PREMIUM RESILENT TILE (PRT) Installation and Maintenance Instructions

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920-458-4664 ● Fax 920-458-1368
www.vpicorp.com

READ THIS DOCUMENT BEFORE INSTALLATION

NOTICE TO OWNER & INSTALLER

THIS DOCUMENT CONTAINS IMPORTANT INSTALLATION AND MAINTENANCE INFORMATION AS WELL AS CAUTIONS AND WARNINGS. PLEASE MAKE CERTAIN THESE INSTRUCTIONS ARE PLACED IN THE HANDS OF THE FLOOR OWNER. VPI WARRANTY WILL BECOME EFFECTIVE ONLY IF THESE INSTRUCTIONS ARE FOLLOWED IN EVERY ASPECT.

IN SITUATIONS WHEN A WARRANTY CLAIM IS DEEMED VALID BY VPI, VPI'S LIMITED WARRANTY LIMITS VPI'S LIABILITY TO PARTIAL OR TOTAL REPAIR, REPLACEMENT, CREDIT OR OTHER, AT VPI'S SOLE OPTION, FOR VPI FLOOR PRODUCTS FOR WHICH A CLAIM, VALIDATED BY VPI, HAS BEEN MADE ACCORDING TO VPI'S CLAIM PROCEDURE.

CLAIMS FOR SURFACE DEFECTS OR VARIATIONS IN COLOR OR PATTERN MUST BE MADE TO VPI PRIOR TO INSTALLATION OF THE MATERIAL. CONSEQUENTIAL DAMAGES, LABOR COSTS AND ALL OTHER NON-PRODUCT COSTS ARE NOT COVERED BY VPI OR THIS WARRANTY AS A CONDITION OF SALE.

FOR A COMPLETE STATEMENT OF VPI'S EXCLUSIVE WARRANTY, CONTACT: VPI, CUSTOMER SERVICE, P. O. BOX 451, SHEBOYGAN, WI 53082-0451. DO NOT USE VPI PRODUCTS IF UNWILLING TO ACCEPT THE TERMS AND CONDITIONS OF THIS WARRANTY.

Please note: In all cases, installations should comply with procedures outlined in ASTM Standards for installation, at a minimum. For procedures specific to VPI products, please refer to the instructions below or check our website (www.vpicorp.com), for the most current recommended installation techniques.

WARRANTY

PRT tiles are warranted for 25 year "wear through" under normal traffic conditions and for 75 years pertaining to manufacturing workmanship and production materials. This warranty expressly excludes claims for consequential damages and all other related labor costs.

No VPI warranty covers a floor failure due to moisture emission from sub-floor, sub-floor movement, expansion, contraction or settlement caused by any environmental condition.

SUB-FLOOR PREPARATION

Sub-floors must be structurally sound, dry, clean and free of dirt, dust, wax, grease, paint, polishes, oil, curing compounds, sealers and all other materials that would interfere with good tile adhesion. The floor surface must be smooth and flat with a maximum variation of 1/8" in 10 feet.

All cracks, depressions and other imperfections must be repaired with a high quality, cementitious or epoxy leveling compound and or underlayment. Any uncorrected sub-floor irregularities may telegraph through the PRT flooring and be visible on the surface of the finished installation.

Additional information regarding the sub-floor installation and requirements can be found in **ASTM F710**.

NOTE: Gypsum-based underlayment products should not be used.

Adhesive Bond Test: In addition to, and not in lieu of, any relevant moisture tests, perform the Adhesive Bond Test in several locations throughout the area to receive the flooring. Glue down a 3' x 3' area of floor tile with the adhesive, roll with a 150 LB sectional roller, then allow to set for 72 hours. A sufficient amount of force should be required to remove the flooring.

Bond tests should be done across the recommended open time spectrum so that the optimal working time can be determined. Working times vary depending on substrate, environment and many other factors).

****IMPORTANT****
Without dated documents showing pH, RH, calcium chloride and bond test results, no warranty claim will be accepted for consideration.

CONCRETE

Moisture testing: It is essential that moisture tests be performed on all concrete sub-floors regardless of the grade level or whether or not the concrete is freshly poured or is classified as an older slab. Moisture testing **MUST** be performed by either:

ASTM F1869: Moisture Vapor by Calcium Chloride
ASTM F2170: Relative Humidity in Concrete Using Probes

Moisture levels, when measured by these methods, are not to exceed requirements below. If the test results exceed the limitations, the installation should not proceed until the problem has been corrected.

