

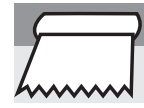


In case of need of different transportation and storage, please refer to the «Storage and Transport guidelines» dedicated to the product. After delivery on jobsite, rolls has to be stored in upright position. Use adapted handling equipment and don't expose materials to pressure in order to avoid permanent deformations.

Always check the material before starting work in order to avoid problems with visible defects. Please inform GERFLOR of any visible defects discovered and do not start work without their approval.



Ambient temperature



Floor temperature

IN ACCORDANCE WITH LOCAL STANDARDS

1. MATERIAL INSPECTION AND SUBFLOOR RECOMMENDATIONS

1.1. MATERIAL INSPECTION

- Rolls are clearly marked with batch numbers and the product should be checked for a match before installing.
- Inspect all materials carefully to verify that the correct colours, lot number, patterns, quality and quantities have been shipped as ordered. Do not install, cut, or fit any material that has visible defects.
- Differences of width (tolerances) may exist between the rolls.
- A contractor who installs material that has visible defects or damage without the prior consent of GERFLOR deems the product acceptable for installation and therefore accepts full responsibility.
- Rolls are soft material. They may be marked if bended or pressed. In such cases, a white line may appear and be softened using the heater. Before doing it on the installation, do it on a loss part to define the accurate temperature and the accurate distance to apply it.

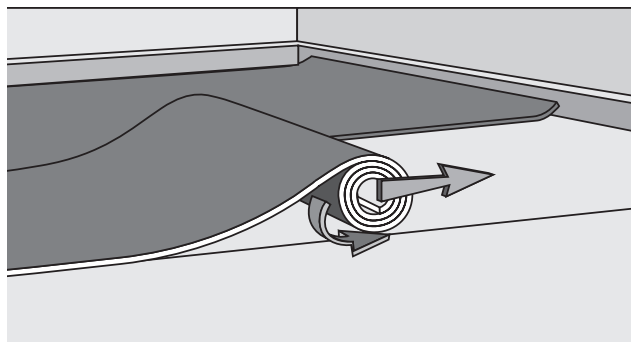
1.2. SUBFLOOR RECOMMENDATIONS

- To prevent the presence of moisture or water in the underside of PVC floor, measure the moisture content before installing the PVC flooring. Moisture levels must be in accordance with local standard. Common reference for moisture tests is performed as per ASTM F2170- 11 "Standard Test Method for Determining Relative Humidity in Concrete Floor Slabs Using In-Situ Probes". Substrate moisture levels shall not exceed for concrete slab with an effective moisture vapor barrier 5-lbs / 80% RH.
- Apply a waterproofing barrier (epoxy resin) if necessary.
- Work on clean and flat subfloor. Do a subfloor preparation if necessary.

2. UNROLLING THE MATERIAL

Minimum ambient temperature for laying : must be in accordance with the local standard.

- Mark longitudinal and transverse axis for reference to place strips.
- Unroll fully material following order of rolls in the venue according to picture.
- Check that the edge of strips are straight. Align the edge of the first strip to longitudinal axis to have a straight reference
- Leave a gap of 1 cm between every strip to let possible full material acclimation in its length as in its width. If area is too small, it is possible to overlap fully two strips.
- Let material relax during 24h. Material will be in the best conditions to be glued and material tensile or bubbles will be mostly released.
- CAUTION: the lengths should be unrolled starting in the centre of the sports hall.
- Rolls are layed in the same direction.

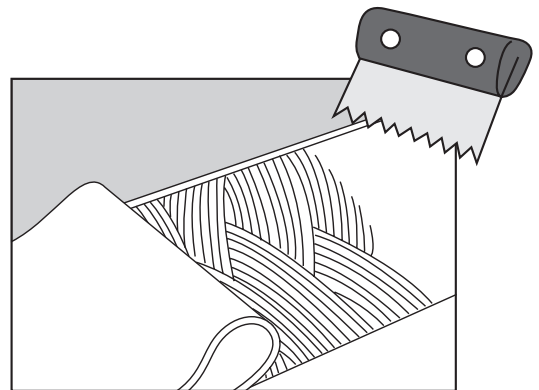
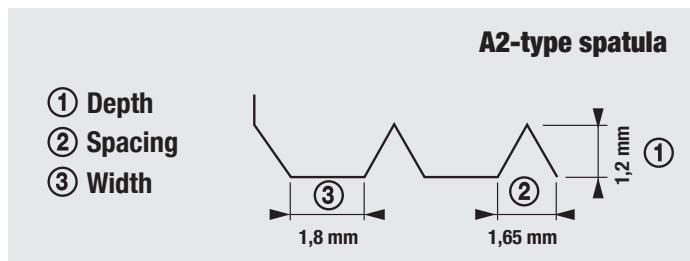


