

Roppe Recoil Fitness Rubber Flooring



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Installation

6.1 General Preparation and Conditioning

First read Roppe Recoil Fitness Flooring literature concerning the product description, product limitations, product installation, adhesive information, product maintenance, and warranty before installing the flooring. Inspect all material for proper type and color. Conduct the proper moisture emission and pH testing on the substrate. Proceed with the installation only when the conditions are proper and correct. A bond test using Roppe 635 One-Part Solvent-Free Moisture-Cured Adhesive throughout the area approximately 50 feet apart should be performed at least one week prior to the scheduled installation to assure the surface is suitable. After 72 hours, there should be an unusual amount of force to lift the flooring from the substrate with adhesive bonding to the tile and the substrate. All materials are to be delivered to the installation location in its original packaging with labels intact. Store products in a dry area protected from the weather on a smooth, flat, dry surface with temperatures maintained between 65° F (19°C) and 85°F (30°C). Remove all plastic wrapping and strapping from the pallets in the installation area at least 48 hours prior to installation. For proper acclimatization, remove the flooring from the packaging and stack tiles evenly no more than 18" high. Rolls must be unrolled and allowed to relax for 48 hours before installing. The installation area, substrate, tile, adhesive are to be maintained between 65° F (19°C) and 85°F (30°C) for at least 48 hours before installation, during installation, and 48 hours after the installation. Maintain room temperatures between 65° F (19°C) and 85°F (30°C) thereafter. Do not install flooring outdoors if temperature ranges drop below 65° F (19°C) or above 85°F (30°C). Flooring should be loose laid in the room or area prior to spreading of adhesive to determine the proper layout to assure the best overall appearance and to minimize small border cuts. Close the area to traffic during installation. Install flooring and accessories after other finishing operations, including painting, have been completed. If the back of the flooring becomes soiled prior to installation, clean with a soft cloth dampened with a mild soap and water solution, rinse, let dry. Flooring may be installed over radiant heated floors, provided the surface temperature is maintained between 65° F (19°C) and 85° F (30°C). If radiant-heated floors have cooled after installation, a gradual increase in temperature is required to prevent adhesive bond from being adversely affected. **Notice:** If the flooring is not laid in the same direction, the reflection of light will cause an optical illusion, making the surface appear to be different shades. When installing single/multiple rolls, square tile or inter-locking tile, always verify color matching prior to installing. **Warning:** Follow all local, state, and federal standards and practices for the proper removal and disposal of flooring, adhesives, or other materials. Follow all local, state, federal, and manufacturer's safety standards for the use of all products and equipment.

6.2 Subfloor/Substrate Inspection and Preparation

6.2.1 All subfloors/substrates must be inspected prior to installation. All substrates must be clean, smooth, permanently dry, flat, and structurally sound. The substrate must be free of moisture, dust, sealers, paint, curing compounds, parting agents, residual adhesives, adhesive removers, hardeners, resinous compounds, solvents, wax, oil, grease, asphalt, gypsum compounds, alkaline salts, excessive



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carbonation or laitance, mold, mildew, any other extraneous coatings, films, materials and all other foreign matter which might interfere/restrict proper adhesive bonding. DO NOT use sweeping compounds, solvents, citrus adhesive removers, or acid etching to clean the substrate. DO NOT install flooring over gypsum-based or plaster based leveling or patching compounds. DO NOT install new floor covering over old floor covering, as the old floor covering may not be adequately bonded, hide possible structural defects, or cause plasticizer migration into the new flooring. However, 3/8" (9.00mm) and 1/2" (12.00mm) Inter-locking Tile can be loose laid over smooth and well bonded resilient flooring, ceramic tile, solid or engineered wood flooring, metal and terrazzo. In renovation or remodel work, remove all existing *adhesive residue so that 100% of the overall area of the original subfloor/substrate is exposed. Follow The Resilient Floor Covering Institute's (RFCI) "Recommended Work Practice for Removal of Existing Floor Covering and Adhesive, and all applicable industry, local, state, and federal standards. Care must be taken to analyze the conditions and correct any problems prior to installation. Follow the manufacturer's recommendations for any patching or underlayment materials, excluding gypsum based or plaster based levelers or patching compounds.

