



the future is safer with altro

Installation guidance

Altro Safety Flooring

Nov 2016

Key points to consider when installing Altro safety flooring

- **Ensure that the correct product is selected for the area type**
- **Ensure that the correct adhesive is selected for the area type**
- **Always hot weld the flooring joints ensuring that the correct tools are used for grooving, hot welding and trimming**
- **Always leave the floor suitably protected from other trades using a suitable non-staining floor protecting covering**

Storage & Handling

Altro safety floor covering must be stored in dry conditions and stood on end on a level floor. Safety precautions should be taken to ensure rolls cannot accidentally fall. If stacked horizontally there is a risk of "flattened areas" developing which can lead to installation difficulties. Altro safety flooring should be laid in accordance with Australian Standard AS 1884-2012.

The material should be checked for any possible faults prior to laying. Please note that if material has been cut, fitted or installed, NO ADJUSTMENTS or CLAIMS (if any) will be considered due to failure to comply with any of the following.

The material should be stored for approximately 24 hours at a room temperature of not below 15°C.

When laying, the area should be at a steady temperature of between 18°C and 30°C for at least 48 hours prior to, during and for at least 24 hours after completion. The material should be cut into lengths and laid loose for conditioning before adhering to the subfloor for a minimum of 2 hours.

Check that the material is the correct colour, pattern and quantity ordered by the customer.

Ensure that the material used in any one area is from the same manufacturing batch and laid in roll numer-

ical sequential order. Install material in same direction – reverse if necessary to obtain shade match.

Note: loose lay out material. Before adhering, step back and inspect the overall effect. If acceptable continue to install. If shade match cannot be achieved, do not install. Contact your Altro consultant. Do not cut or install any damaged or defective material unless accepted, agreed and approved by all parties concerned.

Subfloor

The subfloor must confirm with the requirements of AS 1884-2012.

Adhesive

For the correct choice of Altrofix adhesive, refer to the Altro Adhesives data sheets.

WARNING: Many of the Altro safety floor covering range incorporate a coloured quartz aggregate in the material. Eye protection should be used and care taken during cutting and grooving procedures.

Laying

Altro safety flooring can be straight laid or used in conjunction with feather edge skirtings. The materials can also be self-coved. In areas that are subject to moisture spillage, the complete installation must be sealed i.e.: the use of conventional clamping or weld-

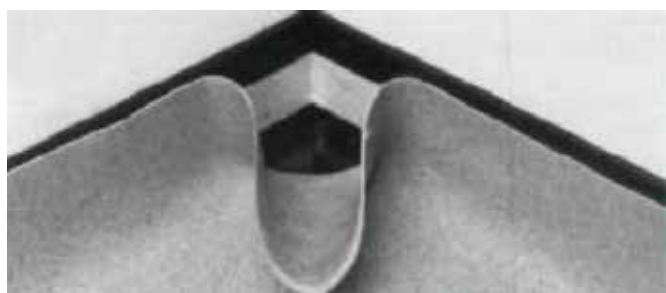
ing type drains, channels and access covers, sealing of pipes, toilet pans, door frames etc. and the use of appropriate sealing methods between the junction of the Altro flooring and the wall covering or other floor surfaces. Refer to the Altro detail diagram sheet of the appropriate finishes.

Once the material has been conditioned, the selvage edge should be removed. The joints can either be cut in before or after applying the adhesive. This will depend upon the preference of the flooring installer, however, it should be borne in mind that in large installations if the joints and/or the perimeter have been cut in, any movement of the sheet whilst placing it into the adhesive will create a problem.

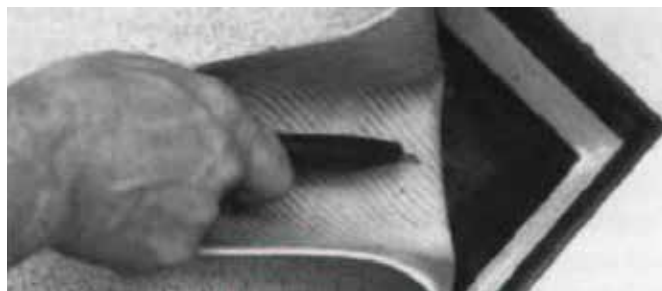
Turn the material back and apply the adhesive to the subfloor in accordance with the adhesive manufacturer's instructions.

