

Revised November 2019

Before proceeding, visit www.teknoflor.com to obtain and review the current installation guide, maintenance guide and other relevant documentation. This installation guide covers Teknoflor® Naturescapes HPD™ sheet flooring. Failure to follow the current installation guidelines and other applicable technical documents may result in unintended installation related issues and void the product warranty.

MATERIAL RECEIVING, STORAGE & HANDLING

- Upon receipt, immediately remove all shrink wrap from pallet(s) and confirm materials are the correct color, style and quantity for each dye lot with consecutive roll numbers for sheet goods. Carefully check all materials for shipping damage. Note any damage on bill of lading when signing for delivery. Visible damage not reported on bill of lading to trucking company is your responsibility.
- Immediately report discrepancies to Teknoflor® Customer Service at (800) 522-9166.
- Store all flooring products and accessories in a dry interior area maintained between 65°F and 85°F (18°C and 29°C). Using outside temporary storage and other uncontrolled storage locations may result in unintended installation issues including bond failure, gapping or buckling and is not covered under the Teknoflor® Naturescapes HPD™ Warranty.
- Handle materials with care to prevent unintended damage.
- SHEET FLOORING - Once received, unstrap all rolls from pallet and store upright within 24 hours. This helps prevent distortion and compression.

JOBSITE EVALUATION & PREPARATION

Proper jobsite evaluation and subfloor preparation are key to a successful and trouble-free installation. Do not install Teknoflor® flooring products without performing a thorough jobsite evaluation and until all non-conforming conditions are rectified. Refer to the current ASTM F710 “Standard Practice for Preparing Concrete Floors to Receive Resilient Flooring” as well as current relevant American Concrete Institute (ACI) specifications and relevant building codes (www.concrete.org). All subfloors must be tested for moisture and confirmed within specification before proceeding. It is strongly advised to have moisture testing conducted by an independent ICRI (International Concrete Restoration Institute) certified contractor.

JOBSITE CONDITIONS AND TESTING MUST BE PROPERLY PERFORMED AND DOCUMENTED BEFORE INSTALLATION. CONFIRM PROJECT MEETS ALL PRODUCT AND ADHESIVE REQUIREMENTS AND SPECIFICATIONS PRIOR TO PROCEEDING. IN ORDER TO FILE A CLAIM, COMPLETE PROJECT DOCUMENTATION, CLEAR DIGITAL PHOTOGRAPHS OF ISSUE AND SAMPLES OF DEFECT ARE REQUIRED. FAILURE TO PROVIDE ALL REQUIRED DOCUMENTATION MAY VOID WARRANTY.

ALL WARRANTIES AND GUARANTEES PERTAINING TO THE SUITABILITY, PERFORMANCE AND USE OF ALL PREPARATION AND ANCILLIARY MATERIALS RESTS SOLY WITH EACH PRODUCT MANUFACTURER AND/OR FLOORING AND GENERAL CONTRACTOR AND NOT WITH TEKNOFLOR®, INC.

ALL PERFORMANCE RELATED ISSUES ARISING FROM OR ATTRIBUTALBE IN ANY WAY TO THE USE OF NON-RECOMMENDED PREPARATION MATERIALS, MOISTURE MITIGATION SYSTEMS, ADHESIVES AND ANY OTHER ANCILLIARY PRODUCTS OR METHODS ARE THE SOLE AND EXCLUSIVE RESPONSIBILITY OF EACH PRDUCT'S MANUFACTURER AND/OR THE FLOORING AND GENERAL CONTRACTOR OR PARTY WHO APPROVED ITS USE OR PRACTICE.

- Attend jobsite construction meeting with the General Contractor (GC), Architect and Owner to review all requirements and expectations and to inspect site conditions. This provides the best opportunity to fully understand the scope of work, coordinate moisture testing and address subfloor level and flatness concerns, request necessary lighting and coordination with other trades to vacate the space during subfloor preparation and installation. Confirm with all parties present if Flooring Contractor (FC) is expected to provide a “Level” surface in addition to a “Flat and Smooth” surface and determine what concrete additives, curing method and fly ash or other additional components are specified and raise awareness to potential issues before construction.
- Determining jobsite suitability rests solely with the General Contractor and Flooring Contractor.
- Teknoflor® floor covering materials are intended for interior use only.
- The building envelope must be enclosed (under roof with walls, windows and doors etc., installed) with operational HVAC for a minimum of 1 week and preferably 2-3 weeks before starting installation. This is critical to remove excess

moisture from the subfloor and to stabilize the interior environment.

