



BEFORE INSTALLATION READ THIS DOCUMENT

# PREMIUM RESILIENT TILE (PRT) INSTALLATION AND MAINTENANCE INSTRUCTIONS

## NOTICE TO OWNER & INSTALLER

THIS DOCUMENT CONTAINS IMPORTANT INSTALLATION AND MAINTENANCE, INFORMATION AS WELL AS CAUTIONS AND WARNINGS. PLEASE MAKE CERTAIN THESE INSTRUCTIONS ARE PLACED IN THE HANDS OF THE FLOOR OWNER. OUR WARRANTY WILL BECOME EFFECTIVE ONLY IF THESE INSTRUCTIONS ARE FOLLOWED IN EVERY ASPECT. IN SITUATIONS WHEN A WARRANTY CLAIM IS DEEMED VALID BY VPI, VPI'S LIMITED WARRANTY LIMITS VPI'S LIABILITY TO PARTIAL OR TOTAL REPAIR, REPLACEMENT, CREDIT OR OTHER, AT VPI'S SOLE OPTION, FOR VPI FLOOR PRODUCTS FOR WHICH A CLAIM, VALIDATED BY VPI, HAS BEEN MADE ACCORDING TO VPI'S CLAIM PROCEDURE. CLAIMS FOR SURFACE DEFECTS OR VARIATIONS IN COLOR OR PATTERN MUST BE MADE TO VPI PRIOR TO INSTALLATION OF THE MATERIAL. CONSEQUENTIAL DAMAGES, LABOR COSTS AND ALL OTHER NON-PRODUCT COSTS ARE NOT COVERED BY VPI OR THIS WARRANTY AS A CONDITION OF SALE. FOR A COMPLETE STATEMENT OF VPI'S EXCLUSIVE WARRANTY, CONTACT: VPI, CUSTOMER SERVICE, P. O. BOX 451, SHEBOYGAN, WI 53082-0451. DO NOT USE VPI PRODUCTS IF UNWILLING TO ACCEPT THE TERMS AND CONDITIONS OF THIS WARRANTY.

Please refer to the installation instruction sheet posted on line at [www.vpiflooring.com](http://www.vpiflooring.com) in case of any installation instruction updates newer than this document.

### WARRANTY:

PRT tiles are warranted for 25 year "wear through" under normal traffic conditions and for 75 years pertaining to manufacturing workmanship and production materials. This warranty expressly excludes claims for consequential damages, labor costs and all related other.

### PREPARATION OF SUB-FLOOR:

It is essential that moisture tests be performed on all concrete sub-floors regardless of the grade level or whether or not the concrete is freshly poured or is classified as an older slab. Moisture testing should be performed by **ASTM F-1869** Calcium Chloride Test procedure with moisture levels not to exceed five (5) pounds per twenty-four (24) hours per one thousand (1000) square feet or **ASTM F-2170**. In Situ (Site or Location), Relative Humidity Test with moisture levels, when measured by this method, are not to exceed seventy-five (75) percent. If the test results exceed the limitations, the installation should not proceed until the problem has been corrected.

**ADHESIVE BOND TEST:** In addition to and not in lieu of the moisture tests, perform the Adhesive Bond Test in several locations throughout the area to receive the flooring. Glue down a 3' x 3' area of floor tile with the adhesive, roll with a 150 LB sectional roller, then allow to set for 72 hours. A sufficient amount of force should be required to remove the flooring. (Bond tests should be done across the recommended open time spectrum so that the optimal working time can be determined. Working times vary depending on substrate, environment and many other factors). This is recommended for VPI 100, VPI 520 and Spray Lock 6500.

**\*\*IMPORTANT\*\*:** Without dated documents showing pH, RH, calcium chloride and bond test results, no warranty claim will be accepted for consideration.

No VPI warranty covers a floor failure due to moisture emission from sub-floor or sub-floor movement, expansion, contraction or settlement caused by any environmental condition.

Additional information regarding the sub-floor installation and requirements can be found in **ASTM F-710**.