Check the applied adhesive for contamination and for signs of off gassing. When the adhesive is ready to receive the floor covering, after the specified open time, which can depend upon the subfloor, porosity and atmosphere conditions, ensure the back of the material is clean and free of debris and place the floor covering back into the adhesive pushing out any air bubbles. Remove any excess adhesive immediately using a damp cloth and depending upon the adhesive used (refer to Altro Adhesives) roll the whole area with a floor roller both width ways and length ways. Weights such as sand bags must be placed over areas such as seams or around drains where pressure is required to keep the back of the Altro floor covering in firm contact with the adhesive until the adhesive has set. All seams shall be fitted nett; and not pressure fitted or gaped. All joints within the sheet must be cut in, grooved and hot welded.

Forming an internal corner



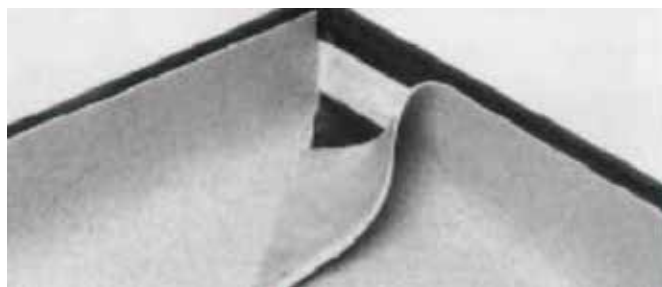
1. Once the main flooring is laid and adhered, push the flooring into the internal angle as far as possible



2. Make a cut from the base out to the top of the flooring in line with the mitre.



3. Fold in one side of the mitre and carefully cut off the surplus material.



4. This completes the first part of the mitre.

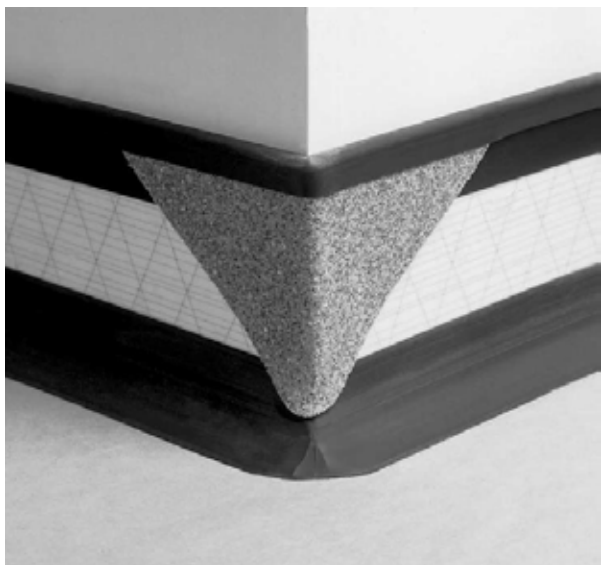


5. Fold in the second side and carefully cut in to

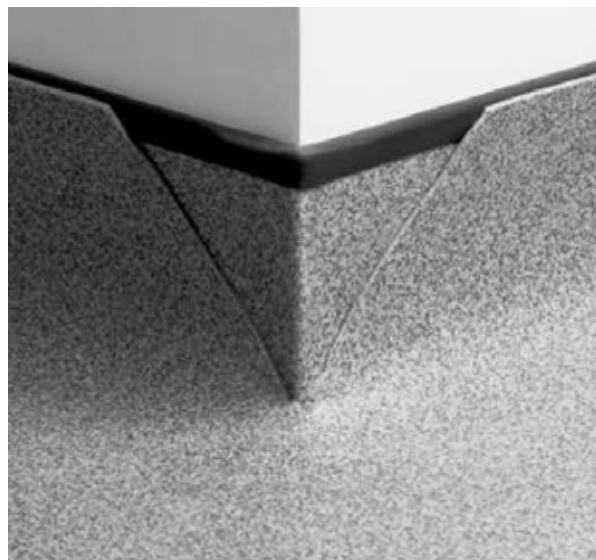


6. Adhere and hot-weld the joint.

Forming an external corner



1. Butterfly corner. Fit the fill piece up under the lip of the cap strip and press into place. Adhere with contact adhesive or contact tape.