- Subfloor must be suitable for intended use and rigid, smooth, flat, level & permanently dry, clean & free of all foreign materials, including, but not limited to, dust, paint, marker, grease, oils, solvents, cutting/parting compounds, sealers and residue from old adhesive or any other deleterious contaminants that may act as a bond breaker or staining agent.

WARNING: Do not sand, dry sweep, dry scrape, drill, saw, bead blast, or mechanically chip or pulverize existing resilient flooring, backing, lining felt, asphaltic “cutback” adhesive, or another adhesive. These products may contain asbestos fibers and/or crystalline silica. Avoid creating dust. Inhalation of such dust is a cancer and respiratory tract hazard. Smoking by individuals exposed to asbestos fibers greatly increases the risk of serious bodily harm. Unless positively certain that the product is non-asbestos containing material, you must presume it contains asbestos. Regulations may require that the material be tested to determine asbestos content. RFCI’s Recommended Workplace Practices for Removal of Resilient Floor Coverings are a defined set of instructions addressed to the task of removing all resilient floor covering structures.

CAUTION: All ink, markers and paint on substrate must be removed by sanding to prevent bleed through and staining of the sheet flooring. Sealing and/or skim coating is not a substitution for sanding.

- New floor covering is not intended to correct an uneven or unsmooth subfloor. Level high spots and fill and smooth surface cracks, grooves, depressions, stationary control joints or other non-moving joints and other surface defects. Use high quality Portland cement and or calcium aluminate based patching and leveling compounds recommended by their manufacturer for use conditions. The underlayment shall be mold, mildew and alkali resistant, non-shrinking and water-resistant with a minimum 3,500 psi cured compressive strength.
- The appearance of your new floor is only as good as your subfloor preparation. Remaining surface irregularities can “telegraph” or show through the new floor surface. Follow the patch manufacturer’s current instructions, paying attention to proper mix water ratio, working time, drying time and moisture testing. Gypsum patching compounds shall not be used unless recommended and warranted by product manufacturer as project compliant.
- Wood subfloors shall be suspended, double layer construction with 18 inches (46 cm) of cross ventilated space beneath having 1 inch (25 mm) minimum total thickness and incorporating a ¼ inch (6 mm) or thicker underlayment grade panel on the surface that is designed for the intended use. Underlayment panels shall be stored, acclimated, prepared and installed in accordance with the current manufacturer’s published instructions. Follow instructions, paying close attention to proper acclimation, subfloor flatness, panel spacing, nailing or staple schedule and seam treatment.
- The surface shall be smooth and flat to 3/16 inch in 10 ft. (5 mm in 3 m) and 1/32 inch in 1 ft. (1 mm in 30 cm).
- Moisture and pH testing shall be performed on ALL new and existing concrete slabs and wood subfloors. Moisture testing shall be performed in accordance with applicable test methods:
 - ❖ Concrete Slabs
 - PREFERRED - ASTM F2170 In-situ Relative Humidity and/or
 - ACCEPTABLE - ASTM F1869 Anhydrous Calcium Chloride
 - ❖ Suspended Wood Subfloors
 - Calibrated Wood Pin Meter
- Allow other finishing trades, especially the overhead and wall trades, to complete their work before beginning the installation.
- During spackling, painting or pipe cutting, cover the substrate to prevent contamination. Spackling, permanent marker, paint, paint thinner or machine oil and other construction trade items that contaminate the substrate can cause bond failure or product discoloration.
- Close working spaces to all non-essential traffic before installation and as specified after installation. After installation, GC shall protect flooring surface from damage from other trades.
- Provide good overhead lighting for proper subfloor preparation and installation.
- Porous and/or dusty structurally sound substrates shall be primed by applying one or more coats of acrylic based primer-sealer or TEK Max Moisture Barrier & Primer with a short-nap paint roller and allowed to dry before proceeding.
- After patching, sand the surface to remove all ridges and rework any remaining low spots or surface defects. Vacuum the entire surface, paying close attention to the perimeter to remove all dust and debris.
- Expansion, isolation and other moving joints are designed and incorporated in concrete slabs to permit movement without causing random cracks. Moving joints shall not be filled or covered with any floor covering. Moving joints must be honored through the flooring and should be treated with an expansion joint covering system as determined through consultation with the expansion joint product manufacturer.

