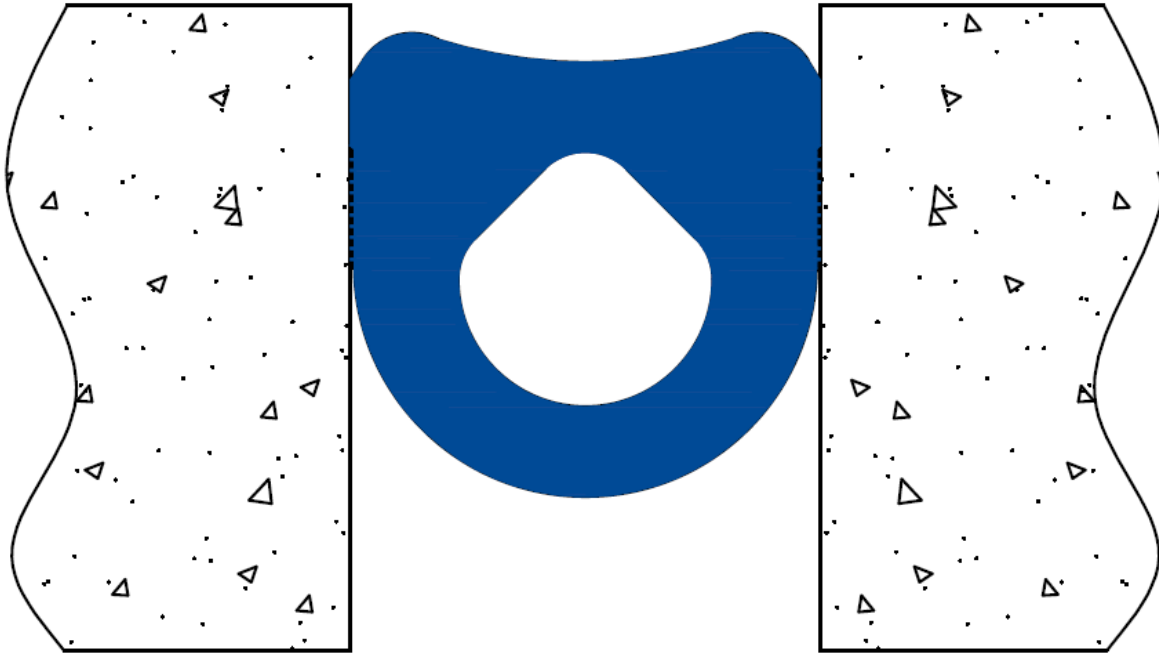


# Installation Procedure

Last Updated: December 2018



## Wabo®InverSeal IV-100 thru IV-400

Preformed, Flexible Closed-cell Neoprene Joint Seal

The following installation procedure is very important and must be fully understood prior to beginning any work. To ensure proper installation and performance of expansion joint system the following actions must be completed by the installing contractor. Failure to do so will affect product warranty.

- 1) Carefully read and understand installation procedure. Contact WBA's Technical Service Department at (800) 677-4922 for product assistance.
- 2) Inspect all shipments and materials for missing or damaged components and hardware. Contact Customer Service at (800) 677-4922 with WBA's order number and invoice for prompt assistance.
- 3) Inspect substrate or adjacent construction for acceptance before beginning work. Report unacceptable construction to the project manager for scheduled repair work.
- 4) Review WBA shop drawings for project specific detailed information if Engineering services were purchased at time of order.

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## Health & Safety

During the installation of any Watson Bowman Acme product, appropriate personal protective items should be worn at all times, including but not limited to the following:

- Proper work clothing
- Safety glasses
- Safety boots
- Gloves
- Hard hat



Local rules and regulations regarding safe work environments and health should be followed.

## Product Components

The following components are required for the installation of this product:



Wabo® Paste Adhesive Package  
(P/N – 2800J)



Wabo® Conditioning Agent  
(P/N – 2802J)

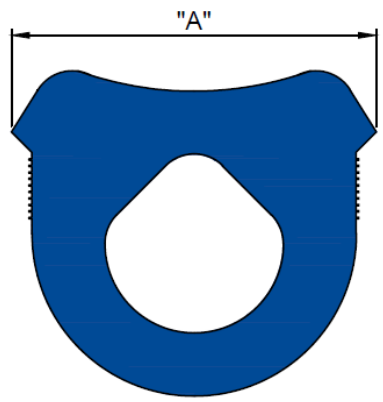


\*Aron Alpha 241 Glue  
(P/N – 2876J)



Wabo® Concrete Cleaner  
(P/N – 2731J)

\*Optional components for splice procedures. Place order for required quantities.



