

**INSTALLATION INSTRUCTIONS FOR GERFLOR RECREATION SPORT FLOORING OVER ISOLSPORT**

This document refers to the following products:

Product	Thickness	Width	Installation direction	Seam treatment
Recreation 85	8.5 mm	Approximately 4' 11"	Same	Welded
Recreation 60	6 mm	Approximately 4' 11"	Same	Welded
Recreation 45	4.5 mm	Approximately 4' 11"	Same	Welded

**IMPORTANT NOTE: DO NOT INSTALL GERFLOR RECREATION SURFACE OVER ISOLSPORT**

**1. STANDARDS:** The guidelines detailed in this document are based upon industry accepted installation recommendations and reference the following standards:

- 1.1. ACI 302.1R Guide for Concrete Floor and Slab Construction.
- 1.2. ACI 302.2R Guide for Concrete Slabs that Receive Moisture-Sensitive Flooring Materials
- 1.3. ASTM F710-17 Standard Practice for Preparing Concrete Floors to Receive Resilient Flooring
- 1.4. ASTM F1869-16 Standard Test Method for Measuring Moisture Evaporation Rate of Concrete Subfloor Using Anhydrous Calcium Chloride.
- 1.5. ASTM F2170-16 Standard Test Method for Determining Relative Humidity in Concrete Floor Slabs Using In-Situ Probes.
- 1.6. ASTM F1516-13 Standard Practice for Sealing Seams of Resilient Flooring by the Heat Weld Method.
- 1.7. ASTM F1482-15 Standard Practice for Installation and Preparation of Panel Type Underlayments to Receive Resilient Flooring
- 1.8. ASTM F2419-11(2017) Standard Practice for Installation of Thick Poured Gypsum Concrete Underlayments and Preparation of the Surface to Receive Resilient Flooring
- 1.9. ASTM F2678-16 Standard Practice for Preparing Panel Underlayments, Thick Poured Gypsum Concrete Underlayments, Thick Poured Lightweight Cellular Concrete Underlayments, and Concrete Subfloors with Underlayment Patching Compound
- 1.10. ASTM F2873-13 Standard Practice for the Installation of Self-Leveling Underlayment and the Preparation of Surface to Receive Resilient Flooring
- 1.11. ASTM F3010-13 Standard Practice for Two-Component Resin Based Membrane-Forming Moisture Mitigation Systems for Use Under Resilient Floor Coverings
- 1.12. ASTM F3191-16 Standard Practice for Field Determination of Substrate Water Absorption (Porosity) for Substrates to Receive Resilient Flooring1
- 1.13. Recommended Work Practices for Removal of Resilient Floor Coverings of Resilient Floor Covering Institute (RFCI).

**2. GENERAL INFORMATION**

- 2.1. Gerflor Recreation Sport products installed over Isolsport are formulated to withstand high moisture conditions. To perform as designed, the concrete must be properly prepared to create a contaminate free and porous substrate.

- 2.2. **Gerflor Recreation Sport products installed over Isolsport products are not designed to withstand hydrostatic or osmotic pressure.**
- 2.3. The guidelines offered within this document are not intended to be all inclusive. Only qualified, professional flooring technicians experienced in the field of resilient flooring should proceed with this installation system.
- 2.4. It is recommended to mechanically prepare the concrete via grinding or bead blasting the surface to achieve a clean and porous substrate.
- 2.5. Moisture and pH testing must be performed in accordance with ASTM F710-17.
- 2.6. Where patching is required to correct minor subfloor deviations/deficiencies use only **GerPatch**.
- 2.7. If a self-leveling material is required to achieve a flat, smooth and/or level surface, the use of a moisture tolerant, cementitious product that meets ASTM F2873-13 is required.
- 2.8. **Do not install material that has visible defects or damage. A contractor that installs material that has visible defects or damage assumes responsibility for the damaged material.**

### 3. STORAGE AND HANDLING

- 3.1. Rolls may be shipped laying down. If shipped in this manner, place them in an upright position on a clean, flat, solid surface in an interior, controlled space. Do not store rolls laying down for extended periods.
- 3.2. Store rolls of Gerflor Recreation Sport products and Isolsport on clean, flat, and solid surfaces in a controlled environment. Place rolls in an upright position. Do not stack rolls on top of each other.
- 3.3. Follow sequence number while storing. It will be easier to follow the sequence while unrolling.
- 3.4. If the material will be stored for an extended period, remove the rolls from the skids and secure them upright as detailed above. Rolls that are displaced due to a broken skid or left on their side for an extended period will damage the flooring.
- 3.5. Caution should be used in the moving and lifting of rolls. Allow for appropriate equipment and manpower to safely move materials. **Work safe and always follow the relevant safety protocols for the activity you are engaged in.**
- 3.6. **Do not store any material outdoor.**