MANUFACTURER	WEB ADDRESS	PHONE NUMBER
Balco USA	www.balcousa.com	(800) 767-0082
C-S Group	www.c-sgroup.com	(800) 233-8493
EM Seal Joint Systems	www.emseal.com	(800) 526-8365

InPro Corp	www.inprocorp.com	(800) 222-5556
MM Systems	www.mmsystemscorp.com	(800) 241-3460
Nystrom	www.nystrom.com	(800) 547-2635
Watson Bowman Acme	www.wbacorp.com	(800) 677-4922

- Once all substrate testing and surface preparations are complete and comply with installation and product specifications, continue with the flooring installation.

ACCLIMATION

- Acclimate the flooring, adhesive and subfloor at the jobsite in the area to be installed to a stable and consistent temperature between 65°F and 85°F (18°C and 29°C) and a minimum of 68°F (20°C) for spray adhesives with ambient relative humidity between 35% and 65% RH. The key is to condition the flooring materials, adhesive and jobsite environment to closely match the facilities operational environmental conditions. Maintain the stable and consistent temperature for a minimum of 48 hours before, during, and for a minimum of 48 hours after installation. Check the subfloor surface, flooring materials and sundries with a temperature gauge and confirm all are at the same temperature (no more than 3°F difference) before and during the entire installation.
- Sheet goods require further conditioning and relaxing by making room cuts and allowing the flooring to lay flat on the floor for 24 hours before installation. For cuts that are showing roll memory by curling up and not laying flat, it may be necessary to back-roll the materials in a loose coil 12 in. to 18 in. (30 - 45 cm) in diameter and stand on end overnight.
- Radiant heated subfloors must be turned off 2 days or longer before installation until 2 days after installation and temperature maintained with supplemental heat. Gradually bring the temperature up 2°F (1°C) per day until reaching normal operating temperature.
- Stable acclimation of materials and substrate usually takes a minimum of 24 hours to accomplish and may take up to 72 hours or longer depending on storage and jobsite environmental conditions. Check for consistent and stable temperature of the flooring materials and subfloor surface before and throughout the installation process.
- After installation, maintain a consistent operational temperature and RH for optimal flooring performance. The minimum floor surface temperature should not go below 55°F (13°C).

SUITABLE SUBFLOORS

- Teknoflor® flooring products may be installed over properly prepared concrete, suspended wood and metal (aluminum, bronze, brass, copper, steel and stainless steel) subfloors. Proper subfloor testing and preparation is critical to achieve a beautiful and lasting installation.
- Teknoflor® recommends the removal of all existing flooring and adhesives and starting any new installation directly to the base subfloor as a best practice. Realizing there are situations where this is not possible, Teknoflor® flooring products may be installed over fully bonded and intact existing flooring, including ceramic and quarry tile, stone and cementitious terrazzo, and existing, single layer non-cushion resilient (sheet or tile).
- Polymeric, resinous or seamless poured floors may be installed over, but great care must be taken in determining substrate suitability. It is difficult to confirm if they are well bonded to the substrate and they are prone to moisture related issues, especially when covered with an impervious surface.
- Existing flooring must have all loose or damaged areas removed and all finish or polish stripped off. Once the damaged areas are removed and the surface is thoroughly clean, prepare the surface by leveling and smoothing with an appropriate patching compound. Glazed, polished, smooth or dense surfaces must have the surface mechanically abraded. In addition, surface preparation materials may require the use of a primer or bonding agent to mechanically key to the surface prior to application.
- Metal Substrates must be completely clean, dry and free of dust, dirt, wax, marker, paint, grease or any other deleterious contaminants that may act as a bond breaker or staining agent. Prior to mechanically abrading the surface, degrease using an appropriate heavy-duty degreasing cleaner. Mineral spirits may be necessary to remove grease and/or oil contaminants. Always perform a bond test prior to installation. Metal substrates are non-porous and shall be installed using the appropriate adhesive installation method. Lead is very soft and will easily dent and deform. Lead and all soft metal substrates are recommended to be coated over with a 1/8 inch (3 mm) or thicker layer of patch to stabilize the surface. Follow patch manufacturer's recommendations for proper application.
- Existing, non-cushioned, single layer resilient flooring may be installed over on suspended or on-grade installations (not below grade). Do not install over existing cushioned resilient flooring, rubber or safety (slip resistant) flooring. Repair all loose and damaged areas, remove all coatings or finish, and smooth surface using an appropriate floor patching and smoothing product.
- Thick-pour gypsum-based underlayments must be manufactured and installed in compliance with ASTM F2419 "Standard Practice for Installation of Thick Poured Gypsum Concrete Underlayments and Preparation of the Surface to

