

Terra-Flex Rolls Flooring Installation Recommendation Instructions & Product Warranty



Upon Delivery of Product

1. Check packing slip with product and order.
2. Make sure to inspect the delivered product completely. Please inform us if there are any discrepancies with the original order, such as product defects, etc. Note: There will be no reimbursement or warranty claim compensated for labor on material installed with **visual** defects. However, physical defects, including size, color or otherwise, **must be reported to Rubber-Cal, Inc., prior to installation.**
3. Place products and adhesives in a clean, dry environment with temperatures ranging between 70 F and 80 F.
4. Please refer to the product and sub-floor preparation steps, instructions, warranty information and other disclaimers carefully and completely before beginning any installation.



Warning:

All Substrates (especially new concrete) must be fully cured and properly installed, alkaline vapor emissions tested and found to be at appropriate, prior to installing rubber products.

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I- Recommended Tools

- 1- Measuring tape or ruler
- 2- Metal straight edge
- 3- Non-retractable utility knife w/ extra blades
- 4- White marker or chalk
- 5- Chalkline
- 6- 2x4 wood block
- 7- Cellophane, masking or packaging tape
- 8- Rubber mallet
- 9- "V" notched trowel 1/8" X 1/8" outdoor installations or
"V" notched trowel 1/16" X 1/16" indoor installations
- 10- Mineral spirits and rag
- 11- Rubber gloves
- 12- Commercial grade caulking gun
- 13- Carpenter's square
- 14- Paint Roller Frames, Roller Extensions and Fluffy Rollers
- 15- Paint Roller Trays

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II- Adhesive Options

A- Shurtape® Double Sided Carpet Tape

Description: This product is a 3" double-sided pressure sensitive carpet tape designed for loose-lay installations as well as modular and semi-permanent applications. As an adhesive option, double-sided pressure sensitive tape is intended for perimeter and seam application on rubber flooring products.

B- Chemrex® CX-941

Description: Chemrex® CX-941 is a one component, polyurethane-based trowel-grade, waterproof structural adhesive with vapor reducing properties. Its elastomeric characteristics enable it to move as it expands and contracts. The patented formula is VOC compliant and contains no solvents or water. Chemrex® CX-941 provides exceptional initial green strength and excellent bond strength. This product is formulated for indoor and outdoor applications.

C- Chemrex® CX-948 Seam Sealant

Description: Chemrex® CX-948 is a polyurethane-based one component, moisture-curing adhesive/sealant. This product maintains permanent flexibility with high bond strength and as a result provides outstanding durability.

Chemrex® CX-941 Trowel Grade Polyurethane Adhesive

Polymer Type:	Polyurethane
Yield:	60 square feet per gallon
Packaging:	2 gallon (7.6 L) pails. 5 gallon (18.95 L) pails
Color:	Light brown
Viscosity:	Creamy Trowelable
Working Time:	45-60 Minutes
Freeze-thaw stability:	Unlimited cycles
Service temp:	-40°F to +150°F or -40°C to +66°C
Slab temp:	+50°F to +100°F or +10°C to +38°C
Shelf Life:	1 year when properly stored
Storage:	Store at 75° F (24° C) and 50% relative humidity. Keep unopened containers away from heat and direct sunshine. In cool weather, store containers at room temperature for at least 24 hours before usage.
Compliance:	ASTM E84-95B: NFPN, class A and UBC, Class1. USDA compliant for use in meat and poultry areas.

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Chemrex® CX-948 Gun-Grade Polyurethane Adhesive

Description:	Chemrex® CX-948 is a one-component, high-strength, high-solids, low-VOC polyurethane based adhesive that is 3 times stronger than conventional adhesives. Its patented technology advanced formula produces a permanent overnight bond to almost any substrate. Use it in all climates.
Compliance:	Adhesive meets or exceeds all requirements of the American Plywood Association Specification AFG-01, Adhesive for Gluing Plywood to Wood Framing. FHA Bulletin UM-60. ASTM D 3498.
Color:	Light brown
Packaging:	313 ml cartridges (24 per case, 44 cases per pallet). 858 ml cartridges (12 per case, 48 cases per pallet). 5 gallon pails (special order only). 55 gallon drums (special order only).
Storage:	Store in unopened containers in a cool, dry area away from direct sunlight. Storing at elevated temperatures will reduce shelf life. In cool or cold weather, store containers at room temperature for at least 24 hours before using.