3. POSITIONING THE FLOORING

Position the lengths in the direction of the longitudinal axis by leaving gap less than 1 mm to allow the chamfering tool to be guided.
Respect the laying direction and the order of rolls as over.

4. STICKING-DOWN

- This is done 24 hours after having unrolled and laid out the lengths.
- The flooring is laid using the single bond method with an acrylic emulsifying adhesive. Spatula A2 (according to TKB standard) is usually used.
- Glue technics and solutions may change. As such, be sure to use a glue accurate for the backing of the material and the support.
- Glue supplier's recommendations have to be respected.



IMPORTANT:

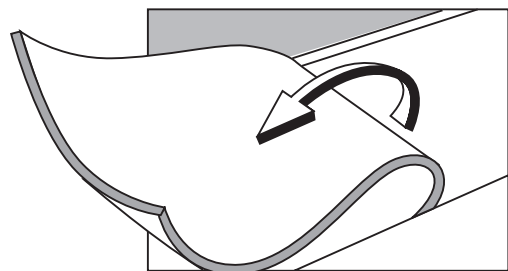
- Forbid any trafficking for 48 hours after laying and 72 hours for any furniture movement.
- Follow carefully the recommendations of the adhesive manufacturer.

Recommendations for good adhesion:

- Respect the waiting time (open time) which depends on the temperature, ambient hygrometry, porosity of the subfloor and the adhesive coverage. If the flooring is applied to adhesive with insufficient waiting time, it will bubble.
- If the flooring is applied to adhesive which has gone past its open time, there will be insufficient adhesive transfer to the underside of the floor finish.

■ 4.1. LAYING THE LENGTH

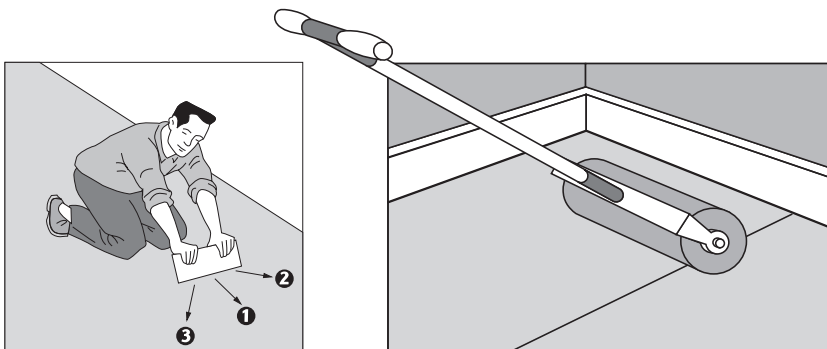
- To stick-down, fold the lengths back halfway (see diag).
- Start laying with the length halves in the centre of the hall located on each side of the first strike line.
- Fold back the second halves and proceed in the same way; then apply the following lengths edge-to-edge without leaving a gap and continue in the same way finishing up at walls.



■ 4.2. ROLLING

It is essential and carried out in two stages:

- Manual rolling to position lengths.
- Final rolling of the whole surface with a flooring roller.



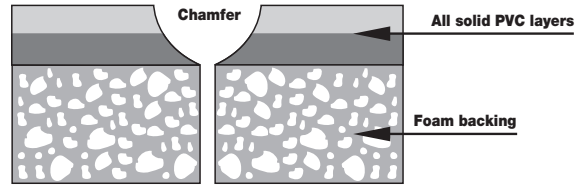
4.3. HOT WELDING (12 HOURS AFTER STICKING-DOWN)

4.3.1 – Grooving / Chamfering

It is necessary to groove through all the solid PVC layer. Leave a gap less than 1 mm to allow the chamfering tool to be guided.

