

## TARAFLEX DRYTEX™ SYSTEM INSTALLATION INSTRUCTIONS

This document refers to the following products:

Product	Thickness	Width	Installation direction	Seams treatment
Taraflex Sport M Plus Dry-Tex™	7 mm	Approximately 4' 11"	Same	Heat Welded
Taraflex Sport M Performance Dry-Tex™	9 mm	Approximately 4' 11"	Same	Heat Welded
Gerpur Urethane Adhesive				
Gerpatch Patching Compound				

**Note: this document refers to the following standards:**

- ACI 302.1R Guide for Concrete Floor and Slab Construction.
- ACI 302.2R Guide for Concrete Slabs that Receive Moisture-Sensitive Flooring Materials
- ASTM F710-11 Standard Practice for Preparing Concrete Floors to Receive Resilient Flooring
- ASTM F1869-16 Standard Test Method for Measuring Moisture Evaporation Rate of Concrete Subfloor Using Anhydrous Calcium Chloride.
- ASTM F2170-16 Standard Test Method for Determining Relative Humidity in Concrete Floor Slabs Using In-Situ Probes.
- ASTM F1516-13 Standard Practice for Sealing Seams of Resilient Flooring by the Heat Weld Method.
- ASTM F1482-15 Standard Practice for Installation and Preparation of Panel Type Underlayments to Receive Resilient Flooring
- ASTM F2419-11 Standard Practice for Installation of Thick Poured Gypsum Concrete Underlayments and Preparation of the Surface to Receive Resilient Flooring
- ASTM F2678-16 Standard Practice for Preparing Panel Underlayments, Thick Poured Gypsum Concrete Underlayments, Thick Poured Lightweight Cellular Concrete Underlayments, and Concrete Subfloors with Underlayment Patching Compound
- ASTM F2873-13 Standard Practice for the Installation of Self-Leveling Underlayment and the Preparation of Surface to Receive Resilient Flooring
- ASTM F3010-13 Standard Practice for Two-Component Resin Based Membrane-Forming Moisture Mitigation Systems for Use Under Resilient Floor Coverings
- Recommended Work Practices for Removal of Resilient Floor Coverings of Resilient Floor Covering Institute (RFCI).

### 1.1. STORAGE AND HANDLING

For safety reasons, some rolls are transported and delivered laid down on pallets. Once you receive the rolls, immediately store the rolls on clean, flat, and solid surfaces in a controlled environment. Do not store outside. Place rolls in an upright position and secure the rolls to ensure a safe working environment. Do not stack rolls on top of each other. Handle all materials carefully and safely. Should the material be stored for a long period, inspect the skids for any damages and make sure that the rolls are well positioned in an upright

position. Displaced material on a skid or a broken skid will damage the flooring. Be aware and act responsibly.

## 1.2. ACCLIMATION

Under normal condition, the rolls must acclimate for 24 hours prior to the installation. In some cases, where the flooring may have a long period in colder conditions, more time will be required for acclimation.