Typical Properties

PROPERTY	VALUE
Viscosity, cps	Up to 1,000,000
Solids, %	90
Working or open time, hrs	Up to 1
Weight, lbs/gal (kg/L)	10.8 (1.30)
Flash point, ° F (° C)	250 (121)
Freeze/thaw stability	Does not freeze
Shrinkage	None
Service temperature, ° F (° C)	Up to 250 (121)
Slab temperature, ° F (° C)	50 to 100 (10 to 38)

Test Data

LAP SHEAR PROPERTY	RESULTS PSI (MPA)	COMMENTS
Chemlite to plywood	341 (2.35)	Plywood failure
Kynar to plywood	340 (2.34)	Primer 733 on Kynar
Extruded polyurethane to plywood	240 (1.65)	32 minutes tack time

ADHESIVE STRENGTH CHART

SUBSTRATE	CHEMREX® CX-948 PSI (MPA)	
	24 hrs	7 days
Plywood to Douglas fir	541 (3.73)	858 (5.91)
Plywood to treated lumber	861 (5.93)	1,000 (6.89)
Metal to Douglas fir	313 (2.16)	313 (2.16)
Foam to foam*	37 (0.25)	37 (0.25)

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Oriented strandboard to oriented strandboard (wet)	354 (2.44)	544 (3.75)
Wet Douglas fir to metal	217 (1.50)	313 (2.16)
Frozen Douglas fir to frozen Douglas fir	360 (2.48)	828 (5.70)
Plywood to F.R.P.	100 (0.69)	222 (1.53)

Note: Average data is from 10 specimens. Wet lumber is from overnight soak.

*Foam tears apart at 37 psi (0.25 MPa).

Test results are typical values obtained under laboratory conditions. Reasonable variations can be expected.

For Best Performance

- It is necessary to wear gloves while applying this product; Chemrex® CX-941 and CX-948 are extremely difficult to remove from both skin and clothing. In the case that this adhesive comes into contact with skin, immediately wipe it off with a dry cloth.
- Do not use this product on frozen surfaces or standing water.
- Prevent this product from coming into contact with water or alcohol before use and before completely cured.
- Please do not use this product in areas that are subject to hydrostatic head pressure.
- Avoid applying this product on wet, contaminated, or friable substrates.
- A leveled subsurface is required for the best possible performance. Since Terra-Flex Rubber Flooring Rolls are 2mm thick, imperfections on the subsurface will definitely appear on the rubber flooring surface
- Do not attempt to set the flooring into an adhesive that already has a dry skin.
- Please remember: Proper application and installation is solely the responsibility of the user.

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III- Health and Safety Information

Caution

Chemrex® CX-941 contains methylene bisphenyl diisocyanate; Talc; hydrotreated light petroleum distillate; polymethylene polyphenol isocyanate; silica and crystalline quartz.

Risks

This product is known to cause skin and eye irritation. Exposure to this product can cause dermatitis and allergic reactions. Please be aware that this product is a potential skin and/or respiratory sensitizer. The inhalation of product vapors may result in irritation as well as symptoms including: headaches, dizziness and nausea. Also, the ingestion of this product may cause irritation. Reports have associated repeated or prolonged occupational overexposure to such solvents with permanent brain, nervous system, liver and kidney damage. Note: this product contains crystalline silica. NTP and IARC recognize that respirable crystalline silica as a human carcinogen. There will be little or no exposure to crystalline silica with normal use of this product.

INTENTIONAL MISUSE BY DELIBERATELY INHALING THE CONTENTS MAY BE HARMFUL OR FATAL.

