



AIRCRAFT INSTALLATION AND MAINTENANCE GUIDELINES

LONSEAL
FLOORING

Acclimate the vinyl in ambient room temperature prior to installation. Loose lay vinyl in the aircraft allowing for extra length and width when installing the material to be trimmed after tape application. Determine the center of the area marking on masking tape on the vinyl, and the substrate with a pencil. Make any necessary relief cuts; avoid any final trimming until after installing into the tape system.

Preparing the substrate – Substrate (i.e. fiberglass, phenolic or graphite floor board panels) should be free of all contaminants prior to installing any sealant, tape or moisture barrier on floor panels. A moisture barrier is recommended beneath the Lonseal flooring product for corrosion control.

Moisture Barrier – Obtain waterseal tape roll as a moisture barrier and pre-fit by laying down a section of tape with backing still in place. Mark the tape approximately 1.5” from the edge of the floor panel and trim the tape at marked locations. Remove the liner from the nonadhesive side of the tape prior to overlapping the adjacent section. Apply the second section of the waterseal tape by overlapping the first 4”.

Bonding Method – Apply double-sided aircraft tape to the top of the moisture barrier in a 100% area coverage with no overlapping. Full spread applications reduce the risk of buckling from rolling loads, and temperature changes. Remove the liner prior to installing the vinyl mat. Place the vinyl mat into the designated area to ensure

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good adherence. Once the vinyl mat is installed, the use of a roller (some are vibrating) can be used to ensure no air bubbles exist and the vinyl mat is completely bonded to the substrate.

Heat welding at seams – Please see the attached Heat Welding Guide for detailed instructions for seaming two sheets of vinyl matting.

Sealing the perimeter – Using a clear or color sealant, line the edges and perimeter of all exposed Lonseal vinyl flooring. Sealant bead should not exceed 3mm height restriction. When installing, using a towel, wipe up excess sealant and ensure full spread application.

INSTALLATION AND MAINTENANCE GUIDELINES

Lonseal's Floor Care Maintenance Program has been designed to extend the aesthetics and performance of Lonseal's resilient vinyl flooring products. Lonseal's sheet vinyl flooring products are chemically resistant to typical contaminants. Please contact Lonseal's Technical Support for further data on chemical resistance and particular cleaning agents outside of our recommendation.

INITIAL MAINTENANCE

1. Remove all surface soiling by dust mopping the flooring using a dry microfiber mop pad.
2. Dilute Loncare 2oz. per gallon of tap water. Using a spray bottle, spray the diluted Loncare onto the flooring and use a clean microfiber mop pad to clean the area of soiling.
3. Remove solution with a wet vac. then damp mop area removing residue with clean water, allow floor to dry.

ROUTINE MAINTENANCE

1. Dilute Loncare 2oz. per gallon of tap water, using a clean microfiber mop pad to clean area for application of floor care products. For embossed surfaces use of a firm bristled brush or plastic scraper may be necessary for removing engrained debris (i.e. gum, food).
2. Remove solution with a wet vac. then damp mop area removing residue with clean water, allow floor to dry.

NOTE: MEK, acetone and other abrasive solvents should not be used on Lonseal's sheet vinyl flooring products. These substances can cause permanent damage to the surface of the product including discoloration.

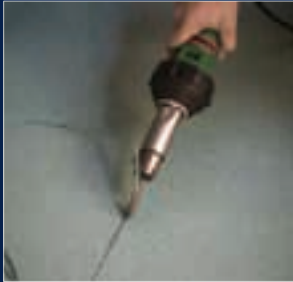
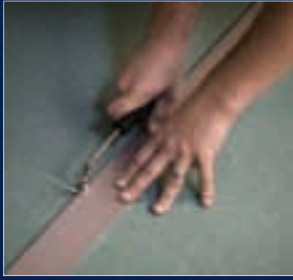
LONSEAL

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Heat Welding



Heat welding is the process of heat fusing two sheets of resilient sheet flooring together at a seam. A properly executed heat welded seam offers impervious reinforced seams recommended for areas of high traffic, exposure to excessive moisture (frequent washing), healthcare applications (sanitation), laboratories and clean rooms as well as floors subjected to heavy rolling or wheeled loads.

The welding thread is a 4mm diameter that is to be used with a 4mm nozzle. Larger diameter nozzles will cause improper bonding or permanent damage to the flooring, including burning and glazing of the vinyl wear layer surface.

Using a straight edge and grooving tool route or groove the seam. Maintain a consistent depth, of $\frac{1}{2}$ the thickness of the material, in the groove. Keep the groove area dry and clean of debris. Practice grooving and welding on scrap material.

Do not groove through to the backing of the material.

Welding

Allow heat gun to preheat to the desired temperature (600°F-700°F) prior to welding the sheets. Once the gun is properly heated, insert the welding thread into the nozzle as it comes into contact with the grooved seam. Make sure the angle of the nozzle is perpendicular to the floor and does not come into contact with the flooring; apply slight downward pressure to the nozzle with a smooth constant speed. If stopping; pull the heat gun from the floor and cut the welding thread, this will prevent the gun from scorching the surface of the flooring as well as the welding thread.

The flooring will be shiny on both sides of the welded area. This is normal for this type of method. Also a small area on either side of the welding thread will have ridging also known as a wash. Using the correct speed and temperature; ensure this area is not scorched or charred.

Trimming

Allow the welding thread to cool before trimming. Trimming or skiving is done in two passes:

a.) With a trim plate and a crescent (half moon) knife and **b.)** With the crescent (half moon) knife only. If attempted in one pass, the welding thread can shrink and cause concaving at the seam. Ensure the crescent knife is flush to the surface of the flooring for a smooth seam.

Glazing

To glaze the welding thread, using the same temperature, allow the gun to hover over the welding thread about $\frac{1}{4}$ ". Move slow enough to glaze the surface but fast enough not to blister the surface. Unglazed welding thread can make the seams visibly dirty and create an "off-color" to the material color. Glazing will correct color matching of the welding thread to the flooring product.