

# INSTALLATION PROCEDURES



## Homogeneous Commercial Tiles

**IMPORTANT!**  
**BEFORE PROCEEDING WITH INSTALLATION, BE SURE TO READ  
THE ESTRIE FLOOR PREPARATION PROCEDURES!**

### Adhesive Systems

**General:** The use of the proper adhesive is critical to a successful end result. Use the following adhesive guidelines. However, if there is any doubt on which adhesive to use contact Estrie or their distributor for additional information.

- Dry slab on grade - check for possible moisture problems and ensure that moisture readings are within acceptable levels. Use #530SF or #444 adhesive.
- Dry slab above grade (suspended) - use #530SF or #444 adhesive. Check moisture readings.
- Dry slab below grade - check for possible moisture problems and ensure that moisture readings are within acceptable levels. Use #530SF adhesives. #444 adhesive can be used in these areas if moisture readings are within the specified tolerances and will not be exceeded in the future.

### **Procedures for Installing InterFuse tiles over Terrazzo, Ceramic, Natural/Agglomerated Marble or Granite:**

- Following the curing of the Ultra/Plan install the InterFuse tiles using #530SF and AD-22 adhesive in accordance with the installation procedures.

### **Procedure for Installing InterFuse tiles over Metal Substrates:**

- For non-porous substrates such as stainless steel and galvanized steel use #530SF adhesive in accordance with the installation procedures.

### #530SF Polyurethane Adhesives

#### **Description:**

#530SF is a polyurethane-based adhesive that is cream when mixed. It is a two part component adhesives that when mixed becomes a pasty consistency. It is formulated to bond InterFuse tiles where a high performance installation is required.

#### **Limitations:**

1. Protect adhesives from freezing in transit and storage. If frozen, allow to return to room temperature without stirring.
2. Do not use when the substrate temperature is below 15°C (59°F) or above 30°C (86°F).
3. For interior installations only.

#### **Directions:**

- Remove the lid of part A and stir using a mechanical mixer.
- Remove the lid of part B and pour all the contents of part B into the container of part A. Use a rubber spatula to remove all of the part B from the container. Thoroughly mix both part A and part B together. The use of a mechanical mixer is required to ensure proper mixing. Inadequate mixing will cause bond failure. Avoid foaming the adhesive.

#### **Application:**

- Pour the full amount of the mixed adhesive onto the floor immediately after mixing and spread with 1.6 x 1.6 x 1.6 mm (1/16" x 1/16" x 1/16") U-notched trowel.

**Note:** Do not leave mixed polyurethane adhesive in original can; the heat generated by this chemical mixture reduces the open time of the adhesive.

- After spreading the adhesive, lay the tile immediately into the adhesive (do not force the tiles together tightly, rather place them so that seams are just touching). Take care to use kneeling boards or work off the tile



# ESTRIE INSTALLATION PROCEDURES



## Homogeneous Commercial Tiles

whenever possible. Remove excessive adhesive from the surface of tile with a cloth moistened with water, denatured ethyl alcohol or isopropyl alcohol (rubbing alcohol) while adhesive is wet.

- Open time of adhesive will vary depending on site conditions (i.e. temperature, humidity). The adhesive is still workable if it is wet and transfers to the fingers when touched. The installer should observe adhesive transfer to the back of the tile prior to and following cross rolling with a 70 Kg (150 pound) sectional roller. The floor **MUST** be rolled prior to adhesive hardening. A second rolling must be done 2 to 3 hours after the first rolling.

### **Clean-Up:**

- Clean excess adhesive off the tile and tools promptly using denatured ethyl alcohol or isopropyl alcohol (rubbing alcohol) while adhesive is wet.  
**Note:** Polyurethane adhesive cannot be removed after it has set.

### **Caution:**

- Keep from freezing.

### **Coverage:**

- #530SF up to 15 sq m per 3.79 liter unit (163 sq ft per US gal).

### **#444 Acrylic/Latex Adhesive**

#### **Description:**

#444 adhesive is a water-based acrylic polymer, light beige in colour and of syrupy consistency. It is formulated to bond InterFuse tiles over concrete or plywood.

#### **Limitations:**

1. Protect from freezing in transit and storage. If frozen, allow to return to room temperature without stirring.
2. Do not install when the substrate temperature is below 15°C (59°F) or above 30°C (86°F).
3. For interior installations only.

#### **Directions:**

- Remove the lid from the container and apply directly from the container.

#### **Application:**

- Using a 1.6 x 1.6 x 1.6 mm (1/16" x 1/16" x 1/16") U-notched trowel, apply the adhesive evenly to the floor.
- Start laying the tile after 10 minutes allowing the moisture to flash off. Laying of the tiles must start no later than 20 minutes. After the adhesive has been allowed to flash off, lay the tile into the adhesive (do not force the tiles together tightly, rather place them so that seams are just touching). Take care to use kneeling boards or work off the tile whenever possible. The adhesive is still workable if it is wet and transfers to the fingers when touched. Ensure that the adhesive has transferred to the back of the tile by lifting the corners.
- Avoid trapping air bubbles by cross rolling the floor with a 70 Kg (150 pound) sectional roller.