Precautions

Take careful measures to avoid contact with skin, eyes and clothing. Make sure to wash thoroughly after handling this product. To ensure safety, avoid breathing in product vapors and apply in conditions with adequate ventilation. It is necessary to use impermeable gloves, eye protection and—if the TLV is exceeded or if the product is used in a poorly ventilated area—use NIOSH/MSHA approved respiratory protection in accordance with applicable federal, state and local regulations. Warning: NEVER ingest this product. Be sure to keep the container closed; any empty container may contain harmful residues. It is imperative that all label warnings are observed until the container is commercially cleaned or reconditioned.

First Aid

In case of eye contact, flush thoroughly with water for at least 15 minutes. If pain or irritation continues after washing, SEEK IMMEDIATE MEDICAL ATTENTION. In case of skin contact, completely wash the exposed areas with soap and water. If irritation persists, SEEK MEDICAL ATTENTION. If clothing is contaminated, remove and wash until clean. If inhalation of the product causes physical discomfort, please seek fresh air. If the product causes continual discomfort or any breathing difficulty, or if in the unfortunate event it is swallowed, SEEK IMMEDIATE MEDICAL ATTENTION. For further information, please refer to the Chemrex® CX-941 Material Safety Data Sheet (MSDS).

VOC Content

45 g/L or 0.38 lbs/gal less water and exempt solvents.

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IV- Preparation Instructions

Product

Before installing, natural rubber flooring roll products must reach ambient room temperature; this ensures a secure and tight installation with minimal size fluctuation. **Completely unroll each piece of flooring and allow each to set for a full 24 hours prior to installing.** This allows the rolled product to relax (become flat) and to size stabilize at room temperature. Prior to installation, remember to inspect the product for measurable defects and irregularities. **Ensure that the flooring is laid down so that any roll curl is facing down. This will keep the ends of the roll from curling up.**

Subsurface Preparation

For the best installation possible, the intended subsurface should be reasonably flat and free of holes or variances of more than 1/32".

1. To ensure that the floors are structurally sound, allow a minimum of 28 days for them to fully cure. Be sure to test the floor for vapor drive in accordance with anhydrous calcium chloride test. Vapor drive should not surpass the industry standard of less than 3.0 lbs per 1,000 ft² in 24 hours.
2. For instances when test results are greater than 3.0 but less than 12 lbs per 1,000 ft² in 24 hours, refer to the product data sheet for Chemrex® Concrete Floor Primer (Form No. 1019775).
3. As necessary, make concrete repairs and install joint sealants and fillers. When appropriate use patching materials.
4. Subsurface low spots must be filled with a self-leveling underlayment or level prep.
5. In terms of floor preparation, mechanical surface profiling is the preferred preparation method. Also, it is the only acceptable preparation method where warranties are issued. Note: acid etching is not recommended. In order to remove curing and parting compounds and other surface hardeners and floor coatings, shotblast the floor to a medium-grit sandpaper texture.
6. Be sure to clean floors of oil, grease, and other bond inhibiting materials with a commercial degreaser, that are not otherwise removed by shotblasting or by other mechanical means.

A. Concrete

Fresh concrete must be allowed to cure thoroughly (it usually takes about 28 days) before floor installation. It is necessary to avoid using sealants with a petroleum base. If old concrete is used, it must be repaired and have joint sealants and fillers installed as necessary. All cracks or flaws should be filled in or repaired prior to installing any rubber products. Use patching materials as needed. Any concrete surface must be completely cleaned of dirt, dust, grease, and other foreign matter by shot-blasting (or by other mechanical means) with a commercial degreaser and then allowed to thoroughly dry before beginning installation.

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B. Wood Base

The intended wood subsurface should be completely cleaned of dirt, dust, grease and other foreign matter as well as be absolutely dry prior to installing rubber flooring. Any trapped moisture may rot the wood or interfere with installation adhesives. Before installation, nails and other protrusions should be pounded down or removed, holes must be repaired, and surface variances amended within 1/8" of the acceptable variance level.

V- Seam Sealing Alternative

Rubber-Cal offers Chemrex CX-948, a sealant/adhesive that creates the overall performance of a one-piece floor. This product will act as a bonding agent that will produce uniform flooring seams. Chemrex CX-948 is available in a 10.5 oz (313mm) gun-grade form. To bond the rolled rubber flooring together, leave 1/16" gap between seams for an adequate amount of adhesive to penetrate the adjacent pieces. To seal seams for waterproofing, sealant should be applied post-installation and only thinly applied to the seams. Allow each application approximately 24-48 hours to cure before use.

