



Altro Puresentials installation guide

This publication is designed to provide technical information to assist in the installation of Altro Puressentials. Except where noted, this information applies to the complete range of Altro Puressentials products.

The recommendations herein are derived from actual field and laboratory testing by Altro's technical specialists. The procedures are widely accepted in the wall covering industry.

Install Altro Puressentials according to the definition of standards in this guide. Any deviations from this definition of standards are to be attempted solely at the risk of those specifying or attempting the actual installation, and are not the responsibility of Altro or its distributors.

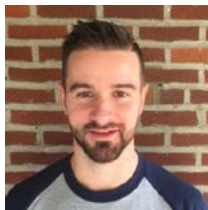
Bidding and installation of any Altro Puressentials should only be undertaken by professional installers versed in the required tools and techniques for professional installations. Failure to correctly install Altro Puressentials will void the Limited Product Warranty.

Technical Department

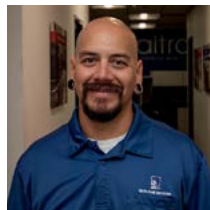
Our technical department, product knowledge and walling expertise is what sets Altro apart from our competitors. We are here for you every step of the way from planning, through installation and even maintenance for the expected life of the surface.



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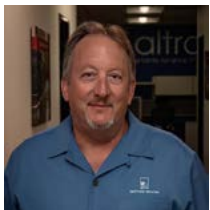
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Discover more online!



To learn more information on Altro Puressentials, read our datasheet on altro.com/us.



Simple cleaning information is also available as a separate document for end-users.

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Chapter 1

Introduction



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Apart from the normal health and safety rules employed within the industry, the following rules should be noted:

- Safety information displayed on all materials must be strictly adhered to.
- Wear appropriate safety equipment (check with local, federal, and OSHA regulations).
- Safety eye wear must be worn when cutting materials, mixing adhesive, cleaning and preparation of site, and where necessary to adhere to site regulations.
- Use face masks and all appropriate safety shoes, cut-proof gloves, clothing, and all other items that are required by local, state and/or federal guidelines and regulations.
- Ensure good ventilation, provide forced air if required.
- Remove and dispose of waste as per all local, state and federal guidelines and requirements.

Altro Puressentials is an innovative wall cladding system that meets your commercial durability, cleanability and hygiene needs yet is a game-changer in terms of sustainability. It is the ideal solution for areas that require PVC-free wall cladding options.

Crafted from thermoplastic polyester (PETG), Altro Puresentials is an eco-friendly choice that contains no halogens or BPA and emits low levels of volatile organic compounds (VOCs) – meeting UL safety certification requirements.

Altro Puressentials has a smooth, matte surface that emulates the appearance of paint. The appearance of paint and will create a durable will create a durable and long-lasting surface that's easy to clean and maintain while protecting against scuffs, stains, and fungal growth.

Altro Puressentials panels are joined using a traditional heat-welding technique, similar to Altro Whiterock, or with a manufacturer approved glue stick for instant bonding. Furthermore, Altro Puressentials is thermoformable, allowing for easy customization and fitting on-site.

This product is commonly used in critical hygiene and healthcare areas that demand PVC-free wall cladding solutions to meet appropriate building codes. However, if you don't require a PVC-free product, Altro recommends our tried and true, industry favorite, Altro Whiterock.

Typical applications for Altro Puresentials

Altro Puressentials product specifications

Panel Sizes	4' x 8'	4' x 9' 10'
	(1.22m x 2.44m)	(1.22m x 3.05m)
Thickness	.080" (2mm)	
Weight	16.605 lbs	20.757 lbs
	7.5 kg	9.4 kg

- Critical hygiene and healthcare areas
- Operating Rooms
- Central Sterile
- Laboratories
- Cleanrooms
- Medical Device Rooms
- Pharmacies
- Any application that requires a PVC-free wall panel

Notes

1.3 Limitations of Altro Puresentials

Altro Puresentials panels can be applied to most surfaces. They should however, not be installed near a heat source such as, steam kettles, pizza ovens, cooking ranges, steam rooms, etc., or where exposed flame or severe heat could cause distortion of the Altro Puresentials panel.

- Temperature Range: Altro Puresentials panels should not be exposed to temperatures above 160° F (71° C). Altro Puresentials can become brittle at low temperatures and is not recommended for installations subject to temperatures below 23° F (-5° C) where it is exposed to high impact.

1.4 Installation tools + equipment

Installation Tools List

- Items with magenta bullets are required and available from Altro
- Items with gray bullets are required tools you must have for Altro Puresentials Installations
- Items with orange bullets are recommended for Altro Puresentials Installations

Hand Tools:

- Edge Scraper (Skarsten Scraper)
- 3/16" Square Notch Trowel (MLN) for most applications
- 1/4" Square Notch Trowel (CTB)
- 1/8" Square Notch Trowel (PRB)
- Rubber Mallet, non-marking
- Wall Roller
- Anti-static Solution
- Caulking Gun
- 3' (1 meter) & 6' (2 meter) levels
- Small Block Plane
- Tape Measure
- Hole Cutters / Drill Bits
- Laser Level
- Ladders and/or Scaffolds
- Chalk Line
- Hammer
- File
- Mozart skiving knife
- 5' and 10' Straight Edges
- Versablade Trowel Handle
- 4mm Narrow Flow Tip
- Trimming Knife Straight Handle Spatula
- Diamond Sharpening Pad
- Steel Clean Out Brush with Xacto Handle
- Metal Trim Plate

Electrical Tools:

- Hot Jet S Welder or Triac BT Weld Gun
- Altro Thermoformer™
- Plunge saw with track guide and vacuum
- Jigsaw with fine toothed blades
- Drill (for mixing paddle and hole saw)
- MultiMaster cutter such as a Rockwell RK5139 K oscillating tool kit

Recommended tools

Please refer to the separate *Construction tools catalog* for a complete list of the tools and equipment offered at Altro. Your instructor will take time to review the walls portion of the *Construction tools catalog* and explain the 30 day tool discount offered for Training Academy attendees.



Chapter 2

Pre-installation



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2.1 Preparation

All surfaces must be smooth, sound, dry, and free of contamination. The wall should be cleaned prior to the installation of Altro Puresentials. The working environment must also be dust free. Failure to comply with these conditions will reduce the bond strength between the adhesive and substrate, and may cause the Altro Puresentials panels to de-bond.

Surface preparation

- All substrates to be dry to 16% WME (wood moisture equivalent) on Protimeter ‘Survey master’ equipment.
- All loose, flaking paint and dust to be removed.
- Friable surfaces to be removed or made sound.
- Depressions in substrate surface should be filled with appropriate patching compound.
- All electrical switches, power points etc., should be in a first-fix/installation ready state. All electrical equipment should only be moved or altered by a qualified electrician.
- All plumbing should have fixtures removed to a first-fix or installation ready state and “tails” left protruding from the substrate. Altro Puresentials panels can then be drilled and slid over the pipe tails. All holes should be drilled 1/8” (3mm) oversize to allow for expansion, then sealed with Altro Sanitary Sealant UC. Plumbing should always be done by a qualified plumber.
- Hot pipes and steam pipes should be insulated and a 1/4” (6mm) expansion gap should be created when installing panels around these pipes, then sealed with Altro Sanitary Sealant UC.
- All pipes, fixing bolts, etc. extending through the Altro Puresentials panels should have a minimum 1/8” (3mm) expansion gap and be sealed using Altro Sanitary Sealant UC.
- Door frames and door casings must be in place prior to the installation of Altro Puresentials.
- Prior to installation, it is advisable to complete any painting which comes in contact with Altro Puresentials, as the Altro Sanitary Sealant UC used at junctions is unpaintable.
- Priming of dusty and overly absorbent surfaces may be necessary. Use 1 coat of any readily available water based primer (Valspar, Benjamin\Moore, Glidden, or equal).

