

## **DOUBLE GLUE INSTALLATION SPECIFICATION 2016**

### **Carpet to Cushion**

- Medium to Heavy Commercial  
AAT-275, AAT-280 and AAT-299
- Light Commercial  
AAT-275, AAT-280, Anchor Bond Premium and Problem Solver Premium
- Minimum Trowel Recommendations \*  
1/8 x 1/8 x 1/16 U or Square Notch
- Spread Rate  
50 - 80 sq. ft. per gallon

\* A notch depth of up to 3/16" might be required when installing some woven and unitary backed products and other carpets with deeply textured backs. A sample installation should be made before every job, so as to ensure that a 100% adhesive transfer to both the cushion and the carpet, including the inner recesses of the back, is achieved.

Floor preparation, environmental conditions, and proper conditioning of all installation supplies, including the carpeting, padding, and adhesive, must be in strict compliance with industry standards and those of the respective manufacturers. Carpet and cushion must also be installed with the approved and recommended procedures as defined by the appropriate manufacturer.

NOTE: If any questions arise as to what trowel or exact procedures should be employed, samples of both carpet and pad, along with complete sub-floor information, may be supplied to AAT prior to installation start-up.

### **Cushion to Floor**

- Release Installation  
AAT-335, AAT-320, and AAT-332  
Typical Trowel Recommendation  
1/16" x 1/16" x 1/16" Square Notch Trowel  
Approximate Coverage 125-150 sq. ft. per gallon
- Permanent Installation  
AAT-275, AAT-280, AAT-295 and AAT-299  
Typical Trowel Recommendation  
1/16" x 1/16" x 1/16" Square Notch Trowel  
Approximate Coverage 125-150 sq. ft. per gallon

For releasable installations spread the specified adhesive with the appropriate trowel. Allow the pressure sensitive adhesive to dry before placing the cushion. The adhesive is ready to accept the cushion when it will not transfer to your finger. It is recommended that porous sub-floors be primed with AAT-570 Primer/Sealer to minimize adhesive absorption. For permanent cushion installations spread the specified adhesive with the appropriate trowel. Allow the permanent adhesive to tack properly before placing the cushion. *Releasable installations may not be appropriate with some carpets and/or cushions. Consult AAT regarding specific recommendations for woven, unitary backed, multiple needle bar graphics, other stiff backed carpets, and all installations over prime urethane or bonded cushions.*

## Seam Sealers

- AAT-181 Universal Seam adhesive, designed for seaming with or without tape.
- AAT-125 Seam Adhesive (non-flammable) solvent based seam adhesive (contains no 1,1,1 Trichloroethane). Apply a 1/8" bead on all seams where hot melt tape is not used.

## Other Double Glue Installation Tips

- Cushion should be laid at right angles to carpet direction. If this is not possible, a minimum of six (6) inches should be maintained between pad seams and carpet seams.
- The tacky installation method should be used for carpet to pad, minimizing the possibility of wet glue being pressed into the carpet's secondary backing construction and also the potential for bubbling due to moisture evaporation.
- The wet installation method should be used for woven carpets. This allows for easier adjustments in pattern match.
- Floor fans can be used to help reduce necessary open time of adhesives used.
- Cushion should be pressed into the adhesive by using a carpet core or back edge of an industrial broom. Carpet to pad should be rolled in North-South and East-West directions using a 35 lb. roller, or the equivalent, with weight not to exceed 35lbs.
- The installation should be protected from all traffic for 24 hours, and from heavy and/or roller traffic, as well as heavy object placement, for up to 72 hours. Traffic on wet, uncured adhesive can cause bond failure, which may not become apparent for months after occupancy.
- Do not wet clean the carpet for a minimum of 30 days after completion of the installation. This will allow the adhesive to cure properly. The cleaning and maintenance program for this type installation must meet carpet manufacturer's specifications and/or IICUC Standard S001. Over wetting and use of chemicals with a 9.0 or higher pH level must be avoided.

## Adhesive Warranty

Advanced Adhesive Technologies, Inc. reserves the right to make specific recommendations or changes in material for each individual double glue installation. If a problem should occur due to the adhesive recommendations or performance, AAT will pay for reasonable repairs or replacement expenses which would be prorated as to time, use, and cost of the original installation. AAT reserves the right to inspect or have an independent inspector or certified laboratory review any claim or complaint which might involve AAT adhesive or products.

AAT cannot and will not be held responsible for the quality or suitability of the carpet and/or padding to be installed and warranted. Cleaning and maintenance methods are also beyond the control of AAT. Refer to IICUC Standard S001-1991 and the carpet and/or pad manufacturers guidelines for proper cleaning and maintenance procedures.

AAT adhesive warranty for double glue installations is seven (7) year pro-rated warranty based on the correct use and procedures of its adhesives and approved cushions. Both labor and materials are warranted against adhesive failures due to defective or improper adhesive quality. A 100% replacement on labor and materials will be honored for the years performance should adhesive failure occur. The seven-year warranty will cover reasonable cost on repair labor at a rate of seventy-five (75) percent for the second and third years (part or whole) that the installation has been installed; fifty (50) percent for the fourth and fifth (50) percent for the sixth and seventh years. The cost covered on replacement labor is fifty (50) percent for the second and third years; twenty-five (25) percent for the fourth and fifth years. No replacement labor cost is covered for the sixth and seventh years. For materials cost on carpet repair or replacement, a straight-line depreciation schedule will be calculated for the second through the seventh year based on mill prices.

This document supersedes any and all documents and specifications for double glue procedures and warranty.