To assure a strong bond, it is highly recommended to thoroughly clean the edges of the mats either by steam cleaning, with a mild dish detergent, or by wiping them down with denatured alcohol. Please allow the mats to completely dry prior to applying the sealant. It is recommended to apply the sealant by either caulking gun or trowel. Wearing gloves during sealant application is strongly encouraged. Note: Once the material has cured it cannot be removed. Due to the extreme strength of Chemrex® CX-948, please do not apply it as heavily as you would a conventional adhesive. To render an appropriate-sized bead, cut the smallest possible opening in the spout. It is important to fill all gaps between the materials. To hold materials in place, use mechanical fasteners until the adhesive has fully cured.

VI-Cleaning Terra-Flex Rubber Flooring

Indoors: sweep, sponge mop or vacuum rubber flooring for everyday maintenance.



STOP Ensure that flooring is laid so that any roll curl is facing down. This will prevent the ends from curling up.

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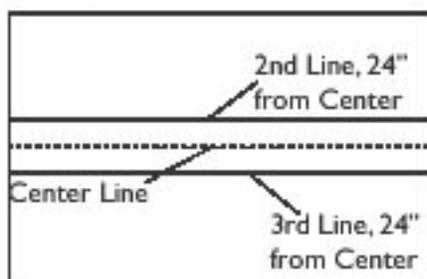
VII- Installation & Application

1. First, ensure that starter rows are firmly in place either by wedging or face nailing. Once initial rows are secure, use Chemrex® CX-941 in a wet-lay or walk-on-work method of installation.
2. Wet-lay method: Begin by applying adhesive to substrate with an appropriate trowel. Immediately place flooring onto the wet adhesive. There is no flashing required. NOTE: Do not apply more adhesive than can be covered in 30 minutes or the adhesive transfer could be jeopardized.
3. It is necessary that A 100 lb roller be used in the wet-lay method during all installations. Then, it must be rolled again within 30 minutes. Uneven flooring should be tacked, weighed down or rolled to ensure satisfactory contact between the flooring and the substrate.
4. Clean up tip: Before troweling Chemrex® CX-941, cover the unused portions of the trowel with duct tape. After troweling, quickly tear off the tape before the material cures.

Indoors

1) **Permanent installations should be handled by a trained professional with experience in rubber flooring installations.** It is important to assume that the walls and/or curbs that the rolls are abutting are not perfectly straight or square. Installation begins by determining the vertical center of the area to be installed. Snap a chalk line. Snap two additional chalk lines 24" out from either side of the original chalk line. (Figure1) This is the guideline for the edges on the first 48" roll. (If the roll to be installed is of another width, divide the width in half and measure that distance out from the original chalk line to determine the first rolls guides.).

Figure 1



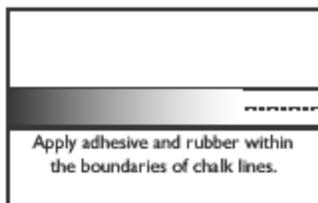
A. If adhesives are needed:

Apply Chemrex® CX-941 adhesive within the 48" marked chalk lines (Figure 2), the length of the room, or the length of the roll, whichever ends first. The adhesive should be applied thinly and evenly with 1/8" X 1/8" X 1/8" "V" trowel for outdoor applications and 1/16" X 1/16" X 1/16" "V" trowel for indoor applications. (Chemrex® CX-941 adhesive will cover 60 sq. ft. per gallon.) Do not apply more adhesive than can be utilized within a 30 minute window as there is approximately 30 minutes of open air time to apply the adhesive, maneuver the rubber mat onto the adhesive, and position prior to curing onset. Wipe off excess adhesive on protected hands or on equipment with mineral spirits. Gloves are strongly suggested during application, as the Chemrex® CX-941 adhesive is aggressive on skin. DO NOT allow mineral spirits to come in direct contact with the rubber rolls.