#### **Clean-Up:**

- Clean excess adhesive off the tile and tools using soap and water. Dry adhesive is more difficult to remove.

#### **Coverage:**

- Up to 15 sq m per 3.79 liter unit (163 sq ft per US gal).

#### **Caution:**

- Keep from freezing.



# INSTALLATION PROCEDURES



## Homogeneous Commercial Tiles

### #AD-42 Adhesive

#### **Description:**

#AD-42 is a non-flammable adhesive specially formulated to resist plasticizer migration and is ideal for the installation of InterFuse tiles.

#### **Directions:**

- Remove the lid from the container and apply directly from the container.

#### **Application:**

- Using a 1.6 x 1.6 x 1.6 mm (1/16" x 1/16" x 1/16") U-notched trowel, apply the adhesive evenly to the floor.
- Start laying the tile after 10 minutes allowing the moisture to flash off. Laying of the tiles must start no later than 20 minutes. After the adhesive has been allowed to flash off, lay the tile into the adhesive (do not force the tiles together tightly, rather place them so that seams are just touching). Take care to use kneeling boards or work off the tile whenever possible. The adhesive is still workable if it is wet and transfers to the fingers when touched. Ensure that the adhesive has transferred to the back of the tile by lifting the corners.
- Avoid trapping air bubbles by cross rolling the floor with a 70 Kg (150 pound) sectional roller.

#### **Clean-Up:**

- Clean excess adhesive on the tile and tools using warm soapy water. Clean dried adhesive using mineral spirits.

#### **Caution:**

- Keep from freezing.

#### **Coverage:**

- Up to 19 sq m per 3.79 liters (200 sq ft per U.S. gal).

### **IMPORTANT!!! FLOOR PROTECTION**

Following installation and cleanup of the tile, protect the tile from other subtrades by laying sheets of brown Kraft paper over the tile, and then lay plywood sheets.

### **CURING TIMES**

Site conditions can greatly affect curing times of the adhesives. Visually check the tile installation to make sure curing of the adhesive is happening by pulling back the corner of the tile. If it will not peel back easily the curing process is underway. This must not be attempted prior to 24 hours following installation.

We recommend the following adhesive curing guidelines:

- Up to 24 hours following installation – no traffic.
- Between 24 and 48 hours – light traffic
- After 72 hours – moderate to heavy traffic, placement of furniture and rolling traffic.

### **HEAT WELDING PROCEDURE**

#### **a) Grooving**

Ensuring that the adhesive has set, proceed to groove the seams by using a power or hand grooving tool. Adjust the grooving tool to cut a V-shaped groove, 2/3 of the tile thickness. Proceed to trim and weld all the tiles in one direction, then repeat this procedure in the other direction.

#### **b) Welding**

Remove all dust and shaving from the area by vacuuming the tile and at the grooved areas. Using a heat welding gun insert the welding rod into the welding nozzle and preheat the welding gun. Temperature will vary depending on the welding speed. We recommend that you conduct a trial weld on a scrap piece of material.



# ESTRIE INSTALLATION PROCEDURES



## Homogeneous Commercial Tiles

Working with seams in one direction at a time, cut a V-groove in the installed bead at the seam intersection and then complete the procedure in the cross direction.

### c) Finishing

- Allow the weld to cool, remove the excess welding bead using a **sharp** crescent knife and a trimming plate/guide.
- Make the finishing trim using the crescent knife without the use of the trimming plate/guide.

**NOTE: If the welding rod is not allowed to completely cool before trimming, shrinkage of the welding can occur resulting in a concave joint finish. Always use a sharp crescent knife.**

### FORMING AND INSTALLING FLASH COVING PROCEDURE

- a) Before proceeding ensure that the floor tile is fully set and that the edge of the installed tile is a minimum of 6" from the wall.
- b) Install cove forming fillet strip along the full length of the wall. Note: The fillet strip is to be resting fully on the floor where the wall and floor intersect. Depending on the type of fillet strip they can be fixed into position by either using adhesive or nails.
- c) Place the edge of the tile to be formed on the edge of the previously installed floor tile. Using a heat gun and applying even heat along the full length of the piece, form the cove to the desired radius. Allow the formed piece to cool in place. Continue to form the remaining coves.
- d) Remove the cooled pieces and apply the adhesive. Install the preformed cove piece into the adhesive and under the cove cap. Gently roll with a hand roller. Make any final trims and adjustments at this point. Apply gentle uniform heat again along the length of the cove to form the final fit and then hand roll.
- e) Clean any excessive adhesive using the recommended cleaner. Protect the installation from being disturbed until the adhesive has set up.

Note:

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