### 4. JOB SITE CONDITIONS

- 4.1. The Gerflor Recreation Sport product and Isolsport rolls and adhesive must be acclimated in the installation area for 24 hours prior to installation. Allow additional acclimation time if the flooring has been exposed to excessive cold or hot temperatures for an extended period.
- 4.2. The concrete floor temperature shall be a minimum of 65°F before laying out the rolls of Gerflor Recreation Sport flooring.
- 4.3. Areas to receive flooring must be fully enclosed with the permanent HVAC system operational and set to a minimum of 65°F or a maximum of 85°F for a minimum of 48 hours prior to, during, and then maintained after the installation.
- 4.4. Prepare substrate in accordance with ASTM F710-17 Standard Practice for Preparing Concrete Floors to Receive Resilient Flooring. Floors should be smooth, permanently dry, clean and free of all foreign materials such as dust, wax, solvents, paint, grease, oils, old adhesive residue, curing compounds and sealers.

- 4.5. Areas to receive flooring should have adequate lighting during all phases of the installation.
- 4.6. Installation should not begin until all trades; painting, ductwork, drywall, etc. are complete. Once the installation begins, the area must be secured from all other trades and foot traffic.

**5. SUBFLOORS – CONCRETE**

- 5.1. The concrete must have been placed in accordance with ACI 302.1R Guide for Concrete Floor and Slab Construction and ACI 302.2R Guide for Concrete Slabs that Receive Moisture-Sensitive Flooring Materials.
- 5.2. Allow concrete to cure for a minimum of twenty-eight (28) days.
- 5.3. The slab flatness will have a tolerance of 1/8" in a 10' maximum plane variation.
- 5.4. Before proceeding with any work, inspect the subfloor surface and report in writing to the Project Manager and the General Contractor any visible defects on the surface such as cracks, bumps, rough areas or variations in flatness.
- 5.5. Check the subfloor for grease, oil, paint, marker, spills, dust or any contamination that may adversely affect the adhesion of the flooring. Mechanically clean the subfloor per the existing conditions. Petroleum products such as cutting oils and hydraulic fluid will penetrate the concrete and become a bond breaker. Areas affected by these oils must be bead-blasted to remove all contaminated concrete.
- 5.6. Mechanically remove any existing adhesive residues, paint over spray, sweeping compounds, dirt, debris or anything that may act as a bond breaker from the surface of the concrete. Where concrete sealers or curing compounds are present they must be completely, mechanically removed via grinding, bead-blasting, Diamabrush <http://www.diamabrush.com/> or similar. Sanding is not sufficient to completely remove curing compounds.
- 5.7. **The concrete slab, new or old, must be tested for moisture. We recommend having the tests performed by a recognized engineering firm. The ICRI website (International Concrete Repair Institute) has a list of certified technicians for the USA: <http://www.icri.org/Certification/Find-CCSMTTs.asp>**
- 5.8. The moisture tests must be performed as per ASTM F1869-16 "Standard Test Method for Measuring Moisture Evaporation Rate of Concrete Subfloor Using Anhydrous Calcium Chloride" and/or ASTM F2170-16 "Standard Test Method for Determining Relative Humidity in Concrete Floor Slabs Using In-Situ Probes".
- 5.9. Where the concrete has been hard-troweled to create a burnished finish, porosity should be determined through the water drop test as detailed in ASTM F3191-16 Standard Practice for Field Determination of Substrate Water Absorption (Porosity) for Substrates to Receive Resilient Flooring.
- 5.10. To minimize the potential for telegraphing, all dormant or non-moving cracks should be repaired with a rigid, two-component, polyurethane crack injection product. Moving joints such as expansion or isolation joints must be honored up through the installation in accordance with ASTM F 710-17.
- 5.11. **Substrate moisture and pH levels shall not exceed:**

	Concrete slab with an effective moisture vapor barrier	Concrete slab with radiant heating system
Styccobond F49 Adhesive	pH 6 to 11 / 8-lbs / 90% RH	Do not install

- 5.12. Sweep and vacuum the area following mechanical preparation to remove all dust and debris.
- 5.13. Where patching is required to correct minor subfloor deviations/deficiencies use only **GerPatch** and allow to cure from 4 to 24 hours depending on the type of adhesive used. Sand if necessary to smooth. If the use of a moisture tolerant, cementitious self-leveler is required, it must meet ASTM F2873-13.
- 5.14. Refer to ASTM F710-17 for additional considerations on concrete substrates that are to receive resilient floor coverings.