### CONCRETE, TERRAZZO, CERAMIC:

Sub-floors must be structurally sound, dry and clean. Free of dirt, dust, wax, grease, paint, polishes, oil, curing compounds, sealers and all other materials that would interfere with good tile adhesion. The floor surface must be smooth and flat with a maximum variation of 1/8" in 10 feet. All cracks, depressions and other imperfections must be repaired with a high quality, cementitious leveling compound and or underlayment.

Gypsum-based underlayment products should not be used.

Any uncorrected sub-floor irregularities may telegraph through the PRT flooring and be visible on the surface on the finished installation.

**Previous covered concrete:** completely remove the old floor down to bare concrete. Be sure to remove 100% of adhesive residue or cover 100% with a high quality cementitious underlayment, warranted for such applications.

It is recommended that new concrete slabs on or below grade should be treated with a permanent moisture barrier such as six mil polyethylene film. Any concrete in contact with earth or with less than 18" of cross-ventilated air space under it is considered to be on grade.

New concrete must be properly cured. A drying time of one month per inch of concrete is generally required after a slab is poured and protected from the weather. Lightweight aggregate concrete floors, and floors with steel or plastic pan construction, and floors poured over a permanent moisture barrier usually require an extended drying time. If lightweight aggregate concrete weighs less than 90 pounds per cubic foot, a topping of regular concrete at least one inch thick is required. To expedite drying time, adequate heat and ventilation should be provided.

Additional information with regard to these tests and results can be obtained through VPI's Technical Service Department.

If concrete surface is exceptionally smooth, it should be acid etched with a 15% diluted solution of muriatic acid before installing flooring. Neutralize the concrete after etching by rinsing with clear water to which a few ounces of ammonia have been added.

Terrazzo floors may have a sealer or film on the surface. This must be removed before proceeding with the installation.

Ceramic tile must be solidly adhered to the substrate. Any loose tiles must be removed. Clean existing ceramic tile using muriatic acid/water as directed above. After the floor has dried, apply a thin rich coat of Portland cementitious underlayment with a liquid latex binder to achieve a smooth surface.

### RADIANT HEATED FLOORS:

PRT tile may be installed on radiant-heated floors, provided that the surface temperature does not exceed 90° F. and the nominal operating temperature runs at 72°F.

### WOOD FLOORS:

Tile may be installed over existing sound, suspended plywood floors of double construction. Do not install directly over wood strip or plank sub-floors. Prepare such floors as follows:

Sub-floor must be solid, well nailed at joints and free from spring. Missing or unsound boards must be replaced. Install ¼" underlayment grade or exterior grade plywood or ¼" underlayment grade hardboard. If floorboards are badly warped, use thicker plywood.

Fill all holes, cracks and seams with wood putty or equivalent filler. Sand all patched areas and uneven joints. Any irregularities allowed to remain may telegraph through the tile and be visible on the surface of the new installation.

### RESILIENT FLOORING:

Whenever possible, remove all old floor covering and sand off all the old adhesives. **Do not install tile over any resilient floor covering on or below grade – only above grade.**

If you are going over resilient floor covering, use the following procedures: the floor covering must be sound and adhered tightly to the floor. Remove any loose or broken areas and replace them either with sound material or with a Portland cementitious underlayment with a liquid latex binder, which should also be used to level any floor irregularities and to fill in any open seams. Thoroughly sand the surface with coarse sandpaper, using an edge sander next to the walls and in spots that a regular sander may have skipped. Completely remove all the old sealers and waxes to ensure a proper bond. Any texture or embossing in the original installation may telegraph through the PRT tile and become visible on the surface of the new installation.

**WARNING:**

If you intend to sand, remove or dispose of an existing resilient floor covering, backing, lining felt or adhesive you should be aware that these products may contain asbestos fibers. Sanding, removal and disposal of asbestos containing material can place fine particles of asbestos in the air. It has been determined that the inhalation of free airborne asbestos fibers may be injurious to your health. Fines may be assessed against persons violating these regulations.

**NOTE: PRT resilient floor coverings and adhesives have never contained asbestos.**

**METAL DECKS:**

Metal decking must be flat, dry, clean and free from dust, paint, asphalt, old adhesives, grease, oil, rust and other extraneous material. Level all surface irregularities with a Portland cement/liquid latex mixture underlayment. Lightly sand or (scuff) the surface for better adhesion.