All surfaces must meet these requirements:

All surfaces must meet these requirements:

- cold temperatures will make the material brittle and temperatures below 23°F should be avoided during the storage process.
- When stacking pallets they should not be stacked more than 8 pallets high and stacked flat without bumps or rolls and in a square and well aligned configuration, safety precautions should be taken to secure pallets to prevent shifting or falling.
- Eye protection should be used and care taken during cutting, fitting, and thermoforming procedures.
- If more than one pallet of material is used, use material in sequence.
- Panels and all other materials should be moved into the acclimated worksite 72 hours prior to installation.
- Panels and all other materials must be checked for defects before installation. Do not install materials with visible defects.
- Check carefully to see that panels match in shade. If a shade match cannot be accomplished, do not install. Contact your Altro distributor.

- If storage temperature is below 68°F (20°C), Altro materials must be moved to a warmer place and allowed to reach this temperature before installation. The room temperature must not be below 68°F (20°C) and the wall substrate temperature between 65°F (18°C) and 80°F (27°C).
- Altro Puresentials, adhesives and accessories must be stored in enclosed dry conditions and not subjected to freezing or excessive heat. Heat above 160°F will distort and damage the material.

Operating temperature

Environment

To ensure that expansion and contraction parameters are not exceeded, **Altro recommends that Altro Puresentials is installed at approximately the same ambient service temperature at which the room area will be when commissioned.** Normal expansion is provided for in the fitting of the material within the seam method and the silicone seals at abutments.

Notes

Suitable surfaces

Check adhesive data for specific requirements

- Minimum 5/8" thick sheet-rock/plasterboard.
- 1/2" Durock or Hardibacker or most tile backer boards
- Minimum 3/8" grade plywood.
- Minimum 3/8" MDF panels.
- Most sound painted surfaces (an adhesive test is advisable to determine suitability).
- New sheet-rock, plaster, and pink finishing plasters are generally dusty. Surfaces to be brushed and thoroughly sealed with paint primer.
- Metal substrates. If metal is susceptible to rusting, apply a coat of rust inhibitor.
- All substrates must meet local building code.

2.3 Workstation and workbench

Set up a 'workstation' in close proximity to the area to be clad. A minimum area of 10'x13' will be required to set up your workstation area.

Adjacent to the workstation, set up a 'glue-station', where all the mixing of adhesive takes place. The floor area in this location needs to be protected with cardboard (or similar) to prevent splashes of adhesive getting onto the floor.

To create your workbench needed you will need the following materials:

- One 4'x8' piece of plywood (¾" thick) - 10' if using a 10' Altro Puresentials panel
- 2" x 4" or 2" x 6" support beams - or appropriate length to support table top
- Stands for Thermoformer using 2 sets of legs (saw horses)

Chapter 3

Installation practices



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3.1 General installation instructions

Note: All terminating edges of Altro Puressentials that are not being heat welded are to be Chamfered/Beveled on both front and back edges so as to remove any sharp edges and to allow the greatest surface area for the application of Altro Sanitary sealant UC.

1. Apply a level datum line around the entire installation area. The datum line is used for the calculation of measurements for ceiling/floor height, outlets, pipes, etc., and to ensure the panels are plumb as the installation proceeds. It is advisable to set this datum line at 5' (60" / 1.55 m) off the finished floor. This way the line is near eye level and is easy to locate when placing the panels on the wall. The datum line height can be adjusted to suit the installer.

When installing as a wainscot the wainscot height will require a lower datum line location. Datum lines can be quickly set up and established using a laser level and chalk line.

2. Place panel on the workbench and inspect for damage. Carefully mark your datum line on the protective film on the face of the panel, using a pen, taking care not to press too hard, and possibly damaging the surface of the Altro Puressentials panel. Your datum line on the panel should also consider if the panel is flush to the floor or the height of the cove reveal.

3. **On the wall:** measure from the datum line down to where the panel is to end.
On the panel: starting from one of the finished ends of a panel, make a mark on the face of the panel with that same measurement. Repeat this measurement on the other side of the panel and draw this datum line across the panel face on the protective film, this is your datum line. You will use this to measure off all of your height measurements. As you have used the bottom of the panel to arrive at your datum line, that bottom edge will not require cutting.

3a. On the wall: Measure from the datum to the ceiling or any other point where you need to determine the height of a cut. Always allow a minimum of 1/16" space between the panel and any abutment.

3b. Cut the panel using a jig saw, circular saw, track saw and track, multimaster or any other appropriate method you choose.

4. Once cut for height and penetrations make any bends as needed using the Thermoformer (See section 3.2 Thermoformer on page 13). Caution it may be necessary to leave your ceiling cut 1"inch longer as this will allow the direct scribe of the panel to the ceiling when the corners are out of square/plumb; the scribe is done to the pane a 2" straight edge or by using dividers set to 2"; the panel seam edge at the leading edge of the panel may now also require that it be re-plumbed / re-leveled and cut to fit straight up and down and level. Peel back and remove the protective film approximately 2" (50mm) from the edge.

5. Hold the panel up to the substrate, check for fit and panel edge plumb/level ensuring you have a minimum 1/16" (2mm) expansion joint at all abutments and pipe work, and other protrusions.

6. When the panel has been made to suit the required finish detail, lay the panel face-down on the workbench and clean the back of the panel with anti-static solution.

7. Apply the double sided tape to the wall substrate at seam locations.
Note: Always apply a coating of AltroFix 75 Spray tape adhesion promoter on the wall where the double sided tape will make contact.

8. Dust and clean the wall surface, prepare the panel and spread the specified adhesive as below:

8a. After all bends and cuts are made, and the tape is in place, apply the adhesive to the back of the panel, using the recommended trowel notch.

8b. If using W39 two-part polyurethane adhesive, carefully mix part B into the part A bucket together using a low-speed mixing drill and paddle for a minimum of 3 minutes, until an even color of the adhesive is reached.

8c. The working time of adhesives is approximately 30 minutes depending on the ambient temperature of the room. The trowel must be held so that the adhesive is applied to an even finish, and the trowel notches are replicated to the same depth over the entire panel. Pull the trowel across the width of the panel so all notches run left to right.

8d. At any points where there may be a gap between the wall and panel, apply additional adhesive. This is especially true at inside and outside corners.

9. After adhesive has been applied, apply double sided tape as required by the jointing method used. Lift the panel to the wall and adhere to the required location using the datum line previously applied to the wall. Apply pressure to the whole panel face to ensure the adhesive has been transferred and will be fully bonded to the substrate. This is normally done with a wall roller to prevent the surface from being damaged.
10. Failure to ensure a good transfer of adhesive to the substrate could result in the panel debonding.
11. The curing time of the adhesive is dependent on the absorption of substrate, type of adhesive and the ambient temperature.

3.2 Thermoformer

The thermoformer allows installers to heat and shape Altro Puresentials wall panels to conform to the contours of a room. This allows the Altro Puresentials wall system to remain seamless around inside and outside corners.

While using the thermoformer, work should be done on an appropriate sized worktable. The table top should be flush with the height and sides of the thermoformer. This is so the panel can be laid across the heat source while thermoforming and an even distribution of heat is obtained along the length of the bend line.

Alternatively you may set up a 4' x 8' workbench made of a panel of thick plywood on saw horses and set the thermoformer adjacent on separate metal stands.