## **6. SUBFLOORS – CONCRETE WITH RADIANT HEATING SYSTEMS**

- 6.1. **Do not install over a concrete slab with radiant heating system**

## **7. SUBFLOORS – GYPSUM BASE SUBSTRATE**

- 7.1. Prohibit circulation of other trades in the installation area.
- 7.2. The General Contractor shall patch and repair all cracks, voids and other imperfections of the gypsum base subfloor with high strength gypsum base patching compounds compatible with the gypsum base product.
- 7.3. After completion of patching and leveling, vacuum or sweep entire surface of the gypsum base subfloor to remove loose dust and dirt.
- 7.4. Apply an acrylic base primer per the manufacturer's instructions.
- 7.5. Once the Primer has set, install the flooring following the installation instructions
- 7.6. Do not use Gerflor T-111 polyurethane adhesive over this type of substrate. Refer to Gerflor Technical Service for further instructions

## **8. SUBFLOORS – WOOD**

- 8.1. Do not install over OSB, particle board, chipboard, lauan or composite type underlayments.
- 8.2. Wood subfloors must have a minimum of 18" of cross-ventilation space between the bottom of the joist and the ground.
- 8.3. Any exposed earth crawl space must be sealed with a polyethylene moisture barrier.
- 8.4. Wood subfloors must meet local and national building codes, trade associations (e.g. The APA – The Engineered Wood Association) that offers guidelines to meet the building codes.
- 8.5. Always refer to ASTM F1482-15 Standard Practice for Installation and Preparation of Panel Type Underlayments to Receive Resilient Flooring.
- 8.6. Any subfloor that has a single layer must be covered with a ¼" or more of APA approved underlayment plywood to achieve a total thickness of 1 inch minimum.

## **9. SUBFLOOR PREPARATION**

- 9.1. The General Contractor will supply a smooth, flat concrete finish ready to receive the new resilient sheet flooring in accordance with ACI 302.1R Guide for Concrete Floor and Slab Construction and ACI 302.2R Guide for Concrete Slabs that Receive Moisture-Sensitive Flooring Materials.
- 9.2. The concrete subfloor will be cured for a minimum of at least thirty (30) days.
- 9.3. The slab flatness will have a tolerance of 1/8" in a 10' maximum plane variation.

- 9.4. Prepare substrate as per ASTM F710-17 “Standard Practice for Preparing Concrete Floors to Receive Resilient Flooring”.
- 9.5. The concrete floor temperature must to be maintained at a minimum of 65°F for 48 hours prior, during, and 48 hours after the installation.
- 9.6. **The concrete slab, new or old, must be tested for moisture. We recommend having the tests performed by a recognized engineering firm. The ICRI website (International Concrete Repair Institute) has a list of certified technicians for the USA: <http://www.icri.org/Certification/Find-CCSMTTs.asp>**
- 9.7. The moisture tests must be performed as per ASTM F1869-16 “Standard Test Method for Measuring Moisture Evaporation Rate of Concrete Subfloor Using Anhydrous Calcium Chloride” and/or ASTM F2170-16 “Standard Test Method for Determining Relative Humidity in Concrete Floor Slabs Using In-Situ Probes”.
- 9.8. **Substrate moisture levels shall not exceed:**

	Concrete slab with an effective moisture vapor barrier	Concrete slab with radiant heating system
Styccobond F49 Adhesive	pH 6 to 11 / 8-lbs / 90% RH	Do not install

- 9.9. Prohibit circulation of other trades in the installation area.
- 9.10. Before proceeding with any work, inspect the subfloor surface and report in writing to the Project Manager and the General Contractor any visible defects on the surface such as cracks, bumps, rough areas or variations in evenness.
- 9.11. Check the subfloor for grease, oil, paint, marker, spills, dust or any contamination that may adversely affect the adhesion of the flooring. Clean the subfloor per the existing conditions.
- 9.12. Prohibit circulation of other trades in the installation area.
- 9.13. Sanding of the subfloor will be mandatory in many cases; especially in areas where the subfloor has been contaminated with foreign products. It may be necessary to scarify or bead-blast concrete surface to remove existing adhesives, paint, concrete sealers or other surface applied materials.
- 9.14. **Curing compounds** of all types must be completely removed by means of sanding, scarification or bead-blasting. Self-dissipative curing compounds must be removed using the same methods.
- 9.15. The General Contractor shall patch and repair all cracks, voids and other imperfections of concrete with GerPatch patching compound. **Do not use gypsum-based patching materials.**
- 9.16. After completion of sanding, patching and leveling, vacuum or sweep entire surface of concrete to remove loose dust and dirt before starting the installation of material.

