

INSTALLATION INSTRUCTIONS FOR Graphic Carpet

**Read this information carefully before
installing any Graphic Carpet**

IMPORTANT NOTES

1. The manufacture of carpet is a multi-step process involving many people and machines. Every effort is made to insure that each roll shipped meets the highest standards of workmanship and quality.
2. All seams must be properly sealed using a certified seam sealer.
3. All pattern carpets, due to manufacturing processes, are subject to some pattern run-off when pattern matching. **WE DO NOT GUARANTEE EXACT PATTERN MATCH.**
4. No claim will be considered for roll crush of olefin fabrics as this is a characteristic of the fiber.
5. All carpet should be rolled out and stored at 70° F for a minimum of twenty-four hours prior to installation.
6. Read all instructions prior to beginning any installation.

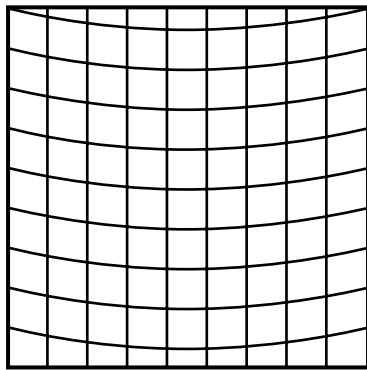
Note: In addition to these instructions, all installations must be performed in compliance with **CRI 104, THE CARPET AND RUG INSTITUTE STANDARD for INSTALLATION of COMMERCIAL CARPET.** The CRI "**STANDARD**" emphasizes the requirements of power-stretching and seam-sealing as well as many other proper installation procedures that improve carpet performance and reduce claim potential.

REMEMBER: If you don't have time to do it right, you surely don't have time to do it over!

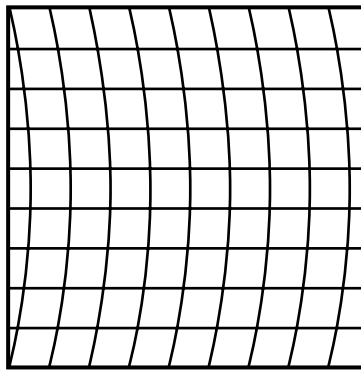
All pattern carpet is subject to certain industry tolerances. We feel our tolerances are more stringent than standard industry tolerances. Our tolerances are as follows:

NOTE: Stop installation and contact mill if the following tolerances have been exceeded.

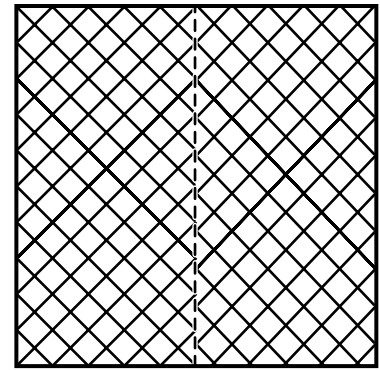
1. If bowing is greater than 1 1/2 inches in 12 foot width or 1 1/2 inches in 30 foot length.
2. If Pattern Elongation is more than an average of the following:
 - A. On patterns with repeats of less than 4", the tolerance is up to 2" per 12 feet.
 - B. On patterns with repeats of from 4" to 8" the tolerance is up to 1 pattern in 30 feet.



#1 BOW WIDTH



#2 BOW LENGTH



#3 PATTERN ELONGATION

We have established our tolerance so that a match should be achievable by *stretching* the short side to meet the long side.

WE DO NOT GUARANTEE PATTERN REPEAT MATCH

HOW TO: TRIM PATTERN

On all graphics items, it is extremely fundamental to know that the pattern is actually *tufted into the carpet, not printed on*. Because of this tufted-in characteristic, the pattern and the rows must line up. You must cut the center row of a diamond pattern and follow that row. Regardless of how far you travel, that row will fall in exactly the same place in the pattern every time it repeats.

Because of the tufted pattern characteristics, it is most helpful to use a blunt object (screwdriver, awl, etc.) to open up the row prior to using a row cutter to follow the row, thus cutting the pattern in exactly the same place each time. **(*If the pattern is not cut on the row, it will not match! Chalk line, straight edge, or freehand cuts are not recommended and will not achieve a match!)**