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Figure 2



B. Using double-sided sealing tape:

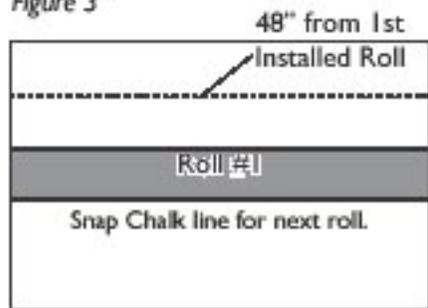
Apply the double sided sealing tape completely around the inside perimeter, in regards to, the width and length of the roll. Do not remove the release paper. (Complete step 2). At the beginning of the seam, fold back the rubber at the width point so that the tape is viewable. Remove release paper and ease rubber back down into place. Do not allow it to "flop" onto the tape, as it may create air pockets. Then, press to adhere. Now, continue this process for the remainder of the floor and then continue to (step 3).

2) Placing the roll end against the wall, unroll the first piece over the prepared area. Maneuver the rubber to lay precisely within the two chalk lines by tapping with a mallet and wood block. If the rubber exceeds the floor space, use a straight edge and non-retractable utility knife to trim the excess length (see cutting guide). Then, press firmly on the mats to remove any curls and bubbles.

NOTE: If using adhesive or sealing tape: after the first 60 minutes have passed, and the adhesive has begun to set, thoroughly roll the first roll of matting with 50-100 lb. carpet roller to assure the rubber has bonded to the adhesive. Be careful not to shift the roll outside of the chalk lines while rolling. Rolling should be done again at 75 and 90 minutes after the initial placement of the roll onto the adhesive. Rolling should be done both widthwise and lengthwise. This will insure intimate contact and the greatest possible bond.

3) Repeat steps above for remaining rolls. For subsequent roll placement, chalk lines can be used to define the areas of installation, but is not as crucial as with the initial piece (Figure 3). See curing times for traffic acceptability.

Figure 3



4) Butting one mat up to another, adjacent to or end to end, will help ensure tight joints without gapping. If gapping does begin to occur during installation, use masking, cellophane or packing tape to hold the mats together until the adhesive cures or the remaining pieces are laid. Do not use duct tape as it may leave residue on the surface when removed.

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VIII-Adhesive Clean-up Tips

Before troweling with Chemrex® CX-941, cover the unused portions of the trowel with duct tape. After troweling, quickly tear off the tape before the material cures. Be sure to clean all tools and excess Chemrex® CX-941 immediately after use with mineral spirits. When handling solvents, take all necessary precautions. Cured adhesive can be removed by cutting with a mechanical tool. DO NOT allow mineral spirits to come into contact with the rubber rolls.

IX- Rubber Cutting Guide

Tips on cutting rolled rubber: This procedure works best when using a recommended non-retractable utility knife. When using a utility knife, be sure to keep the blades sharp to aid in cutting, and help reduce the possibility of injury due to a dull blade.

- 1) First, mark the rolls you will need to cut with chalk or a chalk line.
- 2) After marking the rolls, put your straight edge on the corresponding marks.
- 3) Score the mats two or three times, while holding the straight edge firmly in place. **
- 4) Position the rubber close to the score line, then, lift and bend the mat toward you. The score line will "break open."
- 5) Make several more passes with the knife, working down the established cut, until the cut is complete.

**This process may be made easier by cutting the mat on a raised surface such as the 2x4 wood block used during installation. Gravity will depress the cut edge down and away from the cut, and will be less likely to catch the knife blade.

X- Curing Times

Adhesive

Cure time is dependent on temperature and humidity. Times are based on 75° F (57° C) and 50% relative humidity.

Firm set: 1 – 2 hours

Light foot traffic: 24-48 hours

Normal traffic: 48-72 hours

Higher temperatures and humidity shorten the cure rate, while lower temperatures and humidity lengthen the time.

Double Sided Carpet Tape:

Foot traffic Immediate

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XI- Product Warranty

Three Year Warranty

Rubber-Cal, Inc. offers the following limited warranty on all sheet rubber, flooring and matting products for a period of three years from date of sale to the original purchaser of our products.

