

SECTION 3

Individual Product Information

DOMCO TARKETT is committed to provide the finest quality resilient flooring products available on the market today. Through world class technology and international cooperation continual advancement in manufacturing is occurring with the end result being superior products, performance designed.

These next pages describe commercial Azrock branded products manufactured or distributed by the various DOMCO TARKETT facilities. Product lines have been placed into general categories according to their properties. Each particular line and brand of Azrock Commercial resilient flooring has its own set of unique properties and characteristics which determine their use and suitability for specific areas.

Azrock Commercial flooring is designed for commercial or industrial use. These typically only have temporary factory or jobsite applied "wearlayers" in the form of acrylic emulsion finishes which must be periodically re-applied and removed or buffing procedures that must be performed on a consistent basis. Even if these flooring products are used in a residential setting, recommended commercial maintenance procedures must be performed. The maintenance section of this book gives specific maintenance guidelines for DOMCO TARKETT's Azrock commercial products.

If any questions arise as to the suitability, use, or warranty on a DOMCO TARKETT floor covering line for a particular purpose or jobsite condition contact your local DOMCO TARKETT distributor for assistance.

Note on Product Performance under Heavy Load Conditions

Azrock Commercial Flooring is used in many areas subjected to heavy static and dynamic loads. Some fixtures and equipment in certain environments may be equipped with castors or floor contact devices, which concentrate rather than dissipate the weight load on the surface of the flooring. While this may aid in the movement of the equipment they can be particularly damaging to resilient flooring systems. One such an example area is hospital patient rooms. We suggest that any fixtures or equipment be fitted with floor contact devices which avoid concentrating weight loads. Please review Section 6 which details recommended floor protection devices.

Our experience has shown that the use of hard setting reactive adhesives offer advantages and help protect against damages if used to install flooring underneath of such fixtures or equipment, such as DOMCO TARKETT 940 Polyurethane Adhesive. This adhesive may only be necessary in limited areas of any particular installation, such as a zone immediate adjacent to the contact point with the flooring. In the case of certain heavy hospital beds a spread of Polyurethane adhesive in a footprint under the bed wheel locations may be sufficient. For detailed information on any particular situation please contact the DOMCO TARKETT Commercial Installation Services Department.

DOMCO TARKETT cannot accept responsibility for floor damages associated with the use of inappropriate, improperly designed, or insufficient floor protection devices or if our recommendation for the use of DOMCO TARKETT 940 Polyurethane Adhesive is not followed.

VINYL COMPOSITION TILE

Reference Specification

ASTM F 1066-99 "Standard Specification for Vinyl Composition Floor Tile"

- Products:**
- Azrock's Vinyl Composition Tile
 - Standard Price Products
 - Premium Priced Products
 - Slip Resistant (See additional information at the end of this section)
 - Static Dissipative (SD) Tile
- Adhesives:**
- DOMCO TARKETT 100 Clear Thin Spread Adhesive
 - DOMCO TARKETT 110 Sprayable Clear Thin Spread Adhesive
 - DOMCO TARKETT 950 Pressure Sensitive Conductive (SD Tile only)
 - DOMCO TARKETT 940 Polyurethane Adhesive (specialized wet set)
 - (See additional information at the end of this section)

NOTES:

- USE DOMCO TARKETT 100 Clear Thin Spread Adhesive FOR INSTALLATIONS OVER EXISTING FLOORS
- DO NOT USE ANY CLEAR LATEX ADHESIVES OVER EXISTING ASPHALT RESIDUES
- APPLY ADHESIVES WITH THE RECOMMENDED TROWEL NOTCHING WHEN USING DOMCO TARKETT 102 SPRAY GRADE ADHESIVE USE RECOMMENDED SPRAY EQUIPMENT AND PROCEDURES
- WAIT UNTIL CONVENTIONAL TILE ADHESIVES HAVE FULLY DRIED TO THE TOUCH BEFORE INSTALLING TILE
- NEVER SPREAD MORE ADHESIVE THAN CAN BE COVERED OVER IN THE SAME WORK DAY
- INSTALL AZROCK'S THRU-QUARTZ WITH THE DIRECTIONAL ARROWS IN THE SAME DIRECTION
- ALWAYS HEAT THE BACK OF THE TILE FOR CUTTING, NEVER THE FACE
- CUT NET TO ALL VERTICAL SURFACES
- WHEN INSTALLING TILE OVER TILE, PLAN THE LAYOUT SO THAT SEAMS IN THE NEW TILE ARE OFFSET A MINIMUM OF 3 INCHES FROM THAT OF THE EXISTING TILE

ADDITIONAL CONCERNS:

Moisture and Humidity Cautions

In some geographical areas humidity and moisture present problems in the installation of vinyl composition tile. The information given below may be helpful in overcoming some of these problems.

Moisture itself does not have any chemical effect on vinyl composition tile. A piece of tile can be left in pure water indefinitely without deterioration. The effect of moisture is physical.

There are microscopic voids or spaces in the tile into which water can be drawn by

capillary attraction. If all these spaces on the under side of the tile become over-filled with moisture, an expansion takes place and the tile is curled. The top of the tile is not affected because, being exposed, the moisture evaporates before an excess is accumulated. This is the basic cause for tile sometimes curling. Changes in temperature and changes in relative humidity are usually the forces which make curling evident, but it is the moisture in the bottom of the tile that causes it.

TO PREVENT CURLING: Keep moisture away from the back of the tile until it becomes firmly seated. A careful study of the following specific cautions and instructions will help you to combat moisture and eliminate curling on future jobs.

1. DO NOT remove tile from carton until the tiles are at same temperature as the air in the room (approx. 70°F). In winter, 48 hours are usually required for cold tile to arrive at room temperature. If the tile is cold and the room warm, then water is likely to condense on the surface of the tile like beads of moisture collect on a pitcher of ice water. This moisture may not be visible to the eye but may be present in sufficient amount to prevent full adhesion.
2. Be sure there is a sufficient, proper amount of adhesive on the floor to insure a satisfactory contact with the back of the tile; however, be certain adhesive has reached its initial set before laying the tile. This is very important. It not only hastens the seating of the tile but also prevents tile loosening from the subfloor at a later date. Under ordinary conditions, after a dry tile once becomes firmly and properly cemented to the floor with the recommended film of adhesive, water cannot get to the underside of the tile, in which case it will not curl.
3. DO NOT lay tile in a damp, humid atmosphere; the room should be well ventilated and kept this way until the tiles have become firmly seated. Good ventilation will help prevent dampness from condensing on the subfloor or tile.
4. Be sure conventional tile adhesives have completely broken out and the vehicle has evaporated. DO NOT attempt to lay tile on adhesive which has been spread the day before; first, an invisible film of dust may have collected on the surface during the night; second, most likely early in the morning moisture (like dew) has fallen and covered the surface; and third, continued exposure of adhesive causes oxidation and loss of tackiness at the surface.
5. When laying tile over concrete, the slab and the air in the room should be approximately the same temperature. The slab should always be within 20°F(8°C) of the temperature of the air. For example, if the slab temperature is 60°F (17°C), the air temperature should not exceed 80°F (24°C) and preferably should be 70°F (21°C). This relationship should be maintained until the tile has become firmly seated, because it helps prevent condensation of moisture from the air. Use of an electric fan to circulate the air will help even room and floor temperatures and will speed the breaking out of the adhesive. Burning of natural gas without an exhaust contributes to the condensation of moisture.
6. Caution the customer not to wash the floor for at least one week after installation. Otherwise, water might get under the tile before it is firmly seated. The seating of tile can be speeded up by thorough buffing of the tile with a polishing machine. The friction warms the tile and the vibration helps aid in adhesion of the tile to the floor.
7. Excess humidity in damp rooms can be reduced before and after installation by a dehumidifier or by use of calcium chloride crystals. Place crystals in a cloth or metal mesh suspended over a container. The crystals will absorb moisture which then drips into the

container below. The number and size of such units required for effective reduction of dampness will depend upon the size of the room and the amount of moisture present.

8. Recommended methods for removal of old resilient materials and adhesives usually involve large amounts of water. This water must be allowed sufficient time to evaporate into the atmosphere prior to any new installation. Proper drying will only occur in a low humidity, climatized environment. Moisture and bond tests are recommended to be performed and found acceptable prior to installation.

For more information, consult the booklet, *Addressing Moisture Related Problems Relevant to Resilient Floor Covering Installed Over Concrete*, published by the Resilient Floor Covering Institute, 966 Hungerford Drive, Suite 12-B, Rockville, MD 20850.

STORAGE

All materials to be used in the installation - tile, adhesive, underlayment board, vinyl or rubber wall base-should be stored indoors at an ideal minimum temperature of 70°F (21°C) for 48 hours prior to installation in areas and on floors that are dry and smooth and not subject to temperatures above 90°F.

There is no age limit on Azrock Vinyl Composition Tile, and it does not deteriorate in storage, if storage temperature does not exceed 90°F (32.2°C) and carton stacking limits shown below are observed. Tile must be properly stacked. Storage on uneven surfaces will cause permanent distortion of shape and size of tile.

