

# Installation guidance

Altro safety flooring

## 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

Altro safety flooring should be laid in accordance with the Code of Practice BS 8203:2017. The material should be stored for approximately 24 hours at a room temperature of not below 14°C. When laying, the area should be at a steady temperature of between 14°C and 27°C for at least 48 hours prior to, during and for at least 24 hours after completion.

The material should be checked for any possible faults prior to laying and should be cut into lengths and laid loose for conditioning before adhering to the subfloor for a minimum of 2 hours.

The material should then be “back rolled” or “dressed” before scribing in order to take out any tension in the product. Ensure that the material used in any one area is from the same manufacturing batch and that sheets are laid in the same direction.

Pattern ranges of Altro safety flooring will require the pattern to be matched from sheet to sheet (for further information contact Altro).

Claims against warranty for colour, batch or obvious material defects will only be considered if the flooring has not yet been permanently bonded.

## Subfloor

The subfloor must conform with the requirements of BS 8203:2017.

## Adhesive

For the correct choice of AltroFix™ adhesive, refer to the Altro adhesives data sheets. Excess adhesive should be removed with a cloth with a neutral detergent in the case

of acrylic adhesive or with alcohol for two component adhesives. Removal of excess adhesive should be done as work progresses and whilst the adhesive is still wet.

## Laying

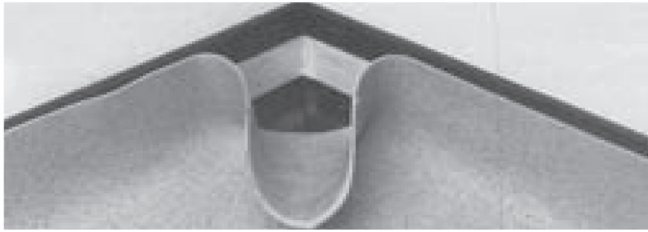
Altro safety flooring can be straight laid or used in conjunction with “sit on” or “set in” skirtings. The materials can also be self-coved. In areas that are subject to moisture spillage, the complete installation must be sealed ie. the use of conventional clamping or welding type drain gulleys and 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 laid out and conditioned, all joints should be overlapped by approximately 20mm and cut in to form a tight joint, these 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 has been cut in, any movement of the sheet whilst placing it into the adhesive will create a problem.

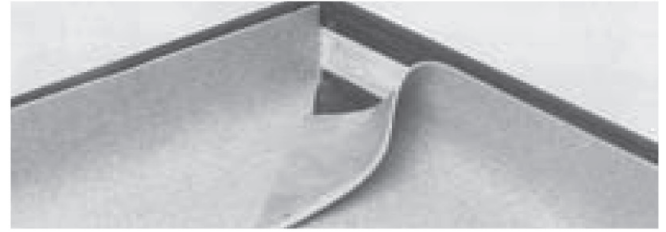
Turn the material back and apply the adhesive to the subfloor in accordance with the manufacturer’s instructions.

After the specified open time, which can depend upon the subfloor, place the floor covering back into the adhesive pushing out any air bubbles. Remove any excess adhesive immediately and depending upon the adhesive used (refer to Altro Adhesives) roll the whole area with a floor roller both width ways and length ways. All joints within the sheet should be cut in, grooved and hot welded.

## Forming an internal mitre



1. Once the main flooring is laid and adhered, push the flooring into the internal angle as far as possible. Make a cut from the base out to the top of the flooring in line with the mitre.

