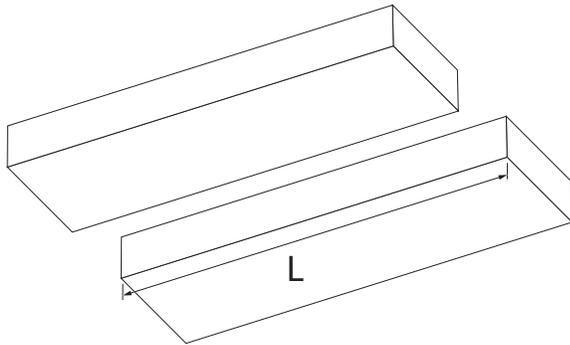


# Installation Instructions

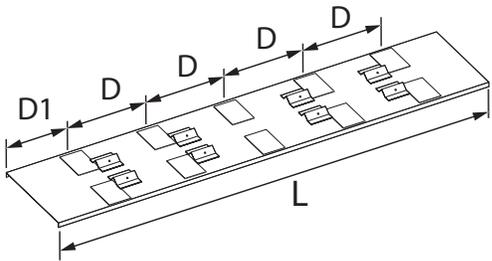
Joint System: 353/353C/355/355C-A18/A24

**Note:** Verify that the structural gap is in conformance with submittal data before beginning installation. If this is a Fire Rated Assembly, install the fire barrier before the Architectural Joint System. Refer to the fire barrier instructions for specific system installation. Reference project specific details before installation. Completely read all instructions before installing.

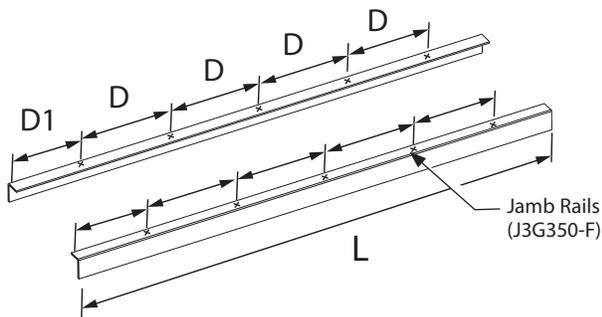
**Fig. 1**



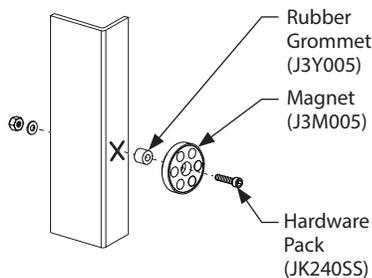
**Fig. 2**



**Fig. 3**



**Fig.3a**



**Fig. 1 - Layout**

1. Before installation measure the total length of the expansion joint. Measure from finished wall to finished wall.
2. If installing system on both ceiling and walls, make sure to finish installation of ceiling before installing walls.

**Fig. 2 - Pan Prep**

3. Cut pans to appropriate length. If cut off section on pan results in a magnetic plate being more than 12" [300mm] from an end; install the provided ferrous plates, and pop up brackets.

**NOTE:** Ensure extra plates are in-line with existing plates on pan. Clean surfaces using denatured alcohol or acetone before adhering components. (Let parts sit for at least 2 hours before installing.)

**Fig. 3 - Magnet Alignment to Magnetic Plates**

4. Record the measurements from one edge of the pan to the center of the first magnetic plate, and the on center distance between the remaining plates. (See Fig. 2)
5. Transfer measurements from step 4 to the short leg on the jamb rails. Ensure the rails are oriented with a left and right orientation as shown in Fig 3.
6. If a pre-fabricated hole exists within 1" [25mm] of the mark from step 5, use that for fastening the magnet to the jamb rail. If not, drill a mounting hole with a 7/32" [5.5mm] bit. Fasten the magnet to the jamb rail using hardware pack JK240SS, (#8x3/4" SS socket head screw, SS washer and #8 SS lock nut) making sure to sandwich J3Y005, rubber grommet, inbetween the magnet and the jamb rail.