**WORK BENCHES:**

Tile can be applied to either wood or metal workbench surfaces. The bench surface must be flat, dry, clean and free from paint, oil, grease and other extraneous material. Metal surfaces should be lightly sanded for better adhesion.

**OTHER TYPES OF INSTALLATION:**

For recommended procedures on other types of installations not covered in these instructions, contact the manufacturer before installation commences.

**WORK OFF THE TILE WHENEVER POSSIBLE.**

When laying individual tile, do not slide tile into place. The correct procedure is to place a corner of the tile in place next to the adjoining tile, carefully guide it into proper position and set it in place. When necessary to work on the tile, avoid shifting by using a kneeling board and by cutting tile to butt tightly at all wall junctions. Roll and cross roll the tile with 150-pound sectional roller immediately after the tile is laid. Roll a second time one hour later. Inspect the floor for raised edges one hour after the second rolling, if necessary, roll a third time. Use a hand roller in areas that cannot be reached with a large roller.

**IMPORTANT! ANY ADHESIVE AT SEAMS OR ON FINISHED SURFACES OF TILE MUST BE REMOVED WHILE THE ADHESIVE IS STILL WET.**

**VPI Recommends:** Isopropanol (IPA), denatured alcohol and/or a mild abrasive cleaner such as Soft Scrub.®. Using a dry cloth and IPA, wipe up adhesive that has oozed from seams or spills immediately followed by Soft Scrub to remove staining. Do not use cleansers containing amines. (Yellowing may occur) Rinse well with water.

Avoid exposure of tile to excessive heat, such as direct sunlight, until adhesive has completely set.

Avoid any traffic over finished floor for at least 72 hours after the installation.

**CONVENTIONAL INSTALLATION:**

Install PRT Flooring in accordance with the following procedures USING ANY OF THE 3 LISTED ADHESIVES. No other adhesives are approved. All three listed adhesives (VPI 100, VPI 520 and Spray Lock 6500) can be used to install PRT tiles on porous and non-porous substrates.

Adhesive usage varies depends on whether the floor is porous or non-porous. It is essential that prior to the installation of the floor that the sub-floor is tested to **verify whether the concrete is porous or non-porous**. To test, place several droplets of water in numerous locations within the installation area. If water is absorbed in less

than 45 to 60 seconds, concrete is to be considered porous. If water remains beaded or is not absorbed into the concrete within recommended time frame, concrete is to be considered non-porous and may have had a surface coating applied such as curing compound and or a sealer.

**ADHESIVE -- APPROVED TYPES:**

**VPI 100** two-part epoxy adhesive is approved for all types of sub-floors below, on or above grade, listed in these instructions.

VPI 100 is recommended when high shear, high traffic and where high loads are expected. **Substrate MAX Condition: pH - 7, MVER - 5 lb, RH - 75%.**

**Coverage** will vary on conditions & porosity but on average, coverage is **about 90-135 sq ft per gallon**. Only a 1/16 x 1/16 square notch trowel with 1/16 flats should be used for the installation.

**Never re-notch a trowel.**

If you have not worked with epoxy adhesives before, you will find that unlike other flooring adhesives, epoxies do not have nor do they develop tackiness as they set up. This makes it extremely important to roll the floor as recommended to avoid raised edges.

**VPI 100 2-PART EPOXY INSTALLATION INFORMATION:**

1a. Preceding the installation, remove the cartons from the pallets, placing the tile on a flat floor surface at 70 degrees OR AT THE EXPECTED TEMPERATURE OF THE OPERATION for a minimum of 48 hours.

1b. After the acclimation, and preceding the installation of the tile, wipe the back of the tiles to remove any manufacturing residue or contaminants.

1c. **\*\*IMPORTANT\*\***: Before starting to install and in order to reduce tile ledging and gapping, the general conditions (ambient temperature, slab temperature, etc.) at the time of the installation should match planned operational and general conditions.

