

## General Installation Instructions

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## Before you Begin

These are general installation instructions only. The information on these pages is to assist you in selecting the appropriate adhesive for your project. Special conditions may result in different recommendations. Please contact us for information regarding

unusual conditions such as substrates of metal, terrazzo or wood treated with fire retardant chemicals, unusual temperature or moisture exposures or other variables which may affect performance. Complete instructions are located on adhesive container labels and at [flexiflor.com](http://flexiflor.com) under "Installation". All products must be adhered using FlexiFlor's recommended adhesive and full spread application and are intended for interior installation only.

## Preparing the Substrate

**New concrete sub-floors** – concrete should be troweled to a smooth even surface and be aged for at least 90 days. Expansion joints should be properly filled. Neutralize the surface of the concrete. Use either 1 part Muriatic Acid and 9 parts water or 1 part vinegar and 5 parts water to make a good neutralizing agent. Solution should remain on floor for at least one hour then flush thoroughly and allow concrete to dry thoroughly (minimum 48 hours at 70°F.). Concrete should be sound, hard and free from scale or other imperfections and **thoroughly** dry when installation is made. It is recommended that all concrete floors undergo a 72-hour moisture test. The moisture level found **should not be more than three (3) pounds per thousand square feet of floor.**

***Caution** - cinder fill, vermiculite, pumice and other aggregates which are hygroscopic in nature cause the concrete to be very slow drying. This type of concrete will easily absorb excessive moisture from atmosphere and other sources. Any concrete curing compound must be completely removed.*

**Wood Sub-Floors:** An exterior grade plywood is recommended with one side sanded. Luan Plywood, Particle Board, Chip Board or Hard Board should not be used as underlayment. Be sure wood sub-floor is thoroughly nailed or otherwise securely fastened to the substrate. If the wood sub-floor is uneven, it should be thoroughly sanded. The dust from the sanding operation should be removed by vacuuming.

***Note:** As with any adhesive, care must be taken to assure proper ventilation on the job site. See label directions on can.*



## Limitations

We do not recommend that our Sheet Rubber or Rubber Tile Flooring be installed in the following:

- below grade installations
- exterior installations
- areas where excessive moisture exists
- commercial kitchens
- over existing floor coverings, adhesives, or painted surfaces

If a non-conductive flooring material can be used in hospital operating suites, #5 Epoxy Adhesive must be used with the installation of FlexiFlor's Sheet Rubber and Rubber Tile Flooring because of the unusual maintenance conditions that prevail.

For on-grade installations where there is a possibility of moisture being present, it is recommended that #5 Epoxy Adhesive be used. Where excessive moisture exists, we do not recommend the installation of our sheet Rubber or Rubber Tile Flooring.

When rubber flooring is to be installed over a plywood sub-floor treated with fire retardants, contact us for recommendations.

***NOTE:*** 3/32" and 1/8" gauge FlexiFlor® Sheet Rubber must be installed by overlapping and double cutting materials.



## Adhesive

### #95 HydroLock

#### FlexiFlor® sheet rubber and tile flooring installations

1. Flooring materials and adhesives should be stored in a pre-heated building where room and substrate temperature should be no less than 65° F, 24 hours before, during and after installation.
2. Sub-floors must be cleaned, free of dust, dirt, grease, wax, paint, curing or parting agents or any other substances that may affect the bond. Concrete floors must be level, fully cured and free of excessive moisture emissions and alkali. All substrate preparation and testing procedures must conform to ASTM F710 guidelines. The relative humidity of the substrate should be 90% (95% for vinyl) or less as defined by ASTM F2170 with pH of 8-11.
3. Trowel recommendations: 1/16 x 1/16 x 1/16 square notch, approximate coverage: 160 – 180 sqft per gallon. It is up to the installer to determine the proper trowel to be used. It is critical to replace the trowel blade when worn to ensure proper spread rate. Adhesive application must be sufficient to achieve 100% transfer of adhesive to the backing of the floor covering.
4. If sheet goods are to be installed, cut to fit before spreading adhesive. All seams must be overlapped and double cut. Flooring may be placed immediately when installed over a porous substrate. If installing over a non-porous substrate allow the adhesive to dry until it no longer transfers to finger when lightly touched. Do not install flooring into wet adhesive over a non-porous substrate. Open time is 15-60 minutes,
5. Lay floorcovering into the adhesive as to minimize air bubbles and wrinkles.
6. Roll flooring with a 75-100lb roller in both north-south and east-west directions to ensure 100% transfer and to remove trapped air.