Using the thermoformer

1. Assemble workbench and thermoformer.
2. Plug-in the thermoformer and let it warm up for approximately thirty minutes before beginning thermoforming.
3. Mark the panel at the edge where the bend is to occur, with these pre-established bend lines marked on the face of the Altro Puresentials panel; center the bend lines over the heat element opening on the thermoformer, heating from the backside when allowable. You may heat the face of the Altro Puresentials for certain bends being careful to not touch the panel to the white insulating stone. Remove the tack film from the surface first.
4. Allow sufficient time for the Altro Puresentials panel to heat up until there is a visible softening of the material over the line where the material is to be thermoformed (about 30 seconds).
5. Immediately move the material from the thermoformer onto the flat worktable.
6. Forming the heated panel can be done in one of two ways:

Notes

Sharper corner edges

This is accomplished by using just enough heat to bend and form the material, approximately 20 to 30 seconds on the thermoformer, then the material is folded directly to the required corner angle and held to cool (do not bend the panel all the way in half and then back to the desired angle), cooling takes about 1 minute—Use a 'T' style straight edge to help form this and other bends.

Softer corner edges

This is accomplished by keeping the panel on the thermoformer for longer (30 seconds or more) period of time and utilizing more heat, the longer (more) heat that is used the farther the heat radiates out from the bend area and the softer and larger the radius angle (bend) will be when formed; the material can be bent all the way in half when forming softer corners—hold the panel at the desired angle (bend) until the panel has cooled and becomes rigid. Use the 'T' style straight edge to hold the panel bend in place while cooling.

- 7. Make any additional bends needed in the material following the same procedure.
- 8. When measuring for bends, always consider and allow for the thickness of the panel and the adhesive.

3.3 Measuring for bends

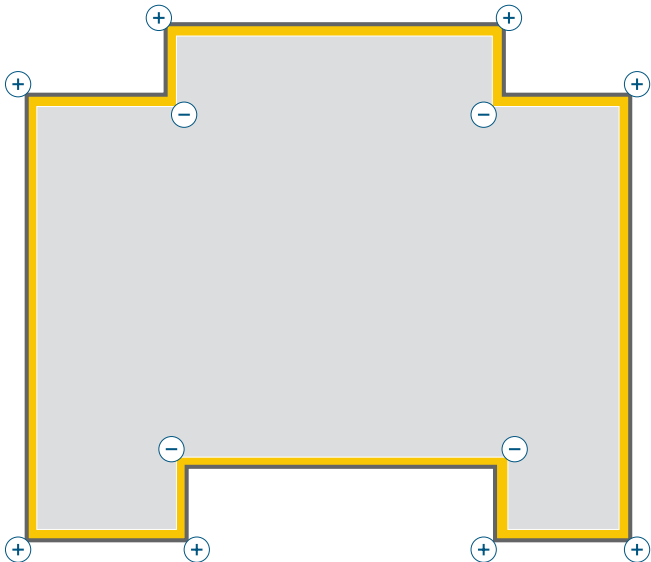
Altro recommends using thermoformed internal/external corner detail when installing Altro Puresentials. This is achieved by heating the panel on the thermoformer and manually forming the panel to the desired angle.

- When possible, always mark on the face of the panels on the protective plastic film
- Always measure on the face of the panels
- Estimate the panel thickness and the adhesive to be approximately 3/32" thick
- Always take three measurements, top, middle and bottom of the corner being wrapped/thermoformed

What size panel do I need?

See mock-up diagram below for an example with measurements.

+	Measuring with outside corners	Use the widest measurement, then add 3/32" per corner to the total length of the panel.
-	Measuring with inside corners	Use the narrowest measurement, then subtract 3/32" per corner from the total length of the panel.
	Measuring with inside and outside corners	Use the narrowest measurement, do not add or subtract anything.



Chapter 4

Adhesives, tapes and sealants



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4.1 Adhesives

Altro W157

Water-based acrylic adhesive is suitable for surfaces in dry, climate controlled areas and may only be used with absorbent substrates.

Altro W39

Two-part polyurethane adhesive suitable for all absorbent and non-absorbent surfaces. When in doubt, use this adhesive.

Adhesive spread rate is approximately 1 gallon of adhesive per 8' panel when using the 3/16" inch square notch trowel. Bond test should be performed on all surfaces.

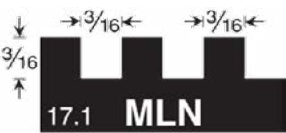
AltroFix 75 Spray tape adhesion promoter

Apply a coating of AltroFix 75 Spray adhesive on the wall where the double-sided tape will make contact.

Substrate	Altro W39	Altro W157
Drywall Minimum 1/2" thick	A & B	A, B, & E
Plywood Minimum 3/8" thick	B & G	B & G
Metal	Required Choice	Not Recommended
Plaster	B & G	B & G
Concrete	B	B
Painted	D	E
(A) All gypsum joint compound needs to be primed.		
(B) Very absorbent surfaces must be primed.		
(C) Provided tiles are firmly bonded to the substrate and free from surface contamination, soap scum, grease etc.		
(D) A bond test is advisable to check adhesive does not react with paint.		
(E) W157 should not be used for bonding to moisture resistant substrates.		
(F) Brickwork and block-work should be of good quality and joints should be flush.		
(G) Test for moisture with a GE Protimeter, which should give a maximum reading of 16% WME (wood moisture equivalent).		

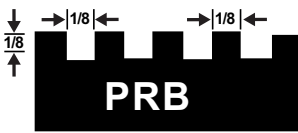
Recommended trowels

Use only approved adhesives and trowel notches as recommended by Altro. Consult the adhesive label for additional information. MLN 3/16th trowel notch is recommended for most applications. Other trowel notch sizes based on substrate conditions. Contact Altro technical for further information.



MLN - 3/16th

Recommended trowel notch for most applications



PRB

For very smooth substrates

Chapter 5

Seaming methods



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5.1 Heat-welding system

Substrates

When installing Altro Puressentials panels with welded joints, it is imperative the substrate is in smooth condition. Surfaces must be sound, clean, smooth, true, flat, and flush; in particular these conditions MUST be present where the welded panel joints will be. Recommended substrates include drywall, plywood, finishing plaster and most types of sand & cement. See section 2.1 Preparation on page 8 for additional substrate recommendations.

Planning layout

When planning the layout of the panels it is important to minimize the number of joints in the wall system. Ensure joints do not fall too close to corners. We suggest joints should not be formed any closer than 12" from a corner. Consider if the person doing the heat-welding is a right handed person or a left handed person, as a left hander can get closer to a left hand corner than a right handed person can and vice versa with a right hander getting closer to a right hand corner than a left handed person can.

Always apply a coating of AltroFix 75 Spray tape adhesion promoter on the wall where the tapes will make contact. Altro recommends Altro W39 adhesive for heat welded installations.

Preparing the joint

Note: Before installing the panels, you must fit the double sided tape to the substrate at the center point where the two panels will meet so the tape is 1" under each panel.

Panel preparation

Always inspect all panel/seam edges to check and ensure that all edges are straight, clean, smooth, true, and free from burrs, or edge curl; de-burr, re-cut, or re-plumb/straiten panel seam edges as needed. It is recommended to use factory edges when possible.

When cutting panels, you will obtain a truer edge if you use a track saw and guide, if using a jigsaw or other cutting method cut the panels slightly larger than the size required and then use a carpenters hand plane to plane the edge to size and to obtain a clean and 'crisp' square edge.

Check that there is no loose debris left on the edge of the panel from where it was cut. This debris could burn when Heat-welding the joint and will leave a blemish which cannot be removed from the joint.