Carton Stacking Limits - Following are the recommended maximum heights for stacking cartons of Azrock tile:

Product	No. of Cartons
3/32" Gauge Tile	6
1/8" Gauge Tile	5

VINYL COMPOSITION TILE INSTALLATION SYSTEMS

- Categories:**
- I. Conventional Smooth Surface**
 - II. Slip Resistant Surface**
 - III. Static Dissipative (SD) Tile**

I. Conventional Smooth Surface

Suitable Subfloors:

- Concrete below, on or above grade
- Suspended Plywood
- Single Layer existing Vinyl Composition/Asphalt Tile
(on or above grade concrete, suspended wood floors)

Adhesive Recommendations:

DOMCO TARKETT 100 Clear Thin Spread

DOMCO TARKETT 110 Sprayable Adhesive

The above adhesives must be dry to the touch prior to tile placement. Consult specific adhesive product data for open times. We strongly recommend that adhesives be spread and covered over in the same day.

On remodel work it is an acceptable work practice to install new vinyl composition tile over existing asphalt based adhesive residue. For the residue to be acceptable it should be scraped to a thin, smooth layer with no ridges or puddles present. New asphalt based adhesive can be spread over the residue avoiding excessive spread of new adhesive. Clear Thin Spread adhesives should never be applied over existing asphalt residue. These two types are incompatible and have been known in the past to lead to installation difficulties. If clear thin spread adhesive is to be utilized existing residue must either be removed by acceptable methods or encapsulated.

Azrock Vinyl Composition Tile cartons are marked with pattern and lot numbers as well as manufacture timing. We recommend that all material to be installed be checked prior to job commencement for correctness of pattern, color, and lot numbers. If at all possible material from the same lot number should be used on any one installation. If otherwise care should be taken to ensure that possible subtle shade differences between lot numbers be avoided by proper staging and re-arranging of material on the jobsite. In addition we also recommend that material be installed in order of carton sequential timing. This again helps in ensuring the best shade flow on the jobsite.

Procedures See Section 4, Resilient Tile Layout
 See Section 3, Adhesive Information

Dry-Set System

The dry-set system requires the adhesive to be troweled on the approved subfloor and allowed to dry prior to tile placement. This procedure allows the adhesive vehicle to dissipate into the atmosphere for water or solvent-based adhesive products. This system is designed for use over properly prepared concrete subfloors below, on or above grade as well as above grade plywood subfloors. This procedure is also utilized for those adhesives and flooring materials which may be installed over existing resilient subfloors.

General directions are as follows:

1. After the recommended subfloor has been prepared and is ready for flooring installation, prepare tile layout as described in Section 5, Tile Layout, Squares or Planks.
2. Spread recommended adhesive in area to be covered in accordance with adhesive label recommendations. In most cases adhesive should be spread over flooring layout lines, adhesive will dry translucent and lines can be seen. Over some subfloors if lines are removed during adhesive troweling these should be re-striking over the spread adhesive.
3. Allow adhesive to dry completely to the touch. Proper drying is usually determined when by placing your thumb into the adhesive it has a "tack" and does not transfer to your finger. Do not lay tile until adhesive has sufficiently dried and developed tack.
4. Begin installing tile carefully at the pre-set starting point. Once placed into the adhesive tile will be difficult to shift, remove, and/or replace. Starting off properly is most critical in that the first tile placement will greatly determine the lay-up of the area to be installed.
5. Continue laying tile, working away from the start point by placing and pressing tile into the adhesive film. Carefully place tile wherever a new row is started. Since adhesive will instantly grab tile placed into it, it will not shift, allowing you to work on newly laid tile. Install tile along the chalk lines first then working into the field in a pyramid fashion
6. All vinyl composition tile installed residentially should be thoroughly cross-rolled with a 100 lb. (kg) three-sectional-roller. Rolling is considered optional for most commercial applications. When necessary, thoroughly roll completed area with the recommended three-sectional weighted roller. Rolling procedure should involve rolling first in one direction (north/south), the other (east/west), then diagonally.
7. Follow this same procedure when installing other areas of the jobsite.
8. Floor is ready for light traffic only immediately. Do not allow heavy traffic on the floor for several days or until after recommended initial maintenance has been performed. Do not maintain the floor for at least 3 days after installation.

Spray Adhesive Installation System

To facilitate large installations of vinyl composition tile DOMCO TARKETT has developed a special adhesive and application system for use in paint spraying equipment. This system offers significant advantages in terms of adhesive application labor and consistency. Also, this system eliminates the need for replacing or re-notching of trowels, thus eliminating one source of trowel swirls typically noticed after installation of expanses of vinyl composition tile. This system is compatible with the installation of all Azrock Vinyl Composition Tile. Limitations for use of this system is the same as that listed for normal trowelable DOMCO TARKETT 100 Clear Thin Spread Adhesive.

This system consists of the following items:

DOMCO TARKETT 110 SPRAYABLE CLEAR THIN SPREAD ADHESIVE

GRACO ULTRA MAX 695 AIRLESS SPRAYER

(DOMCO TARKETT recommends purchasing of the complete Sprayer Kit, Graco Part # 245001. This system comes complete with a Contractors Gun, HandTite (Tip Guard, 50' X 1/4") (15 M X 6.3 mm) BlueMax(Hose)

Other Graco Accessories required:

- Heavy Duty 20" (500 mm) Extension Part # 232122
- Graco Standard Swivel Part # 235486
- Several # 635 Tips (Orange handle)
- Throat Seal Liquid Part # 206094

Contact Graco Inc. direct for distribution and equipment availability information:

Graco Inc.
 P.O. Box 1441
 Minneapolis, MN 55440-1441
 (800) 690-2894 Fax: (800) 334-6955 www.Graco.com

- 2 Clean 5 Gallon Buckets
- Small amount of Ivory or similar dish detergent

Equipment should be assembled as recommended by Graco. Review all operational and clean up details as supplied by Graco. Attach extension with swivel and tip guard to the trigger gun mechanism. Do not insert spray tip until after equipment has been primed with adhesive.

We do recommend that BOTH the Manifold and Gun filters be removed and not utilized during adhesive spraying. Equipment will require a daily clean out procedure. DO NOT allow adhesive to remain in any spray equipment or hoses if equipment is not being utilized.

DIRECTIONS FOR USE OF SPRAY EQUIPMENT

Remove the lid from a bucket of DOMCO TARKETT 110 Sprayable Clear Thin Spread Adhesive and place under pump extension housing. When first starting, prime the equipment and hoses by running adhesive through under low (<500 P.S.I.) pressure until only adhesive flows freely through the system.

Insert a # 635 tip ensuring the arrow handle is pointed in the direction to be sprayed. Turn on equipment and adjust pressure to achieve between 500-800 P.S.I. during operation. Higher pressure will produce a finer spray, lower pressure will produce a coarser spray. Test spray an area to determine fan width and tip height from the floor that best provides coverage and user comfort. A optimum fan width of about 15" - 18" (375-450 mm) would be achieved at a floor to spray tip height of between 18" - 24" (450-600 mm) at about 750 P.S.I. equipment operational pressure. Slight adjustments of equipment pressure and tip height may be required based on slight variations of jobsite temperatures, relative humidity, adhesive viscosity, user comfort level, and other factors.

Start spraying the floor at your tile installation start lines, ensuring a constant linear motion of the tip relative to the floor. Do not apply adhesive in a sweeping motion or stop while holding spray trigger open. While spraying a slightly heavier application will occur at the extreme ends of the spray fan. This is normal. Best results are achieved by conducting adhesive application in long directional rows, first in one direction than reversing and applying the next row in the other direction. A slight overlap of spray should occur but avoid a double build up from the adhesive at the extreme ends of the fan. Correct equipment settings and operator procedures will result in a spray rate of about 425 square feet (36 M²). Properly adjusted equipment and user operation should cover this area and

adhesive quantity in about 1 minute. If the tip becomes clogged (resulting in an uneven fan width) reverse the direction of the tip and briefly spray into a waste bucket. This will clean out the tip. Turn tip to face correct spray direction before continuing the spray operation.

Add adhesive to the bucket being pumped before adhesive reaches sump filter. Continue to add adhesive as consumed, there will be no need to replace the actual pump bucket. In addition a partially filled bucket can be moved with the equipment through use of the pump handle on the front of the machine. Equipment can be moved when necessary, but spray operation should not be performed during equipment movement. Purchase of an additional 50' (15 M) length of hose will help in limiting actual equipment moving. While a single person operation is possible best productivity is achieved by having a dedicated spray head operator along with an equipment operator.

Adhesive will be ready for installation in about 15 - 30 minutes depending on temperature, relative humidity, and porosity of subfloor. Adhesive will turn from a milky color to a clear film. Open time is a maximum of 8 hours.

For cleanup, pump bucket is removed and cover replaced for possible later use. Remove the #635 spray tip and place into a container of clean water or mineral spirits. Equipment is flushed by placing a bucket of clean water under pump extension housing. Clean water is pumped through the equipment into another waste bucket. Run water through until material runs clean. Clean pump extension housing of adhesive residue during this process. Repeat the process using a new bucket of clean water with some small amount of liquid dish detergent. Prior to this second flush, clean out empty manifold chamber (filter element occupies the chamber during paint spray operation) and ensure bottom screen filter of pump extension housing is free of debris. Second flush out operation should be for no less than 2 minutes. If the Graco unit utilized comes equipped with their AutoClean option, this can be used for the second flush out procedure. Properly dispose of any waste water or adhesive.

