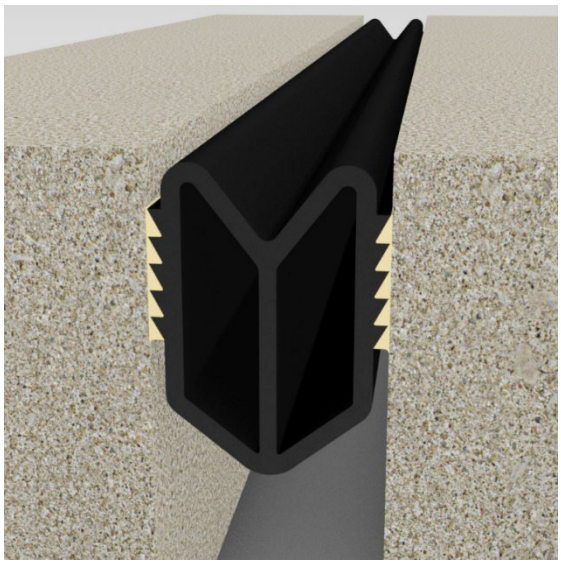
Installation Procedure

Last Updated: August 2025



Jeene®

Multi-Directional Structural Sealing Joint System

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:

Aron Alpha 241 Adhesive
P/n: 2803J

Profile Conditioning Agent

End Cap Material
P/n: 2803J

Concrete Cleaner
P/n: 2731J

Air Valve Material
P/n: 2804J

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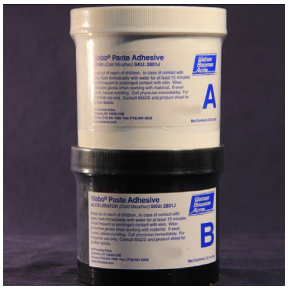
Warm Weather Adhesive
P/n: 2800J



Cold Weather Adhesive
P/n: 2801J

Installer's note: We offer Wabo Paste adhesives for Cold Weather and Warm Weather An optional gel adhesive is available upon request. Choose your adhesive based on the installation conditions. Consult your shipping documents for proper listings and requirements.

Recommended Equipment

WBA recommends the following equipment for an easy and successful installation:

- Sandblasting Equipment
- 1 - 3/8" Hand Drill (For Mixing Epoxy)
- 1 - Small Jiffy mixing paddle
- 1 - Wire wheel for 1/2" Drill (Or wire brush)
- Several 2" Margin Trowels and putty knives
- 1 - Box of Clean white non-colored cotton rags
- 4 - Clean 1 gal. plastic buckets
- 2 - Nylon bristle scrub brushes
- Dremel Tool with accessories and 1/8" drill bit
- Solvent for tool clean up (denatured alcohol)
- 1 – 16D nail for every air valve
- Compressor/Vacuum Pump (Grainger Model: 4Z024)
- 1 - Roll of Clear plastic sheeting
- Several pairs of rubber gloves, knee pads, dust masks
- 1 - Bulk caulking gun + Cone plastic tips
- 1 - Knife sharpener
- 2" wide duct tape (Joint length x 2 Qty/roll)
- 1 - Spray bottle for soapy water (Large profile leak check
- Miter Box - Large enough to splice seal
- Back Saw - Remove teeth leaving a razor-sharp edge

Pre-Installation Notes

Installation must be performed only in joint openings with sound, clean and dry substrates. Joint openings must have parallel and dimensionally consistent side walls. Careful attention should be given to any concrete cracks at and around the joint opening. Care should also be taken to ensure that the area of joint opening in contact with the seal is prepared to the proper depth, depending on seal size.

For staged construction consult with Watson Bowman representative prior to installation.

