Updated February 2016

The purpose of this manual is to provide general installation recommendations based on certain installation environments. If there are other questions about a specific issue not covered in this manual, please contact Parterre Technical Support by phone 888.338.1029 or email techsupport@parterreflooring.com.

Material Receiving & Storage

Upon receipt of material, immediately remove any wrapping and inspect for damage and verify that the correct product and color was received. Do not drop cartons as this may cause damage.

Parterre adhesive, flooring and accessories, ambient air and subfloor must all be stored at a continual temperature of 65° to 80°F, for not less than 48 hours before installing will begin, through 48 hours after installing will be completed.

All cartons containing vinyl tile or plank flooring should be stored on a dry, flat, level surface. Cartons should be stacked squarely on top of one another. DO NOT STORE CARTONS ON EDGE. When flooring is delivered from a colder outdoor temperature (less than 50°F) to a warmer indoor jobsite temperature (minimum of 65°F), cartons of Parterre vinyl flooring shall be spread over jobsite area and stacked no more than two boxes high to ensure proper conditioning before installing.

Jobsite Conditions

Parterre flooring, accessories and adhesive are intended for interior applications only.

Prior to beginning installation, the flooring contractor should visit the jobsite to confirm that permanent heating, ventilating and air conditioning (HVAC) system will be in continuous operation and capable of maintaining area temperature of 65°-80°F continuously from 48 hours before installation, during and through 48 hours after installing. Thereafter, the temperature shall never be below 55°F and above 100°F.

It should be determined that work by other trades will be completed prior to installation, or arrangements made for adequate and continuous protection of installed flooring if other trades will be working at same time or after.

Dust, Dirt and Debris Removal

Broom sweep, vacuum and/or mop to make the installation surface completely clean. Ensure that the surface is completely dry prior to installation.

Subfloors and Underlayments

Flooring contractor should evaluate the suitability of existing surface to receive new flooring.

Surface may be deemed conditionally acceptable with a requirement for additional work and attention to include: patching; removal of surface paint, adhesive, and other substances; smoothing and leveling; addressing moisture and alkali concerns, etc. – to make the surface fully suitable to receive new flooring.

If for any reason there should be failure of underlayment (concrete, underlayment compound, wood or panel), such failure will be responsibility of underlayment applicator, manufacturer or supplier. Parterre accepts no responsibility for underlayment or sub-floor failures. Timely and thorough inspection and preparation of subfloor are first required actions to assure a satisfactory installation. No site work should commence until the flooring contractor is completely familiar with existing subfloor and related site conditions.

Unless there is written agreement to the contrary, commencement of installation by flooring contractor will constitute flooring contractor's acceptance of subfloor and conditions.

Slab Construction

Concrete slab must be in accordance with the American Concrete Institute (ACI) Publication 302.1 R-96 Guide for Concrete Floor Slab Construction for finish, cure and compressive strength of 3500 PSI.

Moisture and Alkalinity Testing

Moisture and alkalinity testing should be performed by an authorized testing service or properly trained entity, not necessarily the installation contractor. Regardless of who performs testing, all test results must be documented and made available to Parterre Flooring in case of a claim.

Perform testing according to ASTM F1869 or according to ASTM F2170 on all concrete slabs, regardless of age, grade level or history of flooring materials previously in place. Please reference the adhesive section of this manual for the moisture limits for these tests for each of the Parterre adhesives.

Slabs must be free of moisture (water vapor), hydrostatic pressure and alkali, and must remain so over time to assure integrity of installation.

Testing for presence of alkali must be performed on all concrete slabs regardless of age or history of flooring material previously in place. Alkalinity should not exceed reading of 9 when tested with pH paper and distilled water.

Moisture emission should be tested at all joints or stress cracks.

A drawing of the site to receive new flooring should be made and marked to show exact location where each moisture test has been made. The report of results at each test location should be attached to the drawing. A copy of the drawing and report should be maintained in project file available for submission to interested parties (owner, architect, general contractor, construction manager).

Testing is meaningful only on the date and time performed. Anytime thereafter, change of conditions could create change in slab moisture to higher than acceptable. Neither Parterre Flooring nor a flooring contractor has control over, or responsibility for, such change of conditions subsequent to installation.