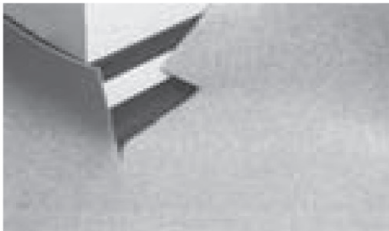


2. Fold in one side of the mitre and carefully cut off the surplus material. This completes the first part of the mitre.

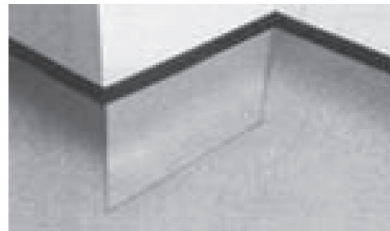


3. Fold in the second side and carefully cut in to complete the joint. Adhere and hot-weld the joint.

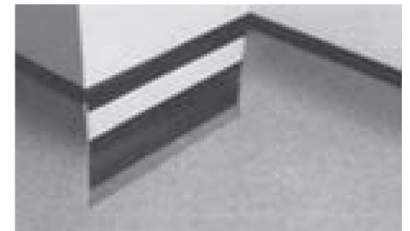
## Forming an external and internal mitre on a make-out section



1. Roughly cut the flooring oversize to meet the required section.



2. Once the main flooring is adhered, cut in the back and front mitres, then cut out the section to remove the make-out.



3. Take a separate piece of flooring roughly cut to size, apply adhesive, position and cut to fit the back internal mitre. Cut in the front external mitre. Groove and hot weld to complete the section.

## Grooving

A 3mm groove to 2/3 depth of the flooring 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.

## Forming a hot welded joint

After cutting in and adhering the sheet vinyl flooring, all joints must be hot welded with Altro Weldrod™, using a hot air welding gun fitted with a 5mm high speed welding nozzle. Internal and external mitres should be hot welded. 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. However, when installing Altro XpressLay™ welding can be carried out immediately after installation as no wet adhesive is used with this system.

## Welding an internal mitre



1. Groove the lower section of the joint, but not the upper. If the flooring has a PUR coating, all joints must be grooved prior to hot welding.

## Welding

The internal and external mitres on the coved sections should be welded first. Turn the speed nozzle at the end of the welding gun to the up position, for easier starting, or use an Altro coving speed nozzle. Once the mitres are finished, turn the nozzle to the down position to hot weld the grooved floor joints.

## Finishing

Once the weld has cooled and set, trim the weld with the most appropriate tool such as a spatula fitted with a spatula guide or sledge. Then, using the spatula only, trim the weld flush with the surface of the flooring material. For external mitres use the square router blade and for internal mitres the round router blade. For Altro Marine™ 20 safety flooring the Altro T20 chisel has been specifically designed for removal of surplus weldrod.

For details on equipment and tools, refer to Altro's Recommended Equipment and Tools data sheet.

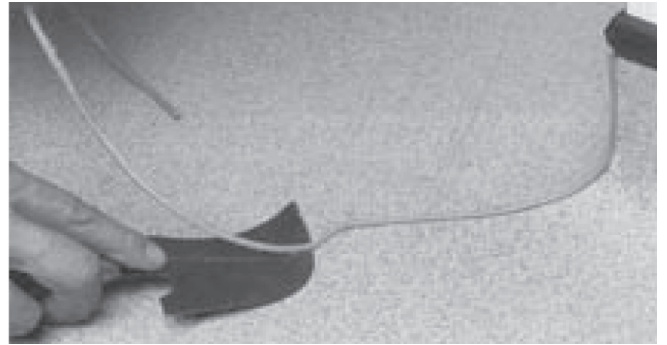


2. Trim the weldrod with the round router blade.

## Welding an external mitre



1. Groove the floor and bottom section. The top section of the mitre forms a natural 'Vee' and does not need grooving. Start welding the mitre from the top, with the weldrod feed above the nozzle. When welding the floor feed the weldrod below the nozzle.



2. Allow the weldrod to cool completely, then trim surplus with the spatula. Chamfer off the external mitre with the square router blade.

## Protection and maintenance

Altro safety flooring must be covered and protected from all other trades with a suitable non-staining protective covering.

For maintenance of Altro safety flooring refer to Altro's cleaning and maintenance recommendations.

## Laying Altro Static Dissipative safety flooring

Altro Walkway™ 20SD should be installed following the same procedure as standard sheet. But the recommended conductive adhesives must be used (refer to the Altro adhesives guide).

The use of copper strips, etc, will depend upon the requirements and standards that the client needs to achieve (for further information contact Altro Technical Services).

**For further information or technical advice**

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