ADHESIVE MOISTURE REQUIREMENTS:

VPI 100	MVER 5 lbs maximum, pH 6 -9, RH 85%
VPI 520	MVER 5 lbs maximum, pH 7 - 11, RH 85%
Spray Lock 6500	MVER 8 lbs maximum, pH 7 - 11, RH 90%

It is recommended that new concrete slabs on or below grade should be treated with a permanent moisture barrier such as six mil polyethylene film. Any concrete in contact with earth or with less than 18" of cross-ventilated air space under it is considered to be on grade.

New concrete must be properly cured. A drying time of one month per inch of concrete is generally required after a slab is poured and protected from the weather. Lightweight aggregate concrete floors, and floors with steel or plastic pan construction, and floors poured over a permanent moisture barrier usually require an extended drying time. If lightweight aggregate concrete weighs less than 90 pounds per cubic foot, a topping of regular concrete at least one inch thick is required. To expedite drying time, adequate heat and ventilation should be provided.

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Alkalinity (pH) Test: To determine the pH of the concrete surface, use wide range pH paper, its associated pH chart, and distilled or deionized water. Place several drops of water on a clean surface of concrete, forming a puddle of approximately 1" diameter. Allow the puddle to set for 1 minute, then dip the pH paper into the water. Remove immediately, and compare to chart to determine pH reading.

Additional information with regard to these tests and results can be obtained through VPI's Technical Service Department.

Exceptionally smooth concrete: If concrete surface is exceptionally smooth, with little porosity, it should be acid etched with a 15% diluted solution of muriatic acid before installing flooring. Neutralize the concrete after etching by rinsing with clear water to which a few ounces of ammonia have been added.

Previously covered concrete: Completely remove all remaining floor down to bare concrete. Be sure to eliminate all residual adhesive, or completely cover the sub-floor with a high quality cementitious underlayment, warranted for such applications.

TERRAZZO FLOORS

Inspect the terrazzo for any sealer or film on the surface. This must be removed before proceeding with the installation.

CERAMIC TILE

All ceramic tiles must be bonded securely to the substrate. Any loose tile must be removed. Clean existing ceramic tile using muriatic acid/water and neutralize with ammonia, as directed for smooth concrete. After floor has dried, apply a thin rich coat of Portland cementitious underlayment with a liquid latex binder to achieve a smooth surface prior to installation of resilient flooring.

RADIANT HEATED FLOORS

PRT tile may be installed on radiant-heated floors, provided that the surface temperature does not exceed 90º F. and the nominal operating temperature runs at 72°F.

EXISTING RESILIENT FLOORING

Whenever possible, remove all old floor covering and sand off all the old adhesives. Any texture or embossing in the original installation may telegraph through the PRT tile and become visible on the surface of the new installation.

Do not install tile over any resilient floor covering on or below grade – only above grade.

If you are going over resilient floor covering, use the following procedures: the floor covering must be sound and adhered tightly to the floor. Remove any loose or broken areas and replace them either with sound material or with a Portland cementitious underlayment with a liquid latex binder, which should also be used to level any floor irregularities and to fill in any open seams. Thoroughly sand the surface with coarse sandpaper, using an edge sander next to the walls and in spots that a regular sander may have skipped. Completely remove all the old sealers and waxes to ensure a proper bond.

WARNING! If you intend to sand, remove or dispose of an existing resilient floor covering, backing, lining felt or adhesive you should be aware that these products may contain asbestos fibers. Sanding, removal and disposal of asbestos containing material can place fine particles of asbestos in the air. It has been determined that the inhalation of free airborne asbestos fibers may be injurious to your health. Fines may be assessed against persons violating these regulations.

NOTE: PRT resilient floor coverings and adhesives have never contained asbestos.

WOOD FLOORS

Tile may be installed over existing sound, suspended plywood floors of double construction. Do not install directly over wood strip or plank sub-floors. Prepare such floors as follows:

- Sub-floor must be solid, well nailed at joints and free from spring. Missing or unsound boards must be replaced. Install ¼" underlayment grade or exterior grade plywood or ¼" underlayment grade hardboard. If floorboards are badly warped, use thicker plywood.

- Fill all holes, cracks and seams with wood putty or equivalent filler. Sand all patched areas and uneven joints. Any irregularities allowed to remain may telegraph through the tile and be visible on the surface of the new installation.