* Some previous manufactured asphaltic "cutback" contained asbestos. For removal instructions, refer to the Resilient Floor Covering Institute's publication "Recommended Work Practices for Removal of Resilient Floor Covering".

6.2 Subfloor/Substrate Inspection and Preparation

6.2.1 All subfloors/substrates must be inspected prior to installation. All substrates must be clean, smooth, permanently dry, flat, and structurally sound. The substrate must be free of moisture, dust, sealers, paint, primers, curing compounds, parting agents, residual adhesives, adhesive removers, hardeners, resinous compounds, solvents, wax, oil, grease, asphalt, gypsum compounds, alkaline salts, excessive carbonation or laitance, mold, mildew, any other extraneous coatings, films, materials and all other foreign matter which might interfere/restrict proper adhesive bonding. DO NOT use sweeping compounds, solvents, citrus adhesive removers, or acid etching to clean the substrate. DO NOT install flooring over gypsum-based or plaster based leveling or patching compounds. DO NOT install new floor covering over old floor covering, as the old floor covering may not be adequately bonded, hide possible structural defects, or cause plasticizer migration into the new flooring. In renovation or remodel work, remove all existing *adhesive residue so that 100% of the overall area of the original subfloor/substrate is exposed. Follow The Resilient Floor Covering Institute's (RFCI) "Recommended Work Practice for Removal of Existing Floor Covering and Adhesive, and all applicable industry, local, state, and federal standards. Care must be taken to analyze the conditions and correct any problems prior to installation. Follow the manufacturer's recommendations for any patching or underlayment materials, excluding gypsum based or plaster based levelers or patching compounds.

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6.2.2 Concrete substrates on all Grade Levels must be tested in accordance with ASTM F 1869 Standard Test Method for Measuring Moisture Vapor Emission Rate of Concrete Subfloor Using



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Anhydrous Calcium Chloride or ASTM F 2170 Standard Test Method for Determining Relative Humidity in Concrete Floor Slabs using *in situ* Probes to quantitatively determine the amount of moisture vapor emission at least one week prior to the installation. **Caution:** ASTM F 1869 or ASTM F 2170 tests cannot predict long-term moisture conditions of concrete slabs. Moisture testing only indicates moisture conditions at the time the tests are performed. Before conducting ASTM F 1869 or ASTM F 2170 test, the installation area must be maintained between for 65°F (19°C) and 85°F (30°C) or at least 48 hours prior to testing, during testing and thereafter. In addition, the concrete's temperature range must also be identical to that of the installation area. Conduct three tests for the first 1,000 sq. ft. and one additional test for each 1,000 sq. ft. or fraction thereof per grade level (on, below or above grade). The Vapor Emission Rate shall not exceed 5.0 lbs and Relative Humidity Test shall not exceed 75% when using ROP635 or ROP535U (recommended around ice skating rinks). A pH test must be performed to test for excessive alkalinity using a pH pencil or litmus paper and deionized water. A scaly, sandy, or powdery surface is an indication of some form of contaminant, usually excessive alkalis or an alkali-silica residue. A pH reading higher than 8 is an indication of a potential problem and the concrete must be neutralized by rinsing with clear water. Apply clear water with a mop and allow to dry. Re-rinse with clear water, allow to dry and retest to ensure pH level is within acceptable range of 5 to 8 on the pH scale. Continue to neutralize until the pH level is acceptable. The testing of concrete for alkalinity indicates the degree of alkalinity only at the time the test is conducted, and cannot be used to predict long-term conditions. Moisture and alkali salts in the concrete can cause the following problems after installation: adhesive deterioration, bumps, ridges, bubbles, discoloration, mold, mildew, bacteria growth, efflorescence, tile shifting, tile releasing, tile peaking, or sheet seam curling. DO NOT install over burnished (slick troweled) concrete to avoid adhesive and underlayment patch or self-leveling bonding problems due to the non-porosity of the concrete finish. Corrective measures such as bead blasting (shot blasting) or scarifying must be performed prior to installation. The concrete slab must be of good quality, standard density concrete with low water/cement ratios consistent with placing and finishing requirements, having a maximum slump of 4", a minimum compressive strength of 3500 psi, and following the recommendations of ACI Standard 302.1R-96 for class 2 or call 4 floors and the Portland Cement Association's recommendations for slabs on ground. Joints such as expansion joints, contraction joints, isolation joints, saw cuts, control joints, grooves or other moving joints shall not be filled with patching compound or covered with resilient flooring. Expansion joint covers designed for use with resilient flooring should be used. Any non-moving surface cracks, depressions, and other irregularities shall be filled and smoothed with a high quality grade Portland cement-based, water resistant, non-shrinking, non-staining, mildew resistant, alkali resistant underlayment having a minimum compressive strength of 3500 psi after 28 days. Some underlayments may fail under excessive weight; an epoxy caulking compound may be required for certain repairs. Mechanically cleaning the substrate by shot-blasting, scarifying, or sanding shall be performed to achieve a flat, smooth, clean surface to prevent irregularities, roughness, or other defects from telegraphing through the new resilient flooring. The surface of the concrete shall be flat to within the equivalent of 3/16" in 10 feet, as described in ACI 117R. The surface shall be cleaned of all loose material by scraping, brushing, vacuuming, or other methods, or a combination thereof, immediately before commencing installation of resilient flooring. Follow the proper safety practices during the preparation and