Receive Resilient Flooring.” Test and evaluate thick-pour underlayment moisture in accordance with underlayment manufacturer’s recommendations. All thick-pour gypsum underlayments require TEK Max Moisture Barrier & Primer or an acrylic primer to be applied to the surface before adhesive application.

- DO NOT install over subfloors where solvent adhesive-removers have been used or that have been chemically abated.
- Radiant heated subfloors must not exceed 85°F (29°C) under any condition of use.

CONCRETE SLABS & UNDERLAYMENTS

- New and existing concrete slabs shall be in compliance with current versions of the following standards, guides, and codes:
 - ❖ ASTM International
 - ASTM F710 “Standard Practice for Preparing Concrete Floors to Receive Resilient Flooring”
 - ❖ American Concrete Institute (ACI)
 - ACI 201.2 Guide to Durable Concrete
 - ACI 302.1 Guide to Concrete Floor and Slab Construction
 - ACI 302.2 Guide for Concrete Slabs to Receive Moisture Sensitive Flooring Materials
 - ❖ Local and national building codes
- Concrete surfaces to receive resilient flooring shall be suitable for intended use, permanently dry, clean, smooth, and structurally sound. They shall be free of dust, solvent, paint, wax, oil, grease, residual adhesive, adhesive removers, curing, sealing, hardening, or parting compounds, alkaline salts, excessive carbonation or laitance, mold, mildew, and other foreign or deleterious contaminants that may act as a bond breaker or staining agent (ASTM F710).
- Concrete slabs shall have a minimum 3,500 psi cured compressive strength and be designed and placed with water-cement ratio of 0.45 to 0.5, as recommended by the concrete construction industry and appropriate for slabs to receive moisture sensitive finishes. Higher water-cement ratios lead to longer dry times and issues associated with elevated moisture conditions that cause floor failures (ACI 302.1 & ACI 302.2).
- Coal fly ash used as recycled content and replacing Portland cement in concrete slabs is becoming more prevalent with the popularity in sustainable, LEED construction practices. Fly ash contains silicon dioxide and calcium oxide. Silicon dioxide is composed of spherical particles with extremely smooth surfaces to which it is difficult for adhesives to bond. Calcium oxide is a caustic, highly alkaline component which also acts as a bond breaker. As a result, concrete slabs containing fly ash in higher concentrations are difficult to bond to. Always perform a bond test prior to installation. If poor bond performance is identified, skim coat the surface and perform additional bond tests to determine if non-conformity has been corrected. Document your testing and evaluation.
- Concrete slabs on or below grade must be installed directly over properly installed and intact vapor retarder that complies with ASTM E1745 “Standard Specification for Water Vapor Retarders Used in Contact with Soil or Granular Fill Under Concrete Slabs.” On or below grade concrete slabs shall be free from hydrostatic pressure, excessive moisture, alkalinity, or any other deleterious condition.
- Concrete slabs should be wet cured using plastic sheeting or other suitable moisture retaining cover. Do not use curing compounds, as these slow the slab dry time and can act as a bond breaker if not removed.
- Perform moisture testing in accordance with applicable test methods:
 - ❖ PREFERRED - ASTM F2170 “Standard Test method for Determining Relative Humidity in Concrete Floor Slabs Using in situ Probes.” Confirm results are within RH moisture limits for adhesive.
 - ❖ ACCEPTABLE - ASTM F1869 “Standard Test Method for Measuring Moisture Vapor Emission Rate of Concrete Subfloor Using Anhydrous Calcium Chloride.” Confirm results are within MVER moisture limits for adhesive.
- Determine surface porosity in accordance with ASTM F3191 Standard Practice for Field Determination of Substrate Water Absorption (Porosity) for Substrates to Receive Resilient Flooring. Place a single 0.05 mL (approximately 1/4 Inch in diameter) drop of potable water on the surface using a pipette, water dropper, straw, etc. of the concrete and time how long it takes to fully absorb into the concrete surface. If the water drop takes longer than 60 seconds to be fully absorbed, the surface is considered non-porous. Slab absorbency testing should be performed in at least 3 areas for the first 2,000 SF and one additional test for each additional 3,000 SF and no less than one per room on each installation. Slab absorbency and surface texture affect adhesive coverage. Bond testing needs to determine the appropriate trowel to achieve full coverage on the floor backing without having excess adhesive applied. Absorbent (porous) and more textured surfaces require an increase in adhesive application and non-absorbent (non-porous) and smooth surfaces require less adhesive application to achieve proper adhesive coverage.
- Power troweled concrete surfaces can be very smooth, non-absorbent and develop surface laitance. These surface conditions may adversely affect bond of floor preparation materials and adhesive and should be mechanically prepared by grinding or shot blasting to improve bond.
- Remove all curing compounds, silicate-based compounds or sealers that might prevent proper bonding or proper moisture testing. Mechanically abrade surface to ensure 100% removal of any curing compounds or sealers and achieve an absorbent surface.
- Bond testing shall be performed to determine the best trowel size based on substrate surface texture and surface absorbency to achieve optimal adhesion and full coverage on the back of the flooring without excess adhesive. Use the