METAL DECKS

Metal decking must be flat, dry, clean and free from dust, paint, asphalt, old adhesives, grease, oil, rust and other extraneous material. Level all surface irregularities with a Portland cement/liquid latex mixture underlayment. Lightly sand or (scuff) the surface for better adhesion.

WORK BENCHES

Tile can be applied to either wood or metal workbench surfaces. The bench surface must be flat, dry, clean and free from paint, oil, grease and other extraneous material. Metal surfaces should be lightly sanded for better adhesion.

OTHER TYPES OF INSTALLATION

For recommended procedures on other types of installations not covered in these instructions, contact VPI Technical Services before installation commences.

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CONVENTIONAL INSTALLATIONS

GENERAL

The area to receive flooring should be fully enclosed, weather tight, with the permanent HVAC system set and maintained at a minimum temperature of 65° F for 48 hours prior to, during and at least 48 hours after installation.

Avoid exposure of tile to excessive heat, such as direct sunlight, until adhesive has completely set. Avoid any traffic over finished floor for at least 72 hours after the installation.

Install PRT Flooring in accordance with the following procedures using only VPI 100, VPI 520 or Spray Lock 6500 adhesives. **Please note that using unapproved adhesives will void the VPI PRT warranty.** All three listed adhesives can be used to install PRT tiles on porous and non-porous substrates.

Adhesive usage varies depending on whether the substrate floor is porous or non-porous. It is essential that the sub-floor is tested to verify whether the concrete is porous or non-porous **prior** to the installation of the floor**.** To test, place several droplets of water in numerous locations within the installation area. If water is absorbed in less than 45 to 60 seconds, concrete is to be considered porous. If water remains beaded or is not absorbed into the concrete within this time frame, the substrate is to be considered non-porous and may have had a surface coating applied such as curing compound and or a sealer.

Excess Adhesive Removal: Isopropanol (IPA), denatured alcohol and/or a mild abrasive cleaner such as Soft Scrub ® work well to remove adhesives, especially before they cure. Using a dry cloth and IPA, wipe up adhesive that has oozed from seams or spills immediately followed by Soft Scrub to remove staining. Do not use cleansers containing amines, as yellowing may occur. Rinse well with water.

EQUIPMENT

It is essential that the specified trowel and roller be used. **Worn trowels should be discarded. NEVER re-notch a trowel**. If the trowel notches are too large, too much adhesive will be used. This will result in excessive adhesive seepage at the seams and also will cause the tile to float and shift. Clean up after the installation is then very difficult. In addition, the seams will be ledged making them very noticeable and dirt catchers as well.

If you delay rolling the tile because of excessive seepage, the adhesive will not be adequately transferred to the back of the tile causing an adhesion failure. If the notches are worn on the trowel, the adhesive will be spread too thin resulting in adhesion failure.

LAYING TILE

When laying individual tile, do not slide tile into place. The correct procedure is to place a corner of the tile in place next to the adjoining tile, carefully guide it into proper position and set it in place.

WORK OFF THE TILE WHENEVER POSSIBLE. When necessary to work on the tile, avoid shifting by using a kneeling board and by cutting tile to butt tightly at all wall junctions.

Roll and cross roll the tile with 150 pound sectional roller immediately after the tile is laid. Roll a second time one hour later. Inspect the floor for raised edges one hour after the second rolling, if necessary, roll a third time. Use a hand roller in areas that cannot be reached with a large roller.

IMPORTANT! ANY ADHESIVE AT SEAMS OR ON FINISHED SURFACES OF TILE MUST BE REMOVED WHILE THE ADHESIVE IS STILL WET.

Using Adhesives: Read the instructions for proper sub-floor preparation before opening the adhesive. If the installation will be flash coved, see special instructions under FLASH COVING.

All adhesive, floor tile and sub-floor (i.e. concrete slabs) should be conditioned at the expected operational temperature and ambient humidity level. Maintain these levels at least 48 hours before and after the tile is installed using VPI adhesives, and 72 hours before and after the tile is installed using Spray Lock.

Open time, working time and cure time will be longer at lower temperatures, and will shorten at higher temperatures. Ensure that the installation is well lit to allow effective examination of the tile and the overall installation.

VPI 100

VPI 100 is a two-part epoxy adhesive approved for all types of sub-floors below, on or above grade. VPI 100 is recommended when high sheer, high traffic and high loads are expected.

SUBSTRATE REQUIREMENTS: MVER<5LBS, RH ≤85%, pH of 6 - 9

TACK TIME: Epoxy adhesives are different from other adhesives; they **do not** develop tackiness as they set up. This makes it extremely important to roll the floor as recommended to avoid raised edges or adhesion problems.

