



Kiefer ActivePlay Installation Guidelines

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I. Delivery and Storage of Materials



- ActivePlay rolls are to be stored vertically (standing on end) on a dry substrate.
- Rolls may be temporarily laid horizontally for shipping purposes.
- Rolls must not be laid flat or stacked prior to installation.
- It is recommended to allow flooring and adhesive to acclimate to the environment that it will be installed in for 48 hours prior to installation.
- **The Active must be rolled out and allowed to relax overnight or a minimum of 24 hours in the correct environment before installing.**

II. Subfloor

i. Concrete

All concrete floors must meet the current guideline of: ASTM F710 - Standard Practice for Preparing Concrete Floors to Receive Resilient Flooring

- The surface of concrete floors to receive resilient flooring shall be dry, clean, smooth, and structurally sound. They shall be free of dust, solvent, paint, wax, oil, grease, residual adhesive, adhesive removers, any type curing or hardening compound, any type of concrete sealer, alkaline salts, excessive carbonation or laitance, mold, mildew, and other foreign materials on surface of slab.
- Sealers and curing compounds used on concrete are not compatible with resilient adhesives. Non-chemical methods for removal of these compounds are required including but not limited to bead blasting or diamond grinding.
- The use of Portland based patching and leveling compounds is recommended
- Gypsum is not an acceptable patching compound for use under resilient flooring.
- Regardless of which patching or leveling compound is used, any failures in the performance of the compound or floor coverings due to the compound are the responsibility of the individuals placing the compound and/or the compound manufacturer.
- Closely follow the mixing instructions from the patch or leveling compound manufacturer.
- Take appropriate precautions in the removal of contaminants, they may contain lead, asbestos, or other hazardous agents.

WARNING! DO NOT SAND, DRY SWEEP, DRY SCRAPE, DRILL, SAW, BEADBLAST OR MECHANICALLY CHIP OR PULVERIZE EXISTING RESILIENT FLOORING, BACKING, LINING FELT, ASPHALTIC “CUTBACK” ADHESIVES OR OTHER ADHESIVES.

These products may contain either asbestos fibers and/or crystalline silica. Avoid creating dust. Inhalation of such dust is a cancer and respiratory tract hazard. Smoking by individuals exposed to asbestos fibers greatly increases the risk of serious bodily harm. Unless positively certain that the product is a non-asbestos-containing material, you must presume it contains asbestos. Regulations may require that the material be tested to determine asbestos content and may govern the removal and disposal of material. See current edition of the Resilient Floor Covering Institute (RFCI) publication Recommended Work Practices for Removal of Resilient Floor Coverings for detailed information and instructions on removing all resilient covering structures. For current information go to www.rfci.com. Solvent based adhesive removers are not recommended.

- New or existing concrete subfloors must meet the guidelines of the latest edition of ACI 302

- On or below-grade slabs must have an effective vapor retarder directly under the slab
- Wet curing 7 days is the preferred method for curing new concrete.
- Curing compounds (DO NOT USE). If present they can interfere with the bond of the adhesive to the concrete.
- Remove curing compounds 28 days after placement, so concrete can begin drying.

ii. WOOD SUBSTRATES

NOTE: The following are general recommendations. Please contact Kiefer USA before installing over a wood substrate.

- Double-layered APA rated plywood with top layer being "B" or better subfloor and with a minimum 1" total thickness.
- The top layer of plywood must be placed in a full bed of adhesive and screwed to lower layer.
- Do not install over a plywood subfloor laid directly over concrete.
- Underlayment panels can only correct minor deficiencies in the sub-floor and should only be
- Kiefer USA is not responsible for any failure in the performance of the underlayment panels.
- It is recommended that your chosen APA underlayment grade panels be designed for installation under resilient flooring and carry a written warranty covering replacement of the entire flooring system.
- Always follow the underlayment manufacturer's installation instructions.

iii. STRIP – PLANK WOOD FLOORING

- Due to expansion and contraction of individual boards during seasonal changes,
- Moisture content of the existing floor is critical
- Under no condition install over an existing cupped floor!

iv. PARTICLE BOARD

- Particle board shall not be used

v. LIGHTWEIGHT CONCRETE

- All recommendations and guarantees as to the suitability and performance of lightweight concrete under resilient flooring are the responsibility of the lightweight concrete manufacturer and not with
- Any floor covering failures resulting from performance of the substrate will not be considered a manufacturing defect.

vi. LAYING ACTIVEPLAY OVER SLIP SHEET (optional)

vii. Concrete Testing

All concrete floors, old or new, must be tested for moisture and PH.