7. Restrict foot traffic for at least 24 hours and DO NOT move heavy objects on carts over the finished flooring for at least 72 hours. Allow at least five days following the installation before conducting wet cleaning procedures or initial maintenance.

Use a clean wet cloth to clean up adhesive while still wet. Dried adhesive may require the use of an appropriate solvent.

## #56 Latex Adhesive

### FlexiFlor® sheet rubber and tile flooring installations

*Note: For Target® Tile, see #5 Epoxy directions*

1. Be sure the sub-floor is smooth, clean, dry and free of dust or contamination. If Sheet goods are to be installed, cut to fit before spreading adhesive.
2. For best results, FlexiFlor® material, room and adhesive should be 70°F. (21°C.) 48 hours prior to, during and after installation.
3. Apply adhesive with a notched spreader having notches 1/16" deep, spread 1/16" on centers. Apply only to an area of such size that Tile or Sheet Goods can be set while adhesive is still wet. **Avoid letting the adhesive skin over.**
4. Set Tile or Sheet goods in place immediately. Lift a newly set spot occasionally to be sure adhesive is transferring to back. Press Tile in firmly with the hands.
5. Immediately after installation, roll the Flooring with 100 to 150 pound sectional roller. For Tile installations begin at one side and proceed slowly to the other. For Sheet Rubber installations roll each sheet from center out to the edge before double cutting the seams (If double cutting in "wet" adhesive, the adhesive "stolen" on the scrap piece must be replaced); after seams are cut, roll seams thoroughly. All installations should be rolled in both directions. It may be necessary to weight the seam until a suitable bond has been established.



6. Wet adhesive smears should be removed immediately with a damp cloth. Dry adhesive can be cleaned with mineral spirits. Be careful: Mineral spirits is harmful to floor coverings and will ruin the adhesive bond if it gets under the floor covering.
7. Do not place furniture, allow traffic, or institute general cleaning procedures until 48 hours after installation.

### Rubber Stair Tread and Riser Installations

**Notes:** For Tread nosing, see #10 Epoxy Stair Nosing Caulk below  
For Target® Stair Treads, see #5 Epoxy below

1. Be sure the substrate is clean, dry and smooth. Avoid waxed surfaces, loose paint and other contaminations.
2. Stair Treads and Risers should be pre-cut side to side and front to back before spreading any adhesive. Abrasive Strips should be cut 1/16" shorter than the overall length of the Stair Tread. Make sure Stair Treads will slide onto and off of step before applying adhesive. Do not force Treads in at ends - cut loosely.
3. Apply adhesive with a notched spreader having notches 1/16" deep, spread 1/16" on centers. Apply only to an area of such size that stair treads or risers can be set while adhesive is still wet. **Avoid letting the adhesive skin over.**
4. Lay the Stair Treads in place while adhesive is still wet. Be sure good contact is established and maintained. Thoroughly roll the Stair Treads with a hand roller to assure a good bond.
5. Wet adhesive smears should be removed immediately with a damp cloth. Dry adhesive can be cleaned with mineral spirits. Be careful: Mineral spirits is harmful to coverings and will soften the adhesive bond if it gets under the Stair Treads.
6. Do not allow traffic until 48 hours after installation.