Slab Cure versus Dryness

Concrete slabs are never completely dry, and the moisture content of a slab is subject to change beyond the control of Parterre Flooring and the installation contractor. In cases where the slab develops a problem attributable to excess moisture content subsequent to installing of any Parterre Flooring product and sundry items, it is the obligation of the owner to remedy the problem.

Concrete must be fully cured, structurally sound, clean, free of dirt, dust, wax, grease, paint, polish, oil, adhesive residue, curing, hardening, parting compounds, sealers and any material that would interfere with maximum adhesive bond between the existing surface and new flooring.

Expansion Joints

Expansion joints must be permitted to extend through and be flush with the flooring surface, and never be covered over with flooring. Filling an expansion joint with material not specifically designed for that purpose or with floor smoothing underlayment can cause bond failure and surface distortion of new flooring.

Expansion joint covering systems can be purchased. Filling joints with patching or leveling compound will not correct moisture problems

Determining Slab Porosity

The flooring contractor must determine slab porosity to choose the preferred adhesives and procedures.

Ensure surface is dust free prior to performing the following test. Permit surface to dry completely before performing additional activities.
Sparingly, sprinkle a few droplets of water on the surface (do not flood the area). Water that soaks in indicates a porous surface. Water that forms beads indicates a non-porous surface

Radiant Heated Floors

Parterre luxury vinyl flooring products (tile and plank) may be installed on radiant heated slabs providing the heating system will be controlled to never exceed a temperature of 85°F, measured directly over the heating pipes. Contact Parterre Technical Support for specific recommendations.

At any time the radiant heated floor has been allowed to cool after installation, there is a possibility of moisture will be absorbed into the concrete subfloor. Accordingly, it is recommended that when temperature is increased, it be gradual to prevent moisture from adversely affecting the adhesive bond.

Hot water pipes are usually embedded beneath concrete or gypsum toppings. ASTM F710 has minimum requirements for commercial use as follows:

- Surface cracks, grooves, depressions, control joints or other non-moving joints, and other irregularities shall be filled or smoothed with latex patching or underlayment compound recommended by Parterre (the flooring manufacturer) for filling or smoothing, or both.

- Patching or underlayment compound shall be moisture-, mildew-, and alkali-resistant, and, for commercial installations, shall provide a minimum of 3000 psi compressive strength after 28 days.

- At the time of installing the flooring material, the temperature of the floor and the room shall be 65°-75°F.

Wood Subfloors

Must be dry, smooth, free of vertical movement, horizontal expansion; be structurally sound, clean, free of dirt, dust, wax, grease, paint, polish, oil, sealers and material that would interfere with maximum adhesive bond.

Wood subfloors must be double construction with a minimum thickness of 1”. They must also not be in direct contact with the earth and be properly vented in all crawl spaces.

On- or below-grade slab, below suspended wood substrate that will have resilient flooring installed, must be dry and the area well-ventilated (minimum 18” space) to prevent entrapment and accumulation of moisture laden vapor emission and subsequent swelling of wood panels.

Where ground moisture may create conditions of high humidity in crawl space, polyethylene film must be placed over ground earth with length and width overlapped 12” to reduce and control moisture within the crawl space (minimum 18” space).

Moisture content should not exceed 12% when measured with a wood moisture test meter.

Approved Underlayment Panel

Use only underlayment grade that is a quality warranted product.

Double wood subfloors with top boards not wider than 3” require installation of underlayment grade plywood, fully sanded, 1/4” minimum thickness.

Top boards wider than 4” can accept underlayment grade plywood as above, but 3/8” minimum thickness.

Install with face grain perpendicular to board joints. Cross-joints must be staggered maximum 16”, fastened 6” on center throughout and 3” apart along all edges.

Single wood subfloors of tongue and groove planks must have a minimum thickness of 1” and must also be covered with approved underlayment grade plywood, 1/2” minimum thickness, double sheeted, with face grain perpendicular to board joints. Cross-joints must be staggered maximum 16”, fastened 6” on center throughout and 3” apart along all edges.

Unacceptable wood subfloor materials include, but are not limited to; particleboard, flake board, chipboard and luan.

Fasteners

Resin coated, rosin coated and cement coated nails, screws, staples, etc. should NOT be used to install plywood underlayment, because they can cause discoloration of vinyl flooring.

Heads and top surfaces of all fastening devices must be below surface of plywood and covered with suitable, flexible underlayment patch or filler to height of plywood surface.