2. All subfloors must be clean and dry, free of dust, dirt, wax, paint, grease, manufacturing residue or any other contaminates that might interfere with the adhesive bond.

3. Cracks and uneven substrate surfaces must be filled with an approved cement based patching compound.

4. Use the mixing paddle provided or use a mixing paddle on an electric drill to carefully stir Parts A and Part B separately until homogenous. **Pour Part B into Part A.** Be sure to remove as much of Part B from the can as possible by scraping the sides of the container and the bottom of the container with the appropriate paddle provided.

5. **NOTE:** The adhesive shouldn't be poured onto the floor until parts A and B have been properly mixed together. Any improperly mixed adhesive applied to the sub-floor will not stick causing an adhesive floor failure.

6. Mix the combined parts A and B using a slow speed drill (200 RPM) and a mixing paddle. Mix for a minimum of 3 - 4 minutes. **DO NOT mix at higher speed.** This could cause the adhesive to start the curing process and shorten the open time.

**NOTE:** Extended mixing (10 minutes or more) may adversely affect the adhesive. Be sure to mix the entire contents of the can.

7. If mixing by hand, use the rotary motion while at the same time lifting from the bottom. Periodically scrape the sides and the bottom of the can to insure a complete mixing of both parts A & B together. Mix a minimum of 5 minutes.

**CAUTION: THE ADHESIVE WILL NOT CURE THOROUGHLY IF NOT PROPERLY MIXED.**

8. After a complete mixing, **IMMEDIATELY** pour all adhesive on the subfloor and spread as soon as possible. **DO NOT** allow the mixed adhesive to remain in the container.

Spread the adhesive, in 3-foot wide sections, as close to but not over your chalk lines. If you occasionally cross the line with your trowel (1/16" x 1/16" square notch with 1/16 flats) when spreading adhesive, do not be concerned. Any adhesive over the edge of the line must be scraped up before the next row of tile is installed to avoid (ledging) or high edges.

9. Install the tile immediately over the prepared epoxy adhesive surface.

NOTE: The adhesive will appear glossy when first spread and will dull as it sets up. DO NOT allow the adhesive to set up before installing the tile. Be careful not to spread more adhesive than tile or that can be installed or rolled prior to the adhesive setting.

It is essential that the specified trowel and roller be used. If the trowel notches are too large, too much adhesive will be used. This will result in excessive adhesive seepage at the seams and also will cause the tile to float and shift. Clean up after the installation is then very difficult. In addition, the seams will be ledged making them very noticeable and dirt catchers as well. If you delay rolling the tile because of excessive seepage, the adhesive will not be adequately transferred to the back of the tile causing an adhesion failure. If the notches are worn on the trowel, the adhesive will be spread to thin resulting in adhesion failure.

**Worn trowels should be discarded.**

Please note that using unapproved adhesives will void PRT's Exclusive Warranty. Read the instructions for proper sub-floor preparation before opening the adhesive. If the installation will be flash coved, see special instructions under FLASH COVING.

All adhesive, floor tile and sub-floor (slabs) should be conditioned at the expected operational temperature, slab humidity and ambient humidity level. Maintain these levels at least 24 hours before and 48 hours after the tile is installed.

Open time, working time and cure time will be longer at lower temperatures, and will shorten at higher temperatures. Ensure that the installation is well lit to allow effective examination of the tile and the overall installation.

**VPI 520 ONE PART PRESSURE SENSITIVE ACRYLIC SOLVENT FREE ADHESIVE (P.S.)** is approved for all types of sub-floors on or above grade, listed in these instructions.

520 adhesive is a non-flammable, water and alkali resistant, freeze and thaw resistant adhesive, it is tested in accordance with ASTM 7149.

VPI 520 physical properties are excellent moisture resistance, resistant to plasticizer migration, ease of clean up, sets hard, 0 VOC vapors and exceeds the requirement of SCAQMD1168 (Indoor Environmental Air Quality, Low Emitting Materials Study). ASTM F1869 (Calcium Chloride Test) is to be preformed regardless of grade level or concrete age.