Heat weld installation and processes

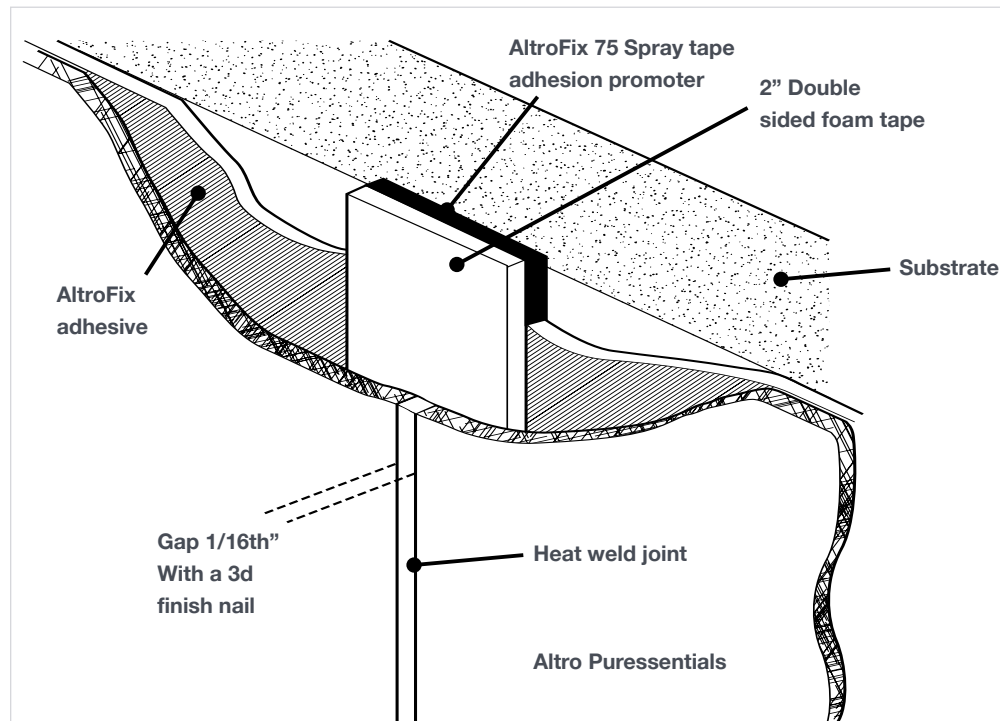
Apply 2" wide double sided tape on the wall so it is centered at the seam (leave the protective paper on the double sided tape). Once the panels have been prepared and the panel seam edge slightly chamfered/beveled to accept the heat-weld bead (this chamfered/ beveled edge can be done with either a carpenters block plane and/or our edge scraper) and the panel dry fitted to check everything is correct, apply the adhesive to the back of the panel, stopping 1" (25mm) short of the seam edges. See Section 3.1 for details

After the panel is placed on the wall and fit to the datum line and panel seam/joint, carefully ease the edge of the panel off the wall and remove the protective paper from the double sided tape and re-set panel (save the protective tape cover). Roll the panel to achieve a transfer of the adhesive to the substrate. When rolling the panel, start in the middle and work outward. Place the tape cover back on the exposed double sided tape to protect it. Note: Always apply a coating of AltroFix 75 Spray tape adhesion promoter on the wall where the tapes will make contact.

Prepare the next panel in the same way as described above (ensure that the seams of the previously installed panel are clean and free of adhesive). Before fitting this panel you must fit a series of "spacer pins" against the edge of the previous panel. This is to provide the correct 'gap spacing' between each panel. A spacer pin may be a 3D finish nail (on gypsum board and drywall) or a dime set on edge and being held in place by the double sided tape (on concrete or cement block) that provides the correct amount of space between each panel. The correct space should be no more than 1/16th" width.

Notes

Notes



Fit the next panel as described, ensuring the panel is butted tightly against the spacers. Once the panel has been rolled almost to the edge, remove the spacer pins and then remove the final part of the double sided tape's protective cover. Press the panel firmly onto the foam tape and then complete the rolling of the panel.

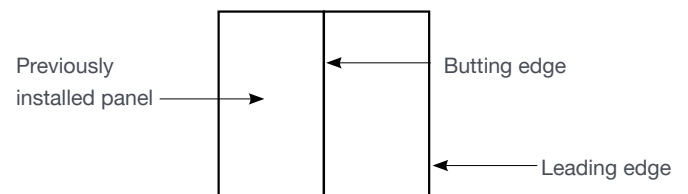
Check that all edges are clean and free of adhesive residue. Once the installation of the panels is complete, you are then ready to weld the joints.

Heat-welding

Clean both the seam area and the weld rod with the anti-static solution. Ensure that the Heat-welding equipment and in particular the heat-welding tip is completely clean and free of any debris or carbon buildup.

The heat-welding technique used to weld Altro Puresentials panels is largely similar to that used with Altro sheet flooring. The same type of tools and welding equipment should be used.

To determine proper temperature and speed for Heat-welding have been satisfied, test weld on a scrap piece of Altro Puresentials before proceeding. **Do not scorch the panels as this will be extremely difficult to repair.**



Check for completeness of weld by trying to roll the bead left to right after it has been welded.

Allow the weld rod to cool down sufficiently before trimming. Apply soapy water to panel along weld to help lubricate the skiving tool. Once the rod has cooled down you can commence final trimming with your trimming tool. Take care not to scratch or damage the Altro Puresentials surface while undertaking this final part of the operation. The use of a trim plate is optional. Try to accomplish this in one pass, as multiple passes tend to leave the weld jagged and increase the risk of scratching the panel.

5.2 Hot glue stick seaming method

When installing Altro Puressentials panels with hot glue seaming method, it is imperative the substrate is in smooth condition. Surfaces must be sound, clean, smooth, true, flat, and flush; these conditions **MUST** be present where the panel joints will be. Recommended substrates include drywall, plywood, finishing plaster and most types of sand & cement.

When planning the layout of the panels it is important to minimize the number of joints in the wall system. Ensure joints do not fall too close to corners. We suggest joints should not be formed any closer than 10" - 12" from a corner.

Always inspect all panel/seam edges to check and ensure that all edges are straight, clean, smooth, true, and free from burrs, or edge curl; de-burr, re-cut, or re-plumb/straiten panel seam edges as needed.

Apply 2" wide double-sided tape on the wall so it is centered at the seam (leave the protective paper on the double sided tape). Once the panels have been prepared and the panel seam edge slightly chamfered/beveled to accept the hot glue stick. Dry fit the panel to check everything is correct, apply the adhesive to the back of the panel, stopping 1" (25mm) short of the seam edges.

Place the tape cover back on the exposed double-sided tape to protect it. Note: Always apply a coating of AltroFix 75 Spray tape adhesion promoter on the wall where the tapes will make contact.

Prepare the next panel in the same way as described above (ensure that the seams of the previously installed panel are clean and free of adhesive). Before fitting this panel, you must fit a series of “spacer pins” against the

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edge of the previous panel. This is to provide the correct 'gap spacing' between each panel. A spacer pin may be a 3D finish nail (on gypsum board and drywall) or a dime set on edge and being held in place by the double sided tape (on concrete or cement block) that provides the correct amount of space between each panel. The correct space should be no more than 1/16th" width.

Fit the next panel as described, ensuring the panel is butted tightly against the spacers. Once the panel has been rolled almost to the edge, remove the spacer pins and then remove the final part of the double-sided tape's protective cover. Press the panel firmly onto the foam tape and then complete the rolling of the panel.

Check that all edges are clean and free of adhesive residue. Once the installation of the panels is complete, you are then ready to hot glue stick the seams.

Application of hot glue stick

Be sure the seam is clean and free of any debris prior to hot gluing.

The hot glue stick method is done by applying a continuous bead of hot glue into the seam which will be proud of the panels. Be careful and steady keeping the hot glue in the seam only and not on the face of the panels.

Trimming off excess hot glue

Allow the hot glue to cool down sufficiently before trimming. Apply soapy water to panel along hot glue to help lubricate the skiving tool. The trimming should be done in two passes like a heat welded seam. Take care not to scratch or damage the Altro Puresentials surface while undertaking this final part of the operation.

When hot gluing , a small mock up must be done and inspected for client approval before proceeding with the entire installation.