Patching or Leveling Existing Floors

When patching or leveling existing floors, using a high quality latex liquid or Portland cement underlayment, or embossing leveler is preferable. For successful results, installation following the instructions provided by the underlayment or embossing leveler manufacturer is necessary. Acceptable alternatives are:

> **For commercial use**: Engineered Gypsum with a minimum requirement of 4500 PSI. The product must be compatible with Parterre flooring adhesives and is the responsibility of the manufacturer of the engineered Gypsum product to provide such assertions of the compatibility and warranty.
>
> **For residential use:** Gypsum with a minimum requirement of 3200 PSI, and the product must be primed before installation. The product and primer must be compatible with Parterre flooring adhesives and is the responsibility of the manufacturer of the Gypsum product to provide such assertions of the compatibility and warranty.

Existing Resilient Flooring

These surfaces may be suitable as substrates for Parterre flooring under the following conditions, with no guarantee or assurance by Parterre for successful and/or satisfactory results and with no liability to Parterre for unsuccessful and/or unsatisfactory results.

This material must be 1 single layer only, non-cushioned; multiple layers are unacceptable. Material must also be structurally sound, dry, clean, free of dirt, dust, wax, grease, paint, polish, oil, curing compounds, sealers and all other materials that would interfere with maximum adhesive bond between existing surface and new flooring.

This material should also be properly installed over an acceptable subfloor and must be uniformly and completely bonded to it.

A surface that is embossed, textured, irregular, uneven or with urethane coating, must be covered with high quality latex liquid/Portland cement underlayment or embossing leveler according to instructions of underlayment or embossing leveler manufacturer to minimize telegraphing.

When doubt exists about the suitability of existing flooring, it should be removed.

Removing Existing Resilient Flooring

After removing resilient flooring, all adhesive residues must be mechanically removed completely by scraping and/or sanding, and the substrate must be covered with high quality latex liquid/Portland cement underlayment according to instruction of manufacturer of product to be utilized.

Do not use solvent-based products, including products containing citrus or soy, to remove "old" adhesive when removing existing resilient flooring. Solvent-based products can, themselves, not always be completely removed from surface to receive new Parterre adhesive. Interaction of Parterre adhesive with solvent-based products that may remain on/under surface can cause an unsatisfactory bond between substrate and new flooring.

These are detailed in the publication titled "Recommended Work Practices for the Removal of Resilient Floor Covering," available from the Resilient Floor Covering Institute, 115 Broad Street, Suite 201, LaGrange, Georgia 30240.

Asbestos

For many years, asbestos was formulated into some resilient floorings and adhesives until federal law banned the use of asbestos in these products.

Wherever a new installation of resilient flooring is intended to be removed or placed over an existing resilient flooring material, the presence of asbestos in the existing flooring should be investigated.

Removal of this flooring could cause asbestos to be released into the atmosphere and if inhaled could cause serious medical problems. DO NOT SAND OR SCRAPE THESE MATERIALS.

Installation of new material over existing material that may contain asbestos is always preferable if jobsite conditions make this possible. When removal of existing flooring cannot be avoided, all safety precautions and proper procedures must be followed.

These are detailed in the publication titled "Recommended Work Practices for the Removal of Resilient Floor Covering," available from the Resilient Floor Covering Institute, 115 Broad Street, Suite 201, LaGrange, Georgia 30240.

Also check state and local laws regarding the removal of asbestos-containing material.

Ceramic, Quarry, Slate and Marble Surfaces

These surfaces may be suitable as substrates for Parterre Flooring under the same conditions and limitations as in the section above, with no guarantee or assurance by Parterre for successful and/or satisfactory results and with no liability to Parterre for unsuccessful and/or unsatisfactory results.

Following these steps may achieve the best results.

- Surfaces must be machine sanded with a 3-1/2 grain size pad or with use of a terrazzo sanding machine.
- Grouted ceramic tile must be stripped and leveled with a Portland base, self-leveling compound.
- Surfaces must be considered non-porous.
- Surfaces must be purged (stripped) of all wax, polish, grease, dirt, paint and all other coatings that would inhibit maximum adhesive bond between existing surface and new flooring.
- Adhesive bond tests must be performed between components, and results must be satisfactory.

Steel, Stainless Steel and Aluminum

These surfaces may be suitable as substrates for Parterre flooring under the following conditions with no guarantee or assurance by Parterre for successful and/or satisfactory results and with no liability to Parterre for unsuccessful and/or unsatisfactory results:

Ensure that the substrate has no surface rust or contaminants and is abraded to provide a suitable bonding surface.