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installation. Follow the recommendations of the American Concrete Institute (ACI 302.1R, *Guide for Concrete Floor and Slab Construction*; ACI 360.R, *Design of Slabs on Grade*; ACI 223, *Standard Practice for the Use of Shrinkage-Compensating Concrete*); The American Society for Testing and Materials (ASTM F 710, *Standard Practice for Preparing Concrete Floors and Other Monolithic Floors to Receive Resilient Flooring*), and the American National Standards Institute (ANSI A157.1, *Recommended Practice for Concrete Floor and Slab Construction*) for the preparation of concrete to receive resilient flooring. Refer to 6.2.1.

6.2.3 Wood subfloors to be used as subfloors/substrates are to follow the procedures recommended for concrete in 6.2.1 and 6.2.2. Wood subfloors should be of double layer construction with a minimum thickness of 1". Crawl spaces underneath wood subfloors shall be in compliance with local building code ventilation practices and have clearance of at least 18" of cross-ventilated space between the ground level and joists. Wood joists should be spaced on no more than 16" centers. Place a moisture retarder; having a maximum rating of 1.0 perm, on the top of the ground under the wood subfloor overlapped at least 8" APA, The Engineered Wood Association, Underlayment Grade plywood, minimum 3/8" thick, with a fully sanded face is to be used. Use APA approved exterior grade plywood if finished floors are subjected to moisture. OSB, lauan, maranti, solid-core mahogany, waferboard, particleboard, chipboard, flakeboard, tempered hardboard, glass mesh mortar units or cementitious tile backer boards, sheathing-grade plywood, preservative-treated plywood, or fire-retardant treated plywood are not recommended as some manufacturers may use resins or other adhesives in the manufacturing of the product that may cause discoloration or staining of the flooring. Wood subfloor movement, flexing or instability will cause the flooring installed to release, buckle or become distorted. Do not proceed with the installation until corrective measures have been made. The warranties, performance, installation, and use are the responsibility of the manufacturer and/or contractor. DO NOT use plastic or resin filler to patch cracks. DO NOT use cement or rosin coated nails or staples or solvent-based construction adhesive to adhere the plywood. Installation on a sleeper, a wood subfloor system constructed over the top of concrete, is not recommended. Installation directly over Sturd-I-Floor panels is not recommended. All wood subfloors, single construction plywood floors, single and/or double tongue-and-groove strip floors, and wood plank floors must be prepared to receive resilient flooring in accordance with federal and industry standards. Follow the recommendations of the APA, The Engineered Wood Association, *Design/Construction Guide, Residential and Commercial*, and ASTM F 1482, *Standard Guide to Wood Underlayment Products Available for Use Under Resilient Flooring*, for the installation and proper construction of the panels to receive resilient flooring. It is the contractor's responsibility to determine if the subfloor is acceptable to receive the flooring. Refer to 6.2.1.