specified flooring and recommended adhesive to install 3 ft. x 3 ft. (91 cm x 91 cm) test areas. Seal the edge of the flooring with duct tape to prevent adhesive from drying prematurely. Wait a minimum of 48 hours and preferably 72 hours to evaluate bond strength.

- Use high quality Portland cement and or calcium aluminate based patching and leveling compounds recommended by their manufacturer for use conditions. The underlayment shall be mold, mildew and alkali resistant, non-shrinking and water-resistant with a minimum 3,500 psi cured compressive strength.
- There are many options for moisture mitigation systems that may be beneficial to resolve elevated moisture conditions. Teknoflor® recommends TEK Max Moisture Barrier and Primer for use with our flooring and adhesives with moisture levels up to 99% RH. Other suitable moisture mitigation systems include products that are in compliance with ASTM F3010 “Standard Practice for Two-Component Resin Based Membrane-Forming Moisture Mitigation Systems for Use Under Resilient Floor Coverings” that provide full product and adhesive bond warranty coverage when installed over a properly applied system. There are several companies that offer compliant mitigation systems that can also provide expertise to effectively deal with moisture issues:

MANUFACTURER	WEB ADDRESS	PHONE NUMBER
Aquafin	www.aquafin.net	(866) 278-2346
Ardex	www.ardexamericas.com	(888) 512-7339
Koster	www.kosterusa.com	(757) 425-1206
Mapei	www.mapei.com/US-EN	(800) 992-6273
Schonox	www.schonox.us	(855) 391-2649
UFLOOR Systems	www.uzin.us	(720) 374-4810