Chapter 6

Floor-to-wall transitions



Topics

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6.2 Installation over epoxy 25

6.3 Altro Puresentials installed first 27

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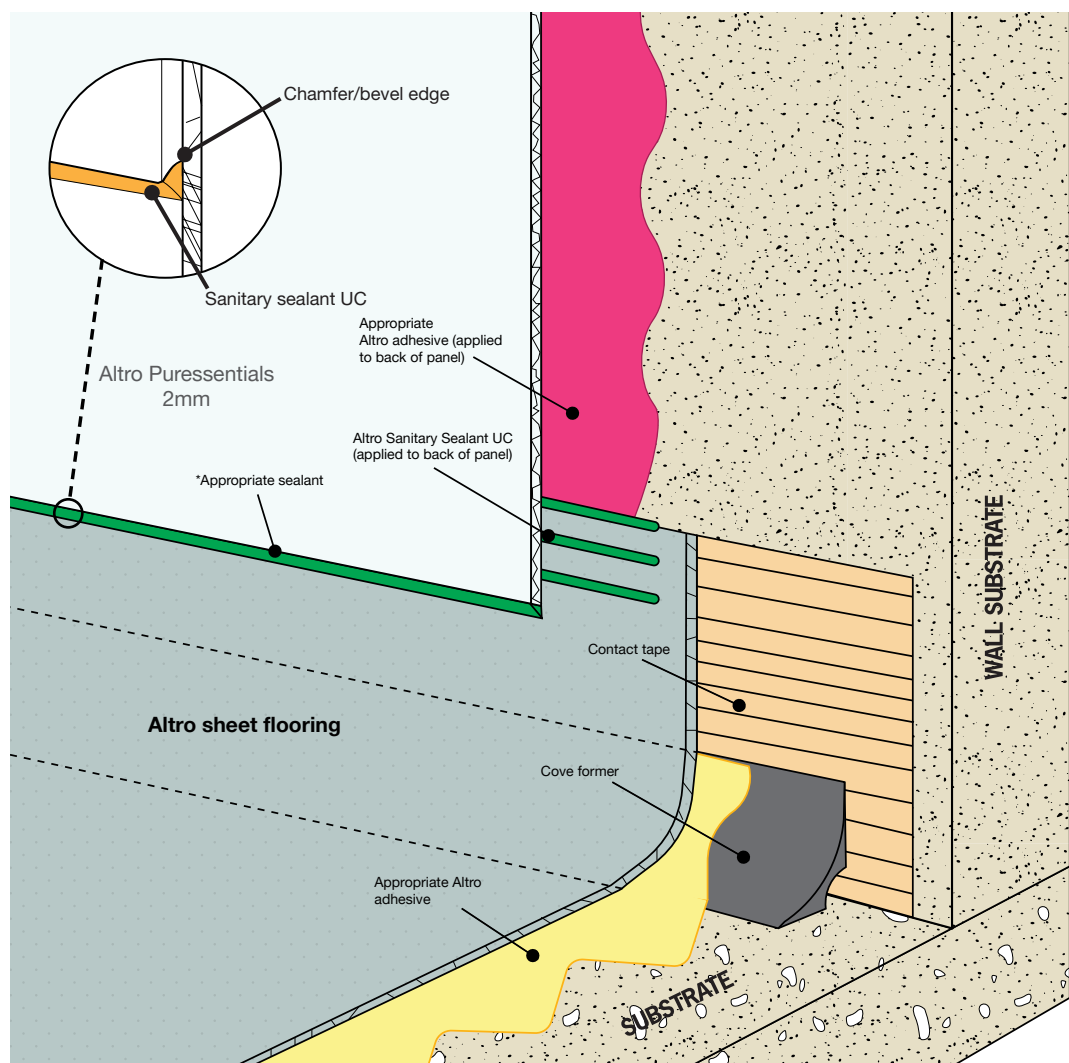
6.1 Floor to wall overlap transition

Preferred method

When using heat-weld panel seam finishing an overlap of the wall panel to floor detail is preferred. The overlap detail is the preferred wall panel to floor detail transition.

Altro wall system overlapping self-coved Altro flooring, fixed with the appropriate adhesive, sealed with Altro Sanitary Sealant UC at the overlap junction.

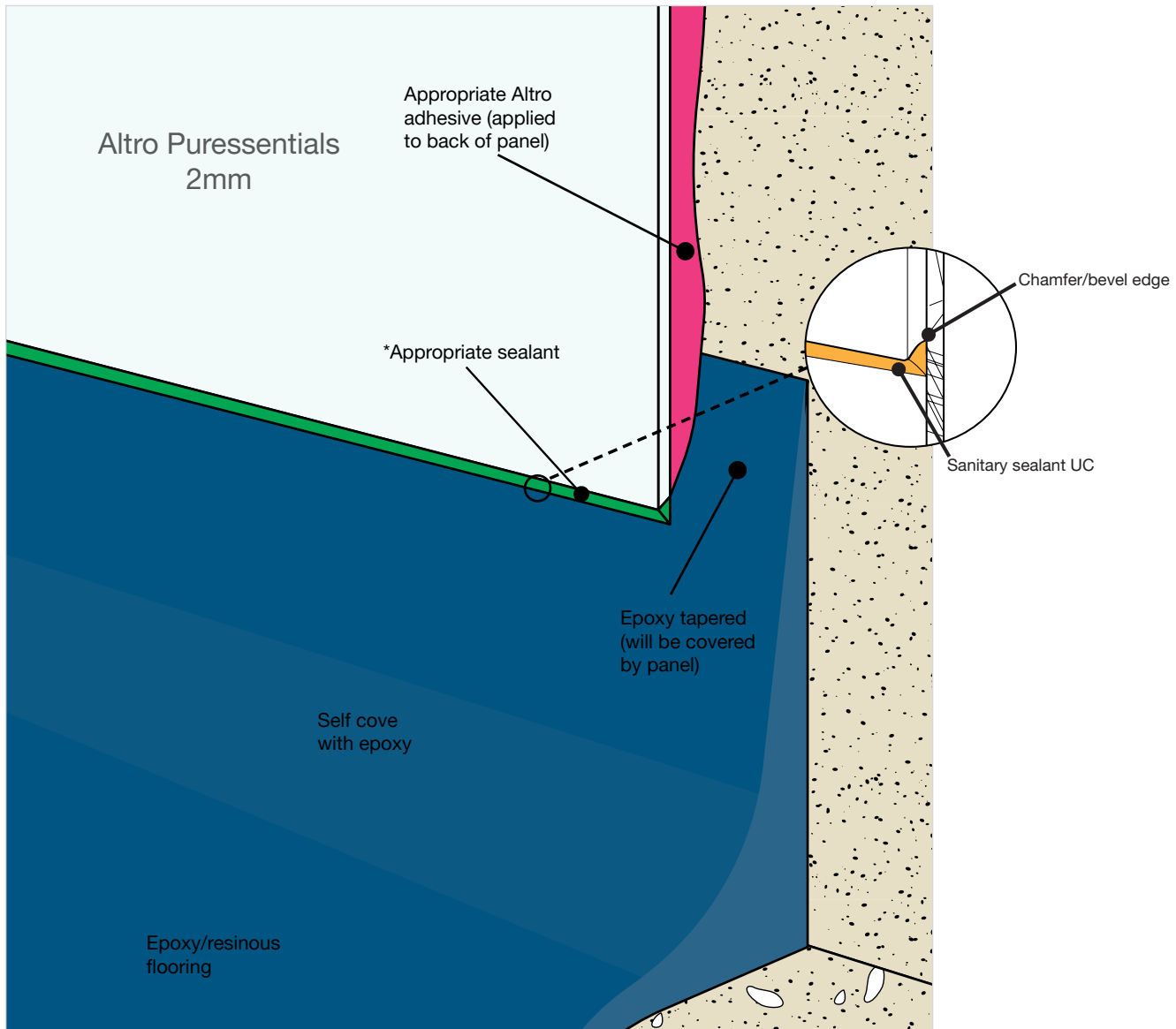
An overlap transition from floor to wall is our preferred installation method and is utilized in most installations. It is completed by installing the flooring 6" – 8" up the wall, dependent on cove size and installing the Altro Puresentials with a 2" overlap. The juncture is then finished with Altro Sanitary Sealant UC.



