



Stretch over Cushion Instructions

TECHNICAL BULLETIN

Attention: Before you start, read this bulletin and other applicable literature pertaining to the installation of carpet. **For additional information, refer to the CRI-105, which is the standard reference guide for Residential Textile Floor Covering Materials.**

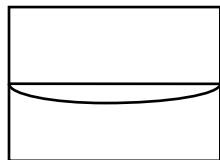
Before starting installation inspect for: Concealed damage, manufacturing defects and shipping errors (example: wrong color, style, etc.)

Warranties: Carpet which has been cut and installed with visible manufacturing defects may exclude all warranties.

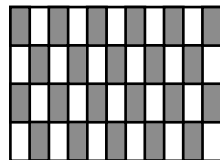
NOTE: Should other trades perform work in areas where carpet has been installed, the installer and / or general contractor assumes total liability for damage and deterioration, including wear, compaction, soiling, staining, abrasion, and stretching. Failure to provide adequate protection until occupancy may void all warranties.

CARPET CONDITIONING: A least 24 hours prior to installation, roll out carpet on the job site and smooth out wrinkles. Conditioning allows the carpet to relax and become more pliable for seaming and stretching for pattern match. **NOTE:** Failure to properly condition the carpet will not allow for a sufficient stretch, which may lead to wrinkling.

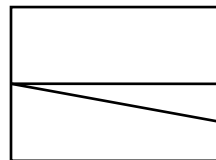
TOLERANCES: Fabrica products are manufactured to rigid quality standards. Because carpet is a textile product, certain tolerances are considered within normal limits and are not considered manufacturing defects.



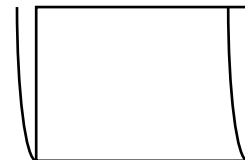
BOWING
0.75 in / 12 ft width



PATTERN REPEAT
1 % or 1.44 in / 12 ft



SKEWING
1.5 in / 12 ft



EDGE TRUNESS
0.50 in 12 ft length

JOB SITE CONDITIONS

TEMPERATURE: Minimum 65 F, 48 to 72 hours prior to, during and after installation.

RELATIVE HUMIDITY: Between 12 % and 65 %.

CONCRETE: Cured for 90 to 120 days, must be sealed.

WOOD FLOORS: Should have a minimum of 18" ventilated air space between the underside of the floor joists and the ground.

Install cushion so that its seams are perpendicular to the carpet seams. The cushion must be properly adhered with pad cement or staples.

SEAMS: A comprehensive seaming diagram must be submitted and approved by the purchasing parties prior to installation. **NOTE:** The seams should run lengthwise in major areas, parallel to traffic paths, into natural and artificial light sources, and be avoided at major pivot points where they may intersect perpendicular to doorways and entrances.

Roll Sequence: For best results install carpet in roll sequence. Check pattern lengths prior to making cuts. Arrange the cuts so that the longest patterns are installed first. Plan your work so that you can stretch the shorter patterns to match the longer ones if necessary. For solid colored textural patterns the roll dye lot sequence must be followed.

Pattern Matching: Dry lay all pieces prior to starting the hot melt tape application. This allows for potentially relocating some pieces for a more acceptable match. **PRE-STRETCH** breadths prior to seaming. This will allow for closer matches and less stretching.

Seam Cutting: Invisible seams are not guaranteed, however, excellent seaming is achievable when following these procedures.

- 1.) Using a straight bit screwdriver, awl or knitting needle, open up the tufted rows.
- 2.) Use a loop pile or cushion back cutter and follow the opened row and keep the blade opposite to the selvage edge.
- 3.) Head Seams: except under the most difficult situations, row cutting works well for head seams. Use of a seam stretcher or "crab" is also helpful for closing head seams.

Seam Tape: The use of 3 inch wide medium grade seaming tape is recommended. Six inch wide tape or tapes with extra hot melt do not add integrity to the seam and may telegraph their shapes through the carpet face. Use specialty tape for low profile products to reduce telegraphing and peaking along the primary backing.

SEAM MANUFACTURE

Seam Sealer: For hot melt seams, use a latex or an acrylic-based seam sealer. Apply a 1/8" bead of seam sealer to both sides of the seam and allow to sufficiently dry before applying the hot melt tape. This applies for both loop pile and cut pile carpets.

Seam Board: Always manufacture the seam over a hard surface. Failure to do so will likely lead to an unlevel seam with an unacceptable appearance. A seaming board works well for this. A seaming board is typically 8" to 10" wide and 3 ½' to 4' in length and made of 3/8" thick plywood, with a slot cut out at one end to slide the unbonded seam tape.

Seaming Iron: Set the thermostat for the iron between 2 ½ and 3. Increasing the temperature of the iron in an effort to speed seaming will only result in damage to the carpet back or face and a lower quality seam.

Seaming: Use a flat carpet tractor to press carpet backing into hot thermoplastic. Spike tractors may damage the carpet fibers. Use a weighted piece of wood or non-conductive material of about 2 feet in length to pull behind the seaming iron. This will aid in heat dissipation and allow for more uniform cooling. **DO NOT USE METAL**, such as a toolbox tray. This will trap heat and compromise the integrity and/or color of the seam.

Using a two head power stretcher or a "**dead man**", stretch the shorter patterns to match the longer ones. Use **stay nails** to hold the stretched side on pattern and use a knee kicker to close gaps or push any fullness toward the center of the carpet. Leave stay nails in place until the hot melt tape has completely cooled.

Complete the installation by obtaining a 1 % to 1 ½ % stretch in the length and snug tight in the width of the carpet. A **power stretcher** must be used. **Knee kickers** are positioning tools and lack sufficient force for stretching. Over stretching the carpet in the width will increase the probability of seam peaking. (See Bulletin # 104, Seam Peaking)