- In Situ Probe (ASTM F2170) Test results may not exceed adhesive limits.
- PH levels must not exceed 10.
- Working temperatures for room (65 – 100), and slab (65 – 85).
- Concrete surface shall not be within 5 degrees of dew point.
- Slab tolerance is 3/16" in 10'
- F - Number System: Overall values of FF 36/FL 20 may be appropriate for resilient floor coverings.

Installation failures due to excessive moisture or alkali are not warranted by Kiefer USA.

III. Layout Patterns

- **Wood grain visuals** - Do **not** reverse sheets for seaming.
- **Solid colors** - Reverse sheets for seaming
- Upon establishing a starting point, typically based on a shop drawing or a seam diagram, chalk a straight line from wall to wall.
- Paying close attention to roll # sequencing. Start by unrolling the material on the chalk line. Continue unrolling material across the room leaving approximately 3" of excess material up the wall and at all end seams.
- Inspect the material for damage or any visible defects. In the event a defect is found, contact Kiefer USA immediately. Do not install.
- Trim edges to ensure a clean uniform seam. Even though the edge of the material may be straight, the factory edge can vary in thickness.

NOTE: REGARDLESS OF APPEARANCE OF THE FACTORY EDGES, TRIMMING OF BOTH EDGES IS REQUIRED FOR A SUCCESSFUL SEAM. ANY VARIATION WILL VOID WARRANTY

IV. Adhesive

Gerfix TPS + - solvent free adhesive.

Gerfix TPS + adhesive is an installer friendly, premium high strength (non-staining) acrylic adhesive. It is designed to permanently install sport flooring. It may be used on all grades of concrete. On above or below grade concrete in the absence of excess moisture, as well as suspended approved wood floors. It may also be used for installing over existing, non-cushioned resilient flooring that has been prepared according to manufacturer's recommended methods. It is non-flammable, water-based (80% RH), alkali (7 – 9 pH) resistant and freeze-thaw stable. It has excellent resistance to plasticizer migration and sets to a tough permanent bond. Less than 34 g/L (calculated) VOC's. CRI Green Label Plus #GLP00226.

Warning: All sub-floor preparation must be complete prior to any adhesive being applied to the substrate.

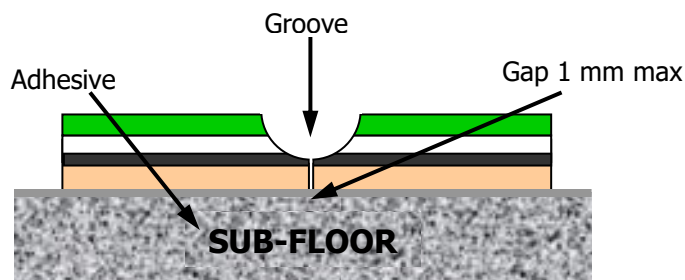
- Depending upon the installers personal comfort level, the material may be folded back from end to end, or side to side. When using the side to side method, it may be necessary to overlap the seams and under scribe.
- Leaving the material down that is unrolled next to the chalk line. Pull back half of the room exposing the substrate. If the material is being pulled back from side to side, open up every other seam.
- Apply adhesive to the uncovered half of the sub-floor, starting with the area next to the chalk line.
- Apply the glue to the sub-floor in an even coat. In order to ensure that the glue is properly transferred to the back of the floor covering, do not glue too large an area at one time.
- Adhesive spread rate is approximately 185 to 245 sf/gallon. (4.53 to 6.0m² / L)
- 1/32" X 1/16" X 1/32" (1 x 1.5 x 1 mm) notch trowel is required for warranty. 
- Using the material next to the chalk line as a strait-edge or guide, push or fold the material into the adhesive after the appropriate flash time specified by the adhesive manufacturer.
- Using a 100 lb. roller, roll the material in both directions to ensure the proper transfer and/or contact with the adhesive. Roll cross ways first, then length wise. Cross ways first assures you never chase an air bubble more than 3 feet.
- Allow adhesive to set overnight before welding

V. Heat Welding

ASTM F 1516 - Standard Practice for Sealing Seams of Resilient Flooring Products by the Heat Weld Method: Instructions and precautions to be observed to ensure satisfactory performance of seams in resilient flooring sealed by the heat weld method.

Always set-up and test your equipment on scrap material prior to beginning.

