

# COMMERCIAL INSTALLATION INSTRUCTIONS

# 01 INTRO

# 02 RECOMMENDED TOOLS

# 03 STORAGE & HANDLING

Visual inspection	05
Conditions of the storage area	05
Pre-cutting	06
Acclimatization	07

# 04 SUBFLOOR

Conditions	08
Subfloor preparation	10

# 05 INSTALLATION

Laying direction	11
Single piece installation	12
Multiple piece installation	15

# 06 AFTER INSTALLATION

# 07 MAINTENANCE

# 01

## INTRO

The information in this document is provided for anyone fitting a Beauflor cushion vinyl floor covering from our commercial range. Beauflor suggests that wherever possible the purchaser uses a professional installer in order to obtain the best results. Please read the complete instructions prior to fitting our vinyl floor covering. Failure to follow our instructions may affect your warranty so it is important to fully understand what is required before installation begins.

Cushion vinyl flooring is intended for **interior use only**. To select the most appropriate product in the Beauflor collection you should consider the **amount of wear and tear** it will receive in the area you are going to use it. The European usage classifications are marked on each technical data sheet and on our website. We recommend to protect the floors from strong sunlight by drawing curtains or blinds.



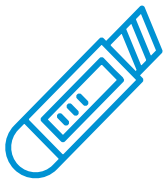
Don't install the floor in rooms with temperatures above 30°C. Also rooms with overexposure of sunlight are not suitable for cushion vinyl.

# 02

## RECOMMENDED TOOLS



A roll of double-sided tape suitable for use with cushioned vinyl floor coverings (plasticizer-resistant)



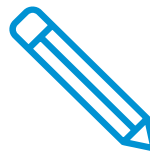
A sharp knife with a straight blade for long cuts



Hair-dryer (optional)



A soft brush



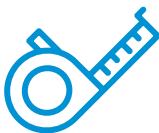
Pencil



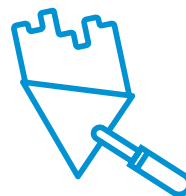
A long metal ruler or straight edge



Damp cloth



A tape measure



Adhesive trowel: type A-1 or A-2. For products with a textile backing type B-2 can also be used.



A tube of suitable seam bond (this is only necessary if there are joints)



Roller (minimum 50kg)

# 03

## STORAGE & HANDLING

### VISUAL INSPECTION

Before installation, always check if the product is the one you ordered in terms of **specification, design and colour**. At the same time carefully inspect the material for any **visible damages and defects**. Although Beauflor rolls are inspected before leaving the factory, it can happen that defects occur during transportation. In such case, contact your Beauflor distributor for assistance.

Beauflor will not pay labour charges or any consequential costs on claims filed for materials installed with obvious visible defects or damage caused by transport, storage and/or handling.

### CONDITIONS OF THE STORAGE AREA



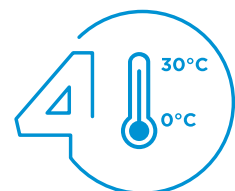
Indoor & protected from the weather



Dry



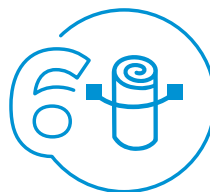
No direct sunlight



Temperature between 0°C and 30°C



Free from contamination or pollution (this would make the vinyl yellow)



≤2M rolls:  
store upright and  
securely fastened



>2M rolls:  
store horizontally,  
not stacked

**Take care to avoid rough handling. If the material is pre-cut and then stored for some time, it must be rolled face out around a cardboard tube before installation, not piled-up or flattened under a heavy weight.**

## PRE-CUTTING

It is recommended that the material is pre-cut (accurately) to fit the room **24 hours prior to installation**. Roll the material face out again but be careful not to damage the surface while handling the roll (do not roll the material face in, until taking it into the room for installation).

Measure the maximum width and length of the room remembering to include any recess or doorway, adding 5cm to each dimension.

If more than one piece is required to fit your room you will need to allow for pattern match along the joint. It is also important that each piece is cut from the same mother roll. This will ensure that you have true colour match along the seam.

Rolls selected from the same batch must be installed in sequence, starting with the roll with the lowest batch number. Pay particular attention if the design needs to be laid in a reverse direction.

### WARNING



If pieces are cut from different rolls, please check with your supplier if these rolls have the same batch number. If not, Beauflor will not accept responsibility for any colour variation.

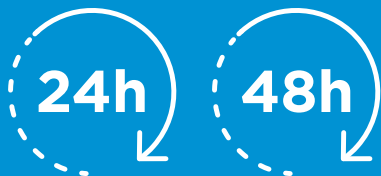
### EXTRA TIP



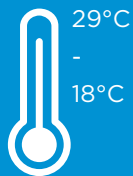
To avoid unnecessary joints in your new floor, it is important to purchase the widest width available. Beauflor offers up to 5M width!

## ACCLIMATISATION

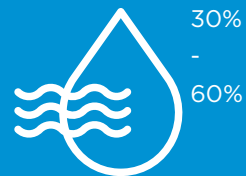
Conditioning of your Beauflor floorings and adhesives:



24 - 48 hours  
prior to installation



Room temperature:  
18 - 29°C



Relative humidity:  
30 - 60%

Before installation, we recommend that the cushioned floor is laid flat and left for 24 hours at a room temperature of +18°C. If it is not possible to do this then the flooring should be loosely rolled and left in the room where it is to be installed for at least 24 hours. This will make the floor more flexible and easier to handle.