Plank and Tile on Walls

Most vertical surfaces may be suitable as substrates for Parterre flooring under the following conditions with no guarantee or assurance by Parterre for successful and/or satisfactory results and with no liability to Parterre for unsuccessful and/or unsatisfactory results.

Apply to structurally sound, solid, adhesive receptive surfaces with a non-staining contact adhesive.

Note: Check with local fire codes as to suitability and restrictions.

Product Installation

On the backside of each vinyl tile there is an arrow indicating the direction in which the tile should be placed, which the designer or end-user can use as a guideline for installation. A monolithic or corner-turned design is the decision of the designer or end-user.

Note: The product HardCore: Mesa has specific directions that can be found online at parterreflooring.com under Technical > Installation > Pattern Instruction-HardCore Mesa.

Installing Remedy Vinyl Sheet Flooring

All requirements for the substrate, preparation thereof and working conditions must conform to requirements of Parterre Flooring, as stated herein, approved and certified in writing by the general contractor or end-user prior to commencement of installation.

Parterre flooring should be installed only by experienced flooring installers, who are fully trained and knowledgeable and possess required tools and techniques to produce professional results.

Placing and Fitting Remedy Vinyl Sheet

There are three general methods for fitting resilient sheet flooring: freehand knifing, direct or straight scribing and pattern scribing. Parterre Remedy sheet is flexible and can be handled easily when cutting and fitting at temperatures of 68°F and above. These characteristics enable Parterre sheets to be fitted with free-hand knifing. If layout is complex and requires precise fitting, traditional pattern scribing and/or direct scribing techniques should be used.

At least 3 hours before the fitting will begin, unroll material to lie flat and allow roll curl to relax.

For long flooring lengths, use a chalk line to help sheet not bow during layout.

For Parterre Remedy, DO NOT reverse direction of cut pieces. Assure all cut pieces are placed and installed in same direction as they are cut from the roll.

For Parterre vinyl sheet styles other than Remedy, consult Parterre before cutting and placing.

Remedy cut pieces should be positioned with ends of planks to be offset 3” to 6”.

Layout of seams should be planned with minimum 6” from subfloor and underlayment joints and to not fall over expansion joints. Seams on new flooring should not coincide with seams or joints on existing flooring.

Choice of seam cutting method should be in accordance with choice of specific hand routing tool to be utilized or plan for use of electric router and plan for seam sealing method – heat welding or liquid chemical bonding.

Plan seams to always be in least conspicuous and lowest traffic areas.

Placing Vinyl Sheet

After sheet flooring has been cut according to plan layout, marked for sequential installation and allowed to lay flat to acclimate for minimum 4 hours, it can then be positioned according to plan layout with material overlapping at seams.

Roll sheets face in after cutting to assure easiest unrolling and positioning at time of installation and to additionally assist in flat lay of material and protection from damage while being positioned.

Note: End and side edges of rolls, as they come from factory production, are not acceptable to be part of a finished seam. Each end and side edge must be trimmed.

Cross seams (end seams) are usually more visually prominent on Parterre sheet than length seams (side seams) that are parallel with wood plank length of Remedy sheet design.

Adhering Vinyl Sheet

Ensure all required conditions and substrate parameters are satisfied before commencing to installation. Refer to “Subfloor Preparation” on page 1 to ensure compliance with Parterre requirements.

After vinyl sheet is in place, install per the following steps:

- Fold back length of sheet (one nearest the wall) to just over half its length and apply Parterre adhesive #339 or #539 per specification.
- Gently place sheet into adhesive with care to avoid trapping air and creating bubbles or blisters. Roll placed flooring as directed in the respective adhesive section. Roll new flooring only up to, and not over, seam area.
- Repeat above activities to adhere remaining sheets. Ensure the untrimmed edge of the seam line is below the trimmed edge of the adjacent piece.

Flash Coving

Flash coving is a procedure for flooring to be continued up the wall, normally 4” to 6”.

Parterre sheet can either be placed flat (straight) to meet the wall or be integrally self-coved.

When flash coving is in plans and specifications, it is necessary to prepare floor and wall junction by installing cove former molding (cove stick) at junction of floor and wall, and to firmly attach cove cap molding to wall at designated height, either mechanically or with non-staining contact adhesive.