WOOD SUBFLOORS & UNDERLAYMENTS

- Wood subfloors shall be of double layer construction with at least 1 inch (25 mm) total thickness and comply with current local and national building code requirements.
- The structural wood panels shall be APA rated and or recommended and warranted by panel manufacturer for intended use.
- Wood subfloors shall have at least 18 inches (46 cm) of well vented air space beneath and the entire crawl space shall be insulated with ground surface smooth to prevent any pooling of water.
- Cover ground completely with a 6-mil plastic ground cover running up walls 6 inches (15 cm).
- Do not install over wood floors in direct contact with the earth, concrete slab, over a sleeper floor assembly.
- Wood subfloors shall have calibrated moisture content of less than 14% and be within 2% of underlayment and wood structural members.
- The double layer wood subfloor shall incorporate an APA Underlayment Grade top layer (such as Multi-Ply® or TEKPLY®) that is designed to meet the following requirements:
 - ❖ Minimum ¼ inch (6 mm) thickness
 - ❖ Sanded face that is free of knots or roughness to prevent any surface telegraphing
 - ❖ Solid core free of voids to resist indentations and punctures from concentrated loads
 - ❖ Designed for resilient flooring use and free of any substance that may stain polyurethane
 - ❖ Moisture content less than 14% and panel layers within 2% of each other
 - ❖ Confirm panel moisture level by checking in several areas using a calibrated pin moisture meter
 - ❖ Compliant with APA or manufacturer recommended as “Underlayment Grade” for resilient flooring
- Do not install directly over Luan, pine or other soft woods, particle board, hardboard, hardwood flooring, treated wood or underlayment panels with core voids, face knots or rough surface, or any underlayment that is not recommended by its manufacturer for the intended use and for use beneath resilient flooring. Cover these and other unacceptable wood-based surfaces with ½ inch (13 mm) thick underlayment grade panel in compliance with all underlayment requirements listed in this guide.
- Do not install with coated fasteners.
- Underlayment panels shall be stored, acclimated, prepared and installed in accordance with the current manufacturer’s published instructions and or current APA Underlayment Installation Guidelines and or ASTM F1482 “Standard Practice for Installation and Preparation of Panel Type Underlayments to Receive Resilient Flooring”. Follow instructions, paying close attention to proper acclimation, subfloor flatness, panel spacing, nailing or staple schedule and seam treatment.

- After underlayment panel installation, sand uneven edges and areas where patch was used, to provide a smooth, level surface.
- Just before installation - thoroughly vacuum the surface, paying close attention to the perimeter and under drywall to remove all dust and debris.
- Once the underlayment is properly installed, dry, smooth, and flat, clean and in compliance with all specifications, proceed with installation.

PRE-INSTALLATION

- Perform a bond test before starting installation to confirm compatibility of adhesive and prepared substrate. Perform multiple bond tests on the prepared surface with 3' x 3' section of flooring. Allow a minimum of 48 hours (preferably 72 hours or longer) before determining compatibility and bond strength. Always check for complete adhesive transfer on the back of the flooring in case more adhesive is needed for porous or rough concrete surface, or if too much adhesive is being used over a nonporous or smooth surface. Adjust trowel size used to increase or decrease the amount of adhesive applied to suit substrate and environmental conditions, ensuring full adhesive coverage to back of flooring and no more.
- Ensure your tools, grooving machine, hot air welder, spatula blade, trowels, 100 lb. roller and all necessary tools and equipment are on-hand and are in good working order. Bring sufficient spare blades, replacement trowel-blades and any other consumable items or supplies to complete project. Consider using cutting blades made from tungsten carbide or high-speed steel or that are treated with titanium dioxide or other ceramic coating for improved cutting performance. Only use replaceable blades for your trowel. Never hand-sharpen trowel blades. It is critical that all blades are sharp and smooth. For trimming weld rod, a Winkelman WDD645 Slim Trim Knife (800-929-4362) or Mozart may be used.
- Confirm all adhesives, sundry items and floor covering materials are on-site and confirm the flooring materials are the correct color, style and quantity for each dye lot with consecutive roll numbers for sheet goods.
- Check flooring for any visible issues or defects BEFORE installation. Installation of flooring implies acceptance of substrate and materials. Any flooring materials found with visible defects or any visible issues are warranted for materials only. No labor costs are covered for flooring materials installed with visible defects or other issues. Immediately contact your local representative or customer service at 800.522.9166 should an issue be discovered.
- Teknoflor does not recommend the use of alternate adhesives with Naturescapes due to its unique composition. Extensive adhesive testing has been conducted and the recommended TEK One Transitional Pressure Sensitive Adhesive or the TEK Five Modified Silane Adhesive provides excellent performance under diverse installation conditions. Teknoflor will not be responsible for any issues arising from or associated with the use of alternate adhesives.