Equipment would then be ready for use the next day. It is not recommended that the equipment be stored containing water for any extensive time periods. Follow Graco recommendations for preparation of equipment for any long term storage. Proper care of the equipment will ensure a long and productive life span.

II. Slip Resistant Surfaces

The above recommendations also hold true for Azrock Slip Resistant Vinyl Composition Tile products with the following exceptions:

- Slip Resistant is utilized in a large number of cases in produce and other areas where increased amounts of surface water or harsher environmental conditions may occur. In these areas the use of DOMCO TARKETT 940 Polyurethane Adhesive offers increased benefits. Thus we recommend that underneath and within 5 feet (1.5 meters) of all freezer, refrigerator, water spraying and similar units tile be installed with this adhesive system. In addition any other areas where surface water and/or temperature fluctuations may occur.
- For proper performance of this adhesive all existing flooring and adhesive residues must be removed in the areas where this adhesive is to be applied.
- DOMCO TARKETT 940 Polyurethane Adhesive is a two part wet-set adhesive type that requires tile to be placed into wet adhesive and rolled thoroughly prior to adhesive set-up. Follow the Wet-Set Installation System as outlined below.

Wet-Set System

The wet-set system requires the adhesive to be troweled on the approved subfloor and tile placed into the adhesive film prior to adhesive skinning-over or set. This procedure requires the adhesive vehicle to dissipate into the subfloor for water or solvent-based adhesive products. This system is designed for use over properly prepared porous concrete subfloors below, on or above grade as well as above grade plywood subfloors. This procedure is **not** recommended for use over existing resilient or other **non-porous** subfloors. We strongly recommend that bond tests be performed, prior to installation, to confirm proper porosity of the substrate.

General directions are as follows:

1. After the recommended subfloor has been prepared and is ready for flooring installation prepare tile layout as described in Section 5, Tile Layout, Squares.
2. Spread recommended adhesive in area to be covered in accordance with adhesive label directions spreading only enough adhesive that can be covered over within its working time. Trowel up to layout lines. Proper adhesive application and tile placement usually requires working "backward." Working this way helps to avoid spreading too large of an area and adhesive setting up prior to tile placement.
3. Place tile into wet adhesive film. Wet film will allow some "slip" if tile placement needs to be adjusted slightly. Continue laying tile by carefully placing them into the wet film. Do not press hard or kneel on newly tile installed tile as this may result in adhesive displacement or oozing. If it is necessary to work on freshly installed tile use kneeling boards or similar apparatus. We recommend that periodically a tile be lifted and checked to ensure adhesive transfer.
4. Thoroughly cross roll installed area using the recommended weighted three-sectional-roller. Rolling procedure should involve rolling first in one direction (north/south), the other (east/west), then diagonally. This would ensure proper transfer of adhesive onto tile backs. Proper transfer is when 90% or better of the tile backs are "smeared" with adhesive with little or no distinct trowel ridges visible. Failure to ensure this can lead to tile loosening later.

5. Continuing working backward follow this same procedure when installing other areas of the jobsite. Roll completed areas occasionally and entire job upon completion.
6. Do not allow traffic on floor a minimum of 24 hours. Allow only light traffic on the floor for the next several days or until recommended initial maintenance has been performed. Do not maintain the floor for at least 3 days after installation.

III. Static Dissipative (SD)

The recommendations for Smooth Surface Tile also hold true for Azrock Static Dissipative (SD) Vinyl Composition Tile products with the following exceptions:

- DOMCO TARKETT's 950 Pressure Sensitive Conductive Adhesive **MUST** be utilized for the installation of this product. The use of any other adhesive will affect finished flooring electrical properties and void your warranty. This adhesive is utilized in a conventional dry set fashion.
- All concrete substrates are required to be tested for moisture vapor transmission by the quantitative calcium chloride test method in accordance with ASTM F 1869 as indicated under Section 1 Concrete Substrates. Acceptable substrates will have in-service moisture vapor transmission rates of no more than 3 lbs./1,000 square feet/24 hours. Acceptable on or below grade slabs will also incorporate a proven and uncompromised vapor barrier that will prevent moisture intrusion from the subsoil.
- Static Dissipative (SD) Tile is not recommended in areas affected by excessive topical water or frequent spillage. Prolonged exposure to topical moisture may affect the bond of the tile to the substrate.
- This product is not recommended to be installed over residual asphalt (cutback) adhesive. Any existing asphaltic adhesive will need to be removed, covered over with appropriate underlayment plywood or DOMCO TARKETT's Kwik Patch and Additive.
- This product is not recommended to be installed over any existing floor coverings. These need to be removed or covered to present an acceptable substrate for tile installation.
- Grounding of the floor is considered by DOMCO TARKETT to be an optional procedure based on end user's requirements. Consult the appropriate parties to determine the need and amount of grounding to be utilized.
- Any electrical testing for certification should be done prior to initial maintenance procedures.
- Floor needs to be maintained in accordance with Azrock's written recommendations for Static Dissipative (SD) Vinyl Composition Tile.

NOTE: The Azrock Cortina SD™ Static Dissipative Tile is produced with a specialized additive. Some individuals may have sensitivity to this material. Thoroughly wash hands with soap and water after handling tile.

VINYL ENHANCED TILE

Reference Specification

ASTM F 1066-99 “Standard Specification for Vinyl Composition Floor Tile”

Products: Azrock’s Vinyl Enhanced Tile (VET™)

Adhesive: DOMCO TARKETT 800 PRESSURE SENSITIVE Adhesive (dry set)

NOTES:

- DO NOT USE ANY LATEX ADHESIVES OVER EXISTING ASPHALT RESIDUES
- APPLY ADHESIVE WITH THE RECOMMENDED TROWEL NOTCHING
- WAIT UNTIL ADHESIVE HAS FULLY DRIED TO THE TOUCH BEFORE INSTALLING TILE
- NEVER SPREAD MORE ADHESIVE THAN CAN BE COVERED OVER IN THE SAME WORK DAY
- INSTALL AZROCK’S CORTINA GRANDE (VET™) WITH THE DIRECTIONAL ARROWS IN THE SAME DIRECTION
- ALWAYS HEAT THE BACK OF THE TILE FOR CUTTING, NEVER THE FACE
- CUT NET TO ALL VERTICAL SURFACES

Dry-Set System

The dry-set system requires the adhesive to be troweled on the approved subfloor and allowed to dry prior to tile placement. This procedure allows the adhesive vehicle to dissipate into the atmosphere for water or solvent-based adhesive products. This system is designed for use over properly prepared concrete subfloors below, on or above grade as well as above grade plywood subfloors. This procedure is also utilized for those adhesives and flooring materials which may be installed over existing resilient subfloors.

General directions are as follows:

1. After the recommended subfloor has been prepared and is ready for flooring installation, prepare tile layout as described in Section 5, Tile Layout, Squares.
2. Spread recommended adhesive in area to be covered in accordance with adhesive label recommendations. In most cases adhesive should be spread over flooring layout lines, adhesive will dry translucent and lines can be seen. Over some subfloors if lines are removed during adhesive troweling these should be re-striking over the spread adhesive.
3. Allow adhesive to dry completely to the touch. Proper drying is usually determined when by placing your thumb into the adhesive it has a “tack” and does not transfer to your finger. Do not lay tile until adhesive has sufficiently dried and developed tack.
4. Begin installing tile carefully at the pre-set starting point. Once placed into the adhesive tile will be difficult to shift, remove, and/or replace. Starting off properly is most critical in that the first tile placement will greatly determine the lay-up of the area to be installed.
5. Continue laying tile, working away from the start point by placing and pressing tile into the adhesive film. Carefully place tile wherever a new row is started. Since adhesive will instantly grab tile placed into it, it will not shift, allowing you to work on newly laid tile.

6. Thoroughly roll completed area with the recommended three-sectional weighted roller. Rolling procedure should involve rolling first in one direction (north/south), the other (east/west), then diagonally.
7. Follow this same procedure when installing other areas of the jobsite.
8. Floor is ready for light traffic only immediately. Do not allow heavy traffic on the floor for several days or until after recommended initial maintenance has been performed. Do not maintain the floor for at least 3 days after installation.

SOLID VINYL TILE

Reference Specification

ASTM F 1700-99 “Standard Specification for Solid Vinyl Floor Tile”

Product Category:	Azrock’s Solid Vinyl Tile (SVT)
Adhesive:	DOMCO TARKETT 800 PRESSURE SENSITIVE Adhesive (dry set)
Fitting:	Conventional Tile Squares Layout

NOTES:

- INSTALL TILE WITH DIRECTIONAL ARROWS IN THE SAME DIRECTION.
- RADIANT HEATED FLOORS REQUIRE THE USE OF DOMCO TARKETT 400 ADHESIVE (WET SET) OR DOMCO TARKETT 940 ADHESIVE (SPECIALIZED WET SET).
- DO NOT USE ANY LATEX ADHESIVES OVER EXISTING ASPHALT RESIDUES
- APPLY ADHESIVES WITH THE RECOMMENDED TROWEL NOTCHING
- WAIT UNTIL ADHESIVE HAS FULLY DRIED TO THE TOUCH BEFORE INSTALLING TILE
- NEVER SPREAD MORE ADHESIVE THAN CAN BE COVERED OVER IN THE SAME WORK DAY
- ALWAYS HEAT THE BACK OF THE TILE FOR CUTTING, NEVER THE FACE
- CUT NET TO ALL VERTICAL SURFACES

Dry-Set System

The dry-set system requires the adhesive to be troweled on the approved subfloor and allowed to dry prior to tile placement. This procedure allows the adhesive vehicle to dissipate into the atmosphere for water or solvent-based adhesive products. This system is designed for use over properly prepared concrete subfloors below, on or above grade as well as above grade plywood subfloors. This procedure is also utilized for those adhesives and flooring materials which may be installed over existing resilient subfloors.

