

## Direct Glue-Down Installation for

Weldlok

Weldlok Unitary

Weldlok Plus

Weldlok Air

Weldlok Plus Air



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## Direct Glue-Down Installation

### Carpet Installation Check List

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1. Newly poured concrete floors generally will take 90 to 120 days to cure. Moisture should not exceed 5 lbs./1000sf per 24 hours as determined by a calcium chloride test per ASTM F1869, or 80% relative humidity per ASTM F2170. If the results are more than 5 lbs. or higher than 80%, do not proceed with the installation. Contact **Field Services** at **1.888.387.9881**. Gypcrete or substrates with excessive dust must be cleaned, and then primed with Mohawk Industries' PrimeCoat or an approved primer, such as a latex milk additive.
2. The alkalinity or pH in a concrete slab should be between 5 and 9 for a glue-down installation. When pH is between 9-12 and moisture is below 5 lbs. or 80% then PrimeCoat can be used to block pH. Should the pH be outside this range, stop and do not proceed with the installation. Contact **Field Services** at **1.888.387.9881**.
3. The floor and room temperature must be acclimated by maintaining the temperature at 65° F and 95° F, and the humidity between 10% and 65%, for at least 48 hours before, during, and 72 hours after installation. In addition, the adhesive and seam sealer should be stored under these conditions for at least 24 hours before installation. The installation site must be acclimated with HVAC in operation.
4. Old adhesive must be properly removed prior to any installation of Mohawk Industries' branded carpet. When cutback adhesive is present or existing adhesive has indications of plasticization or PVC-backed products are being installed, then SureSeal must be applied after the old adhesive has been properly removed. See note #1.
5. Mechanically remove all wax, dirt, grease and paint. DO NOT use solvents to clean the floor. DO NOT use oil-based sweeping compound. Fill cracks more than 1/16" wide with a Portland or cement-based patching compound. The floor must be flat to within 1/8" in 10 feet. Use leveling compound when required. Patched areas may need to be primed (consult patch manufacture for requirements) with PrimeCoat or an approved primer. DO NOT install over resin or silicate-based curing compound.
6. Carpet should only be bent when absolutely necessary for transporting purposes only and must be unrolled immediately. Carpet should be rolled out and allowed to relax for at least 24 hours prior to installation.
7. Never cut carpet over carpet, as this can result in over-penetration of the blade and cutting loops on the lower carpet. Never install broadloom carpet over carpet.
8. Carpet should be protected from heavy traffic and construction dust with a non-staining building material paper. Never use plastic sheeting as it will trap moisture and prevent proper curing of the adhesive. Plastic may also leave residues that can result in rapid soiling after removal.
9. Furniture placement and heavy traffic should be avoided for at least 24 hours after a direct glue-down or double glue installation. Furniture and heavy equipment apply concentrated pressure, and movement over unprotected carpet can cause adhesive breakdown. This can result in buckling and / or wrinkling. It is strongly recommended that plywood or masonite boards be placed over the carpet during the move-in phase to spread the concentrated weight of furniture and heavy equipment.

#### PLEASE NOTE

1. Asbestos-containing floor tiles, any adhesive possibly containing asbestos, or other asbestos-containing floor coverings require special preparation, handling, and removal procedures. Consult the appropriate local or state authorities or the Resilient Floor Covering Institute before disturbing any suspected asbestos-containing material.
2. Unitary and attached cushions can only be installed by the direct glue method.
3. Installation of Mohawk Industries' branded carpet and carpet tile on a floor outside the scope of the guidelines in this document will void all applicable warranties.
4. Mohawk Industries is not responsible for any product failure due to improper floor preparation and / or installation procedures. The required adhesives are Mohawk Industries' family of adhesives.

## Required Equipment

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The following items may be purchased from a local carpet workroom supplier:

- NuBroadlok Adhesive
- NuBroadlok Seam Sealer
- Cushion Back Cutter or Top Cutter
- 1/8" x 1/8" x 1/8" U-notched Trowel  
or 1/8" x 1/8" x 1/16" V-notched Trowel
- 75–100 lb. roller
- Mini or Crab Stretcher and Power Stretcher
- Knee Kicker (to position carpet only)
- Straight Edges
- Razor Knives
- Hammer
- Stay Nails
- Dry Line
- Chalk Line
- Tape Measure

## Pile Direction

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All full-width carpets have an arrow on the back running approximately 2 feet from the selvage along one side of the carpet or a selvage marker to indicate pile direction. When seaming, the pieces of carpet should be joined with the arrow running in the same direction on each breadth. All cut carpet used as fill pieces should be marked to indicate pile direction before the arrows are removed.

## Recommended Cutting Methods

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Tufted and woven carpets should be cut between the rows using a top cutter. In all cut / loop and loop constructions, care must be taken to ensure that no loops are cut.

PLEASE NOTE: Edge Sealer must be used on all woven cuts immediately (length and width).

PLEASE NOTE: Seam Sealer must be used on all seams.

## Lengthwise Cuts

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Bend the carpet along the length to separate the rows and expose the backing yarns. Part or trace the pile with a screwdriver along the length of the proposed cut. Start the cut by making a small incision on the edge with a carpet knife. Insert the top cutter between the backing yarns and cut along the face of the carpet. The top cutter should always be inserted so that the blade is close to the seam edge.