Sheets of two meter wide floor covering should be rolled loosely and stored in an upright position for acclimatization. Sheets of four meter wide floor covering should be cut to size and laid flat for acclimatization.



# 04

## SUBFLOOR

### CONDITIONS

**1. Subfloors must be absolutely level, clean and free from grit, dust, grease, oil, polish & old adhesive.** Solvent-based products, petroleum, pigmented materials on or in the subfloor can permanently stain vinyl floor covering, that's why the subfloor must be free from paint, varnish, oils, solvents, wax, hardening compounds in mastic, asphalt and other similar materials.

Imperfections in the subfloor will affect the final appearance and performance of vinyl flooring. Any particles that could compromise the quality of bonding with the adhesive must be removed.

**2. It is essential that the subfloor is dry.** Dampness can cause discolouration to the flooring. The humidity of the subfloor must meet the standard technical requirements valid in the country where the flooring is to be installed. If in doubt, take a hygrometer reading to check the level of dampness. A **maximum hygrometer reading of 75% RH** is recommended.

**But in any case moisture levels in the substrate must not exceed the following limits:**

SUBSTRATE	METHOD	VALUE
Cement Screed	CM	≤2,0 CM-%
Cement Screed - panel heating	CM	≤1,8 CM-%
Calciumsulfate Screed	CM	≤0,5 CM-%
Calciumsulfate - panel heating	CM	≤0,3 CM-%

*CM Method - Calcium Carbide method*

Concrete	CM	3,0-3,5 CM-%
Magnesia screed	CM	1-3,5 CM-%
Chipboard	Darr	5-12 wt.% recommended ≤ 9 wt.%
OSB	Darr	5-12 wt.% recommended ≤ 9 wt.%
Wood	Darr	5-12 wt.% recommended ≤ 9 wt.%

*CM Method - Calcium Carbide method*

*Darr method for determining moisture content*

Mineral screeds are hygroscopic. Their moisture content will vary according to the ambient humidity and temperature in the room. If the screed is allowed to dry naturally, the above values should be achieved at a substrate temperature of 20°C and a relative humidity below 65%. If the screed is dried artificially, lower CM values are required. CM measurements should be performed in the area where the highest degree of moisture is expected (taking into account exposure to sunlight, air currents etc). Samples should be taken from the lower third of the screed. For every 100 m<sup>2</sup> of screed surface, at least one measurement should be taken.

**Beauflor cannot be held responsible for:**

- Joint or texture show through, ridging over subfloor joints, any raised areas due to an uneven surface (from fasteners such as nails...) in the subfloor.
- Discolouration from a wet subfloor.
- Discolouration from fasteners (such as nail staples ...). Use only non-staining galvanized fasteners.
- Discoloration from stain sources on/in subfloor mentioned above.



## UNDERFLOOR HEATING & COOLING

### UNDERFLOOR HEATING

All Beauflor floorcoverings are **suitable** for use over underfloor heating systems, providing the heating system has been installed properly.

The heating system should have an automatic cut-off to ensure that the **temperature never exceeds 27°C**. This applies to both heated water systems and electrical systems. When the heating system is in contact with the floorcovering and it exceeds 32°C, there is a danger of discoloration.

Ensure that the underfloor heating is working correctly prior to fitting the floor covering. The underfloor heating must be **switched off for 48 hours prior to and 48 hours after the installation** of the vinyl flooring. During this period an alternative form of heating should be provided to maintain a room temperature of 18°C - 30°C. After installation, the temperature of the underfloor heating should be **raised gradually, in increments of 5°C per day**, until the desired level.

Underfloor heating should never be installed over an existing floor covering. Any existing floor covering should be removed and the subfloor should be prepared in line with the manufacturer's specifications.

The thermal resistance of the vinyl flooring will affect the temperature output of the underfloor heating. To ensure optimum performance, you should select a vinyl floor covering with a thermal resistance below 0,10 m<sup>2</sup> K/W. Otherwise the temperature of the underfloor heating would constantly have to be set too high to ensure an adequate transmission of heat.

### UNDERFLOOR COOLING

Vinyl flooring can also be installed over underfloor cooling systems; however, the temperature of the cooling water supply must **never be below 18°C**. Temperatures below this will produce condensation and could damage the floor covering. Similarly, room thermostats must never be set to a temperature which is more than 5°C below the room temperature.



## SUBFLOOR PREPARATION

- **Concrete floors**

Use a levelling compound if the surface is uneven, rough or cracked. It is usual to apply 3-6mm of levelling compound to produce the desired level of smoothness. Concrete floors should be tested for alkalinity. The allowable readings for the installation of Beauflor flooring are 5 to 9 on the pH scale.

- **Floor boarded timber floors**

All loose floorboards should be secured with suitable nails or countersunk screws. Any protruding nails must be hammered down flush with the surface. Cover the floorboards with 3-6mm gauge resin-bonded plywood panels (normally 1200mm x 600mm). Secure the panels with 25mm ring shanked nails, staples or countersunk flat head screws, at 100mm spacing. If the subfloor is timber on top of a solid base (e.g. wood blocks on concrete) remove the timber and treat as concrete. Do not lay the flooring directly on timber treated with wood preservative.