General directions are as follows:

1. After the recommended subfloor has been prepared and is ready for flooring installation, prepare tile layout as described in Section 5, Tile Layout, Squares.
2. Spread recommended adhesive in area to be covered in accordance with adhesive label recommendations. In most cases adhesive should be spread over flooring layout lines, adhesive will dry translucent and lines can be seen. Over some subfloors if lines are removed during adhesive troweling these should be re-striking over the spread adhesive.
3. Allow adhesive to dry completely to the touch. Proper drying is usually determined when by placing your thumb into the adhesive it has a “tack” and does not transfer to your finger. Do not lay tile until adhesive has sufficiently dried and developed tack.

4. Begin installing tile carefully at the pre-set starting point. Once placed into the adhesive tile will be difficult to shift, remove, and/or replace. Starting off properly is most critical in that the first tile placement will greatly determine the lay-up of the area to be installed.
5. Continue laying tile, working away from the start point by placing and pressing tile into the adhesive film. Carefully place tile wherever a new row is started. Since adhesive will instantly grab tile placed into it, it will not shift, allowing you to work on newly laid tile.
6. Thoroughly roll completed area with the recommended three-sectional weighted roller. Rolling procedure should involve rolling first in one direction (north/south), the other (east/west), then diagonally.
7. Follow this same procedure when installing other areas of the jobsite.
8. Floor is ready for light traffic only immediately. Do not allow heavy traffic on the floor for several days or until after recommended initial maintenance has been performed. Do not maintain the floor for at least 3 days after installation.

LUXURY VINYL TILE

Reference Specification

ASTM F 1700-99 “Standard Specification for Solid Vinyl Floor Tile”

Product Category: Azrock’s Luxury Vinyl Tile (LVT)

Adhesive: DOMCO TARKETT 800 PRESSURE SENSITIVE Adhesive (wet/tacky set)

Fitting: Conventional Tile Squares layout
Stripwood layout

NOTES:

- INSTALL OVER CONFIRMED POROUS SUBSTRATES ONLY
- INSTALL TILE WITH DIRECTIONAL ARROWS IN THE SAME DIRECTION.
- RADIANT HEATED FLOORS REQUIRE THE USE OF DOMCO TARKETT 400 ADHESIVE (WET SET) OR DOMCO TARKETT 940 ADHESIVE (SPECIALIZED WET SET).
- FLOORS SUBJECTED TO DIRECT SUNLIGHT REQUIRE THE USE OF DOMCO TARKETT 940 ADHESIVE (SPECIALIZED WET SET).
- DO NOT INSTALL DIRECTLY OVER EXISTING ASPHALT RESIDUES
- APPLY ADHESIVES WITH THE RECOMMENDED TROWEL NOTCHING
- ALWAYS HEAT THE BACK OF THE TILE FOR CUTTING, NEVER THE FACE
- CUT NET TO ALL VERTICAL SURFACES

Wet/Tacky Set System

The wet/tacky set system requires the adhesive to be troweled on the approved subfloor and tile placed into the adhesive film just prior to the adhesive setting up. This procedure does require the adhesive vehicle to partially dissipate into the subfloor. This system is designed for use over properly prepared porous concrete subfloors below, on or above grade as well as above grade plywood subfloors. This procedure is not recommended for use over existing resilient or other non-porous subfloors. We strongly recommend that bond tests be performed, prior to installation, to confirm proper porosity of the substrate.

General directions are as follows:

1. After the recommended subfloor has been prepared and is ready for flooring installation prepare tile layout as described in Section 5, Tile Layout, Squares or Planks.
2. Spread recommended adhesive in area to be covered in accordance with adhesive label directions spreading only enough adhesive that can be covered over within its working time. Trowel up to layout lines. Proper adhesive application and tile placement usually requires working “backward.” Working this way helps to avoid spreading too large of an area and adhesive setting up prior to tile placement.

3. Allow adhesive to partially set up. The time for this may vary depending upon substrate porosity and room humidity conditions. The proper point to start tile placement is when the top of the adhesive ridges still display a “wet” appearance while the adhesive in contact with the substrate has dried clear.
4. Place tile into the adhesive film. Wet/tacky film will allow limited “slip” if tile placement needs to be adjusted slightly. Continue laying tile by carefully placing them into the adhesive film. Do not press hard or kneel on newly tile installed tile as this may result in adhesive displacement or oozing. If it is necessary to work on freshly installed tile use kneeling boards or similar apparatus. We recommend that periodically a tile be lifted and checked to ensure adhesive transfer.
4. Thoroughly cross roll installed area using the recommended weighted three-sectional-roller. Rolling procedure should involve rolling first in one direction (north/south), the other (east/west), then diagonally. This would ensure proper transfer of adhesive onto tile backs. Proper transfer is when 50% or better of the tile backs are “smeared” with adhesive with little or no distinct trowel ridges visible. Failure to ensure this can lead to tile loosening later.
5. Continuing working backward follow this same procedure when installing other areas of the jobsite. Roll completed areas occasionally and entire job upon completion.
6. Do not allow traffic on floor a minimum of 24 hours. Allow only light traffic on the floor for the next several days or until recommended initial maintenance has been performed. Do not maintain the floor for at least 3 days after installation.

COMMERCIAL INLAID SHEET VINYL

Felt Backed/Full Spread

Reference Documents for Specifications:

ASTM F 1303-99 "Standard Specification for Sheet Vinyl Floor Covering with Backing"

Products:	Azrock's Commercial Inlaid Series 8000
Adhesives:	DOMCO TARKETT 400 Acrylic Hard-Set Adhesive
Pattern Match:	No pattern match, reverse sheets
Fitting:	Freehand Knifing
Seam Method:	Double Cut/Double Face Tape (Perma-Seam)
Seam Treatment:	DOMCO TARKETT PVC Seam Sealer (Heat welding Optional- Use TARKETT SOMMER PVC Rods)

NOTES:

- INSTALL ALL CUTS AND ROLLS IN CONSECUTIVE ORDER
- DO NOT INSTALL DIRECTLY OVER RESIDUAL ASPHALT ADHESIVE
- RESPECT ADHESIVE TROWEL NOTCHING AND OPEN TIMES
- DO NOT USE DOUBLE FACE TAPE WHEN HEAT WELDING
- ALL EXPOSED EDGES SHOULD BE COVERED USING COVE BASE, OR WOOD QUARTER ROUND.

COMMERCIAL INLAID SHEET VINYL INSTALLATION SYSTEM

This system is recommended for all commercial felt-backed sheet vinyl. This is also known as the Fully Adhered method in that the DOMCO TARKETT recommended adhesive is spread with the specified notched trowel in a thin, uniform coat over the complete surface of the subfloor. The sheet vinyl is placed into the wet adhesive film and thoroughly cross-rolled to achieve full adhesive transfer.

MATERIAL STORAGE AND HANDLING:

Commercial Inlaid felt-backed sheet vinyl floorings must always be stored tightly rolled on a core, face out. If the material is back rolled it will cause the material edges to curl upward resulting in a difficult or unsatisfactory installation.

Be especially careful not to extend sheet vinyl rolls over the edge of the storage racks, or position over foreign objects this will cause pressure marks and possible material damage.

Prior to the installation, it is the responsibility of the installer to check the suitability of all job site, working conditions and subfloors.

SHEET PLACEMENT AND LAYOUT:

Estimating material requirements:

Single length of material:

Measure the room from wall to wall, length and width, each in two places, using the greater dimension of each direction, plus 3"(80mm). Measurements should also include allowance for doorways, usually being made to the center of the thresholds.

The additional 3" (80mm) allows approximately 1" (25mm) extra, around the perimeter of the room. This is a necessary precaution since walls do not always run true.

When more than one width of flooring is required:

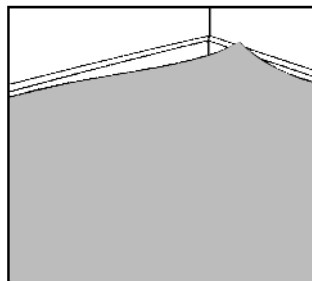
When the installation requires more than one width of material, it will be necessary to make allowance for trimming as above as well as width selvedge edge for seam cutting. Commercial Inlaid does not require pattern matching but sheets are reversed for seaming. (Back printed trademarked edge (TM) to TM edge.)

Second length of material: The second and all succeeding sheets should be cut consecutively from the rolls. After the underlayment has finally been rendered smooth, sweep the room thoroughly, especially around the perimeter removing all dust, dirt, grit or other foreign matter. Concrete substrates should be vacuumed.

