

# Mohawk Group

## Installation Guidelines for Tufted and Woven Goods Double-Stick Installation

ActionBac  
Unibond Flex  
Unibond Flex Bloc  
Weldlock Bloc  
Weldlock Plus  
Woven

 Mohawk Group  
1975 West Oak Circle  
Marietta, GA 30062  
800-554-6637  
[www.themohawkgroup.com](http://www.themohawkgroup.com)

Field Services Department  
405 Virgil Drive  
Dalton, GA 30721  
800-833-6954

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 The Mohawk Group

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Bigelow

 DURKAN

**Carpet Installation Check off List**

1. Newly poured concrete floors generally will take 90 to 120 days to cure. Moisture should not exceed 5 lbs./1000sf per 24 hours as determined by a calcium chloride test per ASTM F1869, or 80% relative humidity per ASTM F2170. If the results are more than 5 lbs or higher than 80% RH, do not proceed with the installation. Contact Field Services at 800-833-6954. Gypcrete or substrates with excessive dust must be cleaned, and then primed with The Mohawk Group's (TMG's) PrimeCoat or an approved primer, such as a latex milk additive.
2. The alkalinity or pH in a concrete slab should be between 5 and 9 for a glue-down installation. When pH is between 9-12 and moisture is below 5 lbs or 80% RH, PrimeCoat can be used to block pH. Should the pH be outside this range, stop and do not proceed with the installation. Contact Field Services at 800-833-6954.
3. The floor and room temperature must be acclimated by maintaining the temperature at 65° F and 95° F, and the humidity between 10% and 65%, for at least 48 hours before, during, and 72 hours after installation. In addition, the carpet, adhesive and seam sealer should be stored under these conditions for at least 24 hours before installation. The installation site must be acclimated with HVAC in operation.
4. Old adhesive must be properly removed prior to any installation of TMG's branded carpet.
5. Mechanically remove all wax, dirt, grease and paint. DO NOT use solvents to clean the floor. DO NOT use oil based sweeping compound. Fill cracks more than 1/16-inch wide with a Portland or cement based patching compound. The floor must be flat to within 1/8" in 10 feet. Use leveling compound when required. Patched areas may need to be primed (Consult patch manufacture for requirements) with PrimeCoat or an approved primer. DO NOT install over resin or silicate based curing compounds.
6. Inspect all carpet prior to cutting, and contact your sales representative before installing the carpet if you discover any problems. No claims will be allowed for visible defects after the carpet has been cut and installed.
7. Carpet should only be bent when absolutely necessary for transporting purposes only and must be unrolled immediately. Carpet should be rolled out and allowed to relax for at least 24 hours prior to installation.
8. Never cut carpet over carpet, as this can result in over penetration of the blade and cutting loops on the lower carpet. Never install broadloom carpet over existing carpet.
9. Carpet should be protected from heavy traffic and construction dust with a non-staining building material paper. Never use plastic sheeting as it will trap moisture and prevent proper curing of the adhesive. Plastic may also leave residues that can result in rapid soiling after removal.
10. Furniture placement and heavy traffic should be avoided for at least 24 hours after a direct glue or double glue installation. Furniture and heavy equipment concentrated pressure, and movement over unprotected carpet can cause adhesive breakdown. This can result in buckling and/or wrinkling. It is strongly recommended that plywood or masonite boards be placed over the carpet during the move-in phase to spread the concentrated weight of furniture and heavy equipment.

**Please Note**

1. Asbestos-containing floor tiles, any adhesive possibly containing asbestos, or other asbestos- containing floor coverings require special preparation, handling, and removal procedures. Consult the appropriate local or state authorities or the Resilient Floor Covering Institute before disturbing any suspected asbestos-containing material.
2. Unibond Flex Bloc and Weldlok Bloc cannot be installed using the tackless/stretch-in method. Attached cushions can only be installed by the direct glue method.
3. Installation of TMG's broadloom carpet on a floor outside the scope of the guidelines in this document will void all applicable warranties.
4. The Mohawk Group is not responsible for any product failure due to improper floor preparation and/or installation procedures. The required adhesives are TMG's family of adhesives.

