

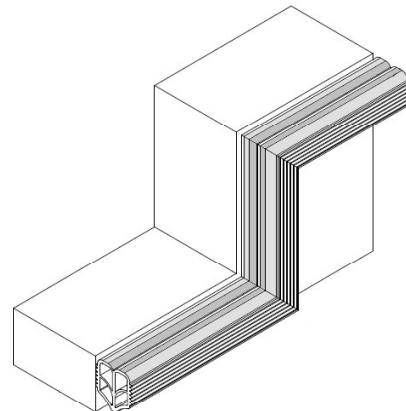
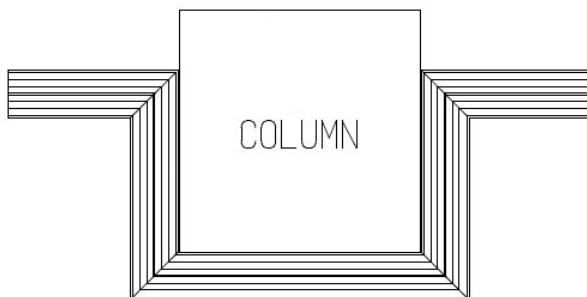
FIELD SPLICE PROCEDURE J AND JP-SERIES SEALS

I) Butt Splice Process

- 1) Use a miter box saw with the teeth edge of the saw ground off to a razor edge.
- 2) When cutting the profile with the modified box saw, slow forward strokes should be made so as to eliminate any distortion of the rubber profile during the cutting process. The use of a spray bottle, filled with water, will provide continuous lubrication during the cutting process. NEVER use oils or other lubricants on the seal.
- 3) After cuts are complete, dry fit ends for alignment. Inspect the cut ends for proper fit. There shall be a hairline fit between the two cuts. If there are voids between the two seals to be mated, use a hand or belt grinder to grind the mating ends flat and flush. Clean off all dust and contaminants from the end of the seal.
- 4) Apply a thin layer of profile glue to one of the seal ends to be spliced. Press together firmly and align the two profiles of the mating seals. Hold the seal splice in position for sixty seconds. After the seal is spliced, inspect the connection closely. Look for any gaps or suspect areas. If necessary, apply a light bead to the area in question. Allow the glued splice to dry, and then proceed with the installation as usual.

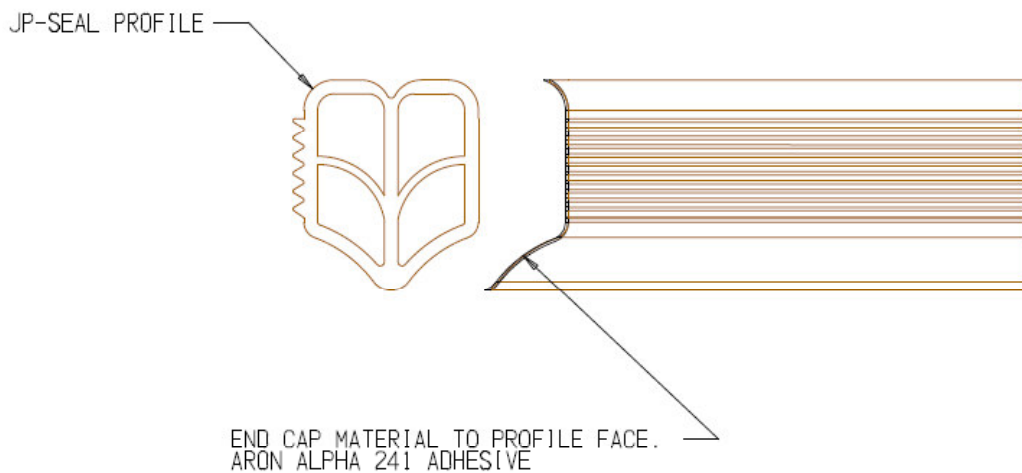
II) Intersections at 90° turns

- 1) For 90° vertical or horizontal direction changes, miter-mating seal ends to half the desired total angle of change desired. For 90° up turns, bevel cut mating 45° angle cuts to each seal end.
- 2) After cuts are complete, dry fit ends for alignment. Inspect the cut ends for proper fit; there shall be a hairline fit between two cuts. Check for desired angle. If there are voids between the two seals to be mated, use a hand or belt grinder to grind the mating ends flat and flush. Clean off all dust and contaminants from the end of the seal.
- 3) Apply a thin layer of profile glue to one of the seal ends to be spliced. Press together firmly and align the two profiles of the mating seals. Hold the seal splice in position for sixty seconds. After the seal is spliced, inspect the connection closely. Look for any gaps or suspect areas. If necessary, apply a light bead to the area in question. Allow the glued splice to dry, and then proceed with the installation as usual.