Joint Preparation

1A

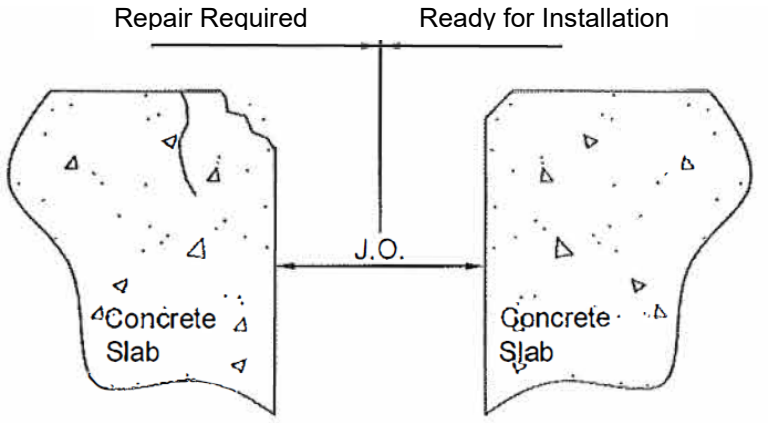
Preparation (New Construction):

- Use forming materials to make a consistent and parallel joint opening.
- Joint opening should be chamfered to help prevent future fracturing and spalling.
- The concrete side walls must be free of all contaminants such as form release agents, grease, oil and all other dirt and debris.
- Sandblasting is the recommended preparation procedure, but where sandblasting is not possible, disc grinding may be employed. However, careful inspection must be made to ensure roughened and completely clean concrete.
- Clean joint opening with compressed air. Immediately prior to installing the Jeene® seal, concrete side walls shall be wiped down with Concrete Cleaner.

1B

Preparation (Existing Construction or Wabo®Crete II Blockouts):

- Joint openings are to be inspected for cracks, loose concrete and spalling.
- Repair joint opening to ensure parallel and consistent side walls. WaboCrete II Elastomeric Concrete Header or similar product be used for rapid repair.
- Concrete side walls must be free of all contaminants such as form release agents, grease, oil and all other dirt and debris.
- Sandblasting is the recommended preparation procedure, but where sandblasting is not possible, disc grinding may be employed.
- Clean joint opening with compressed air. Immediately prior to installing the Jeene® seal, concrete side walls shall be wiped down with Concrete Cleaner.



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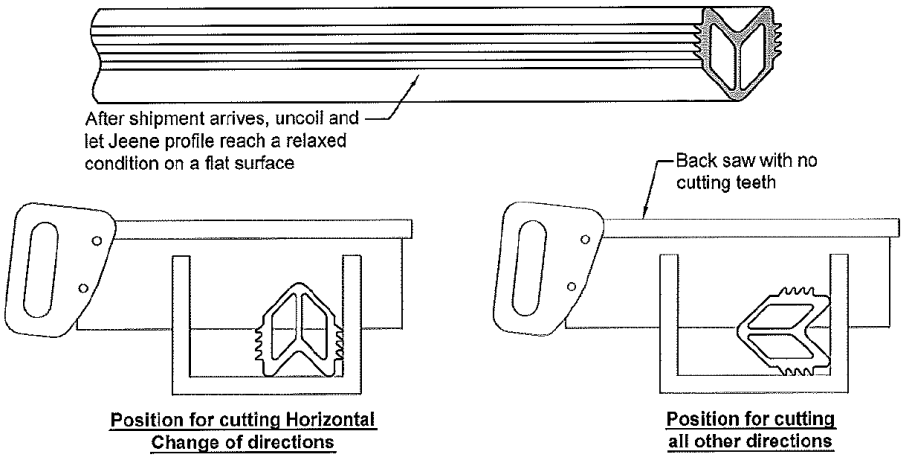
1C **Preparation (Armored Edge – New or Existing)**:

- Armored edge surfaces must be abrasive blasted until near white finish (SP10) is achieved, immediately prior to installation of Jeene®.
- Where sandblasting is not premitted, disc grinding may be used to roughen and abrade the surface to achieve the "White Steel" condition.
- No solvents or cleaners are to be used on steel surfaces prior to applying epoxy adhesive.
- **Galvanized Steel:** wipe with clean white cotton rag and concrete cleaner (denatured alcohol) continue to wipe until surface is clean.
- Installation of Jeene® seal should immediately follow surface prep to avoid re-oxidation of steel surface. Any prepped surfaces left exposed for any length of time that results in oxidation of the surface must be prepped again immediately prior to Jeene® installation.

Seal Prepation

2A **UNCOIL SEAL:**

- Allow seal to be uncoiled and relaxed before cutting seal into desired lengths. The seal has elastic capabilities and will stretch if pulled upon.
- While cutting it is recommended that the seal not be under any tension to ensure that the seal will be cut to desired lengths.
- Manufacturer recommends to grind off all teeth on a back saw, sharpen to a razor sharp edge anduse denatured alcohol as a lubricant to ensure the cleanest and straightest cut.