Note: All terminating edges of Altro Puresentials that are not being heat welded are to be Chamfered/Beveled on both front and back edges so as to remove any sharp edges and to allow the greatest surface area for the application of Altro Sanitary sealant UC.

*In behavioral and mental health facilities, tamper-resistant security sealant must be used per the manufacturers instructions. In other installations we recommend Altro sanitary sealant UC.

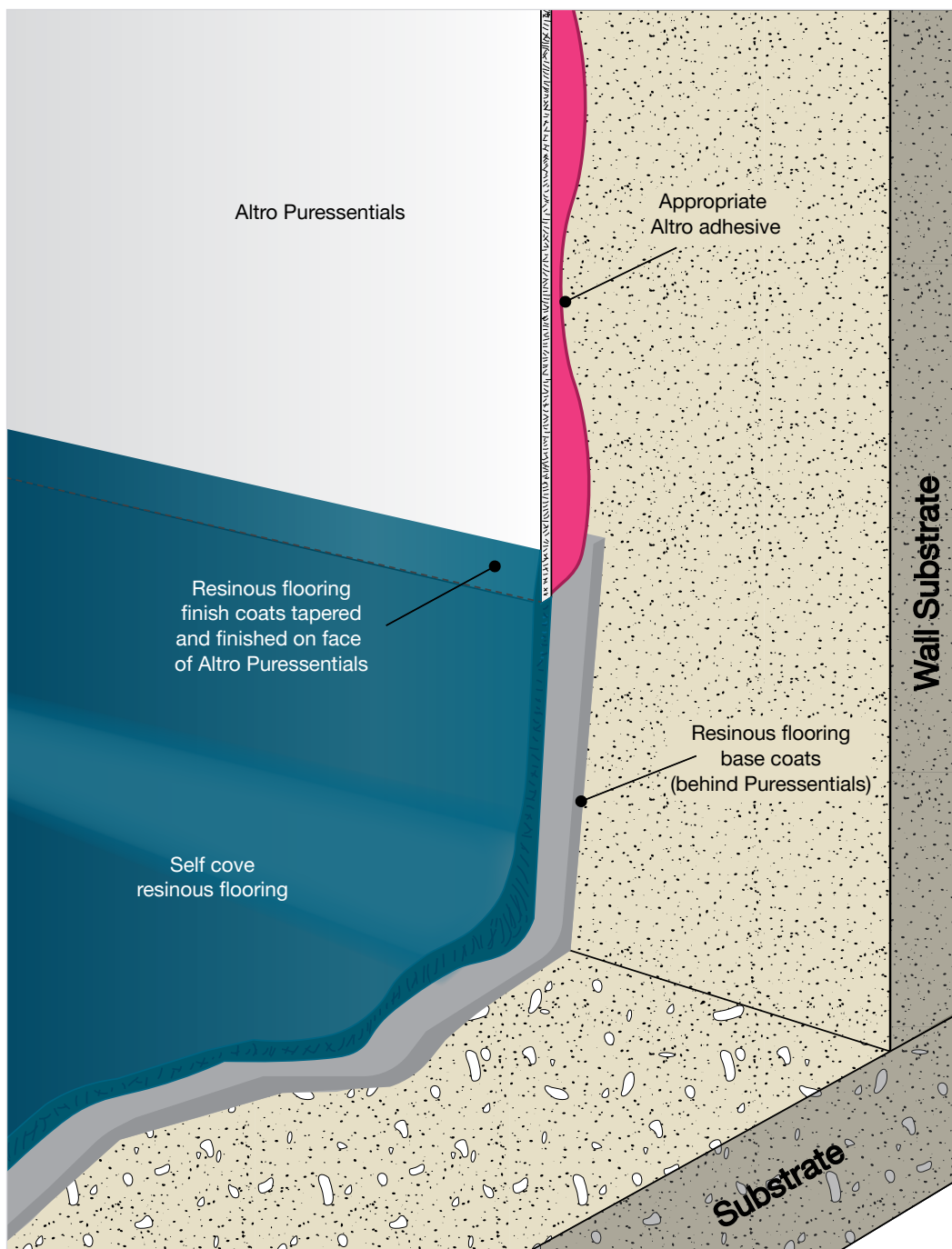
6.2 Installation over epoxy



Note: All terminating edges of Altro Puressentials that are not being heat welded are to be Chamfered/Beveled on both front and back edges so as to remove any sharp edges and to allow the greatest surface area for the application of Altro Sanitary sealant UC.

*In behavioral and mental health facilities, tamper-resistant security sealant must be used per the manufacturers instructions. In other installations we recommend Altro sanitary sealant UC.

Notes



Note: All terminating edges of Altro Puresentials that are not being heat welded are to be Chamfered/Beveled on both front and back edges so as to remove any sharp edges and to allow the greatest surface area for the application of Altro Sanitary sealant.

*In behavioral and mental health facilities, tamper-resistant security sealant must be used per the manufacturers instructions. In other installations we recommend Altro sanitary sealant UC.

6.3 Altro Puressentials installed first overlap detail

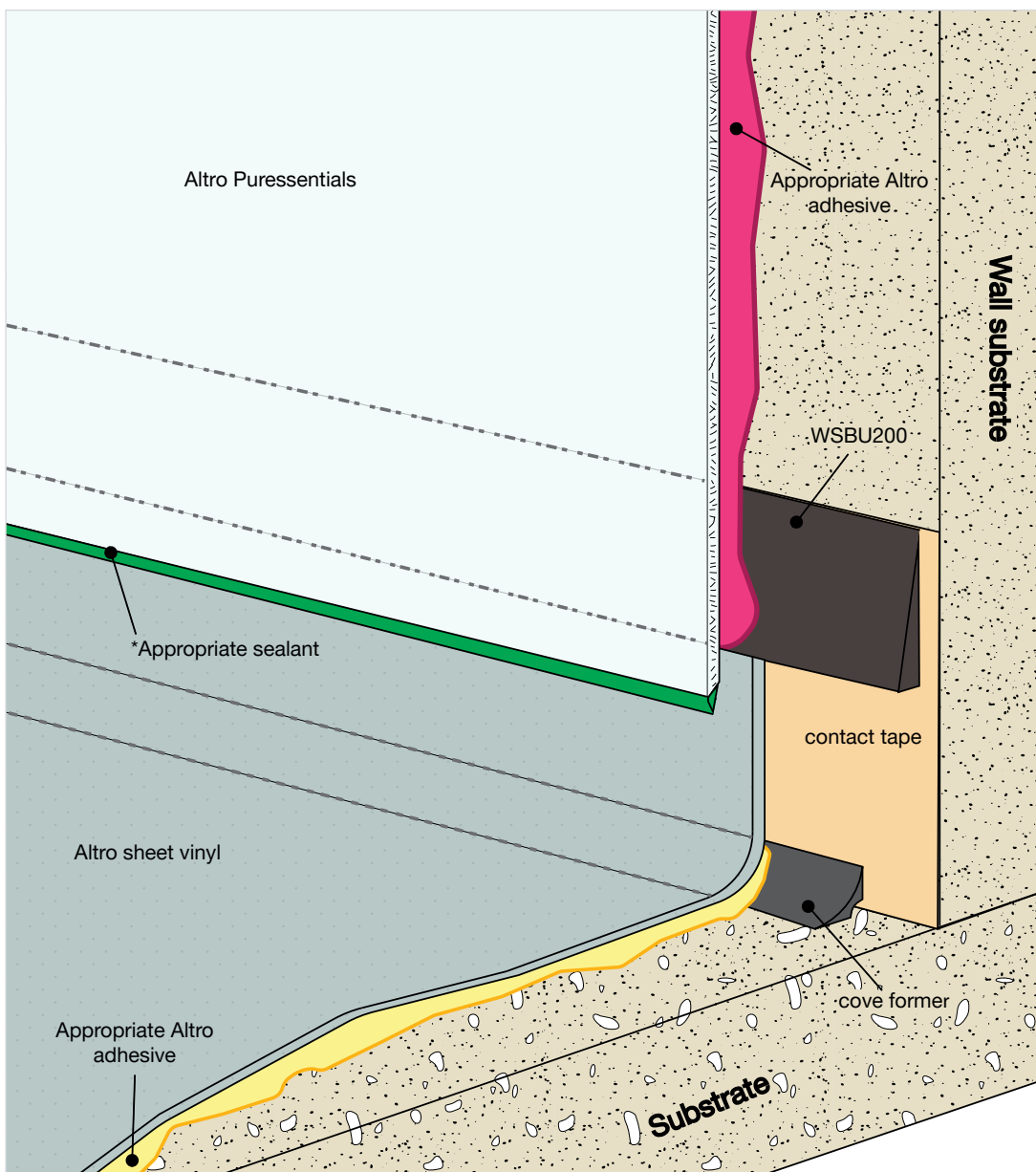
When an overlap detail is specified but the walls are to be installed before the flooring, a WSBU200 vinyl shim backer is utilized behind the wall panels. Doing so allows a gap behind the panel where the sheet vinyl can be inserted.