- **Quarry or ceramic tiles**

Follow the basic requirements above for concrete floors. Any loose or broken tiles should be removed and the floor patched with a suitable concrete batch before using a latex levelling compound to fill the joints between the tiles to create a smooth surface. You can install the floor directly on the ceramic tiles if the joints are 1mm deep and 2mm width. Old quarry tiles were often laid on subfloors without a suitable damp-proof membrane. This should be checked prior to the installation of the floor. If there is no integral DPM then a surface DPM must be installed.

- **Existing smooth flooring**

Remove all existing cushioned vinyl, linoleum, cork flooring.

- **Hard flooring**

Existing hard flooring such as PVC Composite tiles may be left in place. All polish must be removed from the tiles with a solution of 2% household ammonia, the floor must then be thoroughly rinsed with clean water. Any damaged or loose fitting tiles must be removed and the floor patched flush to the remaining tiles with levelling compound. To prevent staining to the new floor, the tiles must then be covered with a MINIMUM 6mm thickness of levelling compound.

- **OSB plates**

All loose floorboards should be secured with suitable nails or countersunk screws. Any protruding nails must be hammered down flush with the surface. Do not lay the flooring directly on timber treated with wood preservative.

After subfloor preparation has been completed, carefully remove all dirt and debris from the subfloor with a vacuum cleaner, a broom or a brush with fine bristles.

### WARNING



Do not sand any existing flooring material, it may contain asbestos fibres, which can be hazardous for your health (Beauflor residential vinyl floors do not contain asbestos).

05

## INSTALLATION

### *LAYING DIRECTION*

Plan the direction and order of the sheets before installation, to ensure that if any seams are required they do not coincide with doorways or main traffic areas. In large, well-lit rooms, sheets should run parallel to the incoming light. In long narrow rooms (like corridors) sheets can be installed along the length of the room.

In square rooms, it is best to lay the rolls parallel to the entrance light, while in long and narrow rooms it is better to have them installed lengthwise.

### IMPORTANT



When you do a multiple piece installation, make sure the seams between rolls are positioned away from areas of heavy traffic.



# SINGLE PIECE INSTALLATION

## FITTING YOUR FLOOR

1. Measure the maximum width and length of the room remembering to include any recess or doorway.
2. Rough cut the material to size leaving about 5cm all round for final trimming in.
3. Line up the cut piece to your selected starting wall. The material is laid with the 5cm over-cut running up the walls, ensuring that the pattern runs parallel to the wall.
4. It is important to cut the floor in gradually. Several small trimming cuts are better than attempting one cut and will result in a better finish. Always hold the knife perpendicular to the floor to keep a straight cut finish.



- ✓ **Internal corners**  
Make small diagonal cuts across the material's corner very gradually until the material fits neatly into the corner.



- ✓ **External corners**  
Push the material firmly down into the joint between the floor and wall. Cut down the material, following the corner and trim flat to the floor. It can be helpful to gently warm the floor with a domestic hair dryer to make it more flexible.



- ✓ **Irregular fittings (radiator pipes etc).**  
Push the material into the joint between the floor and fitting and cut down almost to the floor. A small cross-cut will then stop the material tearing. Gently ease the material down around the fitting by cutting to the floor at all pressure points and cutting flat to the floor.

5. With the material now lying flat around the fittings and corners, the final cutting along the wall lengths can be carried out. Push the flooring into the joint between the wall and floor with a straight edge and cut off small strips at a time, gradually working the material down to the floor keeping the blade tight against the skirting board and held as near the vertical position as possible.
6. Avoid trimming in too tightly as this will prevent the material lying flat (as a general rule leave a gap of 2 - 3mm between the edge of the floor and the skirting board to allow for normal movement, this will avoid any buckling due to room expansion/contraction).
7. Release any trapped air by sweeping with a soft broom.

### EXTRA TIP



Do not crease or fold the vinyl sheets as this can lead to permanent damage. Do not write on the back of the vinyl sheets with a pen or a felt tip marker. If necessary use a soft graphite pencil.

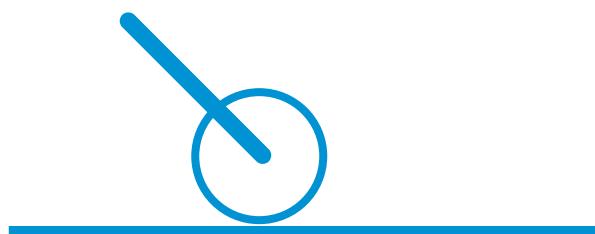
## ADHERING VINYL TO SUBFLOOR

After fitting, turn back the flooring to expose about half of the subfloor. Apply a suitable adhesive to the subfloor in accordance with the adhesive manufacturer's instructions.

We recommend to use adhesives classified with EMI CODE 1 (EC1) or EMI CODE 1+ (EC1+) label (low emission). Since a toothed trowel is usually used for applying adhesive on flooring, always check the information on the adhesive label for the number of teeth on the trowel, as too much adhesive can cause serration. We recommend applying the adhesive over the entire surface.

Apply the adhesive to the entire exposed laying surface, taking care not to leave gaps or voids, and also not to coat the surface too thick or too thin.

Allow the recommended drying time and replace the flooring material slowly and carefully over the prepared subfloor without trapping air bubbles. Turn back the other half and follow the same procedure. Roll the flooring with a 50kg flooring roller to push out any trapped air bubbles.