## 2. SUBFLOOR PREPARATION

- The General Contractor will supply a smooth, flat concrete finish ready to receive the new resilient sheet flooring in accordance with ACI 302.1R Guide for Concrete Floor and Slab Construction and ACI 302.2R Guide for Concrete Slabs that Receive Moisture-Sensitive Flooring Materials.
- The concrete subfloor will be cured for a minimum of at least thirty (30) days.
- The slab will have a tolerance of 1/8" in a 10' radius.
- Prepare substrate as per ASTM F710-11 "Standard Practice for Preparing Concrete Floors to Receive Resilient Flooring".
- The concrete floor temperature must be maintained at a minimum of 65°F for 48 hours prior, during, and 48 hours after the installation.
- To install on a subfloor with a radiant heating system, the system has to be turned off 48 hours before, during and 48 hours after the installation. Always verify that the room temperature is not less than 65°F during that period of time.
- **The concrete slab, new or old, must be tested for moisture. We recommend having the tests performed by a recognized engineering firm. The ICRI website (International Concrete Repair Institute) has a list of certified technicians for the USA: <http://www.icri.org/Certification/Find-CCSMTTs.asp>**
- The moisture tests must be performed as per ASTM F2170-16 "Standard Test Method for Determining Relative Humidity in Concrete Floor Slabs Using In-Situ Probes" and/or ASTM F1869-16 "Standard Test Method for Measuring Moisture Evaporation Rate of Concrete Subfloor Using Anhydrous Calcium Chloride".
- **Moisture tolerance levels for Dry Tex™ System are up to 25 lbs./1000 sq. ft./24 hrs. per ASTM F1869-16 and up to 100% RH per ASTM F2170-16.**
- Prohibit circulation of other trades in the installation area.
- Before proceeding with any work, inspect the subfloor surface and report in writing to the Project Manager and the General Contractor any visible defects on the surface such as cracks, bumps, rough areas or variations in evenness.
- Check the subfloor for grease, oil, paint, marker, spills, dust or any contamination that may adversely affect the adhesion of the flooring. Clean the subfloor per the existing conditions.
- Prohibit circulation of other trades in the installation area.
- Sanding the subfloor will be mandatory in many cases; especially in areas where the subfloor has been contaminated with foreign products. It may be necessary to scarify or bead-blast concrete surface to remove existing adhesives, paint, concrete sealers or other surface applied materials.
- **Curing compounds** of any types must be completely removed by means of sanding, scarification or bead-blasting. Self-dissipative curing compounds must be removed using the same methods.

- The General Contractor shall patch and repair all cracks, voids and other imperfections of concrete with GerPatch patching compound. **Do not use gypsum based patching materials.**  
**IMPORTANT:** Control joints and concrete saw cuts must be filled with 2-component concrete crack filler. Let the product setup overnight.
- After completion of sanding, patching and leveling, vacuum or sweep entire surface of concrete to remove loose dust and dirt before starting the installation of material.

## **2.1. GYPSUM BASE SUBSTRATE**

TARAFLEX DRYTEX is not recommended over gypsum base substrate

## **3. INSTALLATION OF SHEETGOODS**

**IMPORTANT: Prohibit circulation of other trades while installing the floor covering.**

### **3.1. FLOORING INSPECTION**

- While unwrapping the rolls, keep the identification tags of each rolls and verify on the tags whether the flooring is to be installed the same direction or reversed.
- Inspect all the flooring carefully to verify that correct colors, lot number, patterns, quality and quantities have been shipped as ordered. Do not install, cut, or fit any material that has visible defects. Material that may have minor edge damage or distortion must be trimmed and removed prior to installation of the sheets.
- **A contractor that installs material that has visible defects or damage without prior consent of Gerflor deems the product acceptable for installation and therefore accepts full responsibility for said material.**

### **3.2. DRY LAY OF SHEETGOODS**

- The concrete floor temperature will be maintained at a minimum of 65°F for 48 hours prior, during, and 48 hours after the installation.
- Mark the center starting line.
- Unroll the first length of material along this chalk line and then work progressively outward, leaving a ¼" gap between the sheets to allow the material to relax for at least 16-24 hours.
- Seaming should be kept to a minimum and avoid cross seams as much as possible. Place seams in areas exposed to the least amount of traffic.
- Before applying the adhesive, bring the loose sheets close together leaving a gap of 1/32".
- The 1/32" gap is the space needed for the guide of the electric groover.
- This gap must be constant in width.
- Use only Gerflor's Gerpur urethane adhesive.
- Using any other adhesive will void the warranty against moisture.
- Follow the guidelines indicated on the pail of adhesive.
- Recommended trowel size: 1/16" x 1/16" x 1/16", covering up to 150 sq. ft. per US gallon.
- Starting from the center line and working outward, fold back the sheets (width) halfway and apply the adhesive to the subfloor.

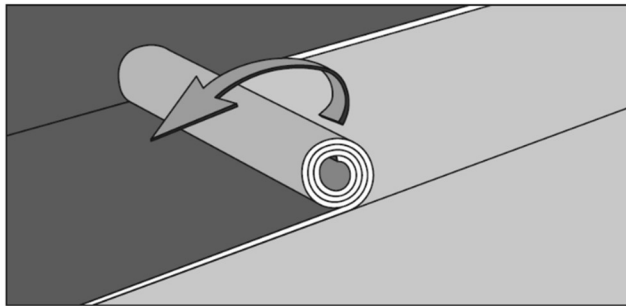


- Installer may also use the “roll back” method. With both methods, do not pre-cut material as if to be the final trim. Leave material 2”-3” longer for trimming after placement.