A curved blade should be used for grooving to ensure proper contact between the weld rod and the flooring. Groove should be 1/2 to 2/3 the thickness of the resilient product. **DO NOT GROOVE INTO THE CLOSED CELL FOAM BACKING.** Remove all debris caused by grooving before attempting to weld.



Item #18-STG



Turbo Sports Flooring Groover

Item#22



Turbo Caddy Automatic Welder

- **Grooving**

Grooving must be performed using a curved blade, as described above.
Groove must be centered between edges for strongest seams.

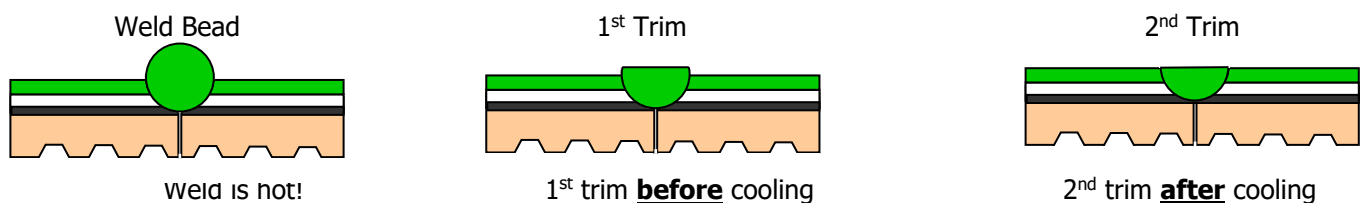
- **Heat Weld**

Although welding can be performed manually, the use of automatic welding equipment is strongly recommended and will produce more consistent, quality welds.

- Heat welding should be done after the flooring adhesive has set up, usually the following day
- Particular attention shall be paid to proper cutting of seams and tightness of cut seams.
- Seam edges should be uniform 1/32" (1 mm) apart. Large gaps in the seams will prevent a quality weld.
- Use only professional quality welding equipment that will maintain sufficient temperatures. Many types, sizes and styles of welding tips are available today. A tip must be chosen to produce a quality weld without damaging the appearance of the sport flooring.
- Temperature should be set at 700° F - 800° F. Setting of 5 ½ - 6 when using green Leister gun.
- Determine the correct welding speed by ensuring that the welding rod actually fuses into the groove. A small ridge must form on either side of the welding rod, at the floor surface. If no ridge forms, you have not heat welded the seam.

- **Trimming the weld**

Welds must be trimmed in two stages to minimize concave appearance.
Final pass skiving knife must be sharp to prevent concave appearance.



viii. Line Painting

NOTE: Game line paint should only be applied by experienced professional game line applicators. Restrict all traffic until paint is fully cured.

- **Preparation of the flooring**

After welding is complete, check the surface to insure it is dry and clean. Mark off game lines with solvent resistant masking tape. 3M 233+ (Green) professional masking tape is recommended.

- **Painting game lines**

Double-check layout and marking of game lines before application. Once cured it is near impossible to remove and may require replacing affected pieces.

Application of paint

NOTE: Primer is required for game line paint adhesion. Please request current application guidelines from Connor Sports Flooring technical department prior to installation.

Apply one to two thin, evenly spread coats to produce neat and clean lines. The second coat should be applied within 4 hours of 1st coat. Remove masking tape as soon as possible. Do not allow paint to completely dry or set overnight. Allow a minimum of 72 hours after application of paint before use.

Tricks for Handling Super-Sized Rolls and Saving Your Back

- Rolls can exceed 500 pounds.
- Hand trucks - With larger tires.
- Hand truck - With ball bearing rollers - dispense material off the roll.
- Dolly's – For placement of rolls, larger wheels are needed to prevent damage.
- Dolly with ball bearing rollers - dispense material off the roll.
- Lifting poles - 2" x 36" or 48" wood dowels can be used without adding excess weight. Be sure and add some type of rubber donut to prevent pinching fingers when two lifting poles are used at the same time.
- Poly sheeting (Visqueen) or blue tarps can be used to easily spin the rolls on top of (prevents scratching).
- Latex coated gloves – Aids in gripping and pulling long drops.

The guidelines offered within this document are recommendations only and are not intended to be all inclusive. It represents current knowledge based on experience, available resources, ASTM, and other industry standards. As every installation is different the flooring contractor needs to verify applicability of these recommendations to the product and jobsite conditions. This manual should only be utilized by professional flooring mechanics who are experts in their field.