



APPLICATION INSTRUCTIONS

WILLSEAL® PF200

Pre-Compressed Watertight & Airtight
Foam Tape with Pre-Cured,
Factory-Applied Sealant Specific for
Prefabricated Applications

1. PURPOSE

- 1.1 The purpose of this document is to establish typical guidelines for installation of Willseal® PF200. 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 PF200 is used as an external primary, vertical, 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. The exterior face of the foam has a pre-cured sealant that allows for the joint material to be color matched to the facade without an additional labor and material step. PF200 is designed for use in applications in a vertical plane only.

2. SCOPE

- 2.1 This document will provide the necessary instructions for installation of Willseal PF200 to qualify for a manufacturer's warranty. Please reference "Willseal PF100 & PF200 Modular Best Practices" for additional information regarding sequencing instructions for applications during the installation of modular units on site.

3. APPROVED SEALANTS

- 3.1 Recommended materials for use with Willseal PF200:
 - a. Spectrem 1
 - b. Spectrem 2
- 3.2 Follow recommended sealant dimension guidelines on sealant manufacturers Data Sheet.

4. AVAILABILITY

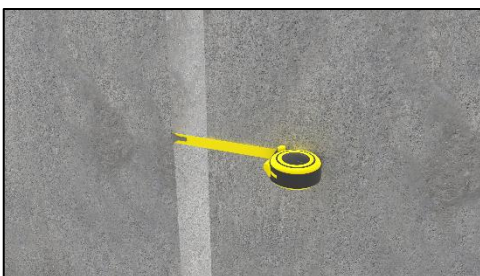
- 4.1 Willseal PF200 is available in joint sizes from 1/2" to 2" (1.3 to 5 cm) wide in 6.5 ft (1.8 m) stick lengths, directly from Willseal as part of a project specific order only. Both pre-notched and prefabricated 4-way connection points are available upon request. For more information contact Customer Service by phone at 800-274-2813 or by email at custserv@willseal.com.

5. STORAGE

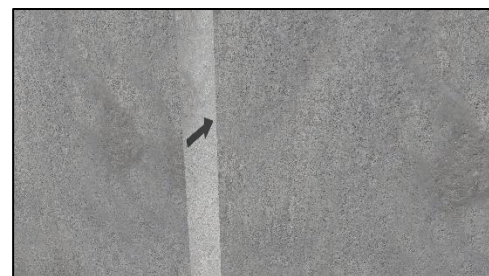
- 5.1 Store materials in a dry, enclosed area, making sure materials are off the ground and out of direct sunlight.
- 5.2 Material will expand faster when hot and slower when cold. In cold temperatures, store material in a heated area 24 hours prior to installation. In hot temperatures, store material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

6. MATERIAL SIZING

- 6.1 Willseal PF200 material should be ordered according to the designed joint size width, with a construction tolerance of 1/4". As construction tolerances can vary, it is recommended the joint size be verified every 5 to 7 ft (1.5 to 2.1 m) to ensure the gap opening is uniform. See Ref 1.
- 6.2 Allow sufficient depth to recess the foam material a minimum 1/4" (3 to 6 mm) into the joint. See Ref 2.



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



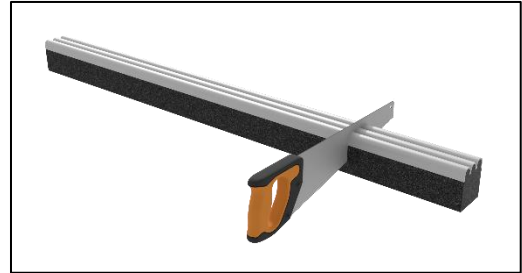
Ref 2 – Ensure depth for 1/4" foam recess minimum.

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.



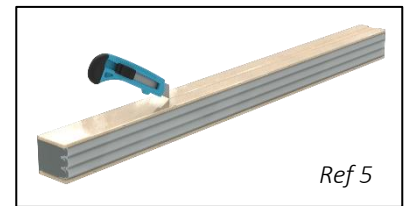
Ref 4 – Cutting with foam knife after shrink wrap removed.

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 Verify the substrate air barrier is backwrapped into the joint to allow contact with the integral air barrier layer.
- 8.7 Joint depth must allow for the installed material to be recessed a minimum of 1/4" from the substrate surface. Joint depth must allow for the integral air barrier layer to maintain contact with the backwrapped air barrier.

