

# DOUBLE-BOND GLUE DOWN

## INSTALLATION BULLETIN

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In this type of installation, a separate cushion is adhered to the floor and the carpet is glued to the cushion, using the same methods utilized for direct glue-down.

**CAUTION:** These are general recommendations. Due to the significant differences that exist in various carpet cushions, you should consult with the manufacturers of the cushion and carpet for their recommendations in this type of installation. Only carpets and cushions specifically approved for this end use and application should be utilized for this type of installation.

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## SITE CONDITIONS AND FLOOR PREPARATION

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See Installation Bulletin WFT-1001 (rev. 02/02/04 ) Site Conditions and Floor Preparation for full instructions.

Check floor for moisture and alkalinity. The floor must be free of dust, oils, alkali, paint, grease, or other foreign matter. Check entire floor and secure loose boards, etc. Cracks 1/8" or more, holes, and unevenness must be filled with a compatible polymer modified cementitious floor patching compound. Surfaces should be vacuumed and thoroughly cleaned before application of the adhesive.

Note: some cushions with a previously applied pressure sensitive adhesive will require the use of a primer such as Taylor Envirotec #2000 Alka Prime Pre-Coat.

Carpet and adhesive must be stored at a minimum temperature of 65°F for at least 72 hours prior to installation. Carpet should be spread in the room 24 hours prior to actual installation, with room temperature between 65°F and 95°F. Building must be heated at a minimum of 65°F for at least 72 hours prior to installation with the relative humidity not more than 65%. The temperature should be consistently maintained at that level during the installation and for at least 72 hours after completion of installation.

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## CUSHION AND CARPET LAYOUT

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After all floor preparation is completed, the layout and cutting of the cushion should be completed. Cushion should be installed in the longest lengths possible with consideration given to the traffic patterns and seam placement of the carpet. Cushion seams should not be directly under carpet seams but should be at right angles to them. When this is not possible, shift either the carpet or the cushion so that the cushion seams are a minimum of 6 inches to one side of the carpet seams. Cushion seams must be butted without compression, leaving no gaps.

Cut the carpet to the proper length and spread out in the area to be carpeted. Carpet should be spread in the room 24 hours prior to actual installation, with room temperature between 65°F and 95°F. The carpet should be cut 3-4 inches longer than the area measurement. Where applicable, allow for pattern repeat. Carpet seams should be at right angle to cushion seams or at least offset a minimum of 6 inches to either side. Align carpet breadths to their proper position and trim the seams.

## TROWEL AND ADHESIVE RECOMMENDATIONS

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### Bonding Cushion to Substrate

Pressure Sensitive Adhesive: Some carpet manufacturers do not recommend releasable installations, follow manufacturer's guidelines. For bonding cushion to substrate. For ease of removal at the end of the carpet service life, you may use a pressure sensitive adhesive for gluing the cushion to the substrate. Use Taylor Envirotech #2027 Pressure Sensitive Adhesive or Taylor Meta-Tec #2082 Tuff-Lok XLink Carpet Tile Adhesive. A 1/16"x1/16"x1/16" square-notch trowel may be sufficient; however, this will depend on the cushion and the porosity of the floor. Rough concrete, particle board, plywood, etc., may require a larger trowel notch. Taylor #2027 can be applied quickly with a short-nap paint roller (the adhesive should be allowed to dry "tacky"). The floor should be covered with a continuous thin film of adhesive.

After the cutting and fitting is completed, fold back the cushion and apply the adhesive to the floor. After the adhesive is allowed to dry "tacky", lay the cushion into the spread adhesive. You will still be able to shift the cushion on the adhesive surface to reposition if necessary. Smooth out any air bubbles with a 2 ft. length of carpet core, push broom or bottom of tool box shelf. Do not use a heavy roller at this time.

Multi-purpose Adhesive: Premium multipurpose adhesive can also be used to glue down cushion; however, removal of cushion from the floor will be more difficult. Use Taylor Envirotec #2055 Performance Plus Fast Tack Carpet Adhesive, Taylor Meta-Tec #2081 Tuff-Lok X-Link Carpet Adhesive, Taylor Envirotec #2100 Delta Force Fast Grab Premium Carpet Adhesive, or Taylor Envirotec #2056 Redi-Set Super Premium Commercial Carpet Adhesive.

### Bonding Carpet to Cushion

The adhesive should be spread uniformly over the cushion with a 1/8"x1/8"x1/16" notch trowel. Use any of the multi-purpose adhesives listed above.

*Note:* The correct open time for the adhesive is required. The applied adhesive must develop "legs" or tack prior to laying in of the carpet into the spread adhesive. Open time will vary depending on the environmental conditions.

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## ROLLING

After sufficient open time, the carpet is to be pressed into the adhesive and rolled with the lightest possible roller that will achieve 100% transfer of the adhesive into the carpet back. It is recommended that the roller weight not exceed 30 lb. Roll in both directions, but do not over roll. Use of a heavier roller may cause bubbles in carpet. *Note:* A unitary backed carpet should be rolled a second time about 3 to 12 hours after the initial rolling to make certain a strong bond is established.

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## SEAMING

Follow carpet manufacturer's recommendation for seam sealing. When adhesive is required to prevent fraying and raveling at the seams a 1/8" continuous bead of seam adhesive should be applied to the base of the first edge where the face yarns enter the backing.

Use Taylor Touchdown #775 Carpet Seam Cement or Taylor Touchdown #2075 Carpet Seam Adhesive. These products are specially formulated for butting primary edges of the carpet where cuts have been made for seams. It will anchor the carpet tufts and prevent gaps in the seams. This will seal the first edge as well as the second when the edges are butted together to form the seam.

Sewn seams or hot melt seams may be used. Should the carpet have a tendency to shrink, it is recommended that the installer use hot melt seams. Be sure to use a hot melt seaming tape that is designated non-silicon. This would be a hot melt seaming tape backed with a non-silicon paper for double-bond applications. Use a tape specifically designed for carpet to cushion in double stick installations.

Caution must be taken to not cut into the cushion under the seam.

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## PROTECTION OF INDOOR INSTALLATION

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If required to protect the finished floorcovering from dirt or paint, or if additional work is to be done after the installation is completed, cover it with a non-staining building material paper.

Plastic sheeting should not be used over glue-down installations as it may trap moisture, retarding adhesive cure, and promoting mold and mildew growth. Protect the installation from rolling traffic by using sheets of hardboard or plywood in affected areas.

Traffic over adhesive installations should be restricted for a minimum of 24 to 48 hours to allow the adhesive to cure. Premature traffic can cause installation failure. Exposure to water cleaning and other sources should be restricted for a minimum of 30 days.

Temperature of indoor carpeted areas should never fall below 50°F regardless of the age of the installation.

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## SUMMARY

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The three leading causes for installation related failures are improper trowel selection, which leads to insufficient adhesive; failure to follow the “tacky” method of installation; and failure to protect from premature traffic.