### Perimeter adhesion

We do not recommend perimeter adhesion of Beauflor Vinyl floor coverings. Especially not in high traffic areas, areas with large temperature variations and areas with heavy rolling loads. Floorcovering has to be heavy in mass so there is minimal movement possible. However double-sided tape (suitable for resilient residential vinyl) can be used in doorways to ensure the vinyl lies flat. Alternatively the floor can be held in place under a suitable threshold strip.

### Full adhesion

Installations requiring full adhesion are best carried out by a professional installer. However, as a general guideline: After applying a suitable adhesive in accordance with the manufacturer's instructions, allow the adhesive to cure until it reaches its initial bonding strength, before putting the floor covering in place.

## LOOSE LAY

Generally, installations requiring only one sheet of flooring material, which is less than 20m<sup>2</sup>, do not require full adhesion. Installations over 20m<sup>2</sup> are better fully adhered especially if they involve more than one piece of flooring.

The maximum room size for loose laying Beauflor flooring is 20m<sup>2</sup> for PVC backed products; for Tex Bac products loose lay up to 45m<sup>2</sup>. Please revert to the table below for loose lay guidelines. Beauflor does not recommend any loose laying of Flextreme products! (Pietro/Supreme/Quintex)

Collections	Subfloor preparation	Loose lay** (without glue or adhesive)	Semi loose lay*** (with double-sided adhesive or velcro at the periphery of the part and at the joint)
<b>Hightex</b>	Minimal subfloor preparation	< 45 m <sup>2</sup>	> 45 m <sup>2</sup>
<b>Puret看</b>	Minimal subfloor preparation	< 45 m <sup>2</sup>	> 45 m <sup>2</sup>
<b>Ultratex</b>	Minimal subfloor preparation	< 45 m <sup>2</sup>	> 45 m <sup>2</sup>
<b>Blacktex</b>	Minimal subfloor preparation	< 35 m <sup>2</sup>	> 35 m <sup>2</sup>
<b>Elite</b>	Minimal subfloor preparation	< 35 m <sup>2</sup>	> 35 m <sup>2</sup>
<b>Evasion</b>	Minimal subfloor preparation	< 35 m <sup>2</sup>	> 35 m <sup>2</sup>
<b>Quintex</b>	Minimal subfloor preparation	< 35 m <sup>2</sup>	> 35 m <sup>2</sup>
<b>Soho</b>	Minimal subfloor preparation	< 35 m <sup>2</sup>	> 35 m <sup>2</sup>
<b>Supreme</b>	Minimal subfloor preparation	< 35 m <sup>2</sup>	> 35 m <sup>2</sup>
<b>Tex-Style</b>	Minimal subfloor preparation	< 35 m <sup>2</sup>	> 35 m <sup>2</sup>
<b>Artex</b>	With limited subfloor preparation	< 25 m <sup>2</sup>	> 25 m <sup>2</sup>
<b>Silvertex</b>	With limited subfloor preparation	< 25 m <sup>2</sup>	> 25 m <sup>2</sup>
<b>Smartex</b>	With limited subfloor preparation	< 25 m <sup>2</sup>	> 25 m <sup>2</sup>
<b>Safe-tex</b>	With limited subfloor preparation	< 25 m <sup>2</sup>	> 25 m <sup>2</sup>
<b>Techno-Tex</b>	With limited subfloor preparation	< 25 m <sup>2</sup>	> 25 m <sup>2</sup>

To allow movement of heavy appliances (fridges/washing machines/ cookers) it is important to fully adhere the vinyl to the floor in the area behind where the appliance will stand. This band should be at least 5cm deep and run beyond the full width of the appliance, where the floor meets the wall. This minimizes the risk of pulling up the flooring during movement. If heavy appliances are to be regularly moved place them on an off cut of vinyl or on a piece of hardboard should be considered. This will reduce further risk of damage to the flooring.

### IMPORTANT



Floors cannot be loose laid if a seam is required. If a seam is required the whole floor must be laid using the appropriate adhesive. See next chapter.

# MULTIPLE PIECE INSTALLATION

## FITTING YOUR FLOOR

Fitting your vinyl floor to the room with multiple pieces is mainly identical as with a single piece installation. The instructions are mentioned on page 12.

Nevertheless, there are some extra things to take into account:

### LENGTH CUTTING

If more than one piece of flooring is needed, cut the pieces to length but add an amount equal to the repeat of the design, plus the 5 cm trimming allowance. The repeat of the design can be checked on our website by clicking on the reference or on the sample from which you made your purchase.

### PATTERN MATCHING

If more than one piece is required to fit your room you will need to allow for pattern match. For best visual results, try cutting in the joints for tile & wood designs. It is also important that each piece is cut from the same mother roll. This will ensure that you have true colour and gloss match along the seam.

If pieces are cut from different rolls, please check with your supplier that these have the same batch number. If not, Beauflor will not accept responsibility for any colour or gloss variation. Rolls selected from the same batch must be installed in sequence, starting with the roll with the lowest batch number. Pay particular attention if the design needs to be laid in a reverse direction.