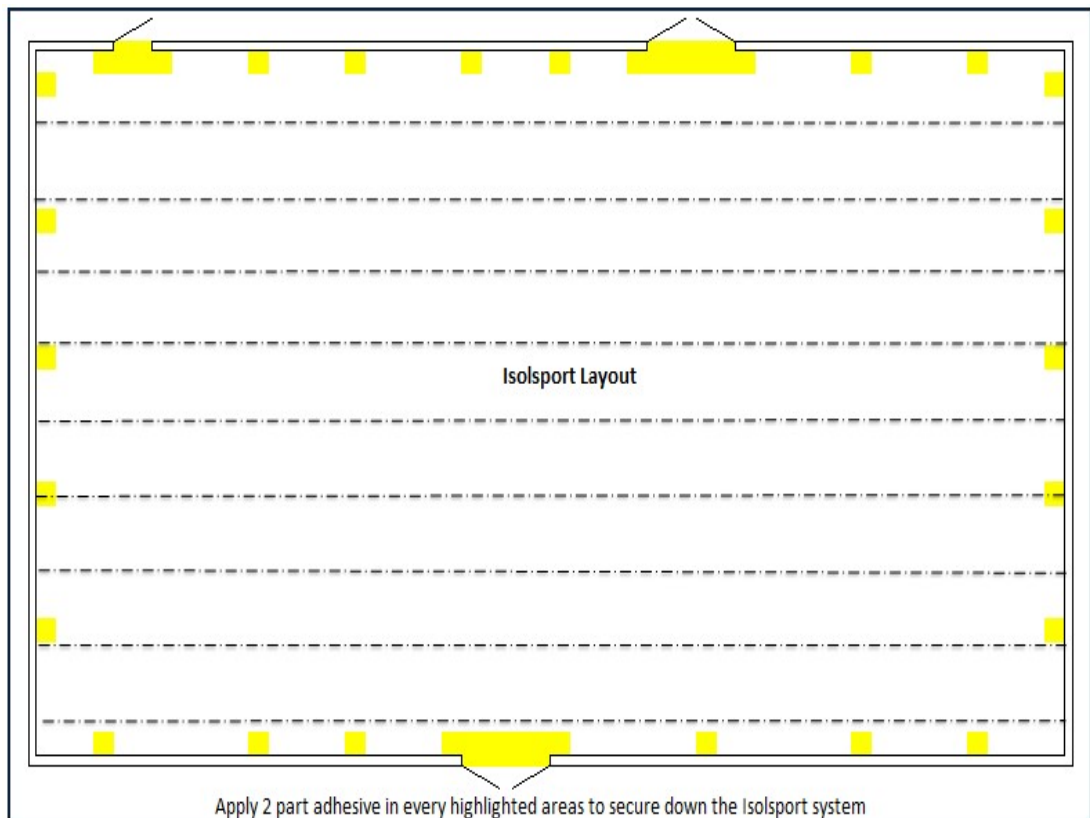
**10. ACCLIMATION**

- 10.1. The rolls and adhesive must be acclimated in the installation area for 24 hours prior to installation. Allow additional acclimation time if the flooring has been exposed to excessive cold or hot temperatures for an extended period.
- 10.2. The concrete floor temperature shall be a minimum of 65°F before laying out rolls.

- 10.3. Areas to receive flooring must be fully enclosed with the permanent HVAC system operational and set to a minimum of 65°F or a maximum of 85°F for a minimum of 48 hours prior to, during, and then maintained after the installation.
- 10.4. Keep the identification tags of each roll and verify that the rolls are being installed in the same direction and in sequential order.
- 10.5. Unroll flooring following the roll number sequence.
- 10.6. Mark a control/starting line. Unroll the first roll along this line.
- 10.7. Unroll successive rolls leaving a minimum ¼" gap left between sheets.
- 10.8. Allow material to relax overnight before proceeding with the installation.

**11. INSTALLATION OF ISOLSPORT UNDERLAYMENT**

- 11.1. The concrete floor temperature will be maintained at a minimum of 65°F for 48 hours prior, during, and 48 hours after the installation.
- 11.2. While the seams of the Sport product will start from the center of the court, underlayment seams must be staggered by at least 6" from those of the Sport product.
- 11.3. Isolsport must be loose laid at the exception of the doors entrances and at the perimeter. See drawing.
- 11.4. Adhesion of the Isolsport at the doors and perimeter should be done at the same time of the installation of the sport flooring.