Install the WSBU200 to the wall continuously around the room only starting and stopping at the corners. The location is to be a minimum of 1" above where the bottom edge of the wall panel will finish.

Foam tape is to be installed at seams and on top of the WSBU200 but stop at the bottom edge. If heat welding is done prior to the flooring being installed and tucked up behind the panel, shims may need to be use at the bottom of the wall panels in order to properly heat weld the seams.

Please contact Altro technical services before proceeding.

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*In behavioral and mental health facilities, tamper-resistant security sealant must be used per the manufacturers instructions. In other installations we recommend Altro sanitary sealant UC.

Chapter 7

Additional details and maintenance

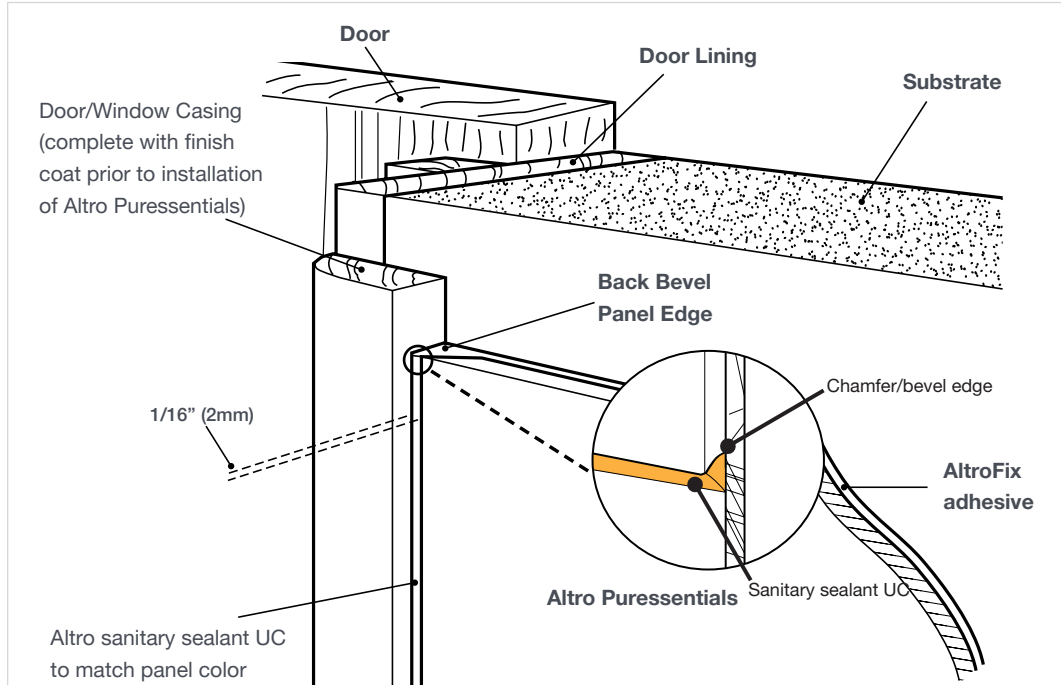


Topics

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7.1 Door, window and pipe installation

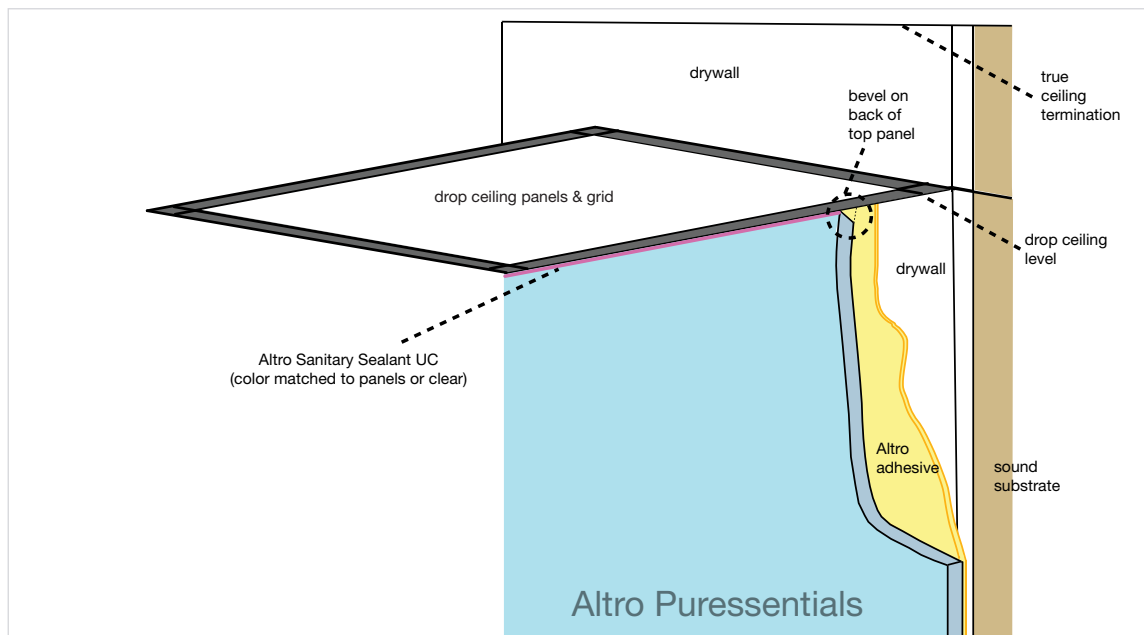
Altro Puresentials wall system sealed to door frame.



Note: All terminating edges of Altro Puresentials that are not being heat welded are to be Chamfered/Beveled on both front and back edges so as to remove any sharp edges and to allow the greatest surface area for the application of Altro Sanitary sealant.

7.2 Terminating Altro Puresentials at true ceiling wall intersection

Altro Puresentials installed over drywall using Altro W39 adhesive, terminating at true ceiling and sealed with Altro sanitary sealant UC at top of panel.