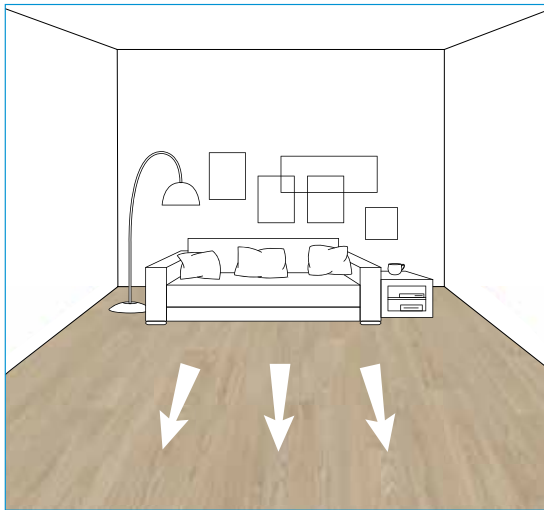
### EXTRA TIP



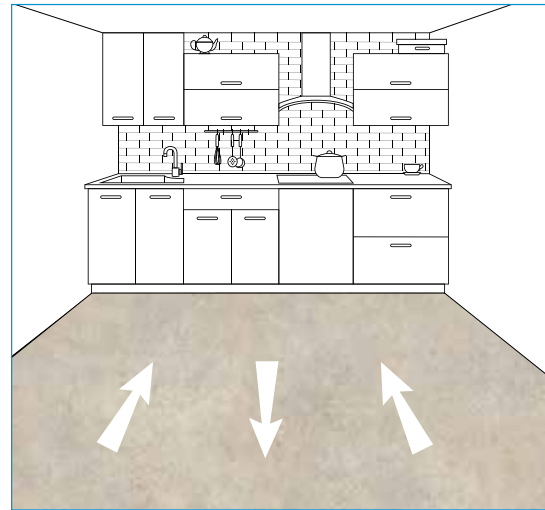
Do not **crease** or fold the vinyl sheets as this can lead to permanent damage. Do **not write on the back** of the vinyl sheets with a pen or a felt tip marker. If necessary use a soft graphite pencil.

## 3M, 4M & 5M ROLLS

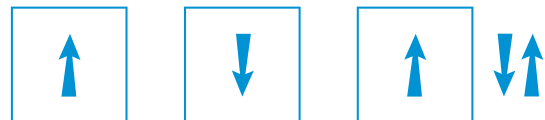
In case of plank and tile designs, we recommend that every sheet be installed in the same direction, for most all-over designs, we recommend that every other sheet is rotated through 180°. The direction of printing is indicated with arrows at the back of the rolls. If in doubt, check with your local professional installer.



For plank designs and tiles, sheets should be installed in the same direction.



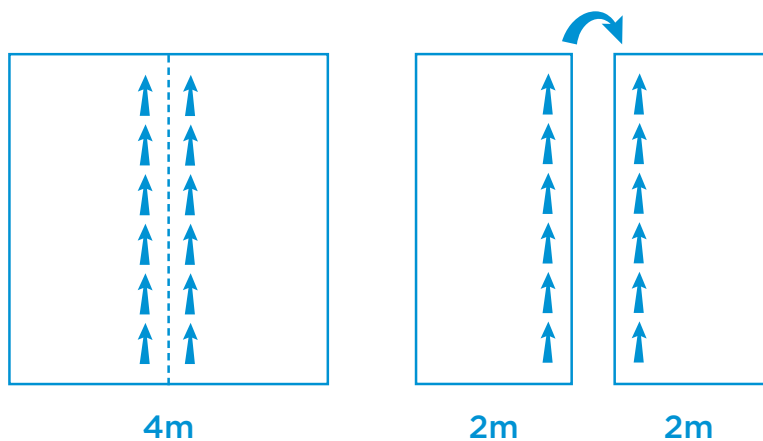
For all-over designs, alternate sheets should be installed in opposite directions.





## 2M ROLLS

When installing 2M rolls, the rules are a bit different. You have to check the back of the rolls and look for the arrows on one side. Place these arrows of 2 rolls next to each other and place the sides without an arrow next to each other. This way you will have a better colormatching.



*If more than one roll of the same colour is required, all the rolls must be from the same batch and installed in the same order as they are numbered. Beauflor cannot guarantee a colour match between different batches.*

### IMPORTANT



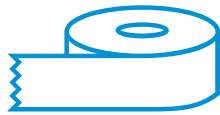
When you are installing 2m rolls next to each other it is important that these are all from the same batch.

### FITTING MULTIPLE PIECES

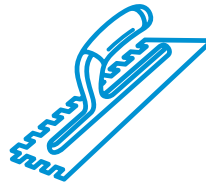
- 1.** Fit the largest of the rough-cut pieces in accordance with the guidelines described on page 12.
- 2.** Lay the next largest rough-cut piece so that it overlaps the first by 35-50mm, ensuring that the pattern matches (4m width only). Adjacent sheet widths should be reversed to minimize apparent shade variation.
- 3.** Fit this second piece as described on page 12.

## ADHERING VINYL TO SUBFLOOR

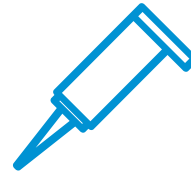
### Additional tools/items required:



Low-tack masking or clear adhesive tape.



Acrylic adhesive and fine notched trowel or a double-sided adhesive tape suitable for vinyl flooring.



Chemical vinyl seam bond (Cold welding fluid Type A).

Where more than one piece is being fully adhered, complete fitting as described above and pattern-match both pieces, but do not cut the seam between two pieces of vinyl before you begin adhering.