## **12. FLOORING INSPECTION**

- 12.1.** While unwrapping the rolls, keep the identification tags of each rolls and verify on the tags whether the flooring is to be installed the same direction or reversed.
- 12.2.** Inspect all the flooring carefully to verify that correct colors, lot number, patterns, quality and quantities have been shipped as ordered. Do not install, cut, or fit any material that has visible defects. Material that may have minor edge damage or distortion must be trimmed and removed prior to installation of the sheets.
- 12.3.** **A contractor that installs material that has visible defects or damage without prior consent of Gerflor deems the product acceptable for installation and therefore accepts full responsibility for said material.**

## **13. DRY LAY OF SHEETGOODS**

- 13.1.** The concrete floor temperature will be maintained at a minimum of 65°F for 48 hours prior, during, and 48 hours after the installation.
- 13.2.** Mark the center starting line.
- 13.3.** Unroll the first length of material along this chalk line and then work progressively outward, leaving a ¼" gap between the sheets to allow the material to relax for at least 16-24 hours.
- 13.4.** Seaming should be kept to a minimum and avoid cross seams as much as possible. Place seams in areas exposed to the least amount of traffic.
- 13.5.** Before applying the adhesive, bring the loose sheets close together leaving a gap of 1/32".
- 13.6.** The 1/32" gap is the space needed for the guide of the electric groover.
- 13.7.** This gap must be constant in width.

**Note:** **These layouts are not to scale and do not account for any head seems that will be part of a real installation.**

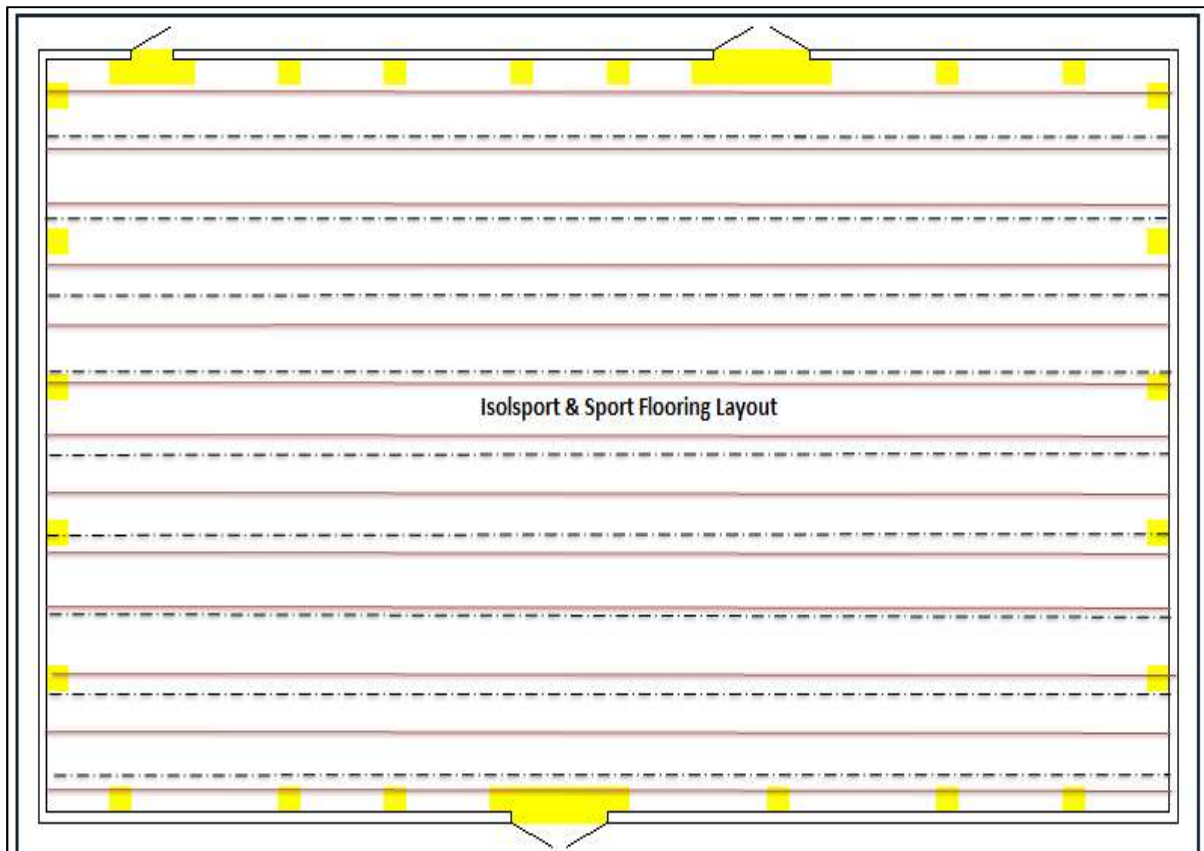
**Dotted lines are showing the seams of the Isolsport.**