IPC.3108/REV.3

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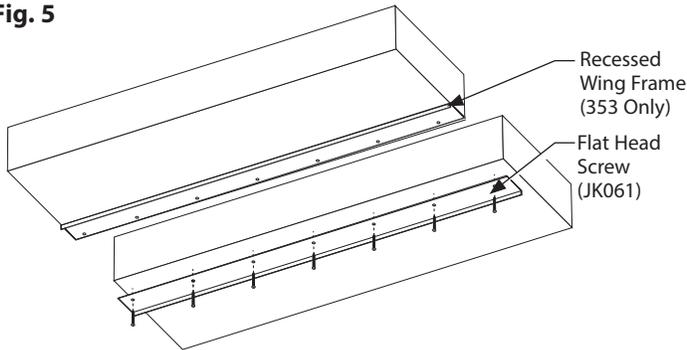
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# Installation Instructions

Joint System: 353/353C/355/355C-A18/A24

Fig. 5



**Fig. 5 - Locating Recessed Wings**

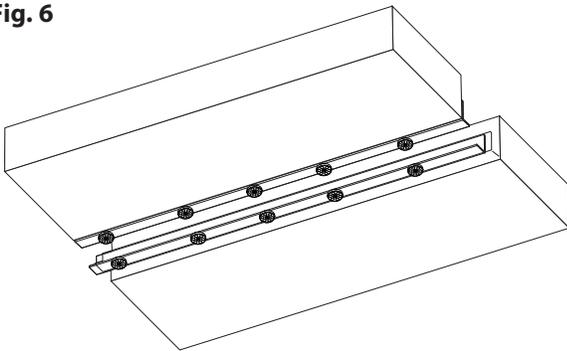
(For 355 recessed system with side wings only)

8. Measure the width of the pan, and install recessed wing frames so they allow a 1 1/4" [31mm] distance from the edge of the pan to the inside face of the recessed wing.

**NOTE:** It is critical to confirm dimension against supplied details, before installation of wings.

9. Fasten recessed wings using the supplied JK061, #8 x 2 [M4x50] flat head sheet metal screws.

Fig. 6



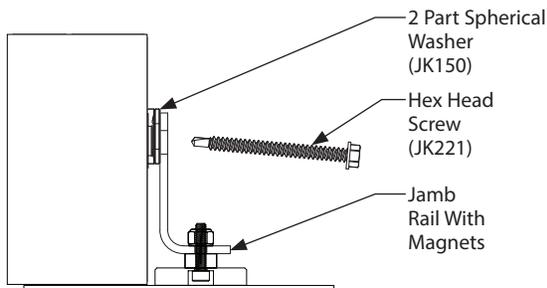
**Fig. 6 - Locating Jamb Rails**

10. Place the jamb rails into the joint opening.

11. Using a straight edge or the supplied extra ferrous metal plate, ensure the top and bottom magnets extend slight past the face of the recessed wings or wall face (not farther than 1/16" [1.5mm]). Adjust each magnets as needed so all align equally. (See Fig 7a)

**TIP:** Mark the slotted hole locations on the inside walls and pre-drill using a 1/8" [3mm] drill bit. To prevent the self-drilling fastener from wandering from desired location.

Fig. 7

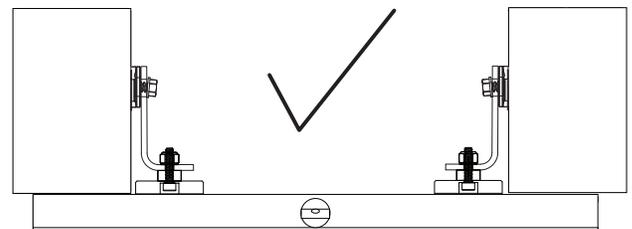
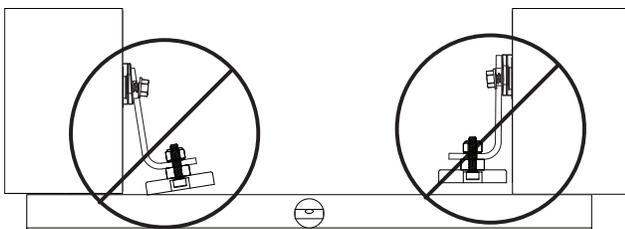


**Fig. 7 - Installing Jamb Rails**

12. Fasten the jamb rails using the supplied JK221, #12 x 2 1/2" [M5x65] hex head sheet metal screws, and JK150 spherical washers. Slotted holes allow for precession locating of jamb rails and attached magnets. Spherical washers assist with squaring of magnets to the cover pan when wall jambs are not exactly a 90° angle.