1. The product will comply with the technical specifications and be fit for those applications as set forth in the manufacturer's published technical and promotional materials at the time of sale. THERE IS NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE, NOR ANY OTHER WARRANTIES WHICH EXTEND BEYOND THE DESCRIPTION ON THE FACE HEREOF.
2. The product will be free of defects in materials and workmanship (subject to the limitations set forth below) for a period of three years from the date of purchase from the manufacturer. This warranty is limited to the repair or replacement of products which are shown to be defective during the Warranty Period. The owner/end-user agrees not to advance any claim for any other measure of damage or loss. Rubber-Cal, Inc. shall not be liable for installation, disassembly, removal, disposal, return shipping, or other similar costs. THIS WARRANTY DOES NOT COVER DISSATISFACTION OR PROBLEMS OR OTHER DAMAGE TO THE MATERIALS AS DESCRIBED IN THE MANUFACTURER WARRANTY STATEMENT.
3. This warranty does not extend to:
 - a. Products which have been improperly installed.
 - b. Products installed over improperly prepared sub-surfaces or preparation of sub-base not specifically approved by manufacturer.
 - c. Normal wear and tear of products.
 - d. The surface appearance of the product or color inconsistency.
 - e. Products subject to misuse, abuse, neglect, chemical cleaning, adhesives not recommended for use, or contact not specifically approved by manufacturer.
 - f. Products which have been altered, modified, fabricated, or amended in any way.
 - g. Cracking, warping, soiling, fading, improper maintenance or abuse caused during the service life and items such as roller skates, golf shoes, pets, cleat, weight and exercise equipment, etc.
4. Manufacturer's sole liability under this limited warranty shall be the repair or replacement, excluding installation and other costs, at its option, of product strictly according to the procedures set forth below. The implied warranties of merchantability and fitness for a particular purpose are hereby specifically disclaimed. In no event shall manufacturer be liable for any special, indirect or consequential damages, whether arising out of contract, tort or any theory of law.
Rubber-Cal, Inc. shall not be liable for any damage, loss or claim whatsoever unless the material is installed and used according to the written instructions provided by Rubber-Cal, Inc. and used only as intended by Rubber-Cal, Inc.
5. To exercise this limited warranty, manufacturer must be notified within fifteen days of any occurrence giving rise to claim and prior to installation, given opportunity to inspect the product, and have issued direction to the original purchaser respecting disposition of product to be replaced under this limited warranty. Purchaser shall comply with all reasonable requests of manufacturer in the administration of

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any warranty claim. Non-compliance with installation instructions and maintenance guidelines as recommended by Rubber-Cal, Inc. Manufacturer cannot assume responsibility for the suitability of flooring and rubber sheet material and accompanying products for each individual installation, use, and application. As manufacturer has no control over the installer's proper application. Should an individual piece be doubtful as to appearance or dimension, the installer should not use the piece in question. Such damage is not covered.

6. NO AGENT OR REPRESENTATIVE OF RUBBER-CAL, INC. HAS ANY EXPRESS OR IMPLIED AUTHORITY TO MAKE ANY REPRESENTATION, PROMISE OR GUARANTEE NOT STATED HEREIN.
7. Exposure to UV light and sunlight will cause color variation to rubber products.
8. No returns will be accepted without written authorization from Rubber-Cal, Inc. Failure to comply with the above constitutes a waiver of your claim.
9. Rubber-Cal, inc. will at its option either repair or replace from current inventory of available products the defective flooring and or rubber sheet, provided the defect is not the result of misuse, accident, abuse or alteration and provided further that the product is used in the manner specifically set forth in literature describing the product which is issued or provided by Rubber-Cal, Inc.

Notice:

Terra-Flex Rubber Flooring, as with any rubber product, can vary. Tolerances in thickness and width have been made as stringent as possible, but some variance is to be expected. Rubber's nature is to expand and contract with changes in temperature and humidity.



*The instructions provided are assuming use of Chemrex® Polyurethane Adhesives. If another adhesive product is used, be cautious as to the manufacturer's instructions, curing times, and bonding window.

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