**Red lines are showing the seams of the sport product.**

## **14. INSTALLATION OF GERFLOR RECREATION SPORT FLOORING OVER ISOLSPORT**

### **14.1. FLOORING INSPECTION**

- 14.1.1.** While unwrapping the rolls, keep the identification tags of each rolls and verify on the tags whether the flooring is to be installed the same direction or reversed.
- 14.1.2.** Unroll flooring following the roll number sequence.
- 14.1.3.** Inspect all the flooring carefully to verify that correct colors, lot number, patterns, quality and quantities have been shipped as ordered. Do not install, cut, or fit any material that has visible defects. Material that may have minor edge damage or distortion must be trimmed and removed prior to installation of the sheets.
- 14.1.4.** A contractor that installs material that has visible defects or damage without prior consent of Gerflor deems the product acceptable for installation and therefore accepts full responsibility for said material.



- 14.2. **Per Section 10 – Acclimation, the material must acclimate and properly relax prior to installation.**
- 14.3. Reposition sheets to allow for no more than a 1/32" gap between them to allow for proper heat welding. Wider gaps will compromise the integrity of the weld.
- 14.4. Material that may have minor edge damage or distortion must be trimmed and removed prior to installation of the sheets.
- 14.5. Avoid cross/head seams if possible. Place these seams in areas exposed to the least amount of traffic or where Game Line Paint will be applied. Roll lengths typically allow for head seams to be placed outside the field area.
- 14.6. Leave material 4"-6" longer on each end for trimming after placement. *Do not net cut material to the final trim until the application of the adhesive.*
- 14.7. Before applying the adhesive, ensure gap between the sheets to a uniform 1/32" along the entire length. This gap will act as a guide for the groover.
- 14.8. **F. Ball Stycobond F49 Adhesive** is the **only** approved adhesive for use with the Sport M Comfort system. Any other adhesive will void the adhesion warranty.
- 14.9. Follow the guidelines indicated on the pail of adhesive.



**14.9.1.** F, Ball Styccobond F49 is a 2-part acrylic adhesive that has a 90 minutes pot life once mixed and 2 hours working time once the adhesive has tack-up and does not transfer to the touch. Adhesive open time and working time will vary based upon site condition.

**14.9.2.** The use of fans is acceptable to speed up the drying time. Be sure to not let debris get into the adhesive.

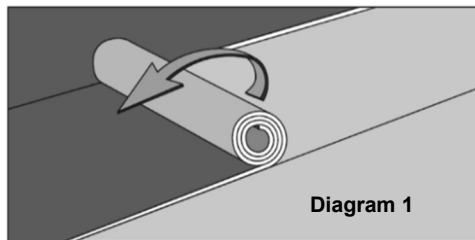
**14.10.** Trowel the adhesive onto the substrate using a 1/32" x 1/16" x 5/64", 'U' notched trowel covering from 500 to 600 sq. ft. per pail. Proper adhesive coverage is required to effectively bond the material. As such, it is imperative to use the proper trowel as well as maintaining the proper notch size over the course of the entire floor. Replace trowel blades often. **Inadequate application of adhesive will void the warranty.**



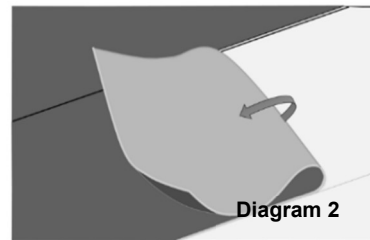
**Note:** It is important to let the adhesive tack up COMPLETELY before installing. No transfer to the fingers when touched.

**14.11.** Beginning from the control\starting line and working outward, fold the sheets halfway back along the width (fold back method) or roll the sheets halfway back (roll back):

**Roll back method**



**Fold back method (along width)**



**14.12.** Working with one roll at a time, apply the Styccobond F49 adhesive to the subfloor or the red foam. Always start gluing from the rolled or folded edge first – glue working away from the roll or fold.