6.2.4 Cementitious Terrazzo and ceramic floors to be used as subfloors/substrates are to follow the procedures recommended for concrete in 6.2.2. Ceramic tile must be solidly adhered and all loose tiles must be removed and repaired or replaced. Ensure all glazed, sealed, smooth, and/or shiny surfaces are properly sanded and cleaned. Fill all grout lines and other irregularities with a manufacturer's recommended Portland cement-based underlayment with a minimum compressive strength of 3500 psi. The subfloor must be structurally sound. Inspect and ensure there is an adequate bond of the old flooring to the original substrate. Do not install



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over epoxy based terrazzo. Cementitious terrazzo must first be sanded to remove all finishes, and then cleaned. Conduct a bond test with adhesive to ensure a successful bond can be achieved before installing. Roppe **will not** warranty the product if there is a bond failure caused by problems relating to the old flooring. Refer to 6.2.1.

6.2.5 Metal floors to be used as subfloors/substrates must be thoroughly cleaned of any residue, oil, paint, primer, sealer, rust, and oxidation and properly sanded/grinded to provide a smooth, level, clean substrate to receive flooring. The flooring must be installed within 12 hours after sanding/grinding to prevent the metal from re-oxidizing. The metal subfloor shall be structurally sound. Deflection of the metal can cause a bond failure between the adhesive and the metal substrate. It is the contractor's responsibility to decide the feasibility of the application, and Roppe Corporation will not be held liable for failures caused by flexing or deterioration of metal substrates. On an extremely smooth, non-porous, metal substrate, a longer "tack up" may be required in order to prevent the adhesive from oozing between the seams. Refer to 6.2.1. Caution: The installation of flooring material will not prevent deterioration of metal substrates from occurring.

6.2.6 Highway Grade Asphalt: The installation of Recoil is recommended over highway grade asphalt only using ROP635 Moisture-Cured Polyurethane Adhesive only. The surface must be firm and level and free of grease, oil or other contaminants. The trowel size used to apply adhesive must be increased in size and depth in order to fill irregularities inherent with this type of porous substrate. Flooring Installer is responsible for determining correct trowel size to ensure a successful installation. In addition, at least a 90% transfer of adhesive to the tile's backing must be achieved. Any future separation, heaving etc. is the responsibility of the owner. Refer to 6.2.1.

6.2.7 Ice Skating Arenas (Off Ice Areas): When installing over approved substrates around the outside perimeter of ice skating rinks, ROP535U Two-Part Urethane Enhance Epoxy Adhesive must be used within six-feet around the perimeter. After installation has been completed around the perimeter, installer has option of either continuing with ROP535U or using ROP635. However, do not spread one adhesive over the other resulting in an adhesive failure. The substrates temperature range must be above 40°F (5° C) prior to applying ROP535U. Refer to 6.2.1.

6.3 Adhesive Application

6.3.1 Roppe 635 Solvent-Free Moisture-Cured Polyurethane Adhesive

Roppe 635 Solvent-Free Moisture-Cured Polyurethane Adhesive is a premium one-part adhesive designed for high performance installations of Roppe Recoil Fitness Flooring for indoor installations over porous, metal and other non-porous substrates, on grade, below grade, or above grade. ROP635 is also required for all outdoor installations of rolls, square & inter-locking tile over concrete only. In addition, ROP635 is required when installing 5/32" (4.00mm) or 1/4" (6.00mm) Inter-Locking Tile indoors to prevent tile from curling. Caution: Rain or exposure to moisture within 72 hours after installation may slow the set up time, and may