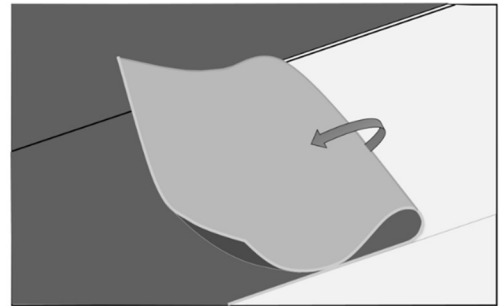
**IMPORTANT NOTICE: SHOULD THE TROWEL SIZE NOT BE RESPECTED, THE EFFECTIVENESS OF THE ADHESIVE AGAINST MOISTURE WOULD BE JEOPARDIZED AND THEREFORE THIS WOULD VOID THE WARRANTY.**

**Note: Fold back and roll back methods are preferred to the fold lengthwise method (as used for rolls of carpet). Some areas, such as perimeter pieces, will dictate the fold lengthwise method.**

**Roll back method**



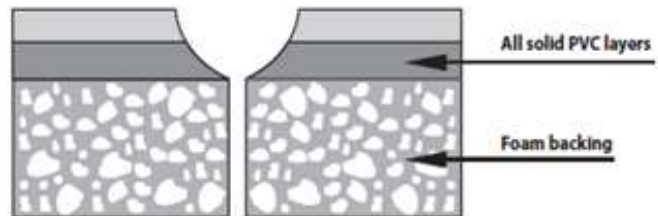
**Fold back method**



- To ensure uniform adhesion of the entire surface, only spread a workable amount of adhesive at one time.
- Maintain a uniform spread rate. Replace trowel (or trowel blade) with every pail used.
- “Open time” of the adhesive is 15-20 minutes depending on porosity of the substrate, temperature, and humidity. It is important that the installers familiarize themselves with the adhesive before starting the installations.
- After the 15-20 minutes flashing period, unroll or unfold the flooring into the still wet adhesive.
- While installing, always work to have complete sheets glued at the end of the day.
- Care must be taken to not flap the flooring too quickly into the adhesive.
- Once flooring is placed into the adhesive, wait another 20-30 minutes before rolling thoroughly with a 3 section 100-lbs roller, in both directions.

**Following the above steps is of the utmost importance for a successful installation that will resist to high moisture levels.**

- The width of the gap has to be even and may be less than 1/32” depending on the guide of the groover used.
- During the installation, always double check the flooring for bubbles with the lights on and off.
- Avoid adhesive displacement by prohibiting traffic for a period of 48 hours and 72 hours for rolling loads.



#### 4. HEAT WELDING (Refer to our document: Verification of Heat Welded Seams)

##### 4.1. ROUTING:

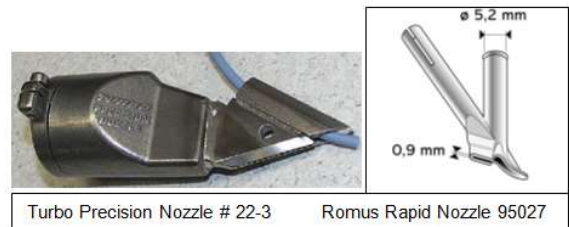
- Use an electric routing machine for major installation such as Leister or equal, approved by manufacturer.
- The Master Turbo Groover is a great tool and is highly recommended to groove our compact products.  
<http://turboheatweldingtools.com/shop/>
- The Master Sport Groover is a great tool and is highly recommended to groove our comfort products.
- The Pico groover is a great tool to groove our products.
- The use of a straight edge and hand groover will provide good results for smaller installations. Maintain a uniform width and depth of groove for a uniform welded seam.
- **Rout 2/3 of the total thickness of the homogeneous and compact heterogeneous flooring.**
- **Rout the solid PVC layers of the sport flooring. Do not rout into the foam layer.**