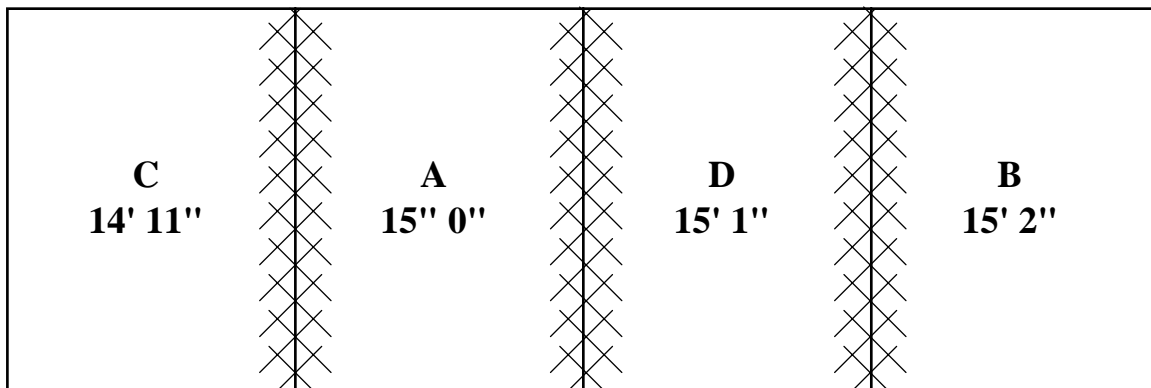
HOW TO: MATCH PATTERN (CORRECTION FOR PATTERN ELONGATION)

Once the patterned carpet has been trimmed in the proper fashion (always use center of diamond patterns):

1. An easy way to determine which cuts will match best is to count off 30 patterns and compare the measurements to determine sequence.

EXAMPLE: DROP: A 30 patterns measure 15' 0"
B 30 patterns measure 15' 2"
C 30 patterns measure 14' 11"
D 30 patterns measure 15' 1"

The proper judgement in this example is to place the drops as follows to diminish the pattern elongation 14' 11", 15' 0", 15' 1", 15' 2".



In this example, the elongation from least to greatest is 3" or 1.6%. Experience has shown that most carpets easily stretch 1.5% - 2% with a power stretcher. The deviation between Drop A and Drop C is only 1/2 of 1%.

2. Dry fit all pieces prior to beginning installation.
3. Cut 24 hours in advance if possible. This allows the carpet to relax.
4. If pattern is only slightly off, tightly rolling the (short side) drops face out and leaving rolled for 24 hours can help.
5. Match all patterns in center of seam and work toward ends.
6. If you are missing dye lots, do not expect color or pattern to match.

THE PROCEDURE

First, determine the short patterned and long patterned side. Since there is no dependable way to shrink a synthetic tufted carpet, we must use a process we know - stretching. We are simply going to stretch the short pattern side out to meet the long pattern, so:

In Glue Down Installations:

1. Glue long pattern drop in place approximately 4' - 6' wide and full length using approved adhesive.
2. Starting from center of seam (and start with center panel if more than two panels are involved), glue as far toward each end as the pattern matches and 4' - 6' wide on the short pattern drop.

(Glue Down Installations continued)

3. Seal all seams with good quality seam sealer.
4. Place carpet in adhesive making seam only as far as match will allow.
5. Roll with lino roller and allow to set up 15 - 30 minutes. Stay-tacking may also be helpful.
6. Roll the side with short pattern up from ends toward center until you come back to the glued areas.
7. Glue 8' - 10' length by 4' - 6' width (or as much as you feel comfortable with).
8. Unroll carpet into adhesive. As long as adhesive is wet it is slippery, not tacky (this will aid in step #9).
9. Using *power stretcher* (not kicker), stretch pattern into register roll and stay-tack (a two head power stretcher works great, one head on each end).
10. Repeat steps 6 - 9 until seam is complete. Leave stay nails in place until glue sets.
11. Use this procedure on each of the other seams.
12. The best way to determine pattern match is to stand back and sight down the diagonals formed by the pattern.

* Remember, we can only stretch the short side (not shrink the long side). Lay out all work so this can be accomplished. Never glue the short side first. *Use of the power stretcher is basic to the installation of all carpet made with ActionBac. A knee kicker can't obtain and hold the necessary amounts of stretch. Failure to use a power stretcher is the major cause of having to restretch!*

In Stretch Installations:

1. Loose lay all drops in place in proper sequence (see #1 - Correction for Pattern Elongation Procedure). Allow to relax for 24 hours if possible.
2. Trip and prepare seams per instruction.
3. Once long and short side is determined, use a two head power stretcher (one head on each end) on short side to match pattern.
4. As always, begin pattern matching in center of the drop. This divides the pattern elongation and makes for less work.
5. Run hot melt seam, making minor adjustments with knee kicker. Run short lengths of seam if necessary. Allow to cool and readjust as needed.
6. The best way to determine pattern match is to stand back and sight down diagonals formed by pattern.

****Be Patient; Be Persistent; Be Professional**