SHEET PLACEMENT AND LAYOUT:

Single width of material for a seamless floor:

Fig. 1-The sheet to be installed should be cut 3" (80mm) oversize to allow for wall irregularities. The excess material is lapped up the walls.



FITTING CORNERS

Fig. 2-Outside corners: Relief cuts are then made at the outside corners, from the top of the lapped-up material to where the floor and wall meet. DO NOT INDUCE STRESSES.

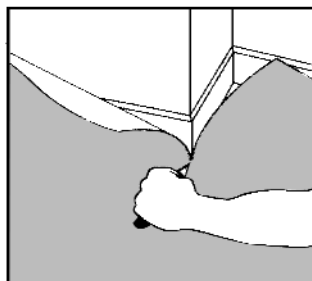


Fig. 3-Inside Corners: Diagonal cutoffs are made at inside corners until the material falls into place in the corner angles.

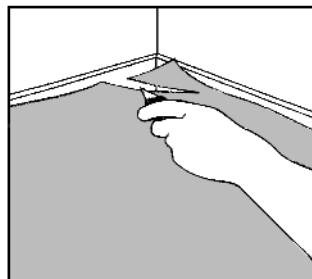
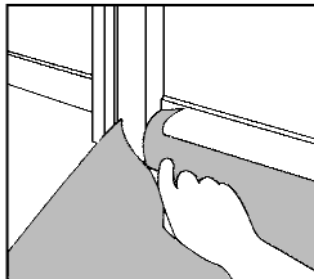


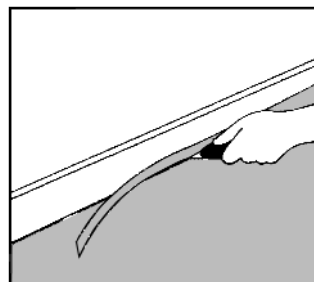
Fig. 4-Door Casing: The base of the door casing may have to be cut to the thickness of the material. This can be neatly done with a trim saw and the flooring tucked under.

Trimming around door casing is more difficult. Therefore, cut only a little material at a time until it fits perfectly. This latter step should be done only after application of adhesive.



TRIMMING ALONG THE WALLS

Fig. 5-Using a heavy duty utility knife with a new clean blade, carefully and gradually trim the lapped material along the perimeter of walls and fixtures.



SPREADING ADHESIVE

When the sheet has been dry laid and fitted into place, turn back carefully, one-half to its length on small installation. On large installations with long runs, turn back one-half of the width. Apply adhesive starting from the rolled back material toward the opposite wall.

The open time for the adhesive will vary somewhat with atmospheric conditions and the temperature of the subfloor. At this point and within 10 minutes the vinyl flooring should be rolled back into the wet adhesive. Do not drop or it will entrap air. The sheet must then be rolled with a three sections (one hundred pounds) roller in both directions to embed the backing in the adhesive and remove air pockets.

Wet adhesive shall be removed immediately from the surface of the sheet vinyl flooring with a damp cloth - never use solvents. Dried spots of adhesive shall be removed with fine nylon pads dipped in DOMCO TARKETT Neutral Floor Cleaner and water.

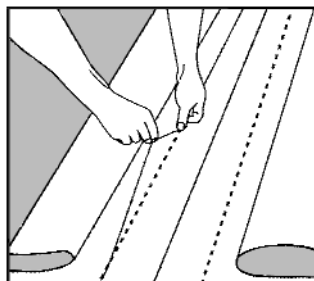
Follow the same procedure for the other half of the sheet.

When more than one width of material is installed:

LOCATION OF THE SEAM

All seams must be dry double-cut, except for heat welded materials (See underscribed seam procedure, Section 3 , page 51). DOMCO TARKETT Sheet Vinyl materials are sufficiently over-width to permit double cutting at all times.

Fig. 6-Determine where the seam will be positioned. Snap a white chalk line where the seam will fall. Seams in the new flooring must be placed at least 6"(153mm) from any seams in underlayment.



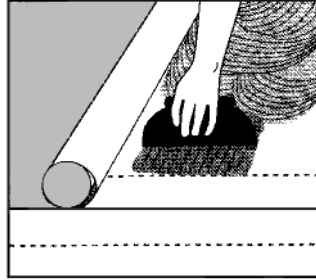
It is also necessary to snap parallel chalk lines 12"(305mm) on both sides of the pencil seam line.

This is to remind you to leave a full 24"(610mm) wide band free of adhesive (dry zone) in the seam area.

Fit the first sheet in the same way described for single sheet installation except that the selvage of the material, furthest from the wall, is carefully laid over the pencil line exactly where the seam will fall. This prevents the sheet from arching and causing problems when the sheets are matched.

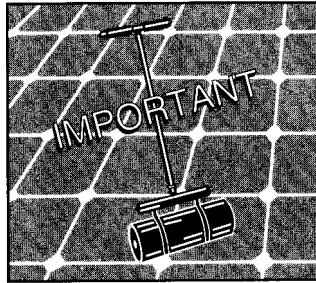
When the first sheet has been fitted, roll it back carefully, one half to its length.

Fig. 7-Spread the adhesive starting from the rolled back material toward the opposite wall and to the 12"(305mm) chalk line. Be sure to spread adhesive over the entire floor area to be covered.



The open time for the adhesive will vary somewhat with atmospheric conditions and the temperature of the subfloor. Within 10 minutes, the vinyl flooring should be rolled back into the adhesive. Do not drop or air will be entrapped.

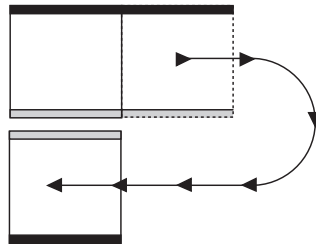
Fig. 8-The sheet must then be rolled with a heavy roller (100 lbs.) in both directions to embed the backing in the adhesive and remove air pockets.



Follow the same procedure for the other half of the sheet.

POSITIONING THE SECOND AND SUBSEQUENT SHEETS.

Fig. 9-Reversal of sheets -Simply means to turn the adjoining sheet 180 degrees to the first sheet. Never 90 degrees. The seaming is done utilizing the same side (selvage) of the sheet.



Reverse sheets -The same selvage edges are placed together.

The adhesive is spread following the same procedure as for the first sheet. Spread the adhesive only to the 12"(305mm) chalk line.

SEAM CUTTING METHOD

DOMCO TARKETT recognizes these following methods for cutting seams in its Azrock Series 8000 Commercial Inlaid Sheet Vinyl:

DOUBLE-CUT Seams can be double-cut dry when cold welding.

Seam edges to be cut are overlapped at least 3/4" (19 mm)

1. With a steel straight edge to guide the knife, cut through both layers of the vinyl flooring. It is important to cut through both layers in a single motion and to hold the knife at a right angle to the floor.
2. Use a very sharp, clean, straight blade utility knife.
3. Remove the scrap pieces.
4. Raise the edge of each sheet, for application of fully adhered Perma-Seam procedure.

UNDERSCRIBE One seam edge is straight edged, the other scribed and cut when heat welding.

All sheets are field cut previously in the area to be installed leaving an approximate 1" (25 mm) overlap. Seams are underscribed wet.

1. Prior to application of adhesive edge trim approximately 1/2" (12 mm) with a straight edge and a new sharp utility knife off of the bottom sheet. Edge trimmers may also be utilized.
2. Material is adhered to the subfloor in accordance with product specific procedure.
3. Using a standard underscriber and following the bottom sheet, the overlapping top sheet is scribe marked. When setting underscriber adjust with a slight gap, no more than 1/32" (0.8 mm) to help guide router.
4. Cut along the scribed mark with a hook blade knife. Be careful not to nick the bottom flooring. When cutting keep the knife blade straight. Material is then both hand rolled at the seam and finished rolled with the three-sectional-roller.
5. Wait 24 hours before heat welding.

DOMCO TARKETT'S PERMA-SEAM PROCEDURE

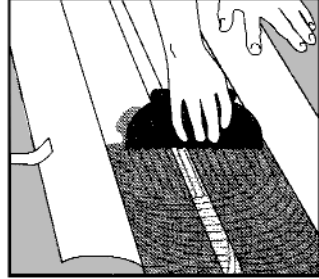
Double Face Tape Method

Since it is extremely important that all precautions be taken to keep adhesive out of the seam and from interfering with chemically welding, DOMCO TARKETT recommends the following Double Face Tape method. DOMCO TARKETT was the innovator of this procedure over twenty years ago to help address seam contamination, the number one reason for seam failure. This procedure will work equally well on all approved subfloors. Recommended types of subfloors must be clean, dry and free of dust and foreign matter. If a dusty concrete subfloor is encountered, we recommend priming with DOMCO TARKETT's Kwik Patch Latex Additive in the seam areas sufficiently in advance to the seaming operation so that it will dry thoroughly. Apply the Additive with a paint brush or a short nap paint roller. Use care not to apply too much primer. Allow primer to dry completely.

This method is recommended for all Azrock Commercial Inlaid installations where cold PVC welding is the recommended procedure. This procedure is not recommended under heat welded seams.