INSTALLATION

- Carefully clean the surface of all debris and contamination and confirm the subfloor is properly prepared and complies with installation and adhesive requirements before proceeding. Installation of flooring implies acceptance of subfloor and jobsite conditions.
- For best appearance, balance the installation within the area to be installed. Determine the center point of the room by marking reference lines on the surface across the center point of opposite walls. Review the alignment of the flooring materials to the reference line and shift reference line to optimize flooring placement. Work from the center outwards, achieving a net fit between sheets and leaving a slight gap (1/16" to 1/64") for a close fit that is not tight or binding along the perimeter between the floor and walls, vertical surfaces or columns.
- All Naturescapes sheet flooring materials have production date codes. Sheet flooring materials installed together in the same area shall be from the same production date code.
- Cut all material 2 - 3 inches (51 mm to 76 mm) more than needed and allow to relax flat and face up on subfloor for 24 hours. Keep all flooring materials running in the same direction (except for non-wood visuals, which should have sheets reversed). Inspect dry-laid flooring for telegraphing of any remaining subfloor defects or sheet imperfections and correct before proceeding.

CAUTION: After dry-laying materials and before applying adhesive, carefully examine sheet edge to edge to ensure there is not a shade difference under normal daytime lighting conditions. Non-wood visuals should have rolls reversed to minimize shading differences. If any shading is noticed, reverse sheets and see if this resolves the issue. Contact your local Teknoflor® sales representative with any questions.

- Check materials as you unroll for any visible issues before cutting. Cut drops a minimum of 2-3 inches (51 mm to 76 mm) longer than length needed for final cuts. Carefully lay out materials making sure not to kink, crease or acutely fold or step on the floor where overlapped as this can result in permanent damage to the floor. Allow materials to relax unrolled flat and face up on substrate for twenty-four (24) hours before installation. Where space is not available to have cuts laid out of the subfloor, the cuts can be back rolled in a 12-18-inch diameter roll and strapped or taped and

- carefully stood on end.
- For materials that are not lying flat, carefully back roll cuts in a 12-18-inch diameter roll and stand on edge to help relax the flooring.
- After 24-hour relaxation, trim selvage edges for installation making sure to remove all edge compression, distortion, and damage. This usually requires the removal of ¼ inch to ½ inch (6 mm to 13 mm) or more of material along each length. Trim off damaged ends and again check materials for any visible issues or defects. For plank flooring it is recommended to trim to the edge of the next full plank width when the width is narrower than ¾ of the plank width.
- Prepare seams edges for installation by straight edge and underscribing for a net fit or double cut by overlapping edges 1 inch (25 mm) and cutting through both layers of flooring with a straight edge and sharp knife held perpendicular to the floor for a net fit. Do not leave a gap along seam edge more than 1/32 inch (1 mm), as this can result in a weak weld and seam splitting. Making sure there is excess flooring to trim for fitting to the opposite wall, trim the ends of the cuts along one wall to fit.
- When applying tape products to flooring surface to maintain edge alignment, only use releasable non-marring tape. Do not exceed the tape manufacturer's recommended removal/use time, as doing so can cause damage to the surface of the flooring.
- When all drops are trimmed, fold back the trimmed ends of the sheets halfway to expose the substrate. Mark a chalk line perpendicular to the rolls to indicate edge of where to apply adhesive. Perform one last sweep of floor to make sure the surface is completely clean.
- Apply adhesive in accordance with adhesive instructions and label instructions. Pay careful attention to ensure proper trowel to achieve correct adhesive coverage, open and working times based on surface absorbency and environmental conditions. Do not apply excess adhesive or leave lumps in adhesive or allow adhesive to over-dry. If adhesive has been down too long before installation, scrape clean and apply fresh adhesive.
- Do not spread more adhesive than can be installed within the recommended working time and time available to install that day. It may be necessary to use a short nap paint roller moistened with adhesive to roll out trowel marks before installation. Periodically check the floor backing for coverage and to make sure that sufficient adhesive has been applied to fully cover the backing and not in excess.
- Once adhesive is applied, allow the appropriate open time for jobsite conditions before installing flooring.
- Carefully place the first sheet into the adhesive. Roll the first sheet into adhesive, being careful to maintain proper alignment and to avoid trapping air between adhesive and sheet. Frequently check adhesive application of back of flooring to ensure full adhesive coverage and that trowel ridges are flattened.
- Once the first portion of the first sheet has been applied into the adhesive and rolled, continue with the adjoining drop. Continue installing each drop until all flooring is bonded on one side.
- With the sheets bonded on one side, trim the opposite end cuts for a net fit to the wall or vertical surface. Once all drops are trimmed for a net fit, fold back the loose section of flooring to where the adhesive has been applied. Before proceeding, carefully sweep the exposed substrate to remove any remaining dirt and debris. Apply adhesive onto the clean substrate for the next section of flooring.
- Proceed with installation as before, allowing adhesive the proper amount of open time and rolling each section as it is installed.
- Once the room is installed, slowly roll the flooring with 50% overlapping passes using a 100 lb. 3 section roller in both directions. Confirm trowel ridges are completely flattened. If trowel ridges are still evident and do not roll out, scrape up that section of adhesive and reapply fresh adhesive. The installer is responsible for understanding the jobsite conditions and managing the installation process to achieve the desired result. This includes laying the flooring into the adhesive and rolling the flooring at the proper time. Continue to check and confirm adhesive trowel ridges are completely flattened to a uniform film thickness and full adhesive transfer to back of flooring.
- Teknoflor® recommends the heat welding of all sheet flooring products, as this provides the strongest seaming method. Do not attempt to chemical-weld Teknoflor® Naturescapes HPD™ sheet flooring, as it is not compatible with chemical-welding chemicals.
- Prepare seams for heat welding after waiting appropriate set up time for adhesive used. Wait 12 hours before heat welding seams over TEK One or TEK Five adhesives. Use a 4 mm round grooving tool and 4 mm or 5 mm round heat weld tip with narrow throat.