##### 4.2. MANUAL WELD:

**Note: Always practice on a scrap piece of material first to assure proper temperature and speed. Welding tests and adjustment of welder must be done every day there is welding to be done on the job site. Doing so will prevent failures.**

- Groove and weld only 16-24 hours after the installation. **HOWEVER, using Gerfix Spray Adhesive will give you the ability to groove and weld the flooring 1 hours after installation.**
- This must be done with a heat welding gun with variable temperature control and a speed weld nozzle by Leister or equal, approved by manufacturer.
- Turbo Precision Nozzle # 22-3 is highly recommended as well for proper welding.  
<http://turboheatweldingtools.com/shop/turbo-precision-nozzle-45mm/>
- Nozzle size is 5mm as the Romus Rapid Nozzle 95027.
- The use of a non-recommended tip will jeopardize proper welding and could damage the flooring.
- Always keep the tip clean.



##### 4.3. AUTOMATIC WELDERS (REQUIRED ON LARGE PROJECT)

**Note: Always practice on a scrap piece of material first to assure proper temperature and speed. This should be done every day there is welding to do on the job site. Doing so will prevent failures.**

- Do not let the robot operate without surveillance.
- Turbo Welding Gun #25 is the recommended welding robot as it comes with the right welding tip.

<http://turboheatweldingtools.com/shop/chiquita/>

**Note: Should another type of welding robot be used, such as Leister robot, care must be taken in the choice of tip as for most**



**cases the opening of the tip is more than 2mm. This could damage the flooring and lead to a seam failure.**

- The recommended tip for the Leister Robot is Romus 95253 2mm Unifloor Anti Glaze Nozzle.

**WARNING:** Do not weld the flooring using the Leister robot without the proper tip.

- Verify not to reduce the power with electrical cords that are too long.
- Frequently verify the weld.
- The ambient temperature, open windows and doors and other electrical equipment plugged in the same electrical outlet may influence proper welding.

**Notes:**

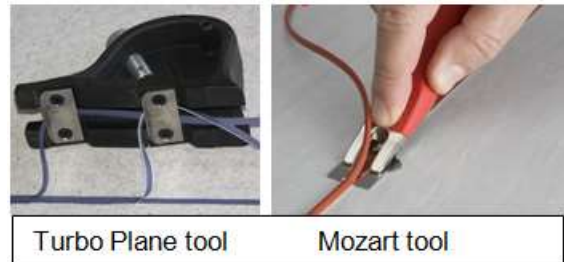
- For any type of installation, do not heat weld resilient flooring for a minimum of 16 to 24 hours after the material has been placed into the adhesive *Unless you are using Gerfix Spray Adhesive.*
- Refer to ASTM F1516-13 "Standard Practice for Sealing Seams of Resilient Flooring by the Heat Weld Method".



**4.4. TRIMMING WELDED ROD**

**Note:** Trimming is done once the welding rod and material have completely cooled.

- **Trimming must be done in two passes.**
- The Turbo Plane tool is recommended and will trim in one pass. <http://turboheatweldingtools.com/shop/>
- Use trimming tools sharpen in the middle only, such as the Mozart trimmer.
- This type of trimmer will not damage the flooring.
- The first trim has to be done with the thickness guide.
- The second trim has to be done with the trimmer only.
- Always verify the trimmed weld to ensure that the welding rod is bonded properly and is flush with the top wear layer.



**7. ONCE THE INSTALLATION IS COMPLETED**

- Perform a visual inspection of the project.
- Verify every welded seam.
- Repair every imperfection before leaving the project.
- Make sure that every vertical obstacle such as doorframes is well trimmed and sealed with a silicone sealer or an equivalent product.

For any information, please refer to Gerflor Technical Services.



Gerflor USA, Inc.  
595 Supreme Drive  
Bensenville, IL 60106



## Technical Services

Tel.: 1-877-Gerflor  
Tel.: 1-877-437-3567  
[Gerflorusa.com](http://Gerflorusa.com)