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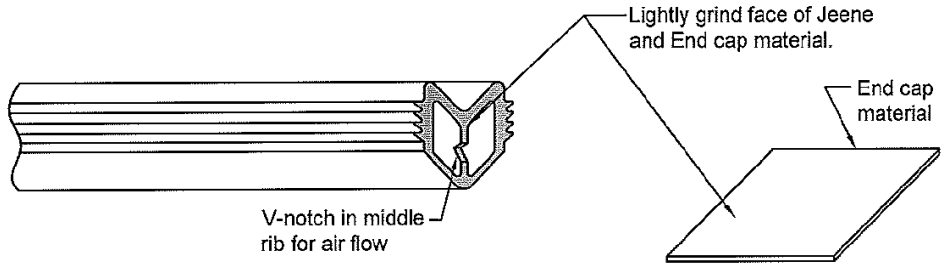
2B

V-NOTCH & END CAP PREPATION:

- Cut a V-notch groove in middle rib to ensure air flow through each chamber when inflating system. Before adhering the end cap material to Jeene® seal seal, each sealend must be lightly ground so that the contact surface face reveals virgin material. Also surfaces must be smooth and powder free.
- Grinding can be accomplished with a dremel tool with barrell sander attachement

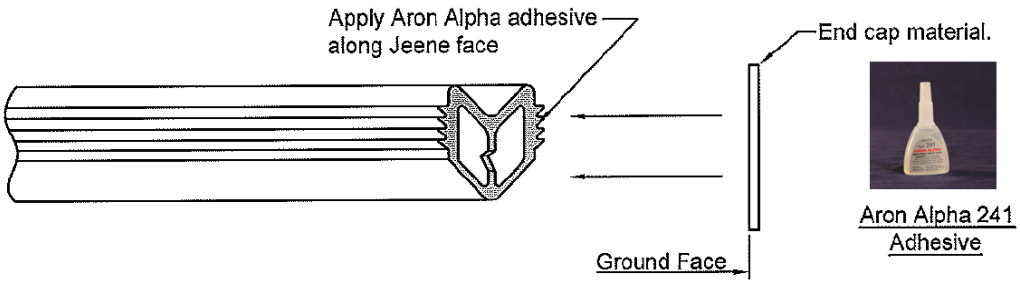


2C

END CAP INSTALLATION:

- The end cap is to be adhered to Jeene® Seal utilizing Aron Alpha 241 adhesive.
- When applying Aron Alpha 241* a thin layer is to be applied to the Jeene® seal end only.
- After adhesive has been applied, firmly press end cap against the Jeene® seal end for at least 60 seconds.
- Repeat same step for other end of seal.
- Best results occur when adhering half of the end cap at a time, especially on larger seals.
- After end cap has been adhered to Jeene® Seal, trim excess end cap material from seal. Exercise care not to damage the seal between the end cap material and Jeene® seal .

***Note**: If Aron Alpha 241 adhesive has a yellowish tint to it do not use. Adhesive should be clear in color for best results.



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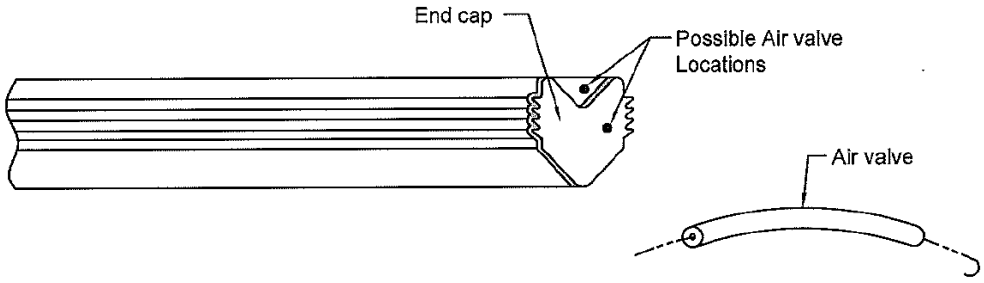
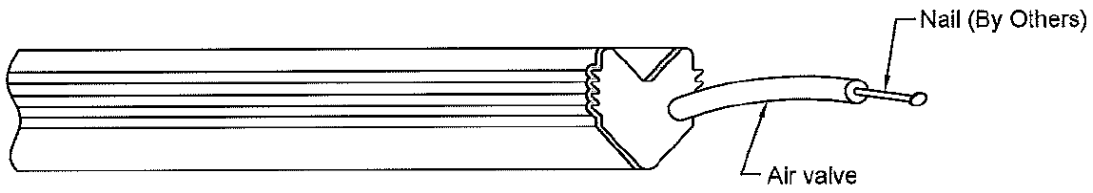
2D INSTALL AIR VALVE:

- After choosing the location of the air valve, the area must be lightly ground, as well as the end of the air valve.
- Utilizing a 1/8" drill bit attached to a dremel tool, drill a hole where the air valve will be adhered.
- Using tywire as a guide for air stem location, install air valve in the same steps as adhering the end cap to Jeene® seal.



2E TESTING FOR AIR LEAKS

- After end caps and air valve have been installed, now seal is ready for inflation.
- Using an air pump, inflate the seal to 15 to 20 PSI., (the end cap should have a slight bulge)
- With a 16D nail, plug valve to hold air.
- Each end cap and air valve locations shall be checked for air leaks.
- Testing for air leaks consists of submerging seal in water or using a spray bottle with soapy water to reveal any bubbles, that indicates escaping air.
- If leaking occurs the connections must be repaired.
- The air leak locations must be dried thoroughly, using a knife point to open air leak area and scrap old adhesive away.
- Now that the leaking area is cleaned, apply additional adhesive into the opened area and press firmly together for another 60 seconds.
- Repeat testing again until there is no leaking.
- The seal shall remain inflated during the sea cleaning process and deflated right before installation process.



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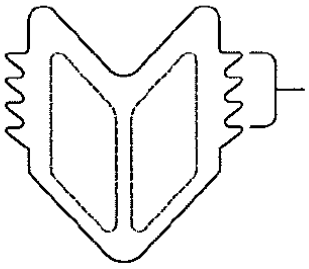
2F

CLEANING THE SEAL:

- Lay plastic sheeting approximately 2'(feet) wide along side of the joint opening,and place Jeene® seal on top of the plastic sheeting
- The inflated and air-tested seal should be vigorously wire brushed along the entire ribbed areathat serves as the bonding surface on both sides. The surface will appear dull and abraded when properly prepared.*
- Following wire brush abrasion, the ribbed area should be aggressively scrubbed with Conditioning agent using a stiff nylon brush
- Wipe ribbed area with a clean white cotton rag that is saturated in Conditioning Agent
- Leave seal to dry. Once surface dries it should appear even duller.

*Note: For 1" seal use nylon brush only.

Profile Conditioning Agent



Rib cleaning area Steps:
1. Wire Brush
2. Nylon brush with Condition Agent
3. Clean white rags with Conditioning agent.

2G

MIX & APPLY EPOXY:

- Epoxy must be mixed in proportions as specified and supplied by the manufacturer. One container of accelerator to one container of resin.
  - Warm Weather Epoxy is a 1:2 ratio, Cold Weather Epoxy is a 1:1 ratio.
- Mix epoxy only after all preparations of joint opening and seal preparation has been completed
- Approximate pot life for epoxy depending on conditions.

Epoxy Type	Temperature	Pot Life
Warm Weather Epoxy	90^0F	60 min
Cold Weather Epoxy	40^0F to 50^0F	60 min

- Epoxy should be mixed in clean pails with a hand drill and small mixing paddle. Color consistency should have no streaking.
  - Premix Cold Weather Part B for 45 seconds.
  - Mix no more than 2 units at a time.