**14.13.** Never pre-cut material to final trim until it is applied into the adhesive. Leave material 2"-3" longer for trimming after placement.

**14.14.** To ensure uniform adhesion of the entire surface, apply a workable amount of adhesive at one time.

**14.15.** Avoid overlapping adhesive or creating a buildup at all start and stop points. Excess adhesive can leave a ridge that will telegraph into the finished floor. Glue and roll the entire run (wall to wall) before proceeding to the next run of material. Use a wet-soapy rag or denatured alcohol to immediately clean up any fresh adhesive that gets on the vinyl surface. Clean any dried adhesive with denatured alcohol.

**14.16.** Immediately after troweling the adhesive onto the concrete use a medium napped paint roller saturated with adhesive to flatten out visible trowel marks and even out the adhesive. A double arm roller frame is recommended to ensure an even coat of adhesive.

**14.17.** Maintain a uniform spread rate. Replace trowel (or trowel blade) with every pail used.

**14.18.** Once the adhesive is applied, fold back or roll back the flooring into the still wet adhesive for 4"-6". This will ease the fold-back or roll back of the second half and it will help avoid an overlap of the glue-line. Should this method not followed, the glue-line mark will telegraph through the flooring.

**14.19.** Open time is the combination of flash time and working time.

**14.20.** “Open time” of the adhesive is dependent upon porosity of the substrate, temperature, and humidity. It is important that the installers familiarize themselves with the adhesive before starting the installations. Insufficient open time for acrylic adhesive will cause bubbling. An insufficient open time will result in poor adhesion.

**14.21.** Application Characteristics over Porous Substrates:

<b>Application Characteristics over Porous Substrates</b>		
	<b>Flash Time*</b>	<b>Working Time**</b>
Sport M Comfort	20 to 30 minutes (to reach a tacky*** state)	120 minutes

\* Flash Time: It is the waiting time required before installing flooring.

\*\* Working time: It is the window of time for the adhesive to accept flooring.

\*\*\* Tacky: When the adhesive is clear sticky and does not transfer to the touch.

**Note: Flash time and working time may vary based on temperature, humidity, substrate porosity, trowel size and jobsite conditions.**

**14.22.** While installing, always work to have complete sheets glued at the end of the day.

**14.23.** To reduce the risk of bubbles, the roll back method is the most recommended.

**14.24.** By keeping the roll tight and maintaining a constant pressure while unrolling into the adhesive, the risk for bubbles will be minimal.

**14.25.** The fold back method is acceptable, but care must be taken to not flap it back too quickly.

**14.26.** Once flooring is placed into the adhesive, immediately roll thoroughly with a 3 section 100-lbs roller in both directions rolling sideways first.

**Note: Use a 14” to 16” cork board or a piece of 2” x 4” wrapped with a piece of carpet to remove air bubbles.**

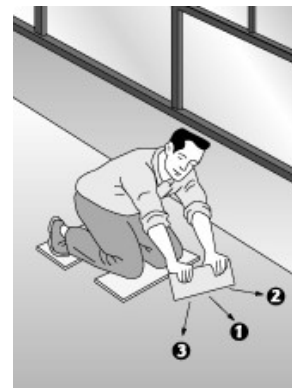
**14.27.** Continue laying sheets by keeping the edges spaced 1/32”, trimming each side with a straight edge or scribing when needed. The goal is to produce a uniform 1/32” spaced seam for welding.

**14.28.** The width of the gap has to be even and may be less than 1/32” depending on the guide of the groover used.

**14.29. Leaving a wider gap to weld directly into the gap without grooving is not recommended and will lead to a welded seam failure**

**14.30.** During the installation, always double check the flooring for bubbles with the lights on and off.

**14.31.** Avoid adhesive displacement by prohibiting traffic for a period of 48 hours and 72 hours for rolling loads.



**15. HEAT WELDING (Refer to our document: Verification of Heat Welded Seams)**

**15.1. ROUTING:**

**15.1.1.** Use an electric routing machine for major installation such as Leister or equal, approved by manufacturer.

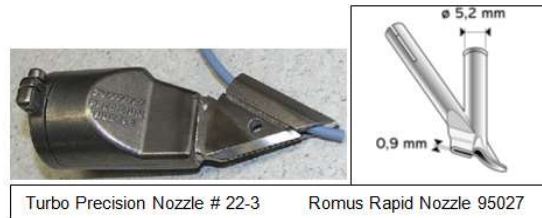
- 15.1.2. The Master Turbo Sport Groover is a great tool and is highly recommended to groove our products. <http://turboheatweldingtools.com/shop/>
- 15.1.3. The Pico groover is a great tool to groove our products.
- 15.1.4. The use of a straight edge and hand groover will provide good results for smaller installations.
- 15.1.5. Maintain a uniform width and depth of groove for a uniform welded seam.
- 15.1.6. **Route the solid PVC layers of the sport flooring. Do not rout into the foam layer.**