## #5 Epoxy Flooring Adhesive

### Target® tile and FlexiFlor® sheet rubber and tile flooring installations

1. Be sure sub-floor is dry, clean, smooth and free from foreign matter.
2. Pour equal amounts of part "B" into part "A" and mix until completely uniform. Bond strength depends on efficient mixing. Do not dilute adhesive.
3. Do not mix more adhesive than you can spread in 30 minutes. A complete unit of part "A" and part "B" should cover approximately 150 sq. ft. per gallon unit.
4. Do not allow mixture of part "A" and part "B" to remain in the container more than 30 minutes.
5. Rubber Floor Covering, room and adhesive should be 70°F. (21°C.) 48 hours prior to, during and after installation. Spread the adhesive with a trowel with (V) notches (notches 1/16" wide and 1/16" deep and on 1/16" centers).
6. Do not place flooring in adhesive too soon. Allow 30 minutes for adhesive to partially set before laying the flooring. This prevents flooring from slipping and adhesive oozing through joints or seams.
7. Do not kneel or walk directly on flooring as installation progresses. Kneel on piece of plywood or Masonite.
8. After Flooring has been in the adhesive for 1 hour, cross roll thoroughly with a 100 to 150 pound sectional roller. It may be necessary to weight seams until a suitable bond has been established.
9. Do not place furniture, allow traffic or institute general cleaning procedures until 48 hours after installation.
10. Remove excess adhesive from flooring and tools with warm, soapy water before adhesive hardens.



## Rubber Stair Tread Installations

*Notes: #5 Epoxy MUST be used for Target® Stair Tread installations  
For Tread nosing, see #10 Epoxy Stair Nosing Caulk below*

1. Be sure the substrate is clean, dry and smooth. Avoid waxed surfaces, loose paint and other contaminations.
2. Stair Treads and Risers should be pre-cut side to side and front to back before spreading any adhesive. Abrasive Strips should be cut 1/16" shorter than the overall length of the Stair Tread. Make sure Stair Treads will slide onto and off of step before applying adhesive. Do not force Treads in at ends - cut loosely.
3. Pour equal amounts of part "B" into part "A" and mix until completely uniform. Bond strength depends on efficient mixing. Do not dilute adhesive with solvents.
4. Do not mix more adhesive than you can spread in 30 minutes. A complete unit of part "A" and part "B" should cover approximately 150 sq. ft. per gallon unit.
5. Do not allow mixture of part "A" and part "B" to remain in the container more than 30 minutes.
6. Rubber Stair Tread, room and adhesive should be 70°F. (21°C.) 48 hours prior to, during and after installation. Spread the adhesive with a trowel with (V) notches (notches 1/16" wide and 1/16" deep and on 1/16" centers).
7. Do not place Stair Treads in adhesive too soon. Allow 30 minutes for adhesive to partially set before laying the Treads. This prevents Tread from slipping and adhesive oozing through joints or seams.
8. Do not kneel or walk directly on Stair Treads as installation progresses. Kneel on piece of plywood or Masonite.





9. After Stair Treads have been in the adhesive for 1 hour, roll thoroughly with a hand roller. It may be necessary to weight Treads until a suitable bond has been established.
10. Do not allow traffic or institute general cleaning procedures until 48 hours after installation.
11. Remove excess adhesive from treads and tools with warm, soapy water before adhesive hardens.

## #10 Epoxy Nosing Caulk

### Rubber Stair Tread Nosing Installations

1. Be sure substrate is clean, dry and smooth.
2. Room and all materials must be minimum 70°F. (21°C.) 48 hours prior to, during and after installation.
3. Stair Treads and Nosing must be precut to length prior to beginning application.
4. Thoroughly mix equal parts of "A" and "B". Bond strength depends on efficient mixing. Do not dilute caulk with solvents.
5. For old stairs trowel mixed caulk onto areas in bad condition to form normal contour. Be sure compound is thoroughly embedded into holes or depressions. Proceed as for new stairs.
6. New stairs - use a spatula to apply sufficient compound to inside of nosing to eliminate any gaps between nosing and stair. Apply appropriate FlexiFlor Stair Tread Adhesive to the step and balance of part being installed. Let dry 10-15 minutes. Install and press nosing firmly into place. Clean excess compound off with water immediately, protect from traffic for 48 hours.