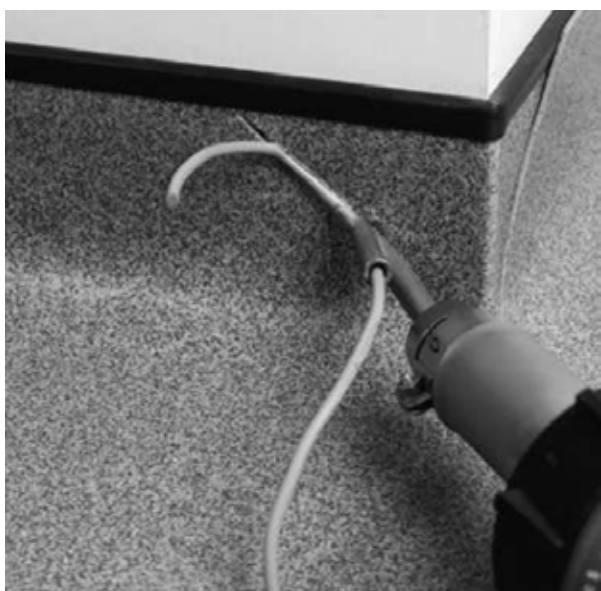
2. Once the butterfly corner fill is in place, the adhesive may be spread and the field material laid into position. The relief cuts must be made so the field material overlaps both edges and the bottom point of the butterfly corner fill.



3. Using an Altro hook blade or concave blade trim the field material to fit net to the perimeter of the butterfly corner fill. Ensure the field material is held firmly down against the cove former while making the final cut.



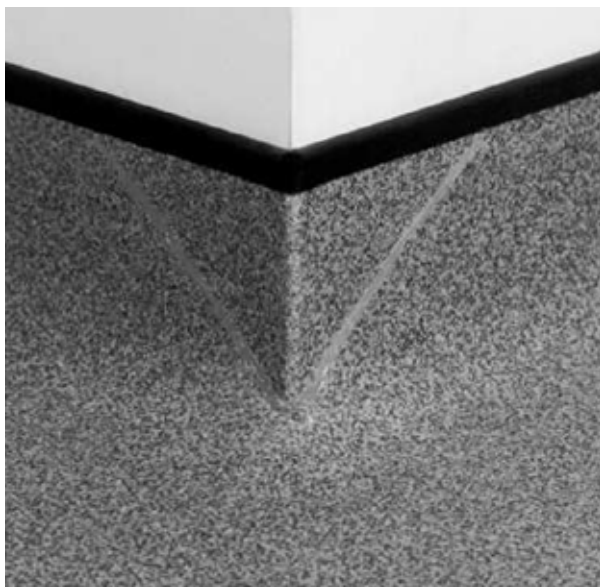
4. Grooving



5. Hot welding



6. Trimming



7. Heat weld to complete the section.

Grooving

A 3mm groove must be cut evenly along each floor joint (except internal/external mitres) using a hand or automatic rotary grooving tool. Use of the special Altro automatic grooving blades is recommended as standard blades are quickly destroyed when used on safety flooring. The depth of the groove shall be to a minimum of $\frac{1}{2}$ to maximum of $\frac{2}{3}$ of the thickness of the Altro Flooring.

Forming a hot welded joint

After cutting in and adhering the sheet vinyl flooring, all joints and mitres must be welded with Altro Weldrod™, using a hot air welding gun fitted with a 5mm high speed welding nozzle. After a long period of use, the filter of the welding gun may become clogged with debris. This must be kept clear to reach the optimum weld temperature. Where possible, allow 12 hours between laying and welding, to ensure the adhesive is properly set.

Welding

The Internal and external mitres on the covered sections should be welded first. Turn the speed nozzle at the end of the welding gun to the up position, for easier starting. Once these are finished, turn the nozzle to the down position to hot weld the grooved floor joints. Insert the weld rod into the speed nozzle until it pokes out the tip and immediately insert the weld rod into the groove. Hold the weld gun at the proper angle

so the tip is parallel with the material. Draw the gun backwards with gentle downward pressure on the tip fusing the weld rod into the groove. Watch the welding process at the junction of the welding rod and the material. A good weld will result when the weld rod and the material form a very slight peak either side of the weld rod. This peak will be trimmed off later. If moving too fast, slight peaking will not occur. If too slow, the peak of the material will burn. Be careful not to burn the material, as it is difficult to repair. Please contact Altro for specific welding advice for products incorporating Altro Easyclean Maxis™ Technology and Altro Easyclean Maxis PUR™ Technology.

Finishing

Once the weld has cooled and set, trim the weld flush with the surface in two passes. For the first pass use the spatula knife and trimming plate. The second pass should be flush with the surface using the spatula knife. For external mitres use the square router blade and for internal mitres the round router blade. For Altro T20™ safety flooring, the Altro T20 chisel has been specially designed for removal of surplus weld rod. For details on equipment and tools, refer to Altro's Recommended Equipment and Tools data sheet. For colours of Altro Weld rod to complement sheet vinyl flooring, refer to Altro's AltroMastic 100/Weldrod data sheet.