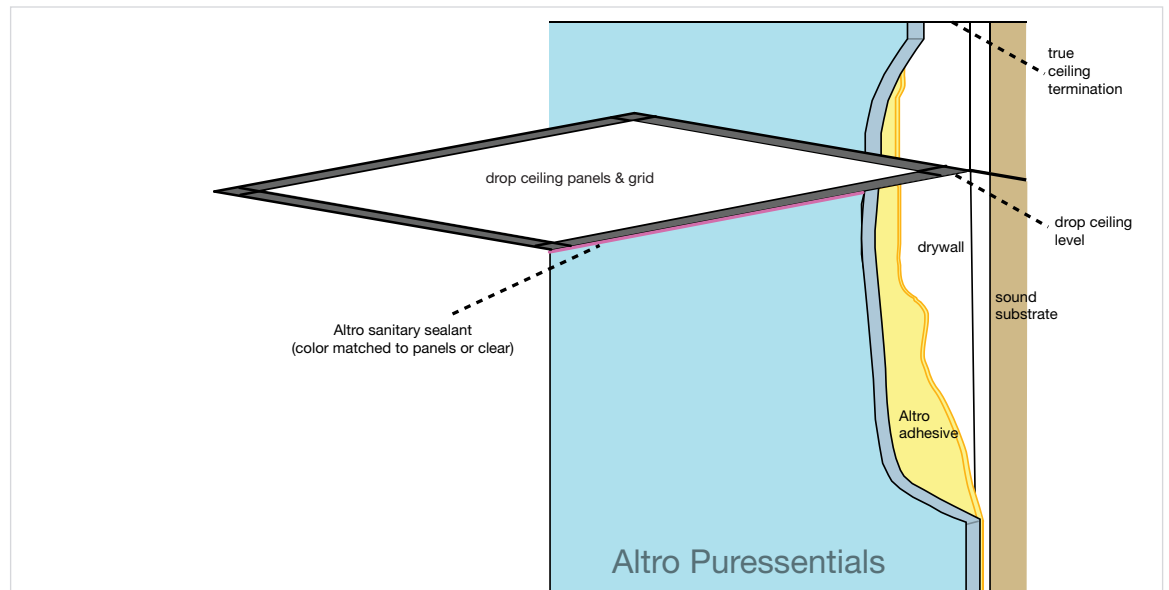
Notes

Altro Puressentials installed over drywall using Altro W39 adhesive, terminating at drop ceiling grid and sealed with Altro sanitary sealant at top of panel.



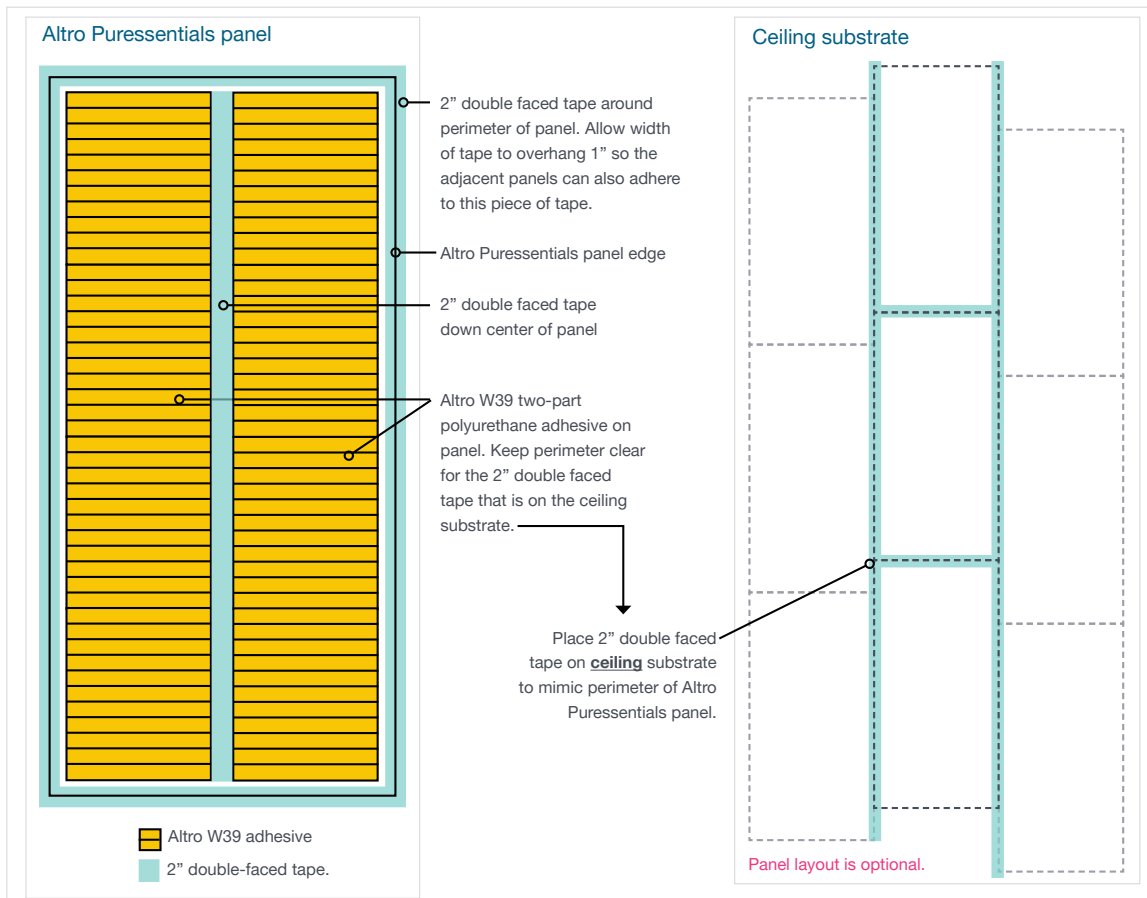
When this installation occurs the ceiling grid must be installed to allow for expansion and contraction. of the wall panel.

This can be achieved by first making a pilot hole slightly larger than the fastener through the panel and then fastening the ceiling grid to the substrate.



7.5 Adhering Altro Puresentials to the ceiling

Altro Puressentials can be installed on smooth ceiling substrate. Altro W39 two part polyurethane adhesive and 2" double sided foam tape must be used. Refer detail below for adhesive and tape placement. Always apply AltroFix 75 Spray tape adhesive promoter to ceiling where tape is to come in contact with ceiling. Follow appropriate instructions for heat welding or hot gluing the seams.



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[illegible]

7.6 Altro Puressentials maintenance

Initial cleaning

Once all panels and joints are installed, remove the protective film and clean all surfaces down with an antistatic solution, or anti-static wipes. This is required as the panel may have static build up, and any dust in the atmosphere will adhere to the surface of the panel. Continue with regular maintenance as described below.

Regular maintenance

- Altro Puressentials can be cleaned with a diluted soap/detergent solution, such as PVC wall cleaner (for stubborn stains) or AltroClean 44 (degreaser).
- Use a lint-free, non-woven wipe or a polyester knit wipe. Both are extremely low in particle generation.
- When cleaning Altro Puressentials, we recommend the temperature of water does not exceed 160°F (71°C).
- Pressure cleaning with hot water may be used with the pressure nozzle, a minimum of 2 feet (600mm) away from the surface.
- To reduce the build-up of static, cleaning the panels with an anti-static solution or anti-static wipes is recommended.
- Some cleaning agents may adversely affect Altro Puressentials. See Altro's chemical resistance chart for reactions to common chemicals at www.altro.com/techdocs.

Maintenance products available to purchase



P/N: ALW A859/325
Altro PVC Cleaner



P/N: ALW A809/05
Anti-Static Solution
5 Liters



P/N: ASF 44 Cleaner
Altro Clean 44 - 5 Liters
1.3 Gallons



P/N: ALW A809
Anti-Static Solution in spray bottle
500ml