CLEAN UP: Remove uncured adhesive by blotting with alcohol or mineral spirits. Do not smear adhesive. Use Original Soft Scrub™ (Paste) to remove remaining stains of wet or cured adhesive. During initial maintenance, dry buff these areas with a red pad on a low speed buffer to restore the factory finish.

WORKING TIME: Maximum working time is about 30 minutes. Exceeding the 30 minutes open time will lead to floor failures due to poor adhesion - do not spread more than you can install in that time. Appearance is glossy when first spread and dulls as it sets up.

TROWEL TYPE: 1/16” x 1/16” Square Notched Trowel.

SURFACE TYPE: The adhesive is good for porous and non-porous areas.

COVERAGE: 90 - 135 ft^2 / gal, depending on porosity of substrate, application style and environment. In applications demonstrating spread rates that are less than 90 SF, additional adhesive should be purchased as required.

VPI 100 2-PART EPOXY INSTALLATION:

1. All floors must be smooth, non-dusting, dry, and completely free of paint, dirt, dust, sealers, curing agents,

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old adhesive, wax, grease, oil, insect repellents, etc. (See Sub-Floor Preparation).

Cracks and uneven substrate surfaces must be filled with approved patching compounds.

2. Preceding the installation, remove tile from any pallets and place on a level flat surface. Tile and adhesive should be kept at the EXPECTED OPERATING TEMPERATURE OF THE SPACE or, ideally, at 70°F ± 5°, for at least 48 hours before application. This temperature should be maintained during, and at least 48 hours after, application.

   NOTE: Tile should not be installed above 85°F.

   After acclimation, but prior to installation, wipe the back of the tiles to remove any manufacturing residue or contaminants.

3. Thoroughly stir Parts A and B separately with a rotary motion, at the same time lifting from bottom. Use a separate mixing paddle for each part, as provided, or a mixing paddle on an electric drill.

4. **Add Part B to Part A**, making sure that the sides of the Part B container are scraped clean. If mixing all materials, ideally, the rims should be removed to allow material to be scraped completely. When using partial mixes, pour equal quantities of Parts A and B into separate containers before combining.

   Mix the two parts thoroughly for 4 minutes with a mixing paddle on an electric drill at low speeds. **DO NOT mix at higher speed**. This could cause the adhesive to start the curing process and shorten the open time.

   CAUTION: Adhesive should not be poured onto the floor until Parts A and B have been completely mixed together. Any unmixed portion applied to the subfloor will not cure properly and adhesion will be affected.

5. After complete mixing, IMMEDIATELY pour ALL adhesive on floor. DO NOT allow the mixed adhesive to remain in the container. As soon as possible, use a 1/16" x 1/16" x 1/16" square notched trowel to spread adhesive. **Do not use excess adhesive, as this can cause oozing and staining at seams.**

   Spread the adhesive, in 3-foot wide sections, as close to but not over your chalk lines. If you occasionally cross the line with your trowel when spreading adhesive, do not be concerned, but note the area. Any adhesive over the edge of the line must be scraped up before the next row of tile is installed to avoid high edges (ledging).

   NOTE: The adhesive will appear glossy when first spread and will dull as it sets up. DO NOT allow the adhesive to set up before installing the tile. Care must be taken by the installer not to spread more adhesive than can be worked appropriately within the recommended time frame.

6. Lay flooring promptly after troweling (in no event more than 30 minutes after mixing) to ensure proper transfer of adhesive to the flooring.

7. Work off the tile whenever possible. When necessary to work on the tile, avoid shifting material by using a kneeling board and by cutting tile to butt tightly at all wall junctions.

8. Roll and cross-roll the flooring with 150 pound sectional roller immediately after flooring is laid. Roll a second time one hour later. Inspect floor for raised edges one hour after second rolling and roll a third time, if necessary. Use hand roller while applying moderate to high pressure in areas which cannot be reached with a large roller.

9. Adhesive on finished floor surface and residuals on tools should be removed while adhesive is still wet, using cloth dampened with soap and water. Alternatively, IPA or denatured alcohol can be used for removal of partially cured material.

10. Avoid traffic over finished floor for at least 48 hours after installation.

11. Do not finish, wash, or service the floor for a minimum of 48 hours after installation to allow the adhesive to properly cure.