ASTM F2170 Situ Relative Humidity Tests are not to exceed, **Substrate MAX Condition: pH - 7, MVER - 5 lb, RH - 75%** required: (a dry, drilled, fully lined hole.) using either Vaisala or Engius Relative Humidity Meter and probes to check RH. Alkalinity of the concrete should not exceed a PH of 10.

**Coverage** will vary on the conditions and the porosity of the substrate but on average the coverage is about **90-135 sq ft per gallon**. Only a 1/16 x 1/16 square notched trowel with 1/16 flats trowel should be used for installation.

**Never re-notch a trowel.**

**VPI 520 ONE PART PRESSURE SENSITIVE ACRYLIC ADHESIVE INSTALLATION INFORMATION:**

1a. Preceding the installation, remove the cartons from the pallets, and place the cartons on a flat floor surface at 70 degrees or at the expected temperature of the operation for a minimum of 48 hours.

1b. After the acclimation, and preceding the installation, wipe the back of the tiles to remove any manufacturing residue or contaminants.

1c. **\*\*IMPORTANT\*\***: Before starting the install and in order to reduce tile ledging and gapping, the general conditions of the working area and (ambient temperature, slab temperature, etc.) should match the planned operational and general conditions.

2. All subfloors must be clean and dry, free of dust, dirt, wax, paint, grease, manufacturing residue or any other contaminates that might interfere with the adhesive bond.

3. Cracks and uneven surfaces must be filled with an approved cementitious based patching compound.

4. Apply using a 1/16"x1/16"x1/16" square notch trowel with 1/16 flats. Replace worn trowels to ensure proper spread rate.

5. NOTE: **Do not re - notch trowels.**

6. Spread the adhesive and **IMMEDIATELY** start laying the tiles when the adhesive has become clear and no longer has a milky appearance.

7. Upon installation, immediately roll with a three section 150 lb. roller.

8. **Remove wet adhesive with water. Dry adhesive may be removed with mineral spirits.**

9. **\*\*IMPORTANT\*\*** From the time when the adhesive no longer has a milky appearance to when it becomes clear, (may range from 30-90 minutes depending on conditions). The time when the last tile should be laid into the adhesive should **NEVER** exceed 3 hours and typically be between 0-2 hours depending on sub floor condition and porosity, patching compound type, direct sunlight conditions, troweling style, atmospheric temperature, slab humidity, slab temperature and other job site conditions. These variables are why bond tests are critical. In summary after adhesive becomes clear, the tiles can be installed for up to 3 hours **MAXIMUM**.

10. If the adhesive is allowed to remain uncovered, after initially drying for periods longer than the typical and recommended 2-3 hours, a loss in adhesion strength and even complete adhesion failure will result.

11. **\*\*IMPORTANT\*\*** Care must be taken by the installer not to spread more adhesive than can be worked appropriately within the recommended time frame.

12. Prevent all traffic for a minimum of 24 hours and heavy traffic and rolling loads for a minimum of 72 hours.

13. **Do not finish, wash, or clean the floor for a minimum of 4-5 days after installation, allow the adhesive to properly cure.**

14. NOTE: If any questions exist by the installer or floor tile contractor as to whether or not this product is appropriate, contact VPI Technical Service Department.

**Spray-Lock 6500** one-part spray-on pressure sensitive (P.S.) adhesive is approved for all types of sub-floors on or above grade, listed in these instructions.

**Coverage** will vary on conditions & porosity but on average coverage is about **100-125 sq ft per can**.

**Substrate MAX Condition: pH - 12, MVER - 7 lb, RH - 92%**. Additional technical information can be found at: [www.spraylock.com](http://www.spraylock.com)

**SPRAY-LOCK 6500 ADHESIVE INSTALLATION INFORMATION:**

1a. Prior to installation, remove cartons from pallets, and place on a flat floor surface at 70 degrees OR AT THE EXPECTED TEMPERATURE OF OPERATION for a minimum of 48 hours.

1b. After acclimation, and prior to installation, wipe the back of the tiles to remove any manufacturing residue or contaminants.

1c. **\*\*IMPORTANT\*\***: Before starting the install and in order to reduce tile ledging and gapping, the general conditions (ambient temperature, slab temperature, etc.) at the time of installation should match planned operational general conditions.