Model	"A"	P/n
IV-100	1.125"	20510
IV-150	1.688"	20515
IV-200	2.25"	20520
IV-250	2.814"	20525
IV-300	3.376"	20530
IV-400	4.50"	20540

Inverseal  
(Refer to Chart for Size and P/N)

## Pre-Installation Notes

### Concrete:

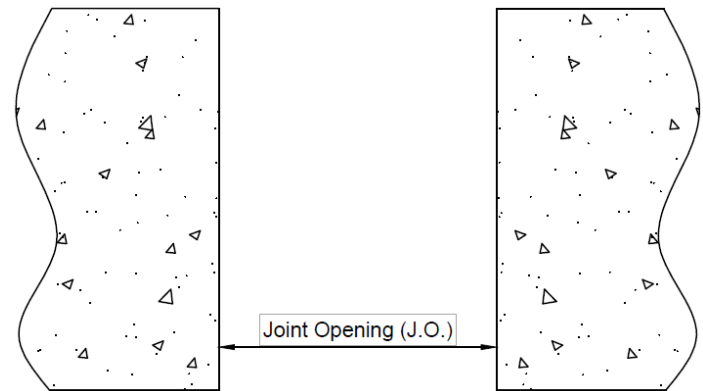
Before installing Wabo®InverSeal, you must check joint openings for sound, clean and dry substrates. To prepare the concrete, you can abrasive blast the joint opening. Where abrasive blasting is not permitted, you can disc grind the opening, taking care to ensure a coarse disc is used to produce an abraded surface. Any loose portions of concrete at the gap must be removed and the concrete must be properly repaired as directed by the engineer.

### Steel:

Before installing Wabo®InverSeal in steel frames, the surfaces must be abrasive blasted immediately prior to installing "IV-XXX." All oxidation must be removed and "White Steel" revealed. When abrasive blasting is not permitted, steel surfaces will be aggressively disc ground to roughen and abrade the surface to achieve the "White Steel" condition.

- Stainless Steel - Requires aggressive grinding and blasting to remove the smooth, glassy surface for acceptable installations.
- Galvanized - The galvanizing material must be removed to look like "White Steel".

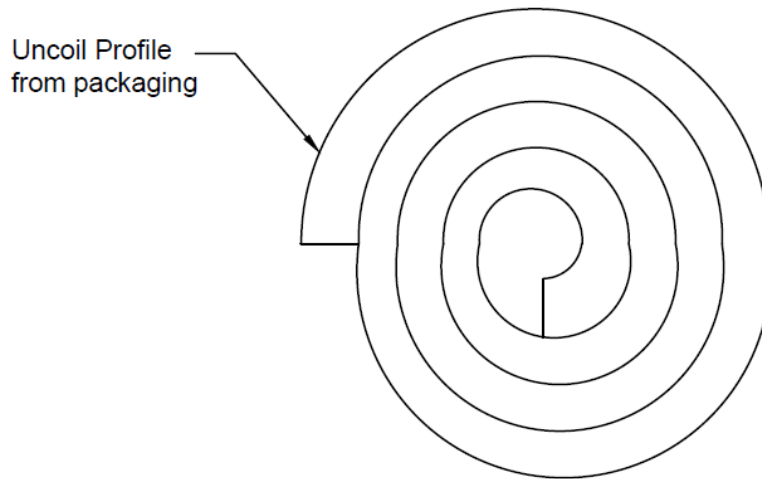
Before installing the seal, the opening shall be blown out with clean air to remove any dust accumulation. In steel applications, you must install the "IV-XXX" seal into the opening to avoid oxidation of the steel surface.



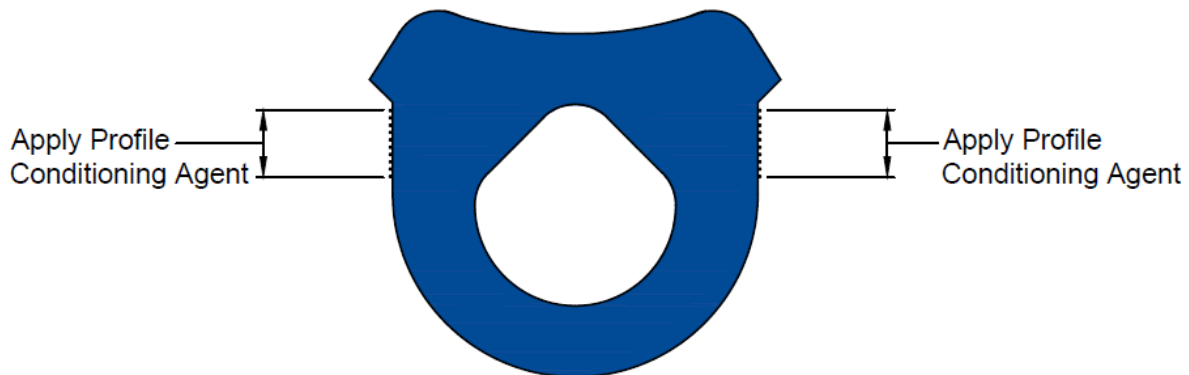
## Installation

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- 1** Prior to installation, you should uncoil the product from shipment packaging and allow it to reach a relaxed state. Once the profile is at its relaxed state, it may be cut to its correct length for installation. When cutting profile to its full length, **MAKE SURE** not to exert any tension on the profile.

