

**ATTENTION:** Always refer to the most current technical information available at [www.lonseal.com](http://www.lonseal.com), and review completely prior to starting the job. Lonseal reserves the right to change its products' design and material, or to improve products or processes at any time without notice. Installation procedures and use of Lonseal products must be in strict accordance with Lonseal's technical documentation for warranty terms to be valid.

**RELATED TECHNICAL DATA SHEETS:**

- ▶ #650 Two-Component, Solvent-Free Epoxy Adhesive
- ▶ Welding Thread

**APPLICATION:**

1. Prepare the approved substrate as detailed in the Interior Flooring Manual and ensure all products have been properly acclimated prior to installation.
2. Apply a full spread of the adhesive using a 1/16 x 1/32 x 1/32 in. (1.6 x 0.8 x 0.8 mm) U-notch trowel and place the flooring into the adhesive immediately. The #650 is a wet-set adhesive and allowing too much open time will reduce its bond strength.
3. Roll the flooring using a minimum 100 lb. (45.4 kg), three-section roller. Roll the floor again 2 to 3 hours later.
4. Heat weld all seams 24 hours after installation. See **Notes** below regarding flooring that cannot be heat welded due to their heavy embossing.
5. Perform initial maintenance 48 hours after installation.
6. The #650 will be fully cured 72 hours after installation.

**NOTES:**

- A. When cutting flooring to fit the installation location, be aware that sheet vinyl is subject to dimensional change. Lonseal accepts no responsibility for dimensional changes to flooring that is cut into shapes or cut outside recommended environmental conditions. The amount of change will depend on the environment in which the flooring is cut versus the environment in which it is installed. Keeping the flooring acclimated in similar, if not the same, environments can help reduce or eliminate this natural occurrence, as can cutting the flooring slightly larger than needed and trimming it to the correct size after installation. Optimal acclimation and installation conditions will be in a controlled environment between 65 – 85 °F (18.3 – 29.4 °C).
- B. Lonseal brand adhesives are intended to be used in a controlled environment to ensure they perform as intended. When not installing in a controlled environment, the adhesive may have different curing times. A bond test should be performed to determine how the adhesive will be affected by these types of installation conditions.
- C. Certain heavily embossed flooring are not able to be properly heat welded due to the height or spacing of the embossing. For this flooring, seams should be double- or underscribe-cut to ensure they are as tight as possible. This will minimize any gaps that could collect soiling. This option is only permitted when these types of floors are used with a full spread of the #650. All other flooring must be heat welded.
- D. DFT, Lonsealer, and all other Lonseal brand adhesives must not be used in elevator installations.