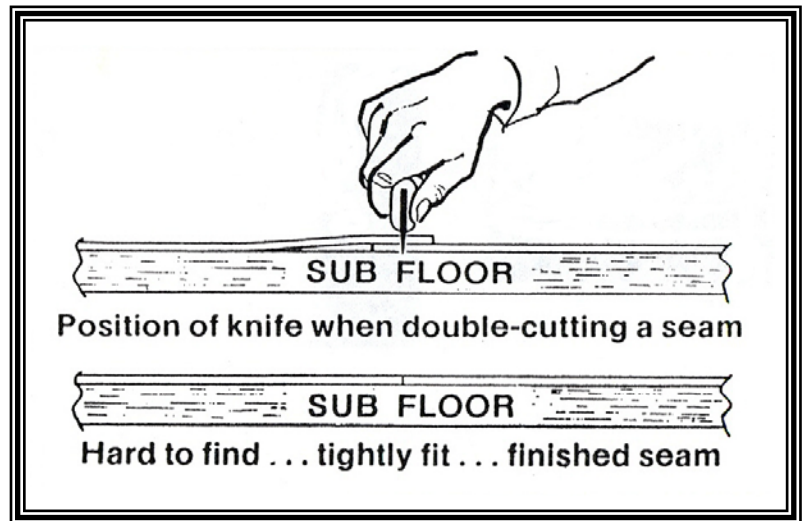


7. Fresh compound may be removed with water. Hardened compound may be removed in first 24 hours with mineral spirits. Be careful: Mineral spirits is harmful to floor coverings and will ruin the adhesive bond if it gets under the Stair Treads.

## Installing FlexiFlor® sheet rubber flooring

1. 1/8" and 3/32" FlexiFlor Sheet Rubber must be installed by overlapping and double cutting materials.

- You have been given an untrimmed edge on the sheet rubber. This will allow the material to be overlapped and double cut and still give you 36" of useable material.



2. Dry lay material letting factory edges overlap at least one (1) inch.

3. Use a straight edge as you cut through both pieces of material with a utility knife.

- When cutting, be sure to hold knife straight up and down (vertical) so you get a clean, straight cut on both pieces of material. This will give you the best seam.

4. After material has been dry cut, pull both rolls back ½ their length lengthwise.

- This ½ of the material will rest on the dry cut area you are not working with.
- This will give you an area that has been cut where you can spread adhesive.

5. Spread proper adhesive with proper trowel.

6. Allow adhesive to tack up. Do not allow it to skim over. Test adhesive with your finger to see if it is ready for the material.



7. Carefully roll material back into the adhesive matching the seams up to where they were dry cut.
8. Do not force the seams together too tightly. This can cause seams to peak.
9. Pull a small amount of material back up to see that you have adhesive transfer.
  - You should get a spider web of adhesive between the sub-floor and the sheet rubber.
10. Roll material in both directions with a 100-150 # roller.
11. Fold back the second ½ of your two (2) rolls to spread adhesive
  - Do not overlap adhesive. When dry, this will telegraph through the material.
12. For subsequent rolls/rows, follow the above directions starting with #4.
13. When complete, roll the entire area again with a 100-150# roller.
16. See adhesive instructions for how long traffic must be kept off the floor.

**Note:** If #5 Epoxy Flooring Adhesive is used, you must weigh the seams until a bond has been established.

**Note:** If you choose to cut material in wet adhesive, remember to re-apply adhesive to any areas where it may have been stolen when the factory cut edges were removed.