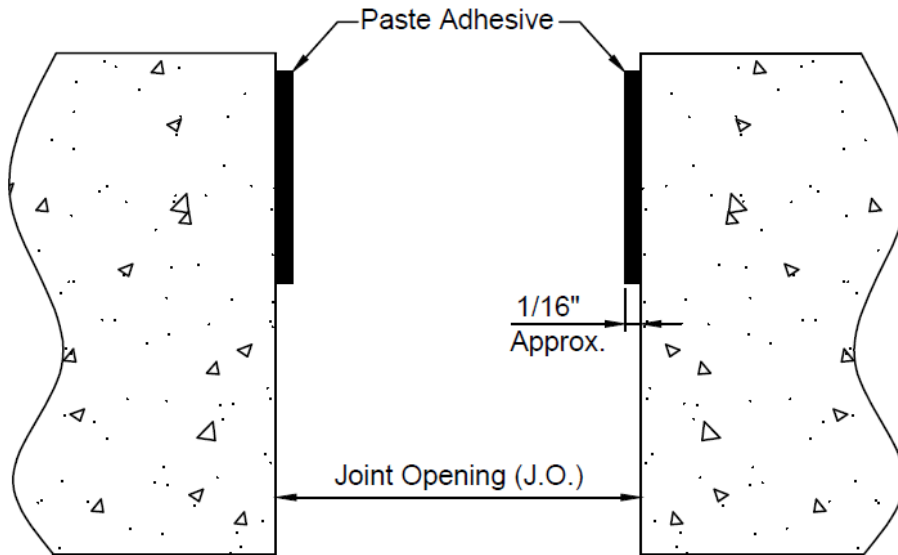


- 2** With a clean rag, the serrated sidewalls should be cleaned with the Wabo® Conditioning Agent supplied. This is to ensure a good clean surface for the adhesive to bond to.

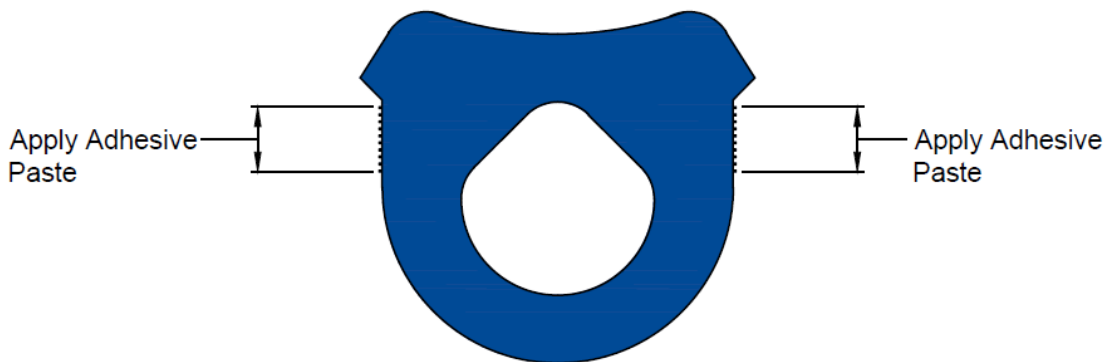


- 3** Mix the two-component epoxy together until there is a uniform color.