**TIP:** After fastening the jamb rails, double check to make sure all magnets are positioned correctly as stated in step 11. (See Fig 7a)

Fig. 7a



# Installation Instructions

Joint System: 353/353C/355/355C-A18/A24

Fig. 8

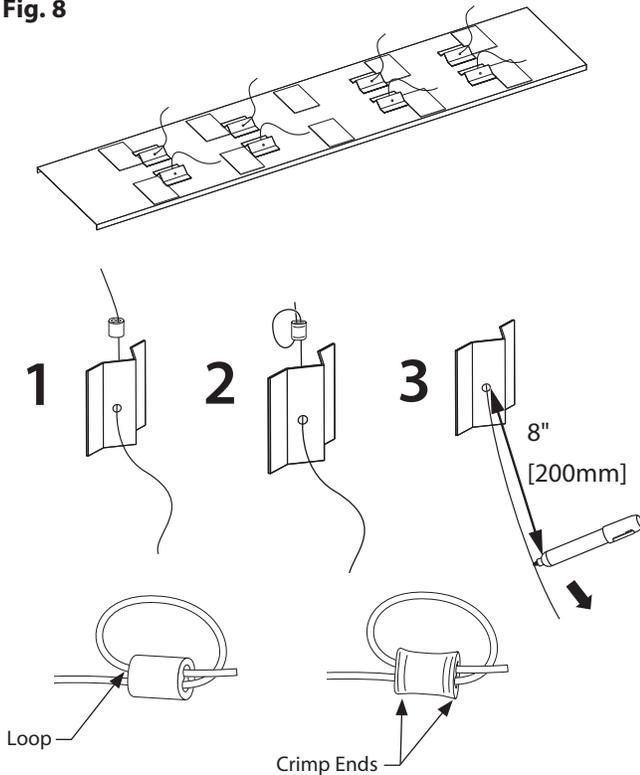


Fig. 9

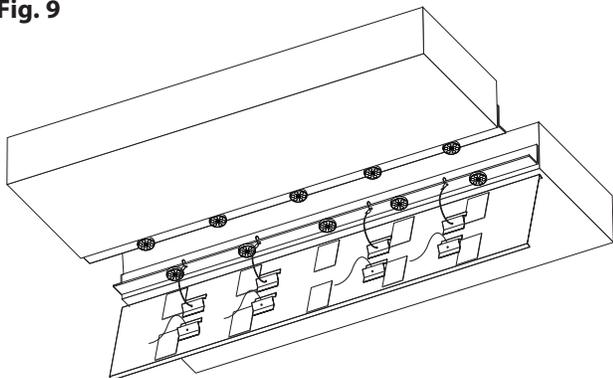


Fig. 9a

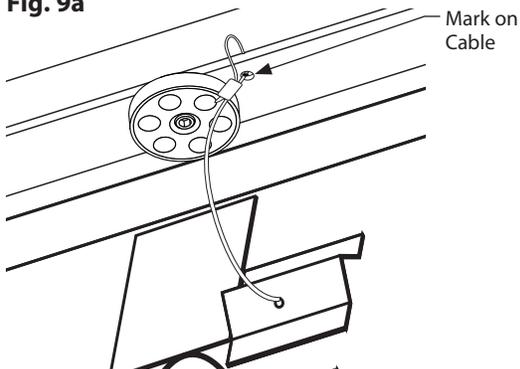


Fig. 8 - Prepping Arrest Cables

13. Secure the stainless steel arrest cables so they are installed through the inside hole on each triangular pop-up bracket.

a. Slide supplied stainless steel cable through pre-drilled hole. Slide supplied crimp onto cable.

b. Loop stainless steel cable around crimp, and slide through other side of crimp. Using a pair of vice grips crush both ends of the crimp on to the cable.