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adversely affect the adhesive resulting in an installation failure. Therefore, use extreme caution when installing outdoors. Roppe 635 has excellent plasticizer migration resistance and superior bond strength. Trowel size and spread rates will vary depending on porosity of the substrate and subfloor. For smooth or non-porous substrates (i.e.: metal, terrazzo & ceramic tile), a 1/16" x 1/16" x 1/16" square notch trowel is required and the approximate coverage is 90-100 square feet per gallon. ROP635 must be allowed to "tack-up" approximately 15 minutes over non-porous substrates (i.e.: metal, terrazzo, ceramic tile) and the flooring must be continuously rolled until the adhesive has dried completely. However, do not allow the adhesive to dry or "skin-over" or extend the "tack-up" time causing very little or no adhesive transfer to the backing of the flooring resulting in an installation failure. For installations over porous or rough substrates, a 3/32" x 3/32" x 3/32" "U" notch trowel is required (approx. coverage: 75-80 sq/ft per gallon) and the adhesive must be allowed to "tack-up" approximately 15 minutes before installing flooring. Coverage will vary according to the type of surface, surface texture, spreading angle, and adhesive temperature). ROP635 is a moisture cured polyurethane adhesive, therefore, the open time will vary depending on ambient temperature, substrate temperature and relative humidity. Typical working time is approximately 3 hours at 75°F (24°C) and 50% relative humidity. At elevated relative humidity levels, the working time can be shortened. Caution: If too much adhesive is applied, oozing at seams, air-bubbles, adhesive displacement, and telegraphing may occur along with adhesive displacement when the floor is rolled or exposed to rolling loads and lateral shear stress resulting in loose and unsightly areas. Therefore, test trowel size and flooring prior to installation to avoid the above noted potential problems. Adhesive is available in two gallon and five gallon pails. Shelf life is six-months @ 70°F (21°C) in an unopened container. Although the urethane components are non-freezing, the adhesive must be allowed to stabilize to ambient temperature before applying. Any adhesive on the surface of the tile/flooring or surrounding area must be removed immediately with a clean cloth dampened with denatured alcohol. DO NOT allow the adhesive to cure on the surface of the flooring, tools etc. A bond failure will occur if the adhesive is not properly applied. Label information is in English and Spanish. Read all of the product and safety information concerning the adhesive and any other chemicals or cleaning agents prior to installation.

Roppe 635 One-Part Solvent-Free Moisture-Cured Calculated VOC's according to California Rule #1168: 44 calculated grams per liter of coating.

6.3.2 Roppe 535U "Universal" Urethane Enhanced Epoxy Two-Part Adhesive

Roppe 535U "Universal" Urethane Enhanced Epoxy is a solvent-free, two-component adhesive for high performance interior installations of Recoil Fitness Rubber Flooring. ROP535U "Universal" is recommended for interior installations over properly prepared and recommended concrete, plywood, metal and other non-porous substrates, on grade, below grade, or above grade. ROP535U "Universal" Adhesive must be used at least six-feet around the perimeter of ice skating rinks (off-ice areas), and the subfloor's temperature range when using ROP535U must be no less than 40°F (5°C). The spread coverage over porous or rough substrates using the required 1/16" x 1/16" x 1/16" square notch trowel is approximately 100-125 square feet (Part A & B Mixed) per US gallon. Over non-porous or smooth substrates, the spread coverage



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using the required 1/32" x 1/16" x 1/32" "U" notch trowel is approximately 125-185 square feet (Part A & B Mixed) per US gallon. Coverage will vary according to the type of surface, surface texture, spreading angle, and adhesive temperature). Caution: If too much adhesive is applied, oozing at seams, air-bubbles, adhesive displacement, and telegraphing may occur when the floor is rolled or exposed to rolling loads resulting in loose and unsightly areas. Therefore, test trowel size and flooring prior to installation to avoid the above noted potential problems. Adhesive is available in 1-gallon units. Shelf life is one year @ 70° F (21° C) in an unopened container. Approximate Working Time: After properly mixed and immediately poured onto substrate: 30 - 40 minutes (depending on substrate temperature & trowel size). Although the epoxy components are non-freezing, the adhesive must be allowed to stabilize to ambient temperature before mixing. Any adhesive on the surface of the tiles or surrounding area must be removed immediately with a clean cloth dampened with warm soapy water or denatured alcohol. DO NOT allow the adhesive to cure on the surface of the flooring. A bond failure will occur if the epoxy is not properly mixed. Label information is in English and Spanish. Read all of the product and safety information concerning the adhesive and any other chemicals or cleaning agents prior to installation.

Roppe 535U "Universal" Solvent Free Urethane Enhanced Epoxy Flooring Adhesive Calculated VOC's according to California Rule #1168: Roppe 535U Part A: 1.3 grams per liter of coating. Roppe 535U Part B: 2.4 grams per liter of coating. ROP535U Part A & Part B Mixed Calculated VOC's: 1.21 grams per liter of coating.