VPI 520

VPI 520 is a one part acrylic pressure sensitive adhesive (P.S.A.) approved for all types of sub-floors on or above grade listed in these instructions.

SUBSTRATE REQUIREMENTS: MVER<5LBS, RH ≤85%, pH of 7 - 11

TACK TIME: Can take from 30-90 minutes, depending on conditions. Adhesive will change from milky to clear.

CLEAN UP: Remove uncured adhesive by washing with water. Use a clean, damp towel and do not use excessive water or adhesion failure can result. Cured adhesive can be removed with mineral spirits. During initial maintenance, dry buff these areas with a red pad on a low speed buffer to restore the factory finish.

WORKING TIME: Once the adhesive has become tacky, but dry, maximum open time is up to 3 hours. Site conditions may decrease this, but they can be determined during the bond test.

TROWEL TYPE: 1/16" x 1/16" Square Notched Trowel.

SURFACE TYPE: The adhesive is good for porous and non-porous areas.

COVERAGE: 90 - 135 ft^2 / gal, depending on porosity of substrate, application style and environment. In applications demonstrating spread rates that are less than 90 ft^2, additional adhesive should be purchased as required.

VPI 520 ONE PART PSA INSTALLATION:

1. All floors must be smooth, non-dusting, dry, and completely free of paint, dirt, dust, sealers, curing agents, old adhesive, wax, grease, oil, insect repellents, etc. (See Sub-Floor Preparation).

   Cracks and uneven substrate surfaces must be filled with approved patching compounds.

2. Preceding the installation, remove tile from any pallets and place on a level flat surface. Tile and adhesive

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should be kept at the EXPECTED OPERATING TEMPERATURE OF THE SPACE or, ideally, at 70°F ± 5°, for at least 48 hours before application. This temperature should be maintained during, and at least 48 hours after, application.

NOTE: Tile should not be installed below 65°F.

After acclimation, but prior to installation, wipe the back of the tiles to remove any manufacturing residue or contaminants.

3. Apply using a 1/16"x1/16"x1/16" square notch trowel with 1/16 flats. Replace worn trowels to ensure proper spread rate. The adhesive must be allowed to dry until it no longer has milky appearance. This time varies based on the porosity of the floor as well as site conditions.
4. Once adhesive has dried to the touch and is clear, IMMEDIATELY begin laying tile. From the time the adhesive has been allowed to dry to the time it must be covered (maximum working time) is up to 3 hours depending on temperature, humidity, and site conditions. Bond tests are critical to determine working times specific to a site.

   CAUTION: A loss in adhesion strength will result if the maximum working time is exceeded! Care must be taken by the installer not to spread more adhesive than can be worked appropriately within the recommended time frame.
5. Work off the tile whenever possible. When necessary to work on the tile, avoid shifting material by using a kneeling board and by cutting tile to butt tightly at all wall junctions.
6. Roll and cross-roll the flooring with 150 pound sectional roller immediately after flooring is laid. Roll a second time one hour later. Inspect floor for raised edges one hour after second rolling and roll a third time, if necessary. Use hand roller while applying moderate to high pressure in areas which cannot be reached with a large roller.
7. Prevent all traffic for a minimum of 24 hours and heavy traffic and rolling loads for a minimum of 72 hours.
8. Do not finish, wash, or service the floor for a minimum of 48 hours after installation to allow the adhesive to properly cure.

SPRAY-LOCK 6500

Spray-Lock 6500 is a one-part spray-on pressure sensitive adhesive (P.S.A.) approved for all types of sub-floors on or above grade, listed in these instructions.

Note: Spray-Lock 6500 can be purchased from any Spray-Lock outlet. Spray-Lock can be reached at: 423-305-6151.

SUBSTRATE REQUIREMENTS: MVER<8LBS, RH ≤90%, pH of 7 - 11

TACK TIME: 10-20 minutes. No adhesive will transfer when touched lightly

CLEAN UP: Remove uncured adhesive by washing with water. Use a clean, damp towel and do not use excessive water or adhesion failure can result.

WORKING TIME: After application, open time is 4 hours. While open, ensure that adhesive is not contaminated by dust.

SURFACE TYPE: The adhesive is good for porous and non-porous areas.

COVERAGE: 100 - 125 ft^2 / can, depending on porosity of substrate, application style and environment. In applications demonstrating spread rates that are less than 100 ft^2, additional adhesive should be purchased as required.