**NOTE:** DO NOT CRUSH MIDDLE OF CRIMP

c. Pull opposite end of cable tight, and measure 8" [200mm] from the hole on the bracket down the length of cable. Mark cable using a permanent marker.

Fig. 9 - Installing Pan Arrest Cables to Jamb

14. Lift the pan (finish side down) up to the ceiling. If possible rest the pan, level, and 8" [200mm] from the jamb rails. Ensure the center and each end of the pan is supported. Secure the arrest cables to the jamb rail through one of the pre-drilled holes.

**NOTE:** Inpro highly recommends the use of a panel lifter or scaffolding to support the panel in position.

**CRITICAL:** Ensure each cable is installed at an equal length.

15. Slide a provided crimp on to the free end of the stainless steel cable. Insert the free end of the cable through the front face of the jamb rail, and loop the cable back into the crimp.

16. Tighten the cable so the marked location is sitting in the pre-drilled hole (see Fig. 9a)

17. Crush crimps using vice grips per steps above.

**NOTE:** It is important to ensure the holes on each opposing side are in line. If they are not, use a 1/8" [3mm] drill bit to make a new hole in the desired location.

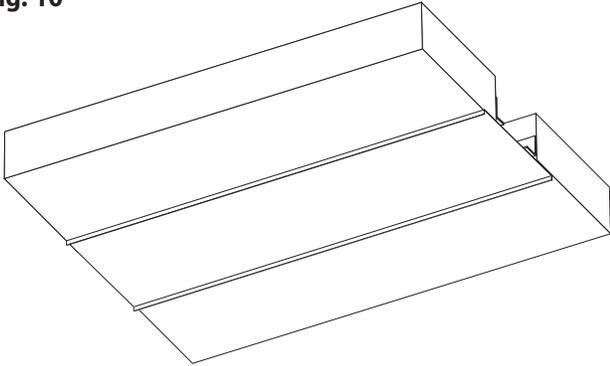
18. Repeat process for all cable locations.

# Installation Instructions

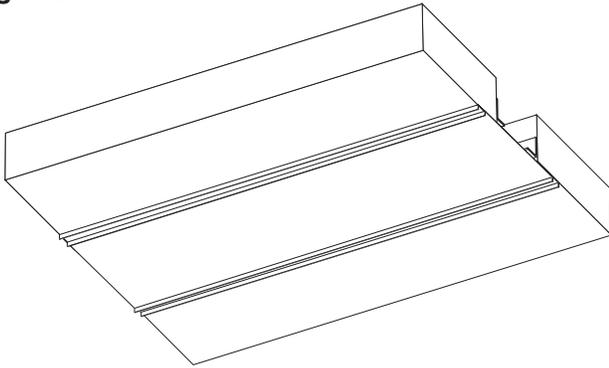
Joint System: 353/353C/355/355C-A18/A24

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**Fig. 10**



**Fig. 10a**



**Fig. 10 - Attaching Pan to Ceiling**

19. Center the cover pan while holding it away from the expansion joint. Then allow magnets to catch the pan as you move it closer, ensuring the each end is spaced evenly from each wall face.

## Installing In-fill Materials

20. Using a wire brush, or a belt/palm sander, roughen the inside surface of the pan on all faces that will receive the infill.

- **Gypsum / Plaster / Cement Board:** To be installed with heavy duty construction adhesives or epoxies. Verify best solution with adhesive manufacturer and/or construction consultant specializing in your finishes specific traits.

- **Ceramic Tile / Solid Surface:** To be installed using 100% silicone adhesive appropriate for bonding to metal to allow for thermal expansion & contraction. Place 3/4" [19mm] wide dabs at 8" [200mm] on center in a grid pattern throughout the pan.

21. Allow infill materials to cure a minimum of 24 hours prior to installation.