**15.2. MANUAL WELD:**

**Note: Always practice on a scrap piece of material first to assure proper temperature and speed. Welding tests and adjustment of welder must be done every day there is welding to be done on the job site. Doing so will prevent failures.**

- 15.2.1. Groove only 16-24 hours after the installation.
- 15.2.2. This must be done with a heat welding gun with variable temperature control and a speed weld nozzle by Leister or equal, approved by manufacturer.
- 15.2.3. Turbo Precision Nozzle # 22-3 is highly recommended as well for proper welding. <http://turboheatweldingtools.com>
- 15.2.4. Nozzle size is 5mm as the Romus Rapid Nozzle 95027.
- 15.2.5. The use of a non-recommended tip will jeopardize proper welding and could damage the flooring.
- 15.2.6. Always keep the tip clean.



**15.3. WELDING ROBOT (REQUIRED ON LARGE PROJECT)**

**Note: Always practice on a scrap piece of material first to assure proper temperature and speed. This should be done every day there is welding to do on the job site. Doing so will prevent failures.**

- 15.3.1. Do not let the robot operate without surveillance.
- 15.3.2. Turbo Welding Gun #25 is the recommended welding robot as it comes with the right welding tip. <http://turboheatweldingtools.com>



**Note: Should another type of welding robot be used, such as Leister robot, care must be taken in the choice of tip as for most cases the opening of the tip is more than 2mm. This could damage the flooring and lead to a seam failure.**

- 15.3.3. The recommended tip for the Leister Robot is Romus 95253 2mm.



**WARNING: Do not weld the flooring using the Leister robot without the proper tip.**

- 15.3.4. Verify not to reduce the power with electrical cords that are too long.
- 15.3.5. Frequently verify the weld.
- 15.3.6. The ambient temperature, open windows and doors and other electrical equipment plugged in the same electrical outlet may influence proper welding.

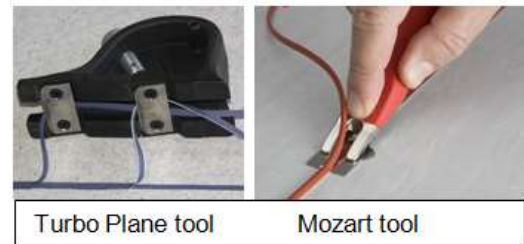
**Notes:** \* For any type of installation, do not heat weld resilient flooring for a minimum of 16 to 24 hours after the material has been placed into the adhesive.

\*\* Refer to ASTM F1516-13 "Standard Practice for Sealing Seams of Resilient Flooring by the Heat Weld Method".

**15.4. TRIMMING WELDED ROD**

**Note: Trimming is done once the welding rod and material have completely cooled.**

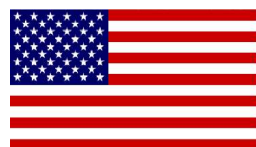
- 15.4.1. Trimming must be done in two passes.
- 15.4.2. The Turbo Plane tool is recommended and will trim in one pass.  
<http://turboheatweldingtools.com>
- 15.4.3. Use trimming tools sharpen in the middle only, such as the Mozart trimmer.
- 15.4.4. This type of trimmer will not damage the flooring.
- 15.4.5. The first trim must be done with the thickness guide.
- 15.4.6. The second trim must be done with the trimmer only.
- 15.4.7. Always verify the trimmed weld to ensure that the welding rod is bonded properly and is flush with the top wear layer.



**16. ONCE THE INSTALLATION IS COMPLETED**

- 16.1. Clean the area to verify there are no imperfections, adhesive residue, scuff marks, etc. Verify every welded seam.
- 16.2. Make sure that the vinyl is well trimmed and sealed with a silicone sealer (or equivalent) around all fixed, vertical objects (e.g. doorways, posts, etc.).
- 16.3. To maximize the aesthetic appearance and serviceability of the newly installed flooring, provide your customer with a copy the **Gerflor USA Maintenance Instructions:**  
<https://www.gerflorusa.com/media/17-usa-website/7-technical-doc/gerflor-usa-maintenance-instructions-sport-products-2017.pdf>

For any information, please refer to Gerflor Technical Services.



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