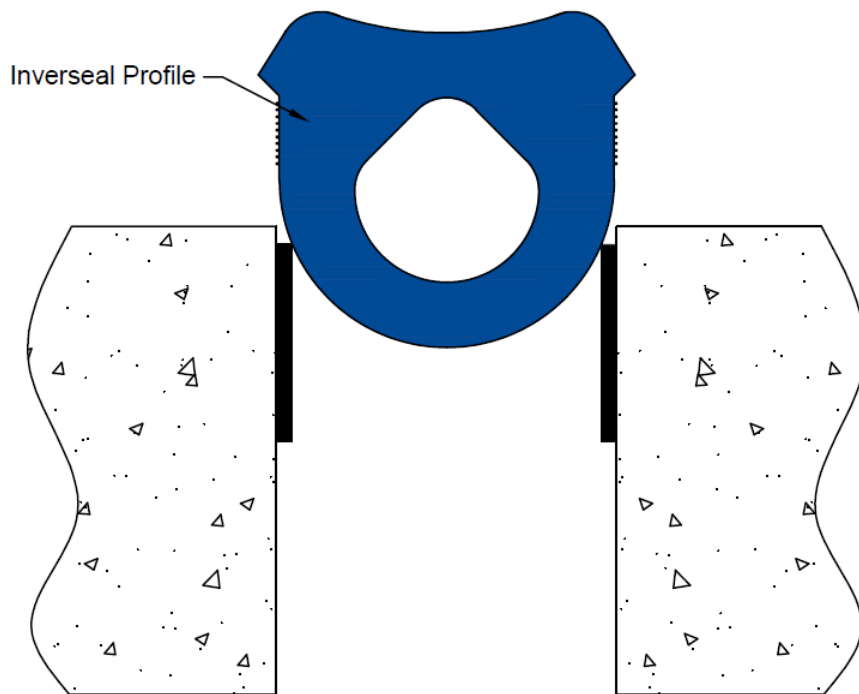
- 4** Once the adhesive is mixed together, take a clean putty knife and apply adhesive to the inside of the joint opening only where the serrated portion of the seal will be in contact with the joint opening. This is done to ensure that you can get the maximum amount of travel out of the seal.



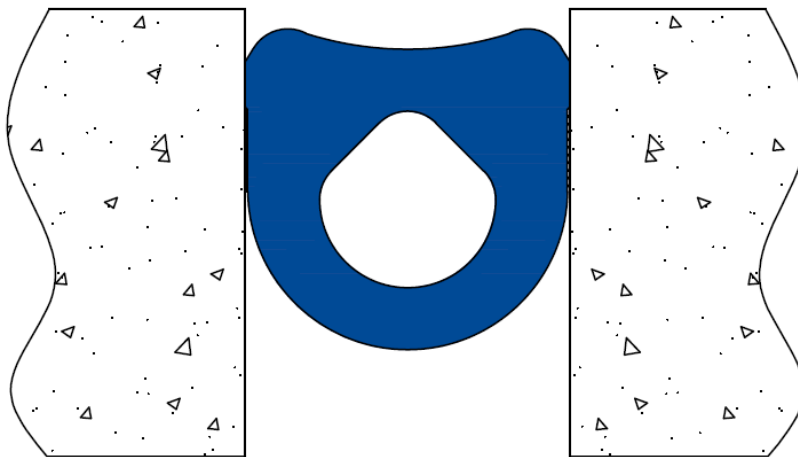
- 4A** Once the adhesive has been applied to the inside of the joint opening, apply adhesive only to the serrated portion of the seal. This ensures you can get the maximum amount of travel out of the seal.



- 5** Once adhesive is on the seal, insert seal into joint opening to the correct depth as stated on detailed drawings.

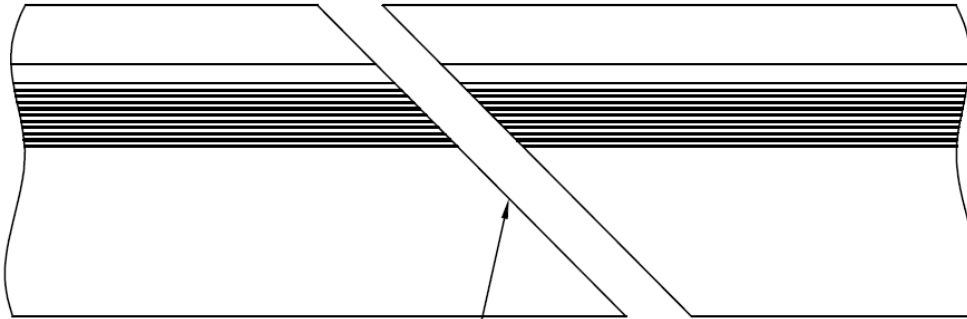


- 6** After the seal has been installed, remove excess adhesive from top of Wabo®InverSeal using a clean rag dampened with Wabo®Concrete Cleaner.



## Suggested Butt Splice Procedure

1. Cut ends of seal with a sharp knife and miter box at a 45° angle. Ensure that cuts are clean and straight.
2. Apply Aron Alpha 241 glue to both seal ends to be joined.
3. Applying pressure, bringing the two surfaces into tight contact immediately after adhesive is applied. Hold in place for one to two minutes for initial bond.
4. Recheck quality of all splices/miters and apply glue as required.
5. To achieve proper working strength, handle with care as it takes 24 hours for glue to fully cure.



Surface to be spliced.  
Note: Make sure that profiles  
match to ensure good adhesion.



\*Aron Alpha 241 Glue  
(P/N – 2876J)

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