There are two chamfering methods:

- Manual using an appropriate tool (triangle, manual groover).



Triangular scraper, Ref. : 95185 by ROMUS



Linéa, Ref. : 95101 by ROMUS



Master Turbo, Ref. : 95200 by ROMUS

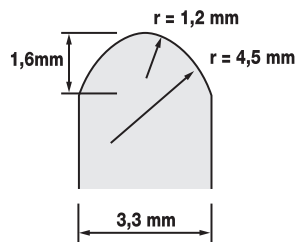


Swift groover Ref. : 262 611 400 by JANSER

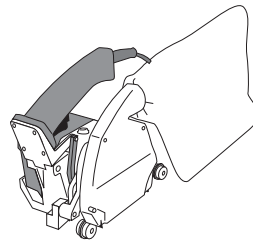


Pico Groover, Ref. : 95122 by ROMUS

- Mechanical using an electric grooving machine fitted with a 3.3 mm width circular plate. The entire thickness of the wear layer must be chamfered, but not the foam underlay.



Profil of a circular saw blade

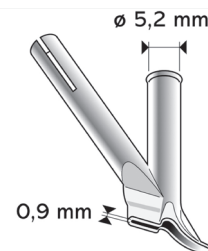
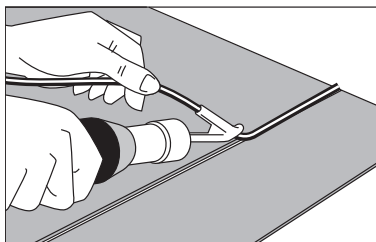


Groover or router

4.3.2 – Heat welding

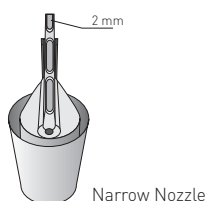
NOTE: Always practice on a scrap piece of material first to assure proper temperature and speed. Doing so will prevent failures.

Manual weld with a SPEED NOZZLE

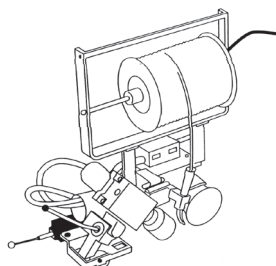


Use the RAPID ULTRA nozzle, diameter 5 mm, air inlet 0.9 mm, Ref.: 224 800 007 from JANSER or 95027 from ROMUS or the narrow nozzle on the automatic welder.

Weld with welding robot (required on large project)



Narrow Nozzle



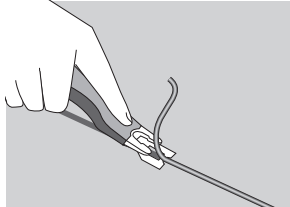
Use a Universal or Unifloor type LEISTER welder with electronically controlled hot air burner air with special multiple fine jets. PVC Nozzle references:
ROMUS: 95254
LEISTER: 105.407
JANSER: 225 860 040

4.3.3 – Trimming weld rod

Trimming must be done in two passes. Using a trimming tool sharpen in the middle only, such as the MOZART, is recommend:

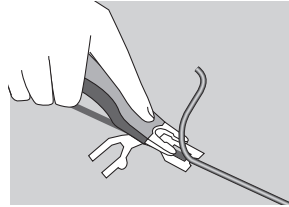
First stage:

Has to be done with the thickness guide.

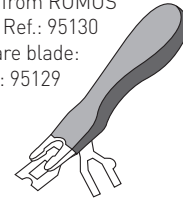


Second stage:

Second trim has to be done with the trimmer only. This method prevents concave welds and must be done when the rod is cold.



Available from ROMUS
Ref.: 95130
Spare blade:
Ref.: 95129



5. FINISHING

A circle cutter fitted with a centring device (part 262 262 500 – JANSER) can be used to achieve attractive trims around openings.



Use of painting: use a water-based polyurethane paint for game lines as TLD AQUA PAINT which can be ordered from GERFLOR.

IMPORTANT: commissioning time frames

- For normal foot traffic, commission the floor no earlier than 48 hours after work completion.
- For installing sports equipment and rolling traffic, a period of 72 hours is required before commissioning.
- Because of foam underlay thickness, weight distribution plates must be installed under heavy static and dynamic loads.