Prior to spreading the adhesive in the 24" (610 mm) dry zone, center the non-staining Double Face Tape 2" (51 mm) on the seam line and roll it down thoroughly with a hand roller onto the subfloor. Leave the release paper on the tape.

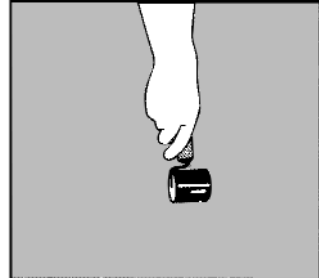
- Apply the adhesive to the remainder of the dry zone, covering the double face tape. Pay particular attention to adhesive open time to ensure success of the seaming operation.



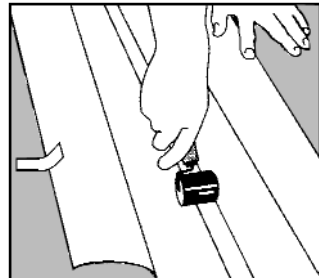
- Remove release paper and place top sheet down onto the adhesive and tape. Next, tuck the second sheet into place.



- Roll the 24" (610 mm) area on both sides of the seam with the Three-Section Roller and then level the material at the seam with a hand seam roller.



- Never use a heavy Three-Section Roller within 3" (80 mm) of either side of the seam.



SEALING THE SEAMS

After completion of the installation, all seams must be sealed as soon as possible to prevent traffic soil contamination. Use the recommended DOMCO TARKETT PVC Seam Sealer using DOMCO TARKETT's Professional Seam Sealer Applicator (Metal tip).

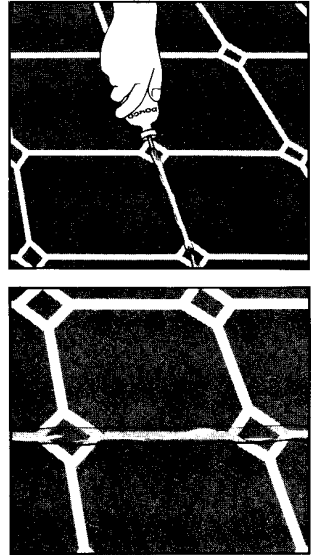
Starting at one end of the seam and progressing slowly, insert the vertical fin of the DOMCO TARKETT Professional Seam Sealer Applicator (metal tip) into the joint, down to the double face tape. This momentarily spreads open the seam to permit the flow of the seam sealing liquid between the edges of the vinyl flooring which fuses the adjoining wearlayers together.

Apply only very light pressure to the DOMCO TARKETT Professional Seam Sealer Applicator to lay down a bead of seam sealer $1/16"$ (1.6 mm) on either side of the seam for a total at the surface of the seam of $1/8"$ (3.175mm) wide.

Avoid spilling seam sealer on the vinyl flooring as there is no suitable solvent for its removal. Any attempt to wipe up the seam-sealer liquid will damage the finish of the flooring. Should spillage occur, the best resort is to leave the spillage un-disturbed and allow it to harden.

The seam area must not be disturbed for at least three hours after sealing. The room shall be used as little as possible for 24 hours.

IMPORTANT: Never leave a seam unsealed overnight.



HEAT WELDED SEAM PROCEDURE

This procedure essentially produces a "seamless" floor which is usually required in critically clean areas. Properly done these seams will last the life of the floor covering and are water tight.

It is important that the Tarkett Sommer PVC welding rod be utilized for welding Azrock's Series 8000 Commercial Inlaid.

TOOLS

Heat welding requires specialized tools in addition to that normally utilized on resilient floor coverings. The following list are suggested tools used for heat welding:

1. Router Mafell KFU 1000, 110 Volt or equivalent with Blade .130" (3.3mm) U-Shaped for .160" (4mm) welding rod
2. Replacement Blades for the above
3. Hot Air Welding Gun, Leister Triac, 110 Volt, complete with carrying case or equivalent
4. 2 Heating Elements for Leister Triac, 1400 watt or equivalent
5. 2 Hand Groovers with guide
6. Spare Blades for groover
7. Pressure Roller for Welding Rod
8. Quarter-moon knife
9. Quarter-moon knife with angular blade
10. Trimming Guide
11. Grindstone
12. Automatic Welding Kit RAPID K 52, 110 Volt or equivalent
13. 2 Heating Elements for RAPID K 52, 1800 Watt or equivalent
14. Round nozzle (4 mm) for welding rod



Routing and welding of the flooring material should be done a minimum of 24 hours after installing and after the adhesives have set up.

Important: Under no condition should the flooring material be routed and heat welded the same day it is put into the adhesive. Routing is performed using a blade that will put a U-shaped groove into the material. Width of the blade should be approximately .130" (3.3mm) for a .160" (4mm) welding rod. Routing depth should be 3/4 of the thickness of the floor covering materials wearing surface. For Azrock's Series 8000 Commercial Inlaid this should be about 40 mils, DO NOT break into the felt backing. Do not rout completely through the thickness of the material. Check router depth on a piece of scrap material.

Larger areas are generally welded using an automatic welding machine. Continuous monitoring of this welding process is essential as job site conditions such as drop in electric current, depressions in the subfloor, or contaminated routed joints may have a negative effect on the quality of the weld.

When using Tarkett Sommer PVC rod immediately after heat welding, trim the exposed welding rod using a spatula knife equipped with a guide blade. This will remove approximately 3/4 of the welding rod above the surface of the floor. After the welding rod has completely cooled, remove the guide blade from the spatula knife and trim the remaining exposed welding rod flush with the surface of the floor. Pay particular attention to keeping the spatula knife very sharp and be careful not to nick or gouge the floor covering material. These precautions will prevent the welded seam from being concave.

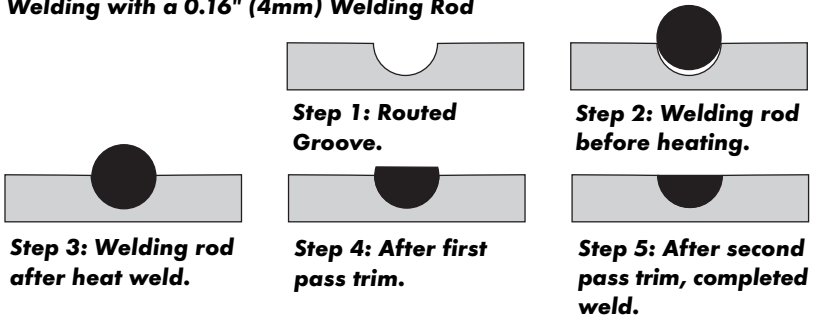
Helpful Hints

The following check list would be helpful in achieving a good heat welded system:

- Correct depth of routing - app. 3/4 the depth of wearing surface
- Correct welding temperature. Try to make sure you are using an electrical outlet on its own circuit breaker.
- Synchronized welding speed and pressure
- Trim welding rod in two steps (see below)
- Use sharp knives only
- It is a good practice to conduct welding tests, on a piece of scrap material, prior to actual welding on the finished installation.

The bond of the heat-welded seam can be checked by pulling on the installed welding rod. If it is removed easily, that means it is a bad weld.

Welding with a 0.16" (4mm) Welding Rod



If there are any questions, please contact Azrock's Installation Services Department prior to starting the installation, and if any problems or questions arise during the installation, stop the job and call us immediately. This can prevent the possibility of compounding a minor problem into a major problem.

Remember, most jobs present some aspects or situations unique to themselves which must be clarified prior to the installation. We will be more than happy to answer all these questions.

PREPARATION

As in most operations, preparation is the all important factor. Seams must be well cut, butt jointed close and secured to the subfloor using the recommended adhesive. A slight gap of no more than 1/32" is allowable to aid in guiding the router down the length of the seam. It must not be assumed that because welded joints have been specified that there can be any inconsistencies in the formation of a proper joint. Great difficulty will be encountered when "grooving out" if open joints or variation in thickness of sheet due to uneven adhesive application is in evidence. At least 24 hours should elapse to allow adhesive to set before the welding operation commences.

METHOD

Use the selected grooving tool adjusted to cut 3/4 into the warlayer thickness of material. (See Fig. 1) Groove a channel along the joint or seam. The channel or groove must be cleared of any material or adhesive waste. Power grooving tools have on the front leading wheel a flange which fits into the sheet seam and will guide the groover without the necessity of a straight edge. (See Fig. 2) Due to the radius of the circular cutting blade and safety cover housing, these machines can only groove to approximately 2" (610 mm) from the wall. A hand tool is therefore necessary to complete the groove by means of a straight edge. (See Fig. 3)



Figure 1

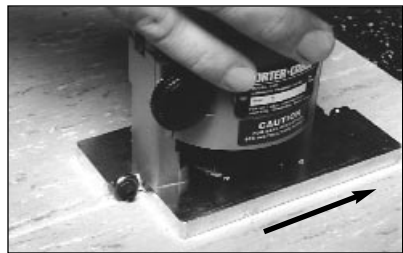


Figure 2: Power grooving.



Figure 3: Hand grooving.

