

## INSTALLATION GUIDELINES

# DOUBLE-STICK INSTALLATION FOR: WELDLOK / WELDLOK PLUS

## CARPET INSTALLATION CHECK LIST

1. Newly poured concrete floors generally will take 90 to 120 days to cure. Moisture should not exceed five 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.
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.
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. the move-in phase to spread the concentrated weight of furniture and heavy equipment.

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. 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.
3. 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

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

- NuBroadlok Adhesive
- NuBroadlok Seam Sealer
- Mohawk Industries EnPress PSA
- Cushion Back Cutter or Top Cutter
- 1/8" x 1/8" x 1/16" U-notched Trowel
- 1/16"x1/16"x1/16" Square Notched Trowel
- Mini or Crab Stretcher and Power Stretcher
- 35 to 50 lb. Roller
- Straight Edges
- Razor Knives
- Hammer
- Stay Nails
- Dry Line
- Chalk Line
- Tape Measure
- Knee Kicker (to position carpet only)

Mohawk Industries does not recommend the use of tool trays, carpet cores, or boards to transfer adhesive from cushion to carpet. These methods usually result in squeezed-out adhesive and could cause pockets of poor adhesion (bubbles). Please note: A premium double-stick seam tape must be used.

## LAYOUT CARPET

It is always advisable to lay out the carpet the day before the installation. This allows the carpet to relax and improves performance. When feasible, install so the majority of the traffic moves in the lengthwise direction of the carpet.

## CUSHION/PADDING

To achieve the best performance, a high-density cushion not more than 3/8" thick and not less than 16 lbs density is recommended. Low-density cushions cannot be successfully used on double-stick installations. Excessive flexing with low-density cushions will cause installation failure; additionally, some pads absorb adhesive. These characteristics must be reviewed with the pad manufacturer prior to installation.

## INSTALLING CUSHION/PADDING

Cushion should be installed in the longest lengths possible, taking into consideration traffic pattern and seam placement. Offset cushion seams from carpet seams by 6". After breadths are in place, fold or roll cushion back and spread with Mohawk Industries' EnPress PSA Adhesive with a 1/16" x 1/16" x 1/16" square notched trowel and allow the adhesive to set until tacky. Lay cushion into adhesive and trim flush with the wall or baseboard.

## PILE DIRECTION

All full-width carpets have an arrow on the back running approximately 2' from the selvage along one side of the carpet. This arrow indicates pile direction. The pile direction can also be checked by the selvage edge. There should be a different color strand running down the length of each side of the selvage. 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

All 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.

### LENGTHWISE CUTS

Bend the carpet along the length to separate the rows and expose the backing. 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 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.

**Please note:** Seam Sealer must be used on all seams.

**Please note:** A premium double-stick tape must be used on all seams. Seaming tapes that have adhesive on the back of the tape may cause problems when stretching the carpet and should be avoided.

### WIDTHWISE CUTS (TUFTED)

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

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" across the 12' width

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

Pattern elongation: 1-1/2" 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

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

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 keep the closest pattern repeats together. After the roll sequence is established, glue half the longer pattern and half the shorter pattern lengthwise. Stretch the shorter pattern to match the longer pattern by starting 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

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.

## GENERAL INSTALLATION PROCEDURES

1. Cut carpet to the necessary length and lay into proper position. Trim selvage, following yarn row on tufted and woven products when possible. When trimming seams, do not allow the knife to penetrate through the cushion, as this could cause loss of adhesive.
2. Fold carpet 3' on each side of the seam and apply NuBroadlok Multi-Purpose, using a 1/8" x 1/8" x 1/16" U-notched trowel. The spread rate should be 6 to 7 square yards per gallon. Allow the adhesive to set, using the proper open time before placing carpet into the adhesive. Open time depends on the amount of humidity in the area. Higher humidity requires a longer open time. A good double-stick pad will not absorb adhesive so it will take longer for the adhesive to reach the tacky stage.
3. Turn on an air conditioner in the summer or heat in the winter to reduce the humidity below 65%.
4. INSTALLING CARPET BEFORE THE ADHESIVE HAS REACHED THE TACKY STAGE WILL RESULT IN INSTALLATION FAILURE.
5. After sufficient open time, fold or drop one side of the carpet into the adhesive. Apply seam sealer to the side of the carpet backing material. Fold and push the next side against the first.
6. Roll carpet into the adhesive using a 35 lb. to 50 lb. roller both widthwise and lengthwise to ensure good transfer of adhesive to the back of carpeting. This will allow the adhesive to penetrate the carpet backing 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.