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Warm Weather Adhesive

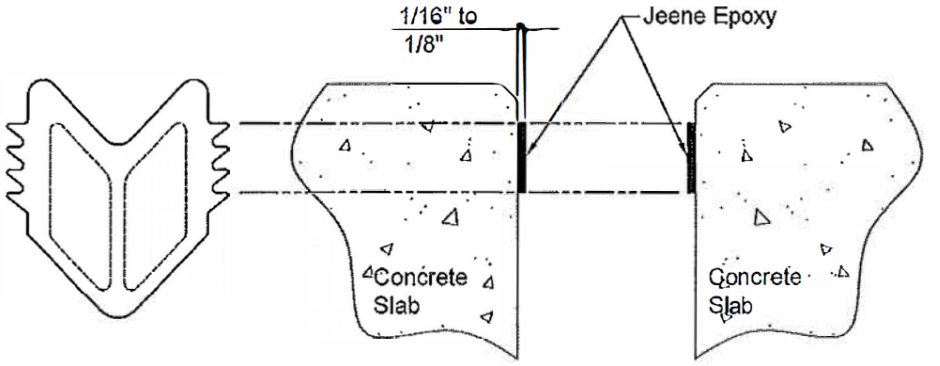
Cold Weather Adhesive

SEAL INSTALLATION

3A

APPLY EPOXY TO JOINT OPENING

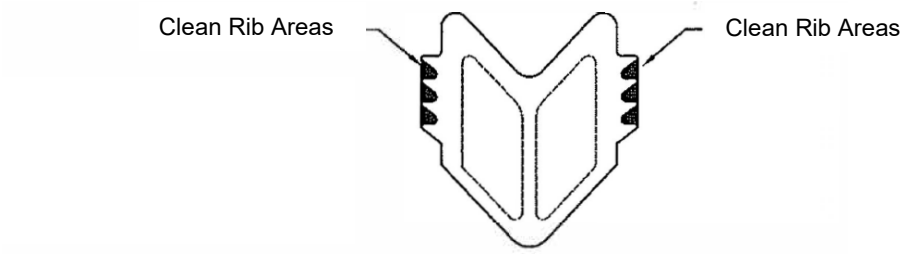
Using a bulk gun, putty knives or margin trowels, apply epoxy to the joint opening side walls to the depth aligning approximately with ribs of the seal to be installed. The Epoxy should be applied and troweled firmly out to a thickness of 1/16" to 1/8".



3B

FINAL CLEANING OF SEAL RIBS

Immediately before applying epoxy to the seal, wipe the seal with Seal Conditioning Agent using a clean white cotton rag. Repeat on each side.



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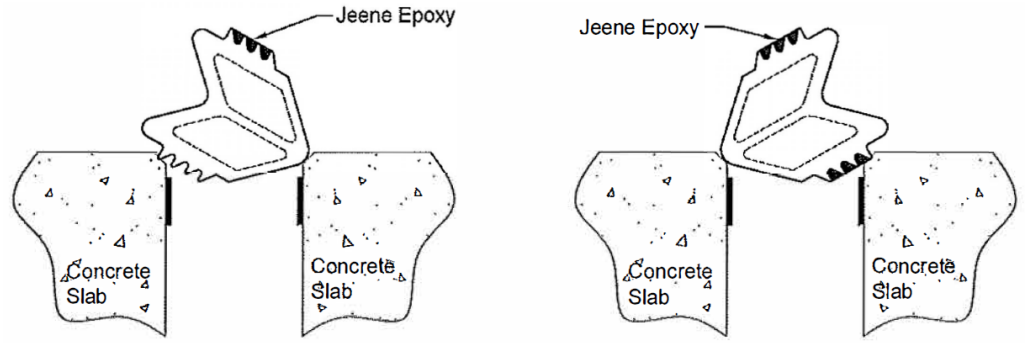
3C

APPLYING EPOXY TO SEAM

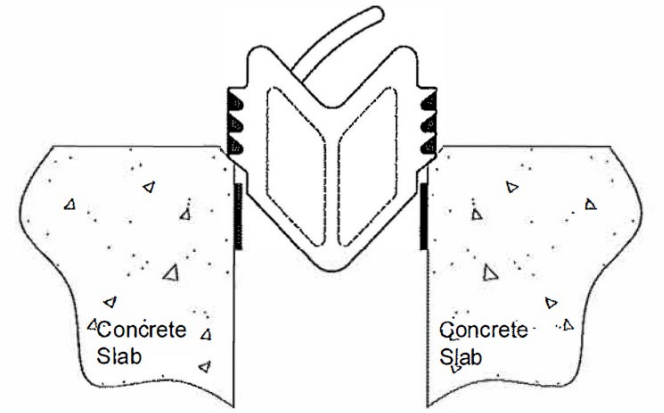
- Epoxy should only be applied to the ribbed area of the seal with putty knives, trowels or bulk guns. More is not better in this case.
- Place seal in joint opening as shown, make sure ribs sit in opening and not against either side wall. Apply Jeene® Epoxy as shown above, flip seal over and the do the same to the other side.