Fully spread adhesive on wall surface with flooring trowel of notch size 1/32” x 1/32” x 1/32”, or spread with a stiff brush.

Adhesive must become almost fully dry for pressure sensitive adhesives or per manufacturer’s instructions when using a contact cement.

When adhesive is dry, place flooring and roll with steel hand roller to ensure complete bond between flooring and wall surface.

Seams on inside and outside corners of flash coved material should be sealed by heat welding.

Fitting by “butterflying” and “wrapping” corners is recommended to eliminate corner joints.

When chemically sealing them, outside corners can be made with a side fill piece (boot) or butterfly piece, fit “net” without gaps.

Groove the back of material at corner positions to ensure wrapped material fits tightly to prevent bubbles or blisters.

Do not groove inside corners that are flash coved for intended heat welded seams. Allow minimum gap and fill with weld thread (rod) that will be skived off after it cools.

Inside corners should be “net” with no fullness or gaps.

Making Seams

Adherence to industry-established principles and techniques by fully trained, knowledgeable, able and experienced flooring contractors should result in satisfactorily finished seams regardless of methods to be used for seam creation.

Allow approximately 2” overlap for cross seams (end seams) and 1” for length seams (side seams).

Seams must be made so the Remedy plank design will “match” to flow evenly from sheet to sheet at all seams of the finished flooring installation. Pattern match in the length is not a concern.

Place vinyl sheet and mark planned location of seams in accordance with project plans and seam diagram. If not included in project plans and seam diagram, the locations of the seams are at discretion of flooring contractor.

The layout plan should include the least practical number of seams taking into account the practical length in areas of the least amount of traffic and the least visually prominent. Ideally, seams should not be placed across entryways, in passageways, where foot traffic will be relatively continuous or where there will be heavy wheel traffic and rolling loads.

Prior to moving forward from this point, flooring contractor should present the plan for sheet layout and seam location for “sign-off” approval by general contractor, project architect and/or owner.

Seam Cutting Options

- Cut seams “net.” Use the “double-cut” or “recess scribe” method.
- When project plans and specs require seam closure by heat welding, seams may be recess scribed slightly open – 1/64” – to assist in guiding the electric router more easily.

Seam Treatment - *Chemical Sealing*

Remove excess adhesive, debris, etc., from seams. Immediately roll flooring at seams with hand roller.

Although an approved installation method, Parterre Flooring Systems does not sell chemical seam sealer. Refer to chemical weld manufacturer for a recommended chemical seam sealer and installation instructions.

Seam Treatment - *Heat Welding*

For each individual Parterre sheet design and color, there is one matching welding rod color. The use of other weld rod colors is at the discretion of the specifier.

Heat welding may be performed a minimum of 3 hours after flooring will be placed into dry (hard set or epoxy) adhesive**.** (Use of the Armstrong S-65 Heat Welding Nozzle on a manual electric heat gun will reduce scorching and shiny appearance at seams.)

Heat Welding - *Grooving*

Maximum heat welding results will be achieved with thorough knowledge of, and experience in, proper heat welding principles and techniques.

Heat welding requires grooving and removing grooved material to make space for the vinyl welding rod.

Grooving can be accomplished with hand-held and automatic grooving tools. Use of a hand-grooving tool requires exact centering on seam line to ensure both sides are grooved equally.

Groove depth should be two-thirds depth of flooring thickness. At this depth, groove width will be almost 1/8" (3mm). **Never groove full thickness of material as this will impede or prevent a satisfactory weld.**

For manual grooving, place center of grooving tool over center of seam line. Use straight edge to touch side of cutting tool and align the straight edge. Hold cutting tool at 90° angle to surface. Pull tool toward you. Move straight edge as required and continue for seam's full distance. Discard groove material. Sweep and vacuum to completely remove all dust and shavings. Groove must be totally clean for heat welding to achieve maximum strength.

For power grooving, align automatic electric powered grooving machine guides with cut line. Press cutter to full depth of cut line, and push machine forward in seam line. At the point where abutment blocks machine movement, use hand grooving tool to complete distance to abutment and for flash coving. Discard groove scrap material. Sweep and vacuum to completely remove all dust and shavings. Groove must be totally clean for heat welding to achieve maximum strength.