**Required Equipment**

The following items may be purchased from a local carpet workroom supplier.

- NuBroadlok Adhesive
- TMG EnPress PSA
- NuBroadlok Edge Sealer
- Row Runners
- Cushion back cutter or top cutter
- 1/8" x 1/8" x 1/16" U-notched trowel
- 1/16"x1/16"x1/16" square notched trowel
- Mini or Crab Stretcher and Power Stretcher
- 35 to 50 lb. Roller
- Straight Edges
- Razor Knives
- Dead Man
- Hammer
- Stay Nails
- Dry Line
- Chalk Line
- Tape Measure
- Knee Kicker(to position carpet only)

TMG does not recommend the use of tool trays, carpet cores, or boards to transfer adhesive from cushion to carpet. These methods usually result in squeezed-out adhesive and could cause pockets of poor adhesion (bubbles).

**Layout Carpet**

It is always advisable to lay out the carpet the day before the installation. This allows the carpet to relax and improves performance. When feasible, install so the majority of the traffic moves in the lengthwise direction of the carpet.

**Cushion/Padding**

Felted underlays (Synthetic Fiber Cushion) such as Durkan's EcoComfort Step, or hair and jute underlays should be at least 28 oz. in weight and should not exceed 3/8" thickness.

Flat rubber or urethane foam padding should not exceed 3/8" thickness and must have a minimum density of 16 lbs.

**Installing Cushion/Padding**

Cushion should be installed in the longest lengths possible, taking into consideration traffic pattern and seam placement. Offset cushion seams from carpet seams by 6 inches. After breadths are in place, fold or roll cushion back and spread with TMG EnPress PSA Adhesive with a 1/16" x 1/16" x 1/16" square notched trowel and allow the adhesive to set until tacky. Lay cushion into adhesive and trim flush with the wall or baseboard. NuBroadlok can also be used to adhere the cushion to the floor using a 1/16" x 1/16" x 1/16" square notched trowel. Spread rate for the 1/16"x1/16"x1/16" square notch trowel is 16-22 yds per gallon.

**Pile Direction**

All full-width carpets have an arrow on the back running approximately 2 feet from the selvage along one side of the carpet. This arrow indicates pile direction. The pile direction can also be checked by the selvage edge. There should be a different color strand running down the length of each side of the selvage. When seaming, the pieces of carpet should be joined with the arrow running in the same direction on each breadth. All cut carpet used as fill pieces should be marked to indicate pile direction before the arrows are removed.

**Carpet Cutting and Seam Trimming**

The seams must be trimmed on the row to ensure that patterned carpet will be matchable. If all possible, trim between patterns in the solid areas of the background. Use a row runner, straight screwdriver, awl, etc to open rows.

Tufted carpet is recommended to trim the selvage with a loop pile cutter or cushion back cutter utilizing a sharp blade. Hold at a slight angle so that more of the backing material is removed. Head seams should be cut from the face with a straight edge and cushion back cutter from pattern to pattern.

Woven carpet is recommended to trim all the seams with a loop pile or cushion back cutter. Cutter should be held straight up and down.

Apply a bead of NuBroadlok Edge Sealer to all cut edges of Woven grades immediately after trimming. Press the latex into the base of the pile with thumb, smoothing out any lumps. Be careful not to rub the edges, which could distort the seam. Allow the Edge Sealer to completely dry before proceeding.

**All seams must be sealed with NuBroadlok Edge Sealer and be heat tape seamed.**

Unibond Flex™ systems require a special seaming tape that is an EVA derivative such as Seam Master Sinch tape and Stixx S125. For all other backing a premium double stick tape is acceptable.

### **Transitions**

All cut edges at transitions must be sealed or covered with an appropriate molding to protect the edges.