SPRAY-LOCK 6500 ADHESIVE INSTALLATION INFORMATION:

1. All floors must be smooth, non-dusting, dry, and completely free of paint, dirt, dust, sealers, curing agents, old adhesive, wax, grease, oil, insect repellents, etc. (See Sub-Floor Preparation).

   Cracks and uneven substrate surfaces must be filled with approved patching compounds.
2. Preceding the installation, remove tile from any pallets and place on a level flat surface. Tile and adhesive should be kept at the EXPECTED OPERATING TEMPERATURE OF THE SPACE or, ideally, at 70°F ± 2°, for at least 72 hours before application. This temperature should be maintained during, and at least 48 hours after, application.

   NOTE: Tile should not be installed below 68°F and adhesive should never be stored below this temperature.

   Protect from overspray with a spray shield, drop cloths, paper or masking products.

   After acclimation, but prior to installation, wipe the back of the tiles to remove any manufacturing residue or contaminants.
3. Shake aerosol can well. Remove cap. Attach hand lever. Slide under lip or use your finger.
4. Stand straight up to spray, bend over only when necessary. Hold can upside down slightly away from your body, approximately 20-30 inches horizontally from the substrate. Aim at floor and depress hand lever or press tip with finger. Adhesive should spray out in a wide mist and fall similar to snow towards desired surface.
5. Walk right to left smoothly to achieve a consistent spray pattern.

   NOTE: Spraying in a sweeping motion may result in an inconsistent spray pattern.

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Excessive buildup or inconsistent spray pattern on substrate may cause telegraphing.

Avoid extremely heavy application

6. If overspray occurs, it may be removed with a damp cloth while the adhesive is still wet.
7. Allow adhesive to dry until there is no adhesive transfer when lightly touched. High humidity and/or low temperature increases tack time.

   NOTE: Open time after application is about 4 hours depending on a variety of factors. While open, ensure that adhesive is not contaminated by dust.
8. Begin laying tile. Ensure proper alignment before application of pressure and reposition as necessary
9. Roll the tile with a 150 lb. roller within 1 hour after installation to complete the bonding process. After rolling, the floor is ready for all access.
10. Do not finish, wash, or service the floor for a minimum of 48 hours after installation to allow the adhesive to properly cure.

SEAMLESS INSTALLATIONS

PRT is available in 36" x 36" or 24" x 24" sections, square edge or pre-grooved, for seamless installations. The 36" x 36" or 24" x 24" sections have different requirements for site acclimation, but are installed in essentially the same manner as described under CONVENTIONAL INSTALLATIONS using VPI 100 or VPI 520 with trowels, or with the application of Spray Lock 6500.

SQUARE EDGE SECTIONS:

1. Remove tile from carton and store flat in stacks (not to exceed 6" in height) at temperatures and durations called for by the adhesive used. This allows tile to adjust to room temperature. Tile will then lay flat and conform to the contour of the sub-floor when installed.
2. Lay out field. For FLASH COVING, the last sections should end at least 6" from the wall to allow space for use of router and hot air welding tool around the room perimeter. Follow the instructions under FLASH COVING to cut and dry-fit appropriate material.
3. Apply the adhesive, per the instructions, and install the field, making sure to properly roll and cross roll with the sectional roller. Allow the adhesive to cure overnight.
4. Using a scrap piece of tile, set the router so that the blade cuts a groove to a depth of approximately one half of the thickness (~.060 in.) of the tile. Route all field seams in one direction only, being careful to keep the groove centered on the seam as closely as possible. Use a chamfering plane to router cove pieces where the router cannot be operated.
5. While seamless installations are usually flash coved, top set cove base or other treatment may be used at the floor-wall junction. In these instances, use a chamfering plane to finish the groove close to the wall where the router cannot be operated.
6. Preheat the hot air welding tool. Using the 4mm welding nozzle, weld the bead into the groove.
7. Trial weld a few scrap pieces before starting on the floor so that adjustments in the heat setting may be made.

   NOTE: Beginners may find it easier to work with a lower heat. However, with experience, welding will be faster with a higher heat.

   A lower heat is recommended for correcting mistakes or welding in awkward places. A good weld is achieved when a small amount of melted bead overflows along the edges of the groove.
8. After the weld has cooled, shave off the excess bead with a spatula. If the bead is shaved before it has cooled, it will shrink below the surface of the flooring. Keep the spatula sharp by periodic honing with a fine sharpening stone.
9. After welding and trimming all seams in one direction, repeat the routing, welding, and trimming procedures on all seams running in the other direction.