6.4 Adhesive Application and Product Installation

Recoil Fitness Flooring Square Edge & Inter-Locking Tile Installation using Roppe 635 One-Part Solvent-Free Moisture-Cured Polyurethane Adhesive.

Read product limitation/precautions and installation literature before proceeding. Follow safety precautions on the adhesive label and Material Safety Data Sheet. Allow enough material for doorways, closets, alcoves etc. Dry lay the flooring to ensure desired aesthetics can be achieved prior to installing. All Recoil Fitness Flooring Square and Inter-locking tile installed outdoors must be fully adhered with ROP635 Adhesive. All interior installations of Square Tile must be fully adhered with ROP635 Adhesive. All 5/32" (4.00mm) and 1/4" (6.00mm) Gauge Inter-Locking Tile installed indoors must be fully adhered with ROP635 Adhesive to prevent curling. Only 3/8" (9.00mm) and 1/2" (12.00mm) Gauge Inter-Locking Tile installed indoors can be loose-laid. Pour the contents of the container onto the substrate and spread evenly, do not puddle adhesive, using the required 1/16" x 1/16" x 1/16" square notch trowel for installations over smooth or non-porous substrates (approx. coverage: 90-100 sq/ft per gallon). For installations over rough or porous substrates, a 3/32" x 3/32" x 3/32" "U" notch trowel is required (approx. coverage: 75-80 sq/ft per gallon). Spreading large areas of adhesive in excess of 150 square feet could possibly allow the adhesive to cure or setup before the flooring is installed which would result in a bond failure. ROP635 must be allowed to "tack-up" approximately 15 minutes over non-porous substrates (i.e.: metal, terrazzo, ceramic tile) and the flooring must be continuously rolled until the adhesive has dried completely. Do not allow the adhesive to dry or



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“skin-over” causing very little or no adhesive transfer to the backing of the flooring resulting in an installation failure. *Caution:* Open time and curing characteristics will vary upon the type of substrate, substrate temperature, ambient temperature, relative humidity, and proper conditioning of the adhesive. Allowing the adhesive to remain open too long will result in a bond failure. *Notice:* A “bottom-down” sticker has been placed on the back of both Square Edge Tile & Inter-Locking Tile indicating the floorings underside. Install all tiles face up to prevent shading issues. *Notice:* Square Edge & Inter-Locking Tile is to be installed in the same manner as traditional tile products. However, Square Edge Tile can be installed in a staggered joint configuration, if preferred to achieve the appearance desired. It is extremely important the tile is balanced in the room to enhance the appearance of the installation, and all bordering tile should be equal in dimension verifying the layout is correct. The room must be precisely measured in order to square-off the area, in order to determine the center point. First, measure area where tile is to be installed to determine the best starting position in the room. Then use a chalk line to mark two lines that intersect these positions at right angles, creating four (4) quadrants. Starting at the corner of one (1) quadrant, install tiles in a pyramid design, ensuring proper tile alignment and proper adhesive (90%) transfer to the products backing. Alignment is to be checked continuously throughout the installation and corrected if needed. Square Edge Tile can be installed in a staggered joint configuration to achieve the appearance desired. The flooring can also be installed diagonally. Carefully select the ideal layout to avoid seams in high traffic areas, while achieving an equal balanced in the room, and all side cuts should be equal in dimension. Fit tile tightly together. It is required to utilize Painter’s Tape (Do not use Duck Tape or similar type products) to temporarily hold the seams tightly together until the adhesive cures (approx. 48 hours) when utilizing the recommended adhesive. When laying the flooring, use a kneeling board, or for best results, work off the flooring whenever possible to avoid shifting of the flooring and to also not track adhesive onto the surface of the flooring. If the adhesive is bleeding or oozing at the seams, either too much adhesive has been applied, or the adhesive is too “wet”. Immediately remove excessive wet adhesive with a soft, clean cloth dampened with denatured alcohol. When installing all 5/32” (4.00mm) and 1/4” (6.00mm) gauge material, it may be necessary to weight-down the seams until the adhesive has cured. Always install the flooring gently into the adhesive to avoid trapping air and preventing bubbles beneath the flooring. *Caution:* If the adhesive is allowed to dry on the face of the flooring, tool etc, it can not be removed. Periodically, lift the flooring to check for proper adhesive transfer. There should be at least a 90% coverage of adhesive on the back of the flooring. Observe the adhesive to assure that the adhesive has not surpassed the open time and has not begun to cure. Borders and other specialty cut tiles/flooring must be scribed and cut to fit snugly, not tightly, against the wall, threshold, transition strip, fixtures, or other obstacles. Forcing incorrectly sized flooring into smaller areas will cause buckling of the flooring. DO NOT wait until all the main aisle flooring has been installed to begin laying the borders. Lay the border tiles/flooring within the adhesive open time. Roll and cross roll each section of flooring laid with a 100-pound (45 kgs) 3-section roller within 15 minutes after the flooring section has been installed. The rolling time may need to be adjusted to climatic conditions. Use a hand roller in areas that cannot be reached with the larger roller. Conduct a visual inspection during the rolling process to assure there has been no shifting of the flooring and that there is no adhesive on the surface of the flooring. DO NOT wait until the entire installation is completed before rolling as the adhesive may have surpassed the



