



# COMPOSITE / TEFLON<sup>®</sup> SPLICE INSTALLATION INSTRUCTIONS

## Tools & Materials Needed:

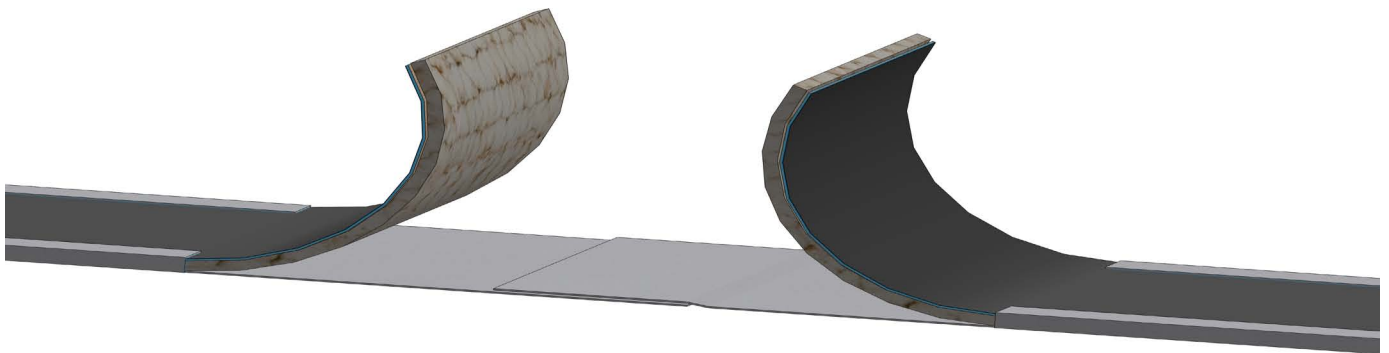
- Heating iron (Capable of Continuous 750°F to 775°F)
- Scissors
- Utility blade\*
- 4" Curved needle (Included with Splice Kit)
- Fire retardant thread (Included)
- PTFE splicing film (Included)
- 10 Gallon steel plate or ½" plywood (or thicker) 6" wide x belt width plus 2"
- Needle nose pliers

## Directions:

Important Note: Leave 2' to 3' of each end of the expansion joint unbolted for ease of splicing.

1. Begin by removing the staples 2' from each end along each edge of the expansion joint.
2. Fold back each individual layer until the innermost fabric is exposed.
3. Pull each end of the joint taut and overlap this material a minimum of 6".
4. Hold tight using a vise grips, spring clamps, or a stapler, while sewing.
5. Using a 4" curved needle and fire retardant thread, sew the overlapped material. See Figure A.

FIGURE A



6. Use close stitches for a strong splice; approximately 1" apart.
7. Use the above process for each individual layer of fabric.
8. Also, alternate the overlapping side of the fabric before each layer is spliced.

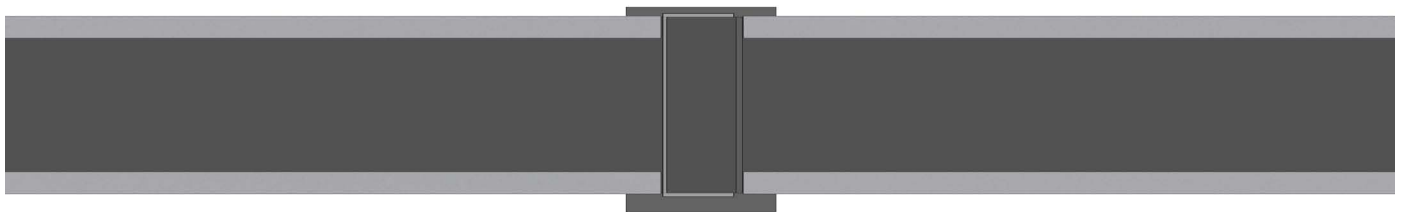
9. For example, if the innermost layer was overlapped left-over-right, then the next layer needs to be overlapped right-over-left. Fiberglass insulation does not need to be sewn.
10. Step down each end of the insulation a minimum of 6" from the end, (1/2) the thickness of insulation. See Figure B.

**FIGURE B**



11. Then overlap the insulation and continue splicing the layers. After all fabric layers are sewn and fiberglass layers overlapped, the cover material will be the last layer to splice. Do not sew this layer!!
12. Overlap the cover material 4", placing the splicing film in between. The extreme edges of the cover material may be stapled to hold the overlap at 4" and to keep the splicing film in place.
13. Place the steel plate (or plywood) behind the entire expansion joint, centering it with the 4" overlapped splice. See Figure C.

**FIGURE C**



14. Using the heating iron after it has reached 750°F, begin heating the cover materials by placing the iron directly on the 4" overlapped area, holding it steady with constant pressure, for 5 to 7 minutes.
15. It is important to continually monitor the splicing iron's temperature as PTFE splicing film will burn if temp is too high or it will not bond properly if temperature is too low. It may be necessary to move the iron multiple times in order to splice the full width of the joint.
16. If this is the case, overlap the iron 1" with the previously sealed section.
17. After all layers have been sewn, overlapped, and heat sealed, remove the steel plate or plywood and finish bolting the expansion joint.