2. All subfloors must be clean and dry, free of dust, dirt, wax, paint, grease, manufacturing residue or any other contaminates that might interfere with the adhesive bond.

3. Cracks and uneven surfaces must be filled with an approved cementitious based patching compound.

4. NOTE: Always store adhesive at a minimum temperature of 68°F (20°C) for 72 hours prior to installation.

5. Ensure the substrate, flooring and surrounding areas are clean and dust free. Damp-mop substrate if dust is present. Use only Portland based patching and leveling compounds. (Wipe hand across surface. If dust transfers, substrate is not clean).

6. HVAC must be continuously operated for a minimum of 72 hours at a temperature of no less than 68°F (20°C) prior to installation. Protect from overspray with a spray shield, drop cloths, paper or masking products.

7. Shake aerosol can well. Remove cap. Attach hand lever. Slide under lip or use your finger.

8. Stand straight up, bend over only when necessary. Adhesive should spray out in a wide mist and fall similar to snow towards desired surface. Hold can upside down slightly away from your body, approximately 20-30 inches horizontally from the substrate. Aim at floor and press hand lever or press tip with finger. Walk right to left smoothly to achieve a consistent spray pattern. Spraying in a sweeping motion may result in an inconsistent spray pattern. Excessive buildup or inconsistent spray pattern on substrate may cause telegraphing.

To ensure optimal spray pattern, remove any adhesive build up that may occur during the application process. If overspray occurs, it may be removed with a damp cloth while the adhesive is still wet. Allow adhesive to dry until there is no adhesive transfer when lightly touched. High humidity and/or low temperature increases tack time.

Open time after application is about 4 hours depending on a variety of factors. While open, ensure that adhesive is not contaminated by dust. Following flooring manufacturer's recommendations for installation.

- Position tile
- Ensure proper alignment before application or pressure
- Reposition as necessary

Roll the tile with a 150 lb. roller within 1 hour after installation to complete the bonding process. After rolling, the floor is ready for all access. Dry cut cove pieces to fit. Remove pieces and apply adhesive to the back of each piece, install and roll with a hand roller. See Flash Coving for more detail.

#### ADHESIVE CURING PROCESS

**UPON INSTALLING AND AFTER USING ANY ADHESIVE, DO NOT WASH FLOOR FOR AT LEAST 5 DAYS TO ENABLE ADHESIVE TO SET THOROUGHLY.**

#### SEAMLESS (NON-CONVENTIONAL) INSTALLATION:

PRT is available in 36" x 36" or 24" x 24" sections, square edge or pre-grooved, for seamless installations. The 36" x 36" or 24" x 24" sections are installed in essentially the same manner as described under CONVENTIONAL INSTALLATION using VPI #100 epoxy adhesive and specified trowel, VPI #520 adhesive and specified trowel OR Spray Lock 6500

#### SQUARE EDGE SECTIONS:

1. Remove tile from carton and store flat in stacks (not to exceed 6" in height) at a temperature of at least 70°F OR AT THE EXPECTED TEMPERATURE OF OPERATION for 48 hours prior to installation. This allows tile to adjust to room temperature. Tile will then lay flat and conform to the contour of the sub-floor when installed.
2. Lay out field so that the last section ends at least 6" from the wall to allow space for use of router and hot air welding tool around the room perimeter.
3. Install the field, making sure to properly roll and cross roll with the proper sectional roller. Allow the adhesive to cure overnight.
4. Dry cut all cove pieces to fit as described under FLASH COVING, and install them. Roll thoroughly with a hand roller.
5. Using a scrap piece of tile, set the router so that the blade cuts a groove to a depth of approximately one half of the thickness (.060) of the tile. Router all field seams in one direction only, being careful to keep the groove centered on the seam as closely as possible. Use chamfering plane to router cove pieces where the router cannot be operated.
6. Preheat the hot air welding tool. Using the 4mm welding nozzle, weld the bead into the groove. Trial welding a few scrap pieces before starting on the floor so that adjustments in the heat setting may be made if desired. Beginners may find it easier to work with a lower heat. However, with experience, welding will be faster with a higher heat. A lower heat is recommended for correcting mistakes or welding in awkward places. A good weld is achieved when a small amount of melted bead overflows along the edges of the groove.
7. After the weld has cooled, shave off the excess bead with a spatula. If the bead is shaved before it has cooled, it will shrink below the surface of the flooring. Keep the spatula sharp by periodic honing with a fine sharpening stone.
8. After welding and trimming all seams in one direction, repeat the router procedure, welding, and trimming procedures on all seams running in the other direction.
9. While seamless installations are usually flash coved, top set cove base or other treatment may be used at the floor-wall junction. In these instances, use a chamfering plane to finish the groove close to the wall where the router cannot be operated.