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open time and be cured. Roll and cross roll a second time approximately 30 minutes after the initial rolling and thereafter as needed. There is to be no foot traffic on the floor for at least 72 hours. Protect flooring against mars, marks, indentations and other damage.

6.3.2 Recoil Fitness Flooring Roll Material Installation using Roppe 635 One-Part Solvent-Free Moisture-Cured Polyurethane Adhesive

Read product limitation/precautions and installation literature before proceeding. Follow safety precautions on the adhesive label and Material Safety Data Sheet. Must have adequate ventilation. Caution: When end-seaming Recoil Rolls factory side edges and ends must first be cut and squared on the job site to assure proper alignment, or roll material can be ordered to specific length required to reduce or eliminate end-seaming. Allow enough material for doorways, closets, alcoves etc. Allow an extra 3" for trimming or more if necessary for walls that are not square. Dry lay the flooring to ensure desired aesthetics have been achieved prior to installing. If the back of the flooring becomes soiled prior to installation, clean with a soft cloth dampened with clean water or denatured alcohol, clean, and let dry. DO NOT allow the urethane adhesive to stand in an open container. **Immediately** after opening the container, pour the contents of the container onto the substrate and spread evenly, do not puddle adhesive, using the required 3/32" x 3/32" x 3/32" "U" notch trowel over rough or porous substrates (approx. coverage 75-80 square feet per gallon). Over non-porous or smooth substrates, the spread coverage using the required 1/16" x 1/16" x 1/16" square notch trowel is approximately 90-100 square feet per gallon. Caution: If too much adhesive is applied, oozing at seams, air-bubbles, adhesive displacement, and telegraphing may occur when the floor is rolled, exposed to rolling loads and lateral shear stress and heavy objects resulting in loose and unsightly areas. Therefore, test trowel size and flooring prior to installation to avoid the above noted potential problems. When installing rolls, install each roll and cuts in the same direction (do not reverse the seams)! If the flooring is not laid in the same direction, the reflection of light will cause an optical illusion, making the surface appear to be different shades. Stagger roll materials cross-seams at least 6-10-feet apart to prevent seam weakness, while also improving the appearance of the installation. After positioning the first roll of material, position the second roll to overlap the first roll at the seam no more than 1/16". After adhesive is applied beneath the seam, work the overlapped seam material back to eliminate the overlap (do not leave the seams overlapped). Following this procedure will ensure the seams are fitted tightly together, eliminating unsightly gaps. It is required to utilize Painter's Tape (Do not use Duck Tape or similar type products) to temporarily hold the seams tightly together until the adhesive cures (approx. 48 hours). Repeat this procedure for each consecutive roll installed, including cross-seams. Spreading large areas of adhesive in excess of 150 square feet could possibly allow the adhesive to cure or setup before the flooring is installed which would result in a bond failure. ROP635 must be allowed to "tack-up" approximately 15 minutes over non-porous substrates (i.e.: metal, terrazzo, ceramic tile) and the flooring must be continuously rolled until the adhesive has dried completely. However, do not allow the adhesive to dry or "skin-over" causing very little or no adhesive transfer to the backing of the flooring resulting in an installation failure. *Caution:* "Tack up" time, open time, and curing characteristics will vary upon the type of substrate, temperature of the substrate, ambient temperature, humidity, and proper conditioning of the adhesive. Observe the