### **Pattern Matching**

It must be understood that carpet is a textile and cannot be made to exact specifications. All patterned carpet is subject to certain manufacturing tolerances, therefore a perfect pattern match cannot be guaranteed. However, a match should be achievable by stretching the short side out to meet the long side. Tolerances for patterned carpet are:

**Bow:** 1-1/2 inches across the 12-foot width

**Skew (bias):** 1-1/2 inches across the 12-foot width

**Pattern elongation:** 1-1/2 inches in 12 feet along the length

**Please Note:** If you are having trouble matching a pattern, STOP and call Field Services at 800-833-6954.

### **Roll Sequencing by pattern count**

Rolls of patterned carpet must be sequenced so the longest pattern is installed first and the roll with the next longest pattern can be stretched to match the longer one. This procedure is critical, because it is impossible to shrink a longer pattern to match a shorter pattern. This requires each roll be measured for pattern repeat prior to installation. See specific pattern elongation installation procedures below.

### **Correcting Pattern Elongation**

All rolls should be dry-laid and the pattern repeat measured to establish the correct roll sequence. The longest pattern must be installed first, then the next longest, etc. This allows the shorter pattern to be stretched to the longer pattern, and keeps the closest pattern repeats together. After the roll sequence is established, glue half the long pattern and half the shorter pattern lengthwise. Stretch the shorter pattern to match the longer pattern by starting the center of the seam and stretching toward the ends. Stay nail will be needed to secure the pattern match as the adhesive sets.

### **Corrective Steps for Bow and Skew**

Make a cut across the patterns at one end. Then apply the adhesive using the proper trowel. Push the short corners to the wall and stretch the excess carpet created by the bow or skew to the opposite wall using a power stretcher and crab stretcher. Use stay nails to hold the pattern in place until the adhesive sets. Follow this procedure throughout the installation. In large rooms start in the center of the seam correcting the bow & skew with a stretcher or mini stretcher. A dry line should be placed along the pattern for reference.

### **Applying Approved Adhesive**

NuBroadlok is the only adhesive approved for use in double-stick installations. The use of NuBroadlok Adhesive is vital to ensure optimum results. Applying an improper adhesive can result in an installation failure for which TMG cannot be held responsible. To make certain that the proper amount of adhesive is transferred to the back of the carpet, a 1/8" x 1/8" x 1/16" U-notched trowel must be used. This will result in a spread rate of approximately 5 - 7 yards per gallon.

**General Installation Procedures**

1. Cut carpet to the necessary length and lay into proper position. Trim selvage, following yarn row on tufted and woven products when possible. When trimming seams, do not allow the knife to penetrate through the cushion, as this could cause loss of adhesive.
2. Fold carpet a workable amount on each side of the seam and apply NuBroadlok Multi-purpose, using a 1/8" x 1/8" x 1/16" U-notched trowel. The spread rate should be 5 to 7 square yards per gallon. Allow the adhesive to set, using the proper open time before placing carpet into the adhesive. Open time depends on the amount of humidity in the area. Higher humidity requires a longer open time. A good double-stick pad will not absorb adhesive so it will take longer for the adhesive to reach the tacky stage.
3. INSTALLING CARPET BEFORE THE ADHESIVE HAS REACHED THE TACKY STAGE WILL RESULT IN INSTALLATION FAILURE.
4. After sufficient open time, fold or drop one side of the carpet into the adhesive. Apply seaming tape under the seam. Fold and push the next side against the first. Use procedures described above to align the pattern at seam and correct bow and skew.
5. After seam is aligned, hot melt the seam together.
6. Roll carpet into the adhesive using a 35 to 50 lb. roller both widthwise and lengthwise to ensure good transfer of adhesive to the back of carpeting. This will allow the adhesive to penetrate the carpet backing properly.

**Please Note:** The use of TMG's branded adhesives are required to ensure optimum results and are the only approved adhesives that TMG will warrant. Failure to use TMG's branded adhesives can result in warranties being null and void.

*This information, offered as a customer service, is based on TMG's engineering tests and field experience. It is intended for installers with professional experience, to be used at their discretion and risk. TMG does not guarantee results and assumes no liability in connection with these installation instructions.*