**1.** Turn back the first piece of flooring (on the wall side parallel to the overlapped side with the next piece of flooring) to expose about half of the subfloor. Apply the adhesive to the subfloor in accordance with the adhesive manufacturer's instructions. Allow the recommended drying time and then carefully reposition the flooring material slowly and carefully over the prepared subfloor without trapping air bubbles. Do the same with the second piece of flooring.

**2.** Now it's time to cut the seam.

**2a.** Place your steel rule or straight edge so that the guiding edge lies over both edges of the overlapping material.

**2b.** Hold firmly and cut through both thicknesses simultaneously (double cut) keeping the knife as vertical as possible to the flooring to create a closely butting seam (This will require gradual cutting - do not attempt to accomplish in one stroke). For best visual results, try cutting in the joints for tile & wood designs.

**3.** Fold back the material from the side of the seam and spread the adhesive in accordance with the manufacturer's instructions.

**4.** Allow the recommended drying time and then carefully reposition the material over the prepared subfloor making sure that the pattern match is correct.

**5.** Roll the flooring with a 50 kg flooring roller to push out any trapped air bubbles. Take care not to force adhesive up into the seam. For Flexxtreme / Tex Bac products : Press the material onto the adhesive with a broom wrapped in a blanket, taking care not to force adhesive up into the seam.



## COVING

**1.** Mark the height of the plinth coving (at least 100 mm) with a pencil and ruler.

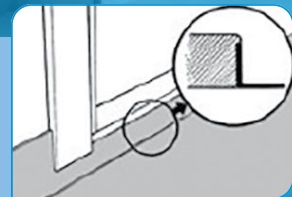
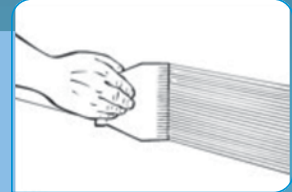
**3.** Use a corner roller or other suitable tool for folding the vinyl flooring to an even radius between the floor and the wall. Then heat and rub firmly against the wall. Heat the area between the flooring and the wall to achieve a better adhesive effect. Press the flooring into the corner with a corner roller or other suitable tool.

**3b.** At outward-facing corners, fold the vinyl flooring towards the corner and cut approx. 5 mm from the floor. The guides in the picture show the corner “transferred” to the flooring and the location of the cut at a 45° angle. Here the material is distributed evenly on each side of the corner.

**2.** Spread the adhesive on the wall to the marking with a toothed adhesive putty knife (adhesive amount approx. 4m<sup>2</sup>/liter). Then spread adhesive on the floor surface. For larger floor areas, perform bonding in stages after placement of the floor sheets (laid edge to edge).

**3a.** At inward-facing corners, the joint is placed 45° up on the wall and the cutting is finished/started approx. 5 mm from the floor. **NOTE:** Ensure that excess adhesive is removed before starting welding.

**4.** The vinyl flooring must be pulled up against any doorsill. The doorsill should be bevelled (folded out) for the mat.



## EXTRA TIP



For easier and safer bonding of the triangular fitting piece, a groove is cut on its back with a grooving tool. The depth of the groove must not exceed half the thickness of the mat. The “triangle” can then be folded easily and mounted on the corner.

## COLD WELDING

Cold welding is used in low-traffic and residential areas, and can be started 24 hours after the installation of vinyl sheet flooring.

Cold seam welding should only be undertaken after the drying process is complete, this will take a minimum of 24 hours.

**1.** Cover the seam between two sheets of vinyl flooring with lightly removable adhesive tape to prevent the sealant fluid from sticking to the surface of the vinyl flooring (do not use a strong adhesive tape as this may damage the floor surface when you remove it).

**2.** Using a sharp blade (e.g. a utility knife), cut through the tape along the seam.

**3.** Insert the applicator needle well into the seam until it touches the subfloor. Pull it slowly along the seam whilst gently squeezing the tube (follow the instructions of the seam bond manufacturer). The needle will allow fluid to flow into the seam and, at the same time, a bead of fluid about 2-4mm wide will be left on the tape.

**4.** After approximately 10 minutes, the sealant starts drying and the adhesive tape can be removed.

The seam will be dry enough to walk on after 20 minutes and fully cured in 2-3 hours, by then it will be a watertight, dirt-resistant seam.

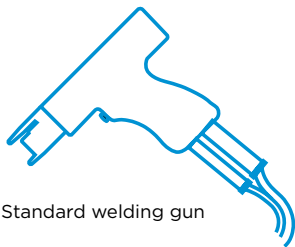
With time, as a consequence of cleaning and normal wear, the joint between two sheets of vinyl flooring disappears.

## HOT WELDING

Where there is a risk of water occasionally pooling on the surface of vinyl flooring, hot welding is used. This will prevent the penetration of water and humidity through the seams. It is also recommended for areas with underfloor heating system.

In order to achieve the best results, it is necessary to wait 48 hours after the installation of the vinyl, to allow the adhesive to completely dry - only then you can start hot welding. Hot welding ensures a homogeneous joint between two sheets of vinyl flooring, guaranteeing a permanent seal and a longer life span for the floor. Hot seam welding is appropriate for commercial floors which do not have a foam backing and should have a wear layer of 0.40mm or more.