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adhesive to assure the adhesive has not surpassed its open time and started to cure. When installing rolls, the finished face of the product is rolled face-in, therefore unroll each roll in the same direction and allow to acclimate as noted above. This will allow the material to relax and ensure the seams, ends and cross-seams lay flat against the substrate. When installing rolls, install each roll and cuts in the same direction (do not reverse the seams)! If the flooring is not laid in the same direction, the reflection of light will cause an optical illusion, making the surface appear to be different shades. When laying the flooring, either use a kneeling board, or for best results work off the flooring whenever possible to avoid shifting of the flooring and to also not track the polyurethane adhesive onto the flooring. If the adhesive is bleeding or oozing at the seams, either too much adhesive has been applied or the adhesive is too "wet". Immediately remove excessive wet adhesive with a soft, clean cloth dampened with denatured alcohol before the polyurethane cures. After cleaning with denatured alcohol, wipe with a clean cloth dampened with clean water. DO NOT allow the polyurethane adhesive to cure on the surface of the flooring, or it will be impossible to remove. Periodically, lift the flooring to check for proper adhesive transfer. There should be at least 90% coverage of adhesive on the back of the flooring. Borders and other specialty cut tiles/flooring must be scribed and cut to fit snugly, not tightly, against the wall, threshold, transition strip, fixtures, or other obstacles. Do not wait until all the main aisle flooring has been installed to begin laying the borders. Roll and cross roll each section of tile/flooring installed with a 100-pound 3-section roller within 30 minutes after the tile/flooring section has been installed. Use a hand roller in areas that cannot be reached with the larger roller. Conduct a visual inspection during the rolling process to assure there has been no shifting of the tiles/flooring and that there is no adhesive on the surface of the flooring. Inspect each section laid after rolling to check for raised edges. Roll and cross roll a second time approximately 30 minutes after the initial rolling. If necessary, roll and cross roll again, & thereafter as needed. There is to be no foot traffic on the tile for at least 48 hours and no wheeled conveyances, furniture, weights, machinery of any kind for at least 3 days. Rain or exposure to moisture within 72 hours after installation may slow the set up time, and may adversely affect the adhesive resulting in an installation failure. Therefore, use extreme caution when installing outdoors. Protect flooring against mars, marks, indentations and other damage.

6.3.3 Ice Rink Expansion Joints Installation: The ice rink slab holding the refrigeration coils is invariably isolated from adjoining slabs with a 3" wide expansion void that must be allowed to absorb the expansion/contraction occurring when the is off/on. This void can not be filled with adhesive! Arrange material so each is centered over and span the void. Apply adhesive to the area 12" from each edge of the void and install while the ice is turned "off" (i.e.: warm slab). The contraction of the slab that occurs when the ice is "on" will be absorbed. Thin sheet metal, 3" wide must be loosely installed beneath the Recoil and directly over the void. If the expansion void is other than the customary 3" width, center Recoil over the void, then apply adhesive on the subfloor up to, but not including, the void itself. During contraction of the slab, the Recoil will stretch, developing small openings between the square spanning the void. An alternative method is to install Recoil normally and then cut through the tiles directly over the void. When the slab contracts, the Recoil will ride the slab and an opening will appear equal to the amount of contraction. There is to be no foot traffic on the floor or cleaning for at least 24 hours and no rolling loads for 72 hours. **Caution:** All seams must be fitted tightly together and held



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immediately with Painter's Tape for a minimum of 24 after the installation has been completed while the adhesive cures. Banked Turns, such as indoor running tracks, must be weighted with sandbags with ample weight to conform the tiles to the subfloor configuration immediately after rolling. Notice: DO NOT use duck tape or other tapes with tacky residues that will be either difficult or impossible to remove.

6.3.4 Interlocking Tile (Loose lay installation {3/8" & 1/2" Gauge Only}). For loose lay installations, install interlocking tiles to the length and width desired creating equal balance in the room. In order to achieve a finished look, the interlocking tile tabs around the perimeter/side of the area installed can be removed by using a straight edge and razor knife.

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