3D

ALIGN SEAL INTO JOINT OPENING

- Using long nose pliers, squeeze the air valve and let the air slowly escape from the seal until it starts to move down into the joint opening.
- In some cases the air has to be vacuumed from the seal by the use of a vacuum pump. When doing so exercise care not to over vacuum it. This could cause the seal to sink into the gap.



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3E SETTING SEAL IN JOINT OPENING

- Once the seal is aligned with the opening, compress and set the seal 1/8" to 1/4" below the finished surface.
- After the seal is set into the correct position, inflate Jeene® seal into it's final stage (approximately 15 to 20 psi). Air pressure should be applied slowly.
- After proper inflation squeeze air valve with pliers and insert nail into air valve.

3F CLEANING AND FINISHING

- Excess epoxy should be scrapped from the top of the seal and the edges of the joint opening with putty knives or margin trowels.
- Wipe down exposed seal with clean white rag dampened with Concrete Cleaner.
- Following these steps, the site can be cleaned up and open to traffic.
- Maintain air pressure for a minimum of 24hrs at 70'F. The lower temperatures require longer time.

3G REMOVE AIR VALVE (OPTIONAL)

- Wait a minimum of 24 hours prior to removal of air valve.
- Carefully cut off air valve as close to seal as possible.
- Lightly grind area with dremel
- Cut a small piece of end cap to match the size of grinded area
- Put a drop of 241 glue on grinded area and place cut end cap piece over hole.

SEAL SPLICING

- Equipment required for spliciing:
  - A miter box and saw is required
  - It is important that the saw be kept razor sharp
- Splices should be cut in a miter box using a sharp saw and concrete cleaner as lubricant.

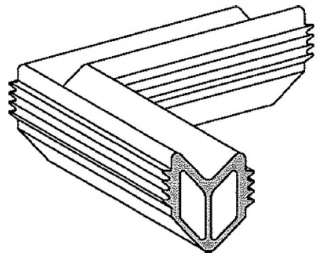
BUTT SPLICING

1. For straight cuts, position the seal with the top against the back wall of the miter box and cut with a smooth, fast sliding motion to avoid distortion. Apply minimal pressure to prevent irregularities that require grinding. NOTE: Refer to Step 2A for recommeded cutting procedures
2. Grind the cut surfaces to correct any distortions and ensure smoothness.
3. Using Aron Alpha 241 adhesive, bond the prepared ends.. A thin layer of adhesive should be applied to one seal end, the two ends should be pressed firmly and evenly together for 60 seconds. The connection is now complete.
4. Tip: It is helpful when adhering seal sections to adhere small sections of the splice at a time.

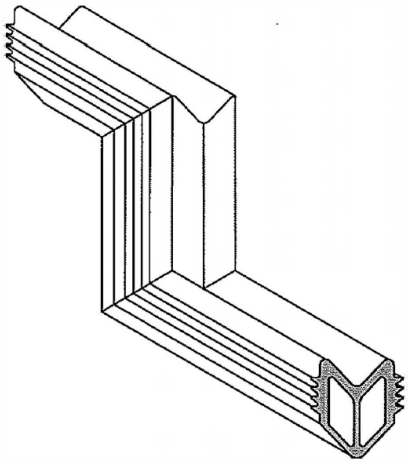
Splicing Procedure – 90° Transitions:

- Follow Butt Splicing Proces for proper cutting of the seal and adjust saw to achieve desired angles.
- Allow for extra material when splicing 90 degree angles
- Cut the ends of the two seals at 45° angles in the miter box. Center webs shall be cut away to prevent them from becoming an obstruction to the mitering operation.
- Grind the cut surfaces until flat and smooth, correcting any distortion and irregularities.
- Using Aron Alpha 241 adhesive, bond the prepared ends according to the job specifics. A thin layer of adhesive should be applied to one seal end, the two ends should be pressed firmly and evenly together for 60 seconds. The connection is now complete.

Tip: It is helpful when adhering seal sections to adhere small sections of the splice at a time.



90° Miter
Horizontal



90° Miter
Vertical

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