



Health Design Rubber Wall Base

INSTALLATION

This document is intended for professional use to provide minimum requirements for substrate preparation, adhesive application, and special installation requirements for a successful installation of these products, each unique application may require additional or further steps to ensure complete satisfaction. We rely on the expertise and professionals that are installing the products to adjust based on site conditions. Refer to product website to confirm that you have the most current revision of this document as the requirements contained within are essential to maintaining the full system warranty for the product installed. Documentation available at time of installation will be referenced regarding warranty.

RECOMMENDED ADHESIVES

The adhesives below are the recommended adhesives for the installation of this product. The first one listed is the primary installation method recommended for applications when the conditions are met as listed. Select the appropriate application method based on the conditions of the substrate. Refer to the adhesive technical data sheet for additional information and when to utilize a different adhesive.

Adhesive	Substrate	Installation Method	Recommended Trowel
WB-600	Absorptive	Wet-Set	1/8" V Notch Spreader from Pail Disposable Spreader Nozzle or 3 Hole Nozzle with a 1/8" V Notch Spreader from Cartridge
C-631	Non-Absorptive	Dry-Set	Roller or Brush Applied

Adhesive	Unit	Approximate Coverages
WB-600	Cartridges	50 lin. ft. Porous Only
WB-600	4-Gallon	240 lin. ft. per Gal / 960 lin. ft. 4-Gal
C-631	Quart	130 lin. ft. per Quart

STORAGE & HANDLING, INSTALLATION & SERVICE ENVIRONMENT, & ACCLIMATION

- All products must be stored in an indoor, climate-controlled (60° - 85° F) space and protected from the elements.
- All products must be stored on a dry, flat, level surface. Carefully stacked aligned neatly and not on edge. Do not stack pallets and protect products from damage.

The reported technical data information for these products is based on a formulation that is designed, manufactured, and evaluated to perform at constant temperatures, not fluctuating more than 10° from normal selected service temperatures from the allowable 60° F (15° C) - 85° F (26° C) range. These products are designed for service on substrate temperatures ranging from 60° F (15° C) - 85° F (26° C) unless otherwise noted in the specific installation section. These products are designed for service within ambient relative humidity between 40% and 60%.

Acclimation of the material is achieved when the following conditions are met within the installation area.

- **Service environment** is defined as the environment in which the materials will be utilized.
- **Service temperature** is