



207 Recycling Way • P.O. Box 2084 • Dalton, GA 30722  
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## **DOUBLE GLUE INSTALLATION INSTRUCTIONS**

Carpet installation should be performed by professional installers with specific training in commercial double-glue installations. Certified installers can be found through the Floor Covering Installation Contractors Association or through Certified Floorcovering Installers.

### **PRE-INSTALLATION CONSIDERATIONS**

Regardless of whether a concrete slab is new or aged, the potential for installation performance problems exists if excess moisture or alkalinity is present, causing degradation of the adhesive. When installing over a concrete slab, confirm that the moisture and alkalinity are within acceptable limits. A calcium chloride moisture test kit for this purpose is commonly available from installation product suppliers.

With careful use, this test can produce reliable results. Note that proper planning is critical, as the test requires 60-72 hours to conduct.

As a general guideline, a moisture emission rate of 3-lbs/1000 sq. ft. /24 hours and a ph between 5 and 9 are acceptable for most carpets. Beyond these limits, the risk of moisture or alkalinity related problems increases. Corrective measures may be needed if limits are exceeded.

Additionally, with the great variety of carpets, cushions and adhesives available for commercial installations, confirm that the products of interest are recommended by the

manufacturers for installation by the double-glue method.

### **SITE CONDITIONS**

The space in which the carpet is to be installed needs to have adequate temperature and humidity control to facilitate proper installation. Beginning 48 hours before the installation and continuing at least 72 hours following the completion of the installation, the temperature needs to be maintained between 65 and 95 degrees F. and the relative humidity between 10% and 65%. To achieve the best possible installation, according to The Carpet & Rug Institute's CRI 104 (2002) Installation Standard, all materials should be acclimated 48 hours prior to installation. If installing over concrete, the slab temperature should not be less than 65 degrees F. The completed installation needs to be maintained at a minimum of 55 degrees F.

### **FLOOR PREPARATION**

The floor should be free of holes and loose tiles or boards. Repairs should be made as necessary to provide a smooth surface for carpet and cushion installation. The floor should be dry and dust free. All contaminants that may



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prevent good adhesion need to be removed. Floors should be vacuumed, mopped if necessary, and otherwise cleaned prior to carpet installation. Excessive use of water for cleaning is not recommended, though mopping with a slightly damp mop is useful to remove dust from the floor surface. Architectural tack strip, properly spaced and secured, may be used to hold the carpet edges in place. Setting cove base on top of carpet will also secure edges.

## **CUSHION LAYOUT**

The cushion should be laid out in the longest lengths possible. Additionally the cushion seams should run perpendicular to the carpet seams. If the seams cannot be at right angles to the carpet seams, the cushion seams should be kept at least 6 inches from the carpet seams. Cushion seam need to be butted without compression, leaving no gaps. Any excess along the perimeter walls should be trimmed and tightly fitted.

## **GLUING THE CUSHION TO THE FLOOR**

Once the entire cushion has been laid out, fold it back and apply adhesive to the floor. Do not staple. Direct special attention to spreading the adhesive adjacent to the walls (cut-in) to prevent edge curling. Apply the adhesive with a u-notched trowel measuring 1/16 x 1/16 x 1/16 inches, or according to the adhesive manufacturer recommendations. Applying the adhesive with a paint roller can result in an inconsistent application. Consult the adhesive

manufacturer for the best application technique. For bonding, the cushion should be laid into the adhesive while in a “tacky wet” condition. For pressure sensitive adhesives, this point is often identified when the adhesive turns clear from its original opaque appearance. Smooth the cushion into the adhesive, working toward the seams. Trim in, eliminating any bubbles or wrinkles so that the seams are tight without overlapping.

## **CARPET LAYOUT**

As the first step, cut the carpet to the proper length and spread it out in the area to be carpeted. The carpet should be 3-4 inches longer than the area measurement. Where applicable, allow for pattern repeat. Carpet seams should be at a right angle to cushion seams or offset at least 6 inches to either side. Align all carpet breadths to their proper position and trim seams.

## **GLUING CARPET TO CUSHION**

It is imperative that the installer use the proper trowel notch and a premium multi-purpose adhesive formulated specifically for double-glue installation.

Spread the floor adhesive uniformly over the cushion with the appropriate U-notched trowel, leaving ridges of sufficient height to achieve full and complete coverage of the cushion and carpet backing, including penetration into the backing’s deepest recesses.

Confirm amount and placement of adhesive by installing a small area, then lifting the carpet, noting adhesive transfer and coverage into the



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backstitch of the carpet. If insufficient coverage is seen, increase notch size and recheck.

Once the adhesive has been spread for a given section, lay carpet according to the adhesive manufacturer's recommendation for open time to allow even distribution and penetration of adhesive on all areas of backing.

Proper open time considerations are critical for a successful installation. Installing carpet into adhesive without sufficient open time may result in installation failure. The use of fans will reduce the required open time and promote tackiness. However, be aware that excessive moving of the air will accelerate the drying time and may not achieve a transfer of adhesive to the backing of the carpet.

Using an appropriate carpet roller, roll in both directions to promote complete adhesion of carpet to cushion. Rolling should be performed with the lightest roller that provides for proper transfer of the adhesive into the carpet back. Refer to manufacturer recommendation for roller weight. Eliminate any bubbles by pressing straight down prior to full adhesive set up time. Do not roll bubbles to edge. Woven carpet should be rolled a second time about 3 to 12 hours after initial rolling to make sure a strong bond is established. Generally, a 35-50 lb. roller is suggested. Due to dimensional instability, double-glue installation of carpet with a unitary backing is not recommended.

Prevent all traffic over carpeted area for a minimum of 24-48 hours after installation. Failure to do so may create areas where inadequate adhesion between carpet and

cushion can lead to future performance problems.

## **OTHER INSTALLATION CONSIDERATIONS**

The first 30 days following installation is a critical period. During this time, the adhesive is under-going the final cure required for long-term installation performance. It is critical that the carpet not be exposed to water from cleaning or other sources during the first 30 days. Exposure to water during this period may interfere with proper curing of the adhesive and can lead to future problems. If cleaning is required, it should be done by a trained, skilled professional. Dry cleaning systems are preferred. Certain types of carpet backing and adhesives are not compatible. Follow manufacturer recommendations as to the correct adhesive and application.

Depending on carpet manufacturer recommendations, seams may be hand sewn, butt-steamed and glued, or hot melt taped using a low profile, non-silicone treated hot melt tape specifically designed for double-glue. Prior to the seaming, both trimmed edges of the carpet sections to be joined must be sealed with an appropriate seam adhesive. Latex seam sealer or thermoplastic adhesives are acceptable. Apply seam adhesive in a manner that encapsulates both primary and secondary backings.

## **DOUBLE GLUE PROCEDURES FOR STAIRS**

Pre-cut and dry the stair carpet before beginning the installation. Position the tack strip on the tread and riser and install as with a conventional installation. Install specified



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cushion, extending completely over the bull nose, which is to be a radius of  $\frac{3}{4}$  inch. After the cushion is adhered, apply the double-glue adhesive on top of the cushion. Install carpet into the wet adhesive, while it is pliable and easy to stretch.

### **INSTALLING PATTERNED CARPET**

It is critical that all parties discuss the pattern configuration, the backing system installation method, and pattern carpet expectations. During the development of specifications, the specifier, end user and the carpet installation contractor must all understand the manufacturer's tolerances for bow, skew, trueness of edge and pattern repeat variation. If tolerances exceed manufacturer's published specifications for these and other pattern carpet attributes, contact the manufacturer before proceeding.