The use of triangular paint scrapers is not recommended, these tend to give uneven channels. **Clean groove thoroughly with a vacuum cleaner or soft brush.**

PRE-HEAT THE WELDING GUN

The recommended welding temperature for Azrock's Series 8000 is 630°F-1,000°F (332°C-573°C). Manufacturer's instructions regarding settings to obtain this temperature should be consulted. Prior to heating ensure that the nozzle is securely fitted, and in good working order. Switch on the hot air gun and allow several minutes to attain the correct pre-selected operating temperature. The gun should, if rested on the flooring, have the hot air jet pointed away from the floor surface. When correct heat is attained, the welding rod can be threaded into the tool.

CHECK STRENGTH OF WELD

After the first 12" (30cm) are welded, check that a good weld is being obtained. Insufficient heat due to excessive speed, lack of downward pressure, dust and debris, or jerkiness will show in the parting of the weld. Welding too slowly or allowing the gun to stop, can result in distortion or total melting of weld rod and charring of material.

HEAT WELDING SEAMS

Cut a sufficient amount of welding rod to weld approximately 1/2 of the seam length.

NOTE: Matching colors of rod are available for each color of flooring. However, contrasting colors may be used if desired. Be sure rod on job site is the color and type specified.

Position excess rod and power cords so they will not interfere with application. Insert welding rod approximately 3" (80 mm) out through hole in welding nozzle starting at wall. Hold extended rod and immediately begin sealing the seam. **CAUTION:** Do not touch nozzle or barrel of welding gun; burn may result. The proper angle for heat welding is achieved when the tip of the welding nozzle is parallel to the flooring and not tilted to the right or left side of the seam.



Figure 4: Proper welding angle.

and trim off approximately 3" (80mm) at the end of the heat welded thread, flush with the flooring surface. (See Fig. 5) Use the hand grooving tool with the half round blade and rout approximately 1" (25mm) at end of flush trimmed thread. This will allow for easy overlap where the second half of the weld is fused to remaining seam length.

Pull the heat gun towards you, allowing the weld thread to feed through the nozzle. Approximately 1/2 of the weld thickness will heat bond in the seam. The excess will be trimmed off when cooled. Too slow a pace will char the weld and flooring. Too fast a pace will result in poor adhesion of the weld to the seam. (See Fig. 4)

Continue welding the seam until the end of the pre-cut vinyl thread. Use the trim knife



Figure 5: Trimming excess thread.

(See Fig. 6) Cut an additional length of rod to complete the remaining seam length. Start at the wall and work toward the center. Overlap approximately 3" (80mm) where second length of weld joins the first. (See Figures 7 & 8).



Figure 7: Forming center splice.

Trimming off welded rod is accomplished in two steps. The first step will remove most of the excess and should be conducted while weld is still warm with PVC rod. The second step is the final trim which is conducted when material is completely cooled.

Step 1 - Attach the trim plate to the crescent shaped spatula trim knife and remove approximately 2/3 of the heat welded rod. (See Fig. 9).

Step 2 - use the quarter moon shaped spatula trim knife (without trim plate) to remove the remaining weld rod protruding above the surface of the flooring at the seam. Apply moderate and continuous steady pressure while trimming the rod. (See Fig. 10).



Figure 6: Trimming for weld splice.

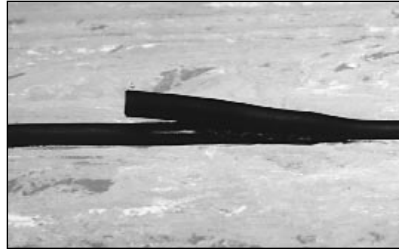


Figure 8: Overlap at splice.



Figure 9: Trimming excess thread.



Figure 10: Second pass finish trimming.

NOTE: Only the bottom side of the knife's cutting edge is sharpened.

Trimming blades must always be kept sharp and should be "honed" at frequent intervals, either on a stone or fine emery board.

Angle the blade of the knife when cutting. This allows the rod to be "sliced away;" with the blade square on, much more force is required.

GLAZE

After trimming, it is good practice to glaze the weld by gently reheating the weld surface. (See Fig. 11).



Figure 11: Glazing finishing weld.

HEAT WELDING PROBLEM AREAS

Failure of weld rod to key into the groove may be attributed to one or all of the following:

1. Wrong type of weld rod being used. Use only the recommended welding rods for the material specified.
2. Badly made seams. If the seam is open, i.e. there is a too wide a gap between the sheets, then welding is extremely difficult.
3. Badly cut groove. Grooving with an unsuitable tool, namely, a triangular paint scraper or tubular type will not produce a deep enough or smooth enough groove. It is essential that the groove be U-shaped and be about 2/3 to 3/4 thickness of the wear surfaces depth. (See Fig. 12).
4. If the groove has been made and left so that dirt or polish can penetrate, then failure is likely. Groove must be thoroughly cleaned of shavings prior to welding.
5. Welding too cold - a temperature of 630°F-1,000°F (332°C-573°C) for Azrock's Series 8000. Heat levels in excess of that will cause scorching.
6. Welding too fast - the maximum welding speed, at the above temperatures, is 3' (.9m)/minute.
7. Concave seams will result if rod is completely trimmed on initial pass. Welding rod must always be trimmed by the two-pass method.



Figure 12: Example of proper groove.

WALL BASE

Reference Documents for Specifications:

ASTM F 1861-98 “Standard Specification for Resilient Wall Base”

Products: DOMCO TARKETT Wall Base (Vinyl and Rubber)

Adhesives: DOMCO TARKETT 700 Wall Base Adhesive

Installation System: Wall Base

NOTES:

- INSTALL ON POROUS SUBSTRATES ONLY
- DO NOT INSTALL ON SUBSTRATES IN DIRECT CONTACT WITH THE GROUND
- HAND ROLL ALL INSTALLATIONS OF WALL BASE
- DO NOT INSTALL OVER EXISTING ADHESIVE RESIDUE
- RESPECT ADHESIVE TROWEL NOTCH AND OPEN TIME

WALL BASE INSTALLATION SYSTEM

This section details installation of vinyl and rubber wall base. As with flooring materials wall base, adhesive, and the area to be installed should be acclimated to normal room temperature of 70°F (21°C) at least 48 hours prior to, during and after installation. A minimum of 55°F (°C) should be maintained afterward.

Substrate Preparation

Suitable substrates for base will be clean, dry, porous, structurally sound, and not in direct contact with the ground. Base should not be installed on existing adhesive residues. Since base is installed with a water vehicle dispersed adhesive substrates must be porous. Laminated or surfaces covered with wallpapers or vinyl coatings are not acceptable and will affect material bond. Walls should be smooth and continuous to within 1/2" (13 mm) of the floor. Fill in any gaps or holes with a quality wall patching material. Base will only bridge over very minor imperfections. If any doubt exists as to possible telegraphing wall should be smoothed or patched. Prime excessively porous substrates with diluted Kwik Patch Additive.

We recommend to install either the **pre-molded outside corners** or jobsite manufactured outside corners first followed by the length base. For the pre-molded corner the recommended adhesive is applied to the back of the corner piece and the wall with the 1/8" (3 mm) V-notched spreader, then the piece is pressed firmly over the outside corner. We recommend the adjacent length base pieces then be installed, prior to adhesive set-up of the corner piece, to allow possible adjustment of the corner piece.

To **make an outside corner**, measure and then bend the wall base face-in at the point where the corner is to be made. With a utility knife held at an angle, shave a strip approximately halfway through and 1/4" (6 mm) wide from the ribbed back of the base at the point the corner is to be made. A small amount of heat, supplied by an electric heat gun, will make forming the corner easier. Allow the piece to cool before applying adhesive. Apply adhesive to the back of the base and also to the wall, position the corner and press firmly into place.

To **make an inside corner**, measure and then cut an inverted V-shaped notch in the toe of the wall base at the point where the bend is to be made. Bend the base at a right angle to shape the corner. A small amount of heat, supplied by an electric heat gun, will make forming the corner easier. Allow the piece to cool before applying adhesive. Apply adhesive to the back of the base and press firmly into position.

Installation of Wall Base

The length base, either in stick or roll form, is then installed between all the corner pieces. Adhesive is applied to the back of the base with the 1/8" (3 mm) V-notched spreader or through the use of the adhesive cartridge. If the wall surface is rough or irregular also apply adhesive to the wall. When applying adhesive either to the wall or the back of the base do not apply adhesive any closer than 1/2" (25 mm) to the top of the base. Although some tacking of the adhesive may aid in quick adhesion, base should be installed and rolled within 10 minutes of spreading the adhesive. The entire length of the piece to be installed must be pressed firmly to the wall to ensure a full transfer of adhesive. Base then is hand rolled firmly in one direction, toward the last piece installed (opposite the direction in which the base is being installed). This helps to prevent stretching of the base. Remove any adhesive smears and smudges as they occur.

During installation of cove-type wall base, press firmly down, flexing the toe tightly against the floor. This is especially important when using roll base. This smoothes out any irregularities in the toe area and prevents dirt from being swept underneath the base. In addition while the base will not be watertight, properly done, it will help against maintenance water intrusion that may get under the floor covering material. Where additional protection against floor surface moisture may be beneficial a bead of non-staining silicon caulk can be gunned behind the cove toe of the base prior to installation of the base. After installation of several pieces or a long length the toe may be butted toward the wall with a slight pressure using a straight piece of wood to achieve a straight line where the toe meets the floor.