CAUTION: Using a heat welding tip with a narrow throat is critical to concentrate the heat into the groove and not on the edge of the flooring where it can cause distortions and/or a shiny edge. The narrow throat also facilitates good melting of the weld rod and fusion between the weld rod and sheet flooring, thereby providing a strong seam. Failure to achieve 100% fusion during heat welding causes a weak weld that can fail over time resulting in seam splitting and gapping. Distorted or shiny edges and split or gapped seam conditions are installer induced and not covered by the Teknoflor® Naturescapes HPD™ Warranty. Properly use the correct tools to prevent unintended installation damage to the flooring.

WARNING: PRACTICE HEAT WELDING BEFORE PROCEEDING. Before heat welding on jobsite, take a large scrap of flooring and practice grooving and welding to determine the best practices to achieve a uniform and consistent centered groove to 2/3 the depth of the sheet flooring and a strong secure heat weld. While practice heat welding, be sure to note the exact temperature setting and speed of application needed to achieve good melting of the weld rod and fusion between

the weld rod and sheet flooring. After installation of a section of weld rod that has cooled for several minutes, roll your fingers perpendicular across weld rod to determine if it is well secured or if it rolls out of the groove. Do not proceed unless you are getting melted weld rod wash at the interface between the edge of the floor and weld rod. Continually look for wash along the base of the weld rod. No fusion or wash is a no-go.

- After the adhesive wait time and just before welding, groove 2/3 the depth of the sheet flooring material centered on the seam. Use specified matching or contrasting weld rod. Confirm correct weld rod color before proceeding. Installation of materials implies acceptance. Use a 4 mm or 5 mm round heat weld tip with a narrow throat to apply weld rod to flooring. Make the first pass after 5-10 minutes. Allow a minimum of 20-30 minutes and ensure weld rod has cooled to room temperature before making the final trim. Failing to wait sufficiently to make the final trim can result in the weld being dished or slightly lower in the center from the weld rod cooling after being trimmed. Make the first pass with guide plate on the trim knife or spatula knife to leave a small amount of rod above the surface of the floor. Carefully make final trim in a continuous straight motion along the seam to cleanly remove excess weld rod and leave a smooth, flush weld. After final trim, carefully glaze the weld rod to seal the weld rod surface. This completes the installation process.
- After installation - protect installation from traffic for time specified for adhesive used.
- The Owner and General Contractor are responsible for protecting the flooring after installation is released by the Flooring Contractor. Cover with protective material appropriate to prevent any damage from other construction trades and until final acceptance by Owner.