#### PRE-GROOVED SECTIONS:

When installing pre-grooved tile, use the same general installation instructions as for square edge. Exceptions to these general instructions are as follows:

1. Take extra care to minimize adhesive seepage at the seams. Any adhesive allowed to remain in the grooves could prevent the vinyl bead and flooring from fusing together properly.

2. After the adhesive has cured overnight, use the chamfering plane to remove all excess adhesive that may have seeped into the grooves.
3. Weld and trim all seams in one direction only.
4. Use the chamfering plane to open each cross seam.
5. Weld and trim all remaining seams.

#### FLASH COVING:

Coving of tile up the wall eliminates accumulations of dirt and bacteria at the floor-wall junction. This procedure can be used with either CONVENTIONAL or SEAMLESS (UNCONVENTIONAL) INSTALLATIONS. The following steps are recommended:

1. Install metal inside and outside corners. Then install a suitable cove cap strip (either metal or plastic) around the entire room. Exercise care so that the tops of the cove cap strip and metal corners are at the same level. Use either flat-headed nails or contact bond adhesive to fasten corners and cove cap strips.
2. Place a cove cap strip at floor-wall junction to support tile at the bend. The radius of cove stick should be at least 7/8 of an inch and must have same radius as the metal corners.
3. When installing 12" x 12" tile, lay out the field so that it ends approximately 6" from the wall. When 24" x 24" or 36" x 36" sections are used, the field can be laid out so that the last section ends at any convenient distance in excess of 6" from the wall. The distance from the edge of the field to the cove cap strip must be less than the width of the formed cove pieces since variations in the floor and wall levels always necessitate cutting the formed cove pieces so that it fits tight to the cove cap and a seamless look can be achieved.
4. Installing the field in accordance with the procedures listed under either CONVENTIONAL or SEAMLESS INSTALLATION, and allowing the adhesive to cure overnight before installing the formed cove pieces is critical for a finished appearance.
5. Dry cut cove tile pieces to fit. Remove pieces and apply adhesive to the exposed floor and wall. Install the pieces and roll thoroughly with a hand roller. If VPI 100 adhesive is used, do as large an area as practical to avoid repeated mixing of adhesive batches.

#### **REQUIRED INITIAL MAINTENANCE – INSTALLATION IS NOT COMPLETE UNTIL INITIAL MAINTENANCE HAS BEEN COMPLETED.**

**Do NOT wash floor for 4 to 5 days after installation to allow the adhesive to set thoroughly.**

Green Prep and Conditioner will cover approximately 10,000 sq. ft per gallon at 10:1 ratio.

For a High Gloss Appearance - PRT Flex Shield coverage is approximately 2,500 sq. ft. per gallon.

Satin or Low Gloss Appearance - PRT Satin Flex Shield coverage is approximately 2,500 sq. ft. per gallon.

#### **HIGH GLOSS APPEARANCE**

##### FLOOR PREP:

1. Sweep or damp mop floor to remove all dirt. (Never use an oil treated mop)
  2. Dilute Green Prep and Conditioner with cool to warm water (1:10) 13 oz/gal.
  3. Apply solution liberally to floor. Using a (Norton maroon pad), agitate floor thoroughly, (roughly 4 passes) with a low-speed rotary machine, or automatic scrubber.
  4. Pick up the solution with a wet vacuum, auto scrubber, or a mop and bucket. Rinse with clear water only.
  5. Allow the floor to dry completely before applying PRT Flex Shield.
  6. Apply PRT Flex Shield in a uniform thin coat, using a new or clean synthetic finish mop. Allow the floor finish to dry approx. 30 minutes before applying the next coat. Apply 4 to 5 coats to maximize foundation.
- \*CAUTION: Any flooring will become slippery when wet. Care must be taken when walking upon the wet floor. Appropriate "Warning" or "Caution" placards should be used if any traffic is possible while the floor is wet.