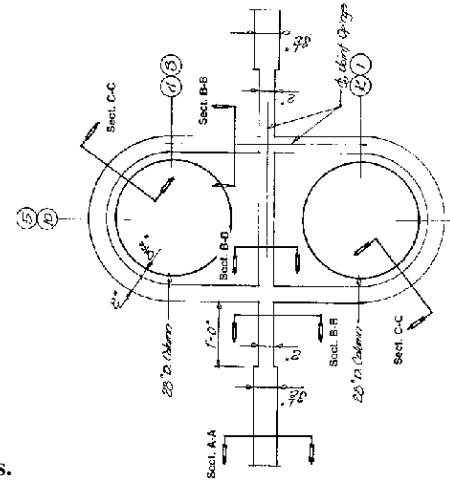
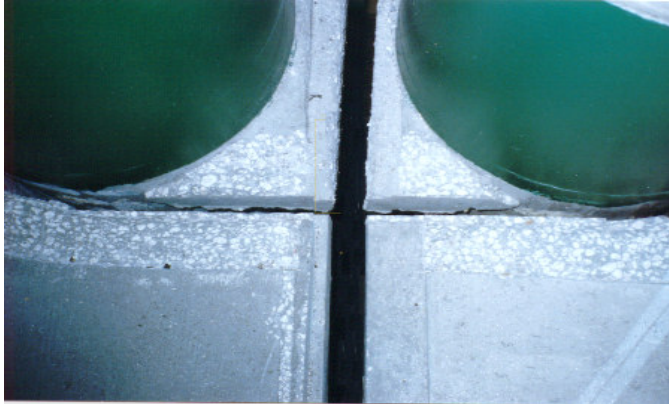


III) Tee Connection Treatment at Intersection

- 1) Tee connections at intersections require no mitering of mating seal ends. The primary joint line will pass through the intersection. The side of the seal at the intersection must have the side ridges ground flush with the root depth of the sidewall of the seal. The width and depth of the grind is determined by the size and width of the secondary seal at the intersection.



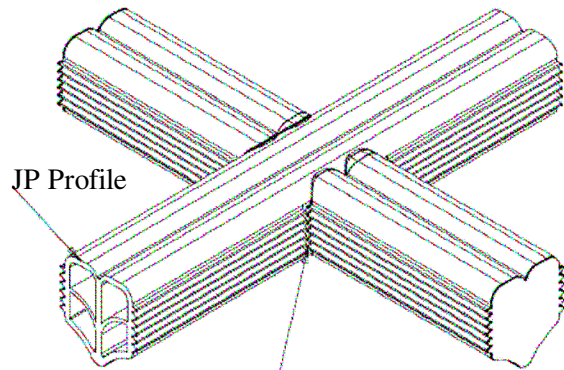
- 2) Prepare the secondary seal ends to glue onto the sidewall of the primary seal. A contour cut on the end of the secondary seal should exactly match the side of the primary seal.
- 3) After the cuts are complete, dry fit the ends to the side of the primary seal to check for alignment. Inspect the cut ends for proper fit; there will be a hairline fit between two cuts. If there are voids between the two seals to be mated, use a hand or belt grinder to grind the mating ends to the desired contour. Clean off all dust and contaminants from the end of the seal.
- 4) Apply a thin layer of profile glue to the end of the seal to be spliced. Press the end cap material firmly against the contoured profile. Hold the seal splice in position for sixty seconds. After the end cap is glued, inspect the connection closely. Look for any gaps or suspect areas. If necessary, apply a light bead to the area in question. Allow the glued splice to dry, and then proceed with the installation as usual.



In this detail, separate joint lines intersect at the base of two circular columns. The major joint line dissects the floor between the columns. The smaller joint profile isolates the deck from the columns and splices back into the main joint line on the other side. This splice procedure was employed to make these transitions work as the engineer had designed.

IV) Cross and Irregular Intersections

- 1) Cross connection intersections require no mitering of mating seal ends. The primary joint line will pass through the intersection. The sides of the seal at the intersection must have the side ridges ground flush with the root depth of the sidewall of the seal. The width and depth of the grind is determined by the size and width of the secondary seal at the intersection.
- 2) Prepare the secondary seal section ends to glue onto the sidewall of the primary seal. A contour cut on the ends of the secondary seals shall exactly match the side of the primary seal.
- 3) After the cuts are complete, dry fit the ends to both sides of the primary seal to check for alignment. Inspect the cut ends for proper fit; there will be a hairline fit between two cuts. If there are voids between the two seals to be mated, use a hand or belt grinder to grind the mating ends to the desired contour. Clean off all dust and contaminants from the end of the seal.
- 4) Apply a thin layer of profile glue to the end of one of the seals to be spliced. Press the end cap material firmly against the contoured profile, and hold the seal splice in position for sixty seconds. After the end cap is glued, inspect the connection closely, looking for any gaps or suspect areas. If necessary, apply a light bead of glue to the area in question. Allow the glued spliced to dry, and then repeat the process for the other side of the T-intersection.



Seal contour fit at connection



The contour fit at cross intersection. Note, the absence of the side ridges on the primary seal to assure a tight flat contact.

V) **Equipment List:**

- 1) Miter box saw with the teeth edge ground off to create a razor-sharp cutting edge
- 2) 4" hand grinder with abrasive wheel
- 3) Stiff nylon brush
- 4) Clean cloth rags
- 5) Neoprene end cap material 1/8" thick
- 6) A pair of scissors to cut neoprene sheet
- 7) Profile adhesive
- 8) Combination square
- 9) Spray water bottle for lubricant
- 10) Miter box
- 11) Safety glasses