SECTION 6

Finishing the Job

Leaving a jobsite in a shape acceptable to the end user is the mark of a professional and the sign of quality workmanship. Properly done this will leave a lasting impression and go a long way to secure repeat business. Take care of all the factors under your control now, before you leave, to help avoid costly and image damaging call-backs. Whenever possible never leave a job with situations you know you will be called back to correct.

The following checklist will help to address the points that should be taken care of after the floor is installed and is considered by professionals to be, "part of the job."

- Is any looseness or surface bubbling noticed with installed sheet flooring? With fully adhered floors these conditions may require application of weights or an additional rolling procedure. DOMCO TARKETT does recommend rolling all commercial Solid and Luxury Vinyl Tile upon job completion.
- Have all the moldings or wall base been replaced? Were any new moldings or wall base required either due to breakage or other requirements? We strongly recommend that all exposed edges of DOMCO TARKETT resilient flooring products be covered over with moldings, wall base, or caulked. Moldings or wall base serve the purpose of preventing maintenance or moisture from other sources from getting under the flooring. Where molding or wall base is not feasible edges should be caulked with a quality non-staining silicon caulk. These come in a number of colors to coordinate with area color schemes. Don't forget edge moldings were flooring may adjoin other either new or pre-existing flooring.
- Have all the seams been sealed using the correct seam sealer? All seams should be cut and sealed on the same day. Seams not sealed the same day cut may be damaged by moisture and dirt penetration. Unforeseen temperature fluctuations overnight may result in a seam gap the next morning that sealer cannot compensate for. The only exception to this rule is when heat welding is to be conducted. Heat welding procedure should be conducted after adhesive cure, usually overnight.
- To remove surface adhesive smears use some neutral cleaner and a clean, white cloth. Small amounts of mineral spirits may be used but the area should then be re-wiped with neutral cleaner. Avoid the use of mineral spirits or excessive amounts of moisture over seams before or within several hours after sealing. Use mineral spirits with caution as they are flammable.
- Remove all small scraps by sweeping, bag, and dispose of properly. Large amounts of trash should be taken off the jobsite and disposed of by the installation professional. Extra tile or pieces of sheet flooring should be boxed or tied and left for the end user for future repair or color matching samples. Roll sheet flooring materials face out.
- When replacing furniture or appliances these should either be carried or slid over plywood/hardboard runners to their permanent place. Do not slide furnishings directly over any newly or existing flooring material of any type. In some cases items can be slid over flooring using a piece of carpet face down, use caution when attempting this in that slight scuffs/scrapes may occur if the carpet picks up a piece of debris. Moving appliances using an Aireded Appliance Moving Unit is both quick and less strenuous.

- Whenever possible resilient flooring should be the last material installed in a new construction or remodeling project. If this is not possible, the new floor should be fully protected from other construction traffic and activity. If building paper is to be used it must be of the non-staining type.
- Room temperature should be kept at room standard of 70°F(21°C) at least 48 hours after installation and no lower than 65°F (14°C) during this period. Sudden temperature fluctuations at this point, prior to optimum bonding of flooring and adhesive to the subfloor, will affect proper adhesive bonding to both the subfloor and the back of the flooring material.

It is important that the installer communicate the need for proper floor protection devices and maintenance appropriate to the floor covering material installed. Are the floor protection devices currently in place sufficient or in any ways deficient or damaged? Advise the end user of any replacement or repair that will be necessary. Careful observation of the local jobsite environment, conditions that may have existed with any previous floor coverings, and anticipated use conditions will be helpful in dictating the maintenance level necessary. A little preventive maintenance now is far superior to damage control later. Please see Section 7 for recommended maintenance procedures for DOMCO TARKETT resilient flooring products. Recommended floor protection devices are contained at the end of this Section.

RECOMMENDED FLOOR PROTECTION DEVICES:

Protect DOMCO TARKETT floors from marks and dents and they will look new indefinitely. All weight bearing or contact areas of furniture, equipment, etc. resting on DOMCO TARKETT floors should be such that:

- The contact surface is smooth, flat and free from small projections, recesses, holes, roughness, etc.
- The contact surface shall be of sufficient size to carry the load without marring the floor.
- All edges are rounded to prevent any cutting action, if momentarily turned on edge.
- Where movement is contemplated, the design will be such that the flat, smooth bearing surface will continue to remain uniformly in contact with the floor.

FOR DESK CHAIRS AND MOVEABLE FURNITURE

USE easy swiveling ball-bearing non-staining rubber tread wide wheel casters or flat glides on furniture that is moved frequently, such as desk chairs. Casters should have large diameter wheels (2 inch/50mm or more) with wide flat soft non-staining rubber composition tread. Small diameter, narrow, hard wheel casters particularly with a crowned tread and without ball swivels will unnecessarily and unduly mark all types of resilient flooring. For heavier furniture, such as pianos, trucks, hospital beds, etc., consult product manufacturer.

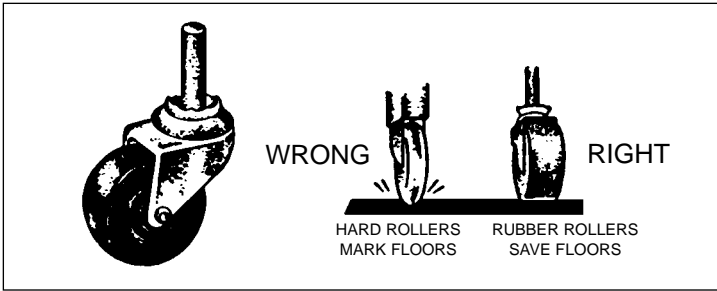


Figure 1. Rubber wheel casters.

FOR SIDE CHAIRS, SMALL CABINETS, ETC.

USE glides having a smooth, flat base, with rounded edges and a flexible pin to maintain flat contact with the floor for side chairs, light cabinets, etc. that may be moved frequently. The size should depend on the weight to be carried. Such glides can be obtained in sizes from about 1" to 2 1/2" (25mm to 64mm) diameter. Small metal domes should be removed from the bottoms of all chair and furniture legs and replaced with flat glides.

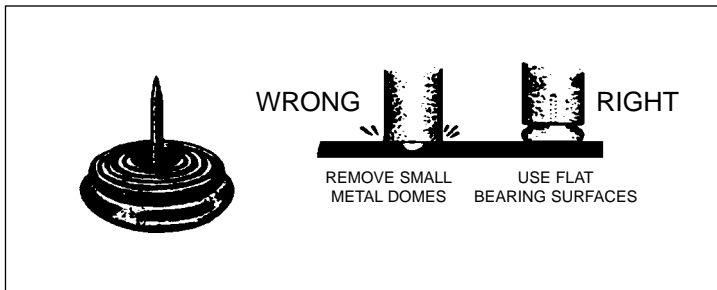


Figure 2. Flat glides with flexible shank.

FOR TABLES AND HEAVY FURNITURE NOT FREQUENTLY MOVED

USE furniture cups made of composition material in a pleasing neutral color designed to prevent legs of furniture from cutting the floor. They are manufactured with openings of varying square and round sizes. They are designed for use on heavier furniture that is moved infrequently.

NOTE: Some rolling-type casters on furniture and appliances may damage resilient flooring. Warranty as to the suitability of factory installed casters rests with the furniture or appliance manufacturers.

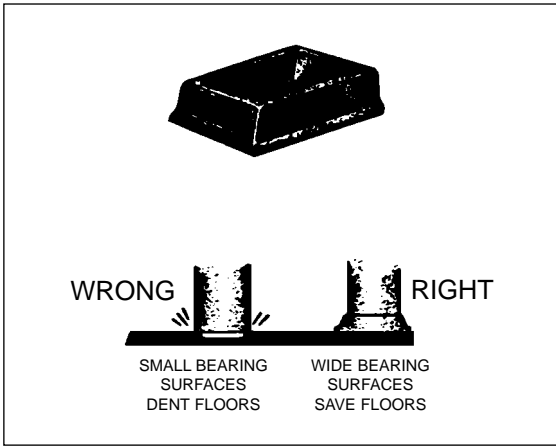
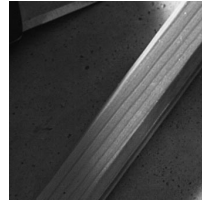
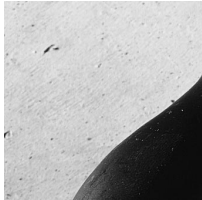


Figure 3. Composition furniture caps.

CAUTION: All vinyl flooring may be subject to various types of staining if not adequately cared for by normal floor maintenance. The floor finish not only keeps the floor at a high level of original appearance but helps protect it from staining and abrasive wear. For example, certain types of deck paint and dyes tracked from other areas of the home or building, soiling agents from asphalt roadways etc. as well as certain rubber heels and dyes in shoe polishes can permanently stain your new floor. Stiletto heels and unprotected legs of tables and chairs may cause permanent damage to your floor.

AZROCK®

Domco Tarkett Commercial
P.O. Box 3145
Houston, Texas 77253-3145
Telephone: (713) 869-5811
Fax: (713) 869-5271



AIM 10003
Printed in U.S.A. 1/03

*Azrock is a brand of
Domco Tarkett Commercial*