### Recommended tools:



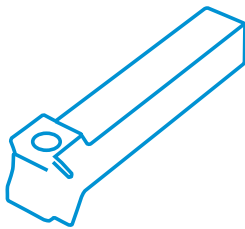
Standard welding gun



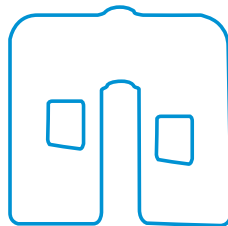
Speed weld nozzle - type 1  
Speed weld nozzle - type 2



For acoustic products:  
nozzle type 5



Grooving tool



Trimming sledge



Half-moon trimming knife

## IMPORTANT



Beauflor suggests that wherever possible the purchaser uses a professional installer in order to achieve the best results.

## HOT WELDING

**1.** Install the floor covering as described in the installation section leaving a gap of max. 1mm at the seam. Allow the adhesive to dry for a minimum of **48 hours before hot-welding the seams.**

**3.** Once the flooring has been grooved the **seam must be cleaned free from dust.** This can be done using a soft brush or by blowing the seam clean using a standard hot-welding gun on its lowest available heat setting.

**5.** It is always best to **do a trial weld on a piece of waste** flooring in order to

set the **correct temperature** and **welding speed.** This is because all floor coverings and welding cables have different compositions and react differently under heat. The speed must be slow enough to ensure a good weld between the cable and the floor covering but not too slow that the surface of the floor covering is discolored in any way. The room temperature influence the temperature of the welding gun. That's why we recommend to do a test every new day and in every new room.



**2.** When the adhesive has fully cured, cut a groove along the seam using a

standard grooving tool. The depth of the groove must be 50-60% of the thickness of the floor covering and must be a maximum of 3mm wide at the surface.

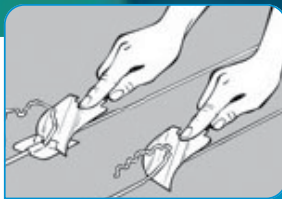


**4.** The seam is welded using **standard 4mm welding cable.**

**6.** In order to reduce the risk of burning the surface we recommend the use of a **special speed weld nozzle.** This type of nozzle concentrates the heat into the groove and reduces the risk of scorching.

7. Once the seam has been welded the **first trim** can be done. This must

be done using a half-moon knife and a sledge. This allows most of the excess welding cable to be trimmed away whilst still warm.



8. The remaining welding cable must be allowed to **cool to room temperature** before further trimming. Failure to do this will mean that the welding cable may contract as it cools creating a dished surface which is unsightly and can trap dirt.

9. Once the weld is completely cool the **final trimming** can be done. This is done using the half-moon knife this time without the sledge. Care must be taken with the angle of attack and the sharpness of the blade to ensure a clean cut without digging into the surface of the product.

10. Once the weld has been trimmed flush to the surface the job is complete.

After the vinyl flooring has been installed, protect the sealed seams for at least 16 hours after seam sealer application to ensure a proper seam bond.

There is sometimes a difference in gloss between the weld cable and the floor covering. This can be reduced by “glazing” the weld using the heat gun. Again this is best tested on a waste sample before use on the full job to judge the correct temperature and heating time required.

06

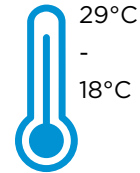
## AFTER INSTALLATION



First 24h:  
do not move heavy  
objects back into  
place



First 48h:  
keep traffic  
to a minimum



Keep room temperature  
between 18 - 29°C

**Furniture should not be placed on the floor until the adhesive has had adequate time to dry (at least 24 hours/after 72 hours).**

Always **move heavy furniture** and appliances with care to avoid damaging or tearing the floor:

**1. Lay strips** of plywood or hardboard panels on the floor.

**2. Roll, “walk” or slide** these items on the strips. Make sure furniture legs have non-staining floor protectors.

**3.** Replace small, narrow metal or dome-shaped glides with **smooth, flat glides** that are in flat contact with the floor. Glides should be equipped with self-adhesive felt pads to avoid scratching the surface of the floor.

**4.** The pads should be **checked periodically** for grit and wear and replaced when necessary.

### EXTRA TIP



Always place mats at outside entrances to prevent dirt, grit and soil from being tracked onto your floor. Don't put rubber-backed mats on your floor.



## DO NOT USE:

- ✓ Rubber-backed mats or other rubber objects as they may permanently stain your floor.
- ✓ Heat-producing appliances (refrigerators, hot air emitting devices...) or cigarettes and matches can scorch, burn or discolour your floor.
- ✓ Spiked heels on floor coverings, they can leave permanent damage.

Prevent the floor from coming into contact with prohibition water for the first 72 hours after installation, or until such time as all seams are welded. Hereafter the adhesive is sufficiently resistant to water so that the bonding strength will not be affected.

During the service life of the floor, the temperature should never fall below 13°C. The performance of the flooring material and adhesives can be adversely affected below this minimum temperature.



# 07

## MAINTENANCE

### GENERAL MAINTENANCE

The amount of daily usage will determine how often cleaning is required. Sweep as necessary with a soft broom. Care must be taken if you use a vacuum cleaner, do not use vacuum cleaners with “beater bars”. Wipe over with a clean damp mop or cloth, which should be rinsed frequently in clean water.

CAUTION: remember that all floors can be slippery when wet.

When necessary wash with a solution of clean water and mild detergent or domestic floor cleaning emulsion. Rinse thoroughly and soak up residual water. For additional luster buff with a dry cloth.

Spots, marks and spillages should be wiped up as soon as possible.

