prior to installation.
3. Apply duct tape to both edges of the substrate face to prevent the epoxy from contacting the deck surface.
4. Check the material for appropriate length, width, and depth.
  - Supplied material should be pre-compressed to a size smaller than the intended joint opening.
  - Joint depth must allow for the installed material to be recessed 1/4" from the substrate surface.

### Epoxy Preparation

1. Mix Part A and Part B separately.
2. Transfer the entire contents of Part A (resin) and then Part B (hardener) into a clean, empty container. 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.
4. Transfer the mixture to another clean container to avoid any leftover residue from streaking the final mixture.

**Warning:**  
Part B must **ALWAYS** be added to part A, and mixed in a 1:1 ratio.

**Tip:**  
Mix only the required amount of epoxy that will be used within a 30 minute timeframe to prevent the epoxy from curing prematurely.

### 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.

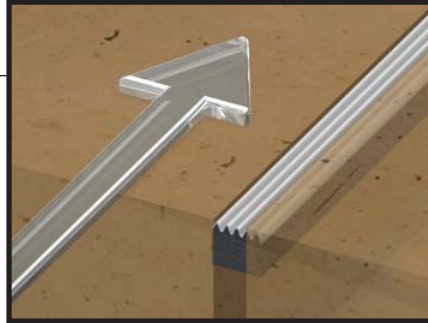
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### Sealant Installation

1. Begin installation at one end of the joint and work to the opposite end using butt seams.



2. When fully prepared to install, apply a 1/16" - 1/8" coating of the epoxy mixture to both joint walls using a 1" margin trowel to a depth of the sealant material plus 1/2".

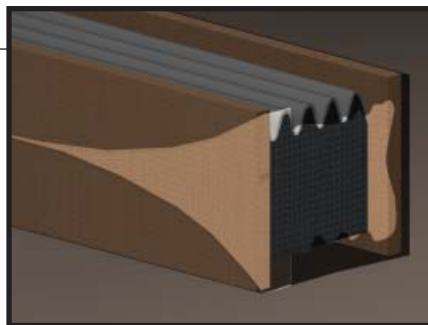
- The epoxy must still be wet upon installation of Sealtite™ 50N; The working time for epoxy is approximately 30 minutes depending on the temperature.
- If the epoxy hardens on the surface of the substrate before installation, another coat of epoxy can be applied within 8 hours. After 8 hours, the substrate surface must be abraded to eliminate the amine blush that occurs during the final cure.



**Warning:**

Pay attention to the direction of insertion marked on the packaging.

3. Cut the shrink packaging along the edge of the masonite strapping.



**Warning:**

Be prepared to install the material immediately once the packaging is removed to prevent the material from expanding past the joint width.

**Note:**

Refer to the **SEAMS** section for further instruction.

4. Verify that the material is cut square at both ends for proper seams. All pieces must be square to the termination point.

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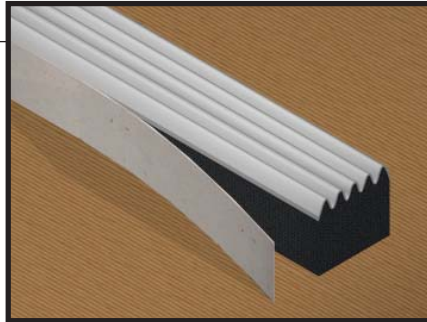
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## Installation Instructions

### Sealant Installation

5. Remove the white release liner on both sides of the Sealtite™ 50N.

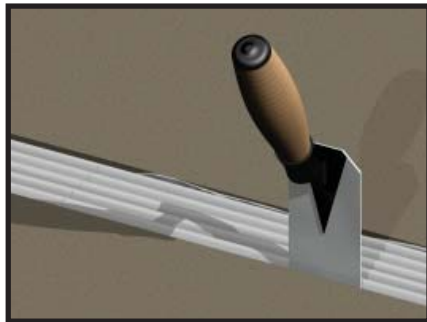
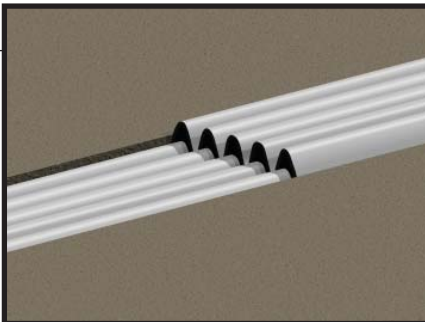


**Warning:**

Make sure not to pull, twist, or stretch the material in the process of installation to avoid tearing the white release liner.

6. Initially, position Sealtite™ 50N 1/8" above the deck surface. Once the material is partially expanded in the joint, it can then be installed to 1/4" below the surface of the joint using a putty knife or margin trowel.

- Wedges can be used to aid installation. **Remove** the wedges once the material begins to expand and before the epoxy cures.



### Seams

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

**Warning:**

Do not apply flexible seal to the faces of Sealtite™ 50N that are in contact with epoxy.

2. Apply flexible seal to the butt end of the new piece of material.

**Tip:**

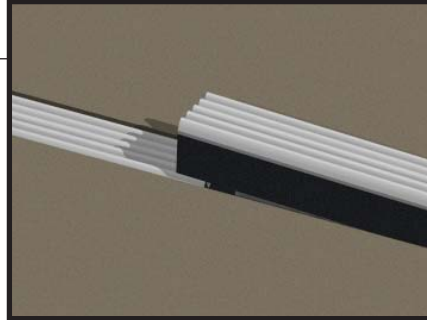
If crew size permits and two lengths of material can be prepared, the ends to be seamed can be held above the deck surface and the mitered pieces can be pushed down into the joint together.

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### Seams (continued)

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



4. Butt seam all "T" and "+" intersections

**Note:**

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

1. Remove any excess flexible seal or epoxy left on the surface of the material or substrate.
2. Remove the duct tape from the joint surface.

**Warning:**

Do not allow the flexible seal or epoxy to cure before removal.

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