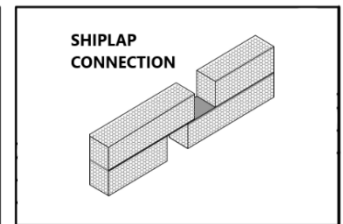
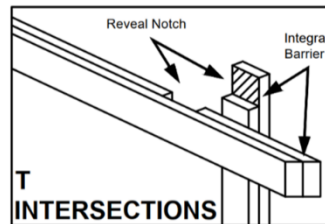
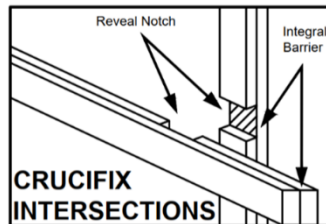
9. APPLICATION PROCEDURE

- 9.1 When fully prepared to install, cut/slit the shrink packaging along the edge of the masonite strapping. See Ref 5.
- 9.2 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).
- 9.3 Verify that the material is cut square at both ends for proper seams; all pieces must be square to the termination point.
- 9.4 For all Crucifix Intersections, T-Intersections, and/or Shiplap Connections, a reveal notch must be cut to expose the integral barrier, taking care not to damage it. See Ref 6.



Ref 5

- a. In these areas, the integral barriers of adjacent sticks must be bonded together with the supplied accessory sealant. The silicone splice adhesive must be



Ref 6 – Example of Crucifix Intersection, T-Intersection, and Shiplap Connection.

Tremco Construction Products Group (CPG) brings together the Commercial Sealants & Waterproofing and Roofing & Building Maintenance divisions of Tremco CPG Inc.; Dryvit, Nudura and Willseal brands; Prebuck LLC; Tremco Barrier Solutions, Inc.; Weatherproofing Technologies, Inc.; Weatherproofing Technologies Canada, Inc.; and Pure Air Control Services, Inc.



tremcosealants.com
800.321.7906

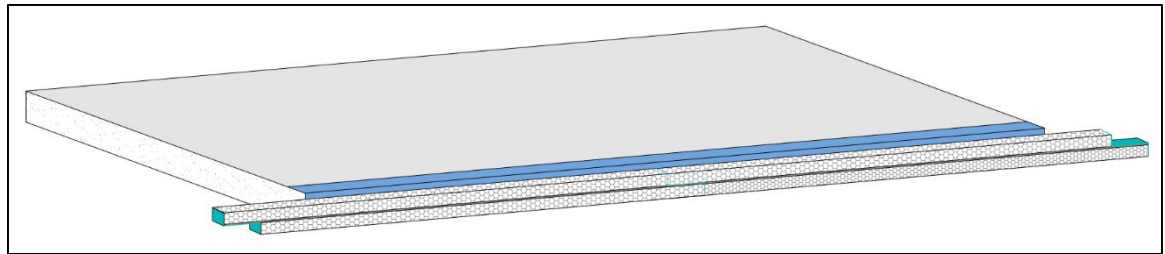


Construction Products Group

3735 Green Rd. | Beachwood, OH 44122
800.321.7906 | tremcocpg.com

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, especially for shiplapped joints.

- 9.5 Willseal PF200 is recommended to be installed to panels pre-flight, but can also be installed with panels already in place.
- 9.6 Remove the release liner from the stick, exposing the pressure sensitive adhesive.
- 9.7 Using the pressure sensitive adhesive, located on one side of the PF200 stick, press the foam tightly against the panel side, ensuring the integral barrier layer is in full contact with the backwrapped air barrier of the panel. Ensure all connecting sticks are facing the same direction and wet splice sealant has been adequately applied. See Ref 7.
 - a. For vertical joints, begin installation at the bottom of the joint and work upward. The installed sticks will assist in supporting subsequent sticks until the material fully expands.
 - b. For joints that run horizontal, begin installing PF200 at one side of the joint (either side) and continue to install the material working towards the opposite end. To ensure compression with the vertical joints, horizontal joints should be cut 1/2" to 1" longer than the panel width and compressed against the vertical sections.
 - c. Sequence will depend on how prefabricated units are being installed. Pay attention to the direction of insertion marked on the packaging.



Ref 7 – Installation of two stick lengths along a panel.

- 9.8 Material will expand during flight or prior to the next panel installation. The pressure sensitive adhesive will hold the PF200 in place until the next panel can be installed. Installation of the next panel will recompress the material. Take care to ensure the PF200 is not displaced. Confirm the integral barrier of PF200 makes full contact with the backwrapped air barrier of the second panel.
- 9.9 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 Willseal PF200 with hydrocarbon solvents and corrosive chemicals.
- 11.2 Willseal PF200 cannot be used as a primary seal where standing or ponding water will occur. Do not apply to damp, contaminated, or frost covered surfaces.
- 11.3 Single wall applications must be installed within 30 minutes. Contact your local Tremco or Willseal Technical Sales Representative for more information.

WPF200-AI/0825

Tremco Construction Products Group (CPG) brings together the Commercial Sealants & Waterproofing and Roofing & Building Maintenance divisions of Tremco CPG Inc.; Dryvit, Nudura and Willseal brands; Prebuck LLC; Tremco Barrier Solutions, Inc.; Weatherproofing Technologies, Inc.; Weatherproofing Technologies Canada, Inc.; and Pure Air Control Services, Inc.



tremcosealants.com
800.321.7906



3735 Green Rd. | Beachwood, OH 44122
800.321.7906 | tremcocpg.com