**For all Buffer Pad requirements please call 1-800-242-7694 or (northwoodstm.com)**

**MAINTENANCE REQUIREMENTS WILL VARY DEPENDING ON VARIOUS ENVIRONMENTAL CONDITIONS BUT HERE IS A TYPICAL MAINTENANCE SCHEDULE:**



04-19-2013

**Daily-Routine Maintenance:**

1. Sweep and damp mop the floor to remove any large debris. (Never use an oil treated mop)
2. Use a low speed floor buffer or industrial automatic scrubbing machine on the floor with a medium red pad using 1/2 oz. per gallon of diluted PRT Cleaner and water.
3. Spray Buff, with PRT Spray Buff, as needed depending on traffic or desired gloss level.

**Periodic Maintenance to Rejuvenate Gloss:**

1. Sweep and damp mop the floor to remove any large debris. (Never use an oil treated mop).
2. Use a low speed floor buffer or industrial automatic scrubbing machine on the floor with a medium red pad using 1/2 oz. per gallon of diluted PRT Cleaner and water.
3. Spray Buff with PRT Spray Buff as needed, or, rinse with clear water, allow the floor to dry, then apply 1-2 coats of PRT Flex Shield.

**SATIN or LOW GLOSS APPEARANCE**

**FLOOR PREP:**

1. Sweep or damp mop floor to remove all dirt. (Never use an oil treated mop)
2. Dilute Green Prep and Conditioner with cool to warm water (1:10) 13 oz/gal.
3. Apply a solution of green prep and conditioner liberally to floor. Use a low-speed rotary machine or industrial floor scrubbing machine and a maroon pad scourer the floor thoroughly, (roughly 4 passes).
4. Pick up the dirt solution with a wet vacuum, industrial auto scrubber or a mop and bucket. Rinse with clear water only.
5. Allow the floor to dry completely before applying PRT Satin Flex Shield.
6. Apply PRT Satin Flex Shield in a uniform thin coat, using a new or clean synthetic finish mop. Allow the floor finish to dry approx. 30 minutes before applying the next coat. Apply 2 to 4 coats to maximize foundation.

**\*CAUTION:** Any flooring will become slippery when wet. Care must be taken when walking upon the wet floor. Appropriate "Warning" or "Caution" placard cards should be used if any traffic is possible while the floor is wet.

**MAINTENANCE REQUIREMENTS WILL VARY DEPENDING ON VARIOUS ENVIRONMENTAL CONDITIONS BUT HERE IS A TYPICAL MAINTENANCE SCHEDULE:**

**Daily-Routine Maintenance:**

1. Sweep and damp mop the floor to remove any large debris. (Never use an oil treated mop).
2. Low speed buff or automatic scrub the floor with a Red pad using 1/2 oz. per gallon diluted solution of PRT Cleaner and water.

**Periodic Maintenance to Rejuvenate Satin Appearance**

1. Sweep and damp mop the floor to remove any large debris. (Never use an oil treated mop)
2. Using a low speed buffing machine or a industrial automatic scrubbing machine on the floor with a medium red pad and using 1/2 oz. per gallon diluted the solution of PRT Cleaner and water, scourer the tiled area.
3. Rinse the area with clear water, allowing the floor to dry, applying 1-2 coats PRT Satin Flex Shield.

For additional information not covered in these instructions, please contact:

VPI Corporation  
3123 S 9<sup>th</sup> Street  
P. O. Box 451  
Sheboygan, WI 53082-0451, U.S.A  
920-458-4664 Fax 920-458-1368  
[www.vpiflooring.com](http://www.vpiflooring.com)

11MK2014-0213R