## Widthwise Cuts (Tufted)

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All widthwise cuts must be made with a top cutter and straight edge following a pattern from point to point. Trim with the blade closest to the seam edge, holding the cutter slightly away from the seam edge at no more than a 5° angle, so as to cut slightly more backing material than face yarn.

## Pattern Matching

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It must be understood that carpet is a textile and cannot be made to exact specifications. All patterned carpet is subject to certain manufacturing tolerances, therefore a perfect pattern match cannot be guaranteed. However, a match should be achievable by stretching the short side out to meet the long side. Tolerances for patterned carpet are:

**Bow:** 1-1/2 inches across the 12-foot width

**Skew (bias):** 1-1/2 inches across the 12-foot width

**Pattern elongation:** 1-1/2 inches in 12 feet along the length

PLEASE NOTE: If you are having trouble matching a pattern, STOP and call **Field Services** at **1.888.387.9881**

## **Roll Sequencing**

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Rolls of patterned carpet must be sequenced so the longest pattern is installed first and the roll with the next longest pattern can be stretched to match the longer one. This procedure is critical, because it is impossible to shrink a longer pattern to match a shorter pattern. This requires each roll be measured for pattern repeat prior to installation. See specific pattern elongation installation procedures below.

## **Pattern Elongation**

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All rolls should be dry-laid and the pattern repeat measured to establish the correct roll sequence. The longest pattern must be installed first, then the next longest, etc. This allows the shorter pattern to be stretched to the longer pattern, and keeps the closest pattern repeats together. After the roll sequence is established, glue half the long pattern and half the shorter pattern lengthwise. Stretch the shorter pattern to match the longer pattern by starting at the center of the seam and stretching toward the ends. Stay nails will be needed to secure the pattern match as the adhesive sets.

## **Corrective Steps for Bow and Skew**

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Make a cut across the patterns at one end. Then apply the adhesive using the proper trowel. Push the short corners to the wall and stretch the excess carpet created by the bow or skew to the opposite wall using a power stretcher and crab stretcher. Use stay nails to hold the pattern in place until the adhesive sets. Follow this procedure throughout the installation. In large rooms start in the center of the seam correcting the bow and skew with a stretcher or mini-stretcher. A dry line should be placed along the pattern for reference.

## **Applying Approved Adhesive**

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NuBroadlok is the only adhesive approved for use in direct glue-down installations. The use of NuBroadlok Adhesive is vital to ensure optimum results. Applying an improper adhesive can result in an installation failure for which Mohawk Industries cannot be held responsible. To make certain that the proper amount of adhesive is transferred to the back of the carpet, a 1/8" x 1/8" x 1/8" U-notched trowel or 1/8" x 1/8" x 1/16" V-notched trowel must be used. This will result in a spread rate of approximately 8 - 10 yards per gallon.

Proper open time is critical for the adhesive to develop the proper tack. Open time will usually range from 10 to 30 minutes but should be evaluated in a small area before proceeding with the installation. Allow the adhesive to remain open long enough to develop tack but not too tacky that the pattern cannot slip to make a proper match.

## **General Installation Procedures**

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1. Make sure that the pile-lay runs in the same direction. Check starting wall for squareness, allowing for an off-square wall. Strike a chalk line the entire length of the area where the seam falls.
2. Place two lengths in the proper position for installing, and trim selvages. Line up the seam edges with the chalk line, making sure they are perfectly flat and tension-free.
3. Fold or roll both widths back 3 feet from the seam area for the entire length of the carpet.
4. Spread NuBroadlok Adhesive from the approximate center toward each end, using a 1/8" x 1/8" x 1/8" U-notched trowel or 1/8" x 1/8" x 1/16" V-notched trowel and steady, even strokes. When sufficient floor area has been covered with NuBroadlok, wait until the adhesive has reached the appropriate tacky stage before dropping the first breadth of carpet into place. Apply a thin coating of NuBroadlok Seam Sealer to the seam edge of the first breadth. Follow this procedure for each succeeding breadth at the seam. Drop or roll the second breadth into position, and fit the seam in tightly using a crab stretcher if necessary. Roll looseness and air bubbles away from the seam.

PLEASE NOTE: Seam Sealer must be used on all seams.

5. The remaining portion of the first breadth can now be folded or rolled back from the floor. Apply NuBroadlok to the floor; wait until the adhesive has reached the proper tacky stage before dropping the carpet into place. Be sure to have enough people spreading the adhesive so that, after the floor is covered with adhesive, each breadth is in place within the determined period of open time.
6. Roll or fold back the dry portion of the second breadth toward the seam, spread the NuBroadlok, and place the carpet to 3 feet from where the next seam will fall.
7. Be sure to roll out looseness and air bubbles as the carpet is put in place. Repeat above procedures on continuing breadths. To trim the carpet at the wall, use a razor-blade knife or suitable wall trimmer.
8. Roll completed installation with a 75 lb. to 100 lb. roller in both length and width. This will allow the adhesive to penetrate the carpet back properly.

PLEASE NOTE: Mohawk Industries' branded adhesives are required to ensure optimum results and are the only approved adhesives that Mohawk Industries will warrant. Failure to use Mohawk Industries' branded adhesives can result in warranties being null and void.

*This information, offered as a customer service, is based on Mohawk Industries' engineering tests and field experience. It is intended for installers with professional experience, to be used at their discretion and risk. Mohawk Industries does not guarantee results and assumes no liability in connection with these installation instructions.*