### MAINTENANCE PRODUCTS

You can use	Do not use
Neutral detergent	Powder or liquid abrasive cleaners
Alkaline detergent	Black soap
Disinfectant detergent	Acetone
Methylated spirit	Wax or varnish
Freeze spray	Oil-based products
	Steam cleaners
	Wire or nylon wool scouring pads
	Furniture polish
	Spirit based polish
	Bleach or strong detergents

### PERIODIC MAINTENANCE

The floor should be cleaned periodically by using a floor machine equipped with a scrubbing brush (we recommend the red pad), wet vacuuming or dry buffing.

Vinyl floors with a protective PU lacquer do not normally require polish. Other floors will require polishing to protect the floor’s surface from staining agents and to give a surface shine. For such floors apply a liquid emulsion floor polish after installation and thereafter at 6 - 12 monthly intervals as required. Always follow the manufacturer’s instructions when using a floor polish or cleaner. To avoid build-up, it is important to remove the previous layer of polish prior to re-polishing. The old polish can be removed by using an appropriate stripping solution and a wet/dry vacuum cleaner. Once the new polish has been applied, buff to a gloss finish using a dry buffing machine.

## **EXTRA CARE TIPS IN CASE OF STUBBORN STAINS:**

Type of stain	How to remove it
Oil, vinegar or lemon stains	Remove oil, vinegar or lemon stains right away as they can cause discoloration on the surface of your vinyl flooring. To remove these stains you can use a mixture of warm water and a neutral detergent.
Ink, tomato or blood	Put very diluted alcohol directly on the stain. Wait for a few minutes before you rinse it off with water. Do not scrub.
Pen or marker	Clean the pen and marker stains by rubbing with a little white spirit or an all-purpose cleaner on a cloth and wipe the vinyl clean with a damp cloth. If it is a permanent marker stain, you can spray with a non-oily hairspray on the stain and blot the marker with a white towel.
Rust	Use an anti-rust sponge or product to remove rust and rinse it off with water. Do not use bleach on rust stains, as this may cause the stain to oxidize and discolor the floor.
Food and heavy grease	Rub with an undiluted product on a cloth and rinse with plenty of water.
Traces of rubber marks or traces of shoes	Apply an alkaline detergent to traces of shoes. Leave the detergent on the stain for 5 minutes and rub afterwards with water.
Chewing gum and paint drips	Use a freeze spray to harden the chewing gum or paint drips and remove it with a plastic spatula or dull kitchen knife. Then rub the area lightly with mineral spirits, isopropyl alcohol or lighter fluid. Repeat as necessary until the stain has been removed.

After removing any stubborn stains always rinse well with clean water.

## ***PROTECTING YOUR FLOOR FROM PHYSICAL DAMAGE***

- Use a doormat at the entrance(s) of your house. Choose a natural fiber mat in preference. Rubber backing on doormats may result in yellow discoloration of the floor immediately beneath.
- Rubber feet on furniture may cause staining. Remove them altogether or replace with coasters or felt pads between them and the floor.
- Avoid spirit-based products such as shoe polish, solvents, hair dye and permanent marker pens. Wipe up spots and marks as quickly as possible. Also applies to turmeric, mustard and strongly colored foodstuffs.
- Corrosive substances such as acid and alkaline solutions can damage the surface of the floor, clean up any spills quickly and carefully avoiding direct with the substance. Wear protective clothing (gloves etc. when doing so).
- Avoid bitumen/tar from freshly resurfaced or melted roads and pathways. Some inexpensive rubber shoe (and slipper) soles can also cause stains.

**The above list is indicative of materials likely to cause damage but is not to be considered restrictive.**



**BEAU  
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Beaulieu  
International  
Group





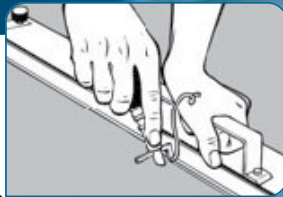
# WELDING

## Cold Welding

Cold welding is used in low-traffic and residential areas, and can be started 24 hours after the installation of vinyl sheet flooring.

Cold seam welding should only be undertaken after the drying process is complete, this will take a minimum of 24 hours.

**1.** Overlap the two sheets till you have a perfect pattern match. Double cut the overlapping in one step (or two in case of thick flooring) alongside a metal ruler.



The result is a very tight seam.

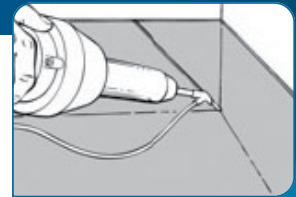
**2.** Cover the seam between two sheets of vinyl flooring with lightly removable adhesive tape to prevent the sealant fluid from sticking to the surface of the vinyl flooring.



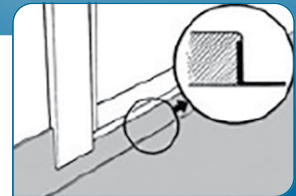
**3.** Using a sharp blade (e.g., a utility knife), cut through the tape along the seam.



**4.** Insert the applicator needle well into the seam until it touches the subfloor. Pull it slowly along the seam whilst gently squeezing the tube (follow the instructions of the seam bond manufacturer).



**5.** The needle will allow fluid to flow into the seam and, at the same time, a bead of fluid about 2-4mm wide will be left on the tape.



**6.** After approximately 10 minutes, the sealant starts drying and the adhesive tape can be removed.

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