Heat Welding Notes

Heat welding is the act of fusing edges of vinyl flooring sheets or pieces together with use of flexible welding rod (also called weld rope and weld thread). Many principles are involved with this process, including:

Smooth and steady movement at constant rate to produce smooth even seams. Performing at different speeds – as a slow/fast activity – will result in rough and uneven seams, with less than optimum appearance.

Temperature at heat gun nozzle and speed at which heat gun is moved should work in combination with each other. A heat setting may be too high if gun is moved too slowly or too low if the gun is moved too rapidly. Either way, less than optimum weld will result.

Heat welding should only be performed when flooring adhesive is completely dry. Adhesive that is not fully dry can bubble/blister from exposure to high heat and can, in turn, adversely affect flooring adhesive bond and seam strength.

If flooring will be placed into dry (pressure sensitive) adhesive, heat welding can commence 3 hours after flooring placement.

Welding with an Automatic Welding Machine

Automatic, electric powered welding will produce a consistent, uniform weld, invariably superior in test results to a manual, electric welding gun and should be used on virtually any project with a seam over 5 ft. long. Operating speed is approximately 12”-20” per minute. Complete operating instructions are supplied with each model from each manufacturer.

Units have a variety of enhancing features including:

- Automatic shut-off
- Automatic turn-away of welding head to one side upon completion
- Automatically stops drive unit and removes heat source from flooring material when unit comes in contact with construction wall or abutment

Heat welding must be performed only by floor covering contractors experienced in this activity and must be according to principles and techniques established and accepted by the floor covering installation industry for this activity.

Heat Welding with a Manual Electric Heat Gun

Scrap flooring should be used to practice heat welding at various gun temperatures and various gun movement speeds to determine best combination of two variables to achieve optimum (strongest, neatest) weld. Adjust variables as required.

Welding can commence when there is satisfaction with testing activity and adhesive is confirmed to be completely dry.

Speed weld (welding nozzle) attachment should be cleaned with a wire brush to assure complete absence of debris that would impede smooth movement of welding rod through its orifice.

Pre-heat welding gun and ensure nozzle is pointing up during this activity to avoid possible damage due to hot air emitting from the gun.

Confirm all required tools and equipment are at hand and in place and groove has been broom swept and/or vacuumed, to be debris free and hygienically clean. Additionally, ensure heat gun has been pre-heated to proper temperature for planned rate of movement. Finally, position weld rod spool to assure smooth peel-out.

CAUTION: Exercise care when inserting weld rod into speed welding nozzle, because nozzle is extremely hot and can cause severe injury upon skin contact.

Position gun so nozzle is directly over and above seam groove. Insert weld rod into nozzle to extend out 3” to 4”. Position gun directly on seam groove. Maintain downward pressure and pull gun along seam groove toward you as weld rod passes through nozzle into groove. Maintain constant speed.

When further backward movement is physically blocked, stop and change welding direction. Lift gun out of groove and cut weld rod at that point.

Allow weld rod to cool where it was reversed and lumped. Use hand grooving tool to groove cooled and lumped weld rod. Result will be groove suited to accept new weld rod. When welding activity commences in opposite direction, it will be into a groove suited to accept weld rod placing. Final result will be a complete and satisfactory welded seam.

Change welding direction 180°. Begin welding from wall and continue back. Stop welding in same manner as earlier – at point where welding rod was previously installed, lumped and grooved. The result should be a smooth and continuous filling with welding rod over entire groove length.

Heat gun temperature control should be turned down gradually to “zero” (off) setting.

Allow a minimum of 30 minutes for welding rod to cool, during which time it will shrink. Use a 2-step process for trimming weld rod above floor surface.

Use spatula trim knife with trim plate attachment to remove virtually all welding rod and leave about 1/32” above flooring surface.

Use spatula trim knife again, this time without trim plate attachment, with blade at absolute maximum sharpness and maximum 10° angle to flooring with sharpened side facing down, against welding rod. Exercise care to avoid cutting or gouging flooring.

Even after second spatula use, high spots may remain. Inspection should make them apparent for removal with careful use of spatula knife without trim plate attachment. If trimming will cause some portion of seam to be lower than adjacent surface, repeating welding and trimming activities may be needed to correct affected area.

Finishing activities should then be performed.

Remove speed-welding nozzle from welding gun. Hold the air output orifice close to welded seam and pass gun over full length of seam. This “glazing” process will increase smoothness of completed weld and slightly darken its color for maximum blending with surrounding flooring.