PRE-GROOVED SECTIONS:

When installing pre-grooved tile, use the same general installation instructions as for square edge. Exceptions to these general instructions are as follows:

1. Take extra care to minimize adhesive seepage at the seams. Any adhesive allowed to remain in the grooves could prevent the vinyl bead and flooring from fusing together properly. If adhesives in the groove have cured, use the chamfering plane to remove all excess adhesive that may have seeped into the grooves.
2. Weld and trim all seams in one direction only.
3. Use the chamfering plane to open each cross seam.
4. Weld and trim all remaining seams.

FLASH COVE INSTALLATIONS

Coving of tile up the wall eliminates accumulations of dirt and bacteria at the floor-wall junction. CONVENTIONAL or SEAMLESS INSTALLATIONS may be flash-coved. Additional instructions for Flash Coving are available at www.vpicorp.com, but the following highlights the procedure:

1. Install a suitable cove cap strip (either metal or plastic) around the entire room. Exercise care so that the top of the cove cap strip height is consistent. Use either flat-headed nails or contact bond adhesive to cove capping.
2. Place a cove strip at floor-wall junction to support tile at the bend.
3. When installing 12" x 12" tile, lay out the field so that it ends approximately 6" from the wall. When 24" x 24" or 36" x 36" sections are used, the field can be laid out so that the last section ends at any convenient distance in excess of 6" from the wall.
4. Install the field in accordance with the procedures listed under either CONVENTIONAL or SEAMLESS INSTALLATIONS, and allow the adhesive to cure for at least 24 hours. This is critical for properly forming coving and achieving a finished appearance.
5. Dry cut cove tile pieces to fit. Remove pieces and apply adhesive to the exposed floor and wall. Install the pieces and roll thoroughly with a hand roller. If VPI 100 adhesive is used, do as large an area as practical to avoid repeated mixing of adhesive batches. Seam weld after 24 hours, if appropriate.

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INITIAL MAINTENANCE INSTRUCTIONS

Initial maintenance is **REQUIRED** to ensure a good visual appearance. Before proceeding, please note the following:

1. Allow the floor 48 hours for the adhesive to set properly before performing any maintenance procedures.
2. VPI only approves the following initial maintenance methods and procedures. Other unapproved methods and procedures may cause poor visual appearance.
3. Never, at any time, buff VPI Tile in excess of 350 RPM.

NOTE: Floors become slippery when wet and care must be taken. Appropriate barriers to wet areas and "warning / caution" placards should be used in all instances.

INITIAL DEEP SCRUB

1. To start the required initial deep scrub cleaning process sweep or dust mop the floor to remove any large debris.

   NOTE: Never use oil base treated dust mops.
2. Dilute VPI PRT Initial Deep Scrub Cleaner with cool clean water (1 part Cleaner to 10 parts water or 13 oz./gal.) and apply liberally to the area to be deep scrubbed.
3. Using the VPI ESD Gray Initial Deep Scrub Pad, agitate floor thoroughly with a low-speed rotary machine or automatic scrubber while ensuring the floor remains very wet with solution. Depending on installation and site conditions, a Maroon Initial Deep Scrub Pad may be necessary. At least 5 passes are required to properly deep scrub the floor – though more may be necessary depending on machine speed and site conditions.

   NOTE: To enhance cleaning, place a "floater pad" (i.e a red pad) above the Initial Deep Scrub Pad before beginning the scrubbing process.
4. Pick up the solution with a wet vacuum, automatic scrubber, or a mop and bucket. Rinse with clear water only.
5. Allow the floor to dry completely.

INITIAL SURFACE CLEANING

1. Place the VPI Initial Surface Cleaning Pad (natural in color, with black strands) onto a low speed floor machine.
2. Mist VPI PRT Initial Surface Cleaner over the area to be cleaned using the mist setting on a trigger sprayer. With the low-speed rotary machine, use the initial pass to evenly distribute the cleaner over the intended area to be surface cleaned (about 10' x 10' at a time) – then begin the buffing action.
3. Buff the area using an even back and forth motion. Approximately 5 passes per row should properly clean the surface but take extra passes to ensure complete surface uniformity. Continue the process until the surface of the entire area has been cleaned and is visually acceptable.
4. If desired, repeating the Initial Surface Cleaning process a second time will ensure the cleaning is even which will optimize appearance.

ONGOING MAINTENANCE INSTRUCTIONS

Ongoing maintenance using the following procedure is optional, but recommended. Before utilizing alternate products and procedures, please, consider the following:

1. PRT floors cannot be harmed by lack of maintenance but no floor keeps itself clean and an ongoing maintenance program will be required. Though there are many non-VPI ongoing maintenance products that can keep your PRT floor looking good, it is impossible for VPI to test and approve all methods. The following VPI ongoing maintenance products are approved by VPI and will ensure excellent results.
2. Frequency of maintenance can be daily or on a periodic basis depending on visual requirements, traffic and other site specific environmental conditions.
3. No maintenance program should ever include high speed burnishing. Never, at any time, buff VPI Tile in excess of 350 RPM.

   NOTE: Floors become slippery when wet and care must be taken. Appropriate barriers to wet areas and "warning / caution" placards should be used in all instances.

APPROVED PERIODIC MAINTENANCE

CLEANING

1. Sweep or dust mop the floor to remove any large debris.

   NOTE: Never use oil base treated dust mops.
2. Dilute VPI PRT Ongoing Cleaner with cool water (1 part Cleaner: 64 parts water or 2 oz./gal.). Damp mop or auto scrub using a generic red pad. Rinse as necessary and then allow to dry completely.

REJUVINATION

To achieve a deep rich luster and make any existing VPI PRT floor "look like new", simply clean the floor using VPI PRT Ongoing Cleaner and then apply VPI PRT Spray Buff.

Specifically:

1. After using VPI PRT Ongoing Cleaner and after the floor is completely dry and free of residue and other contaminants, mist a small area with VPI PRT Spray Buff using the trigger on the fine mist setting.

2. Buff the floor with a red or natural hair pad, using a slow even sweeping motion until desired appearance is obtained.

OPTIONAL MAINTENANCE FINISHES

For customers demanding enhanced aesthetics, with either high-gloss or satin finishes, PRT Flex Shield and PRT Satin Flex Shield are available. The area coverage is approximately 2,500 ft^2 per gallon.

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FLEX SHIELD APPLICATION

If applying PRT Flex Shield or PRT Satin Flex Shield to a new floor that has never been used, but has been Initially Maintained, follow the steps below.

For a previously maintained floor that has had Flex Shield applied, please follow the steps for **STRIPPING FLEX SHIELD** before applying additional coats.

1. Ensure the floor has been allowed to dry completely before applying **PRT Flex Shield** or **PRT Satin Flex Shield.**
2. Using a clean mop bucket, line the inside of the bucket with a garbage can liner to reduce the risk of contamination before pouring **PRT Flex Shield** or **PRT Satin Flex Shield** into the lined bucket. Close the liner when not in use, or between coats.
3. Apply **PRT Flex Shield** or **PRT Satin Flex Shield** as a uniform thin to medium coat using a pre-rinsed, clean synthetic finish mop or microfiber applicator system. Allow the floor finish to dry approx. 30 minutes before applying the next coat. Apply 4 to 5 coats to maximize foundation.

   NOTE: Floors become slippery when wet and care must be taken. Appropriate barriers to wet areas and "warning / caution" placards should be used in all instances.

STRIPPING FLEX SHIELD

VPI PRT Flex Stripper is specially formulated to remove VPI PRT Flex Shield and Satin Flex Shield and no other floor finish.

Approved Stripping Procedures

1. Sweep or dust mop the floor to remove any large debris.

   NOTE: Never use oil base treated dust mops.

2. Dilute VPI PRT Flex Stripper (1 part stripper: 5 parts fresh water or 26 oz./gal.) with cool to warm water.
3. Liberally apply solution to the floor surface. Allow 4-5 minutes contact time. Be sure to keep surface wet at all times.
4. Using the VPI Initial Deep Scrub Pad (gray in color), agitate floor thoroughly with a low-speed rotary machine, or automatic scrubber. This will allow VPI PRT Flex Stripper to liquefy and lift **VPI PRT Flex Shield**, **VPI PRT Satin Flex Shield**, soil and other impurities left behind on the floor.
5. Pick up the liquefied solution with a wet vacuum, automatic scrubber, or a mop and bucket.
6. Rinse with clear water only. Allow to dry.
7. After the floor is completely dry, re-apply **VPI PRT Flex Shield** or **VPI PRT Satin Flex Shield** according to the instructions above or label directions.

   NOTE: Floors become slippery when wet and care must be taken. Appropriate barriers to wet areas and "warning / caution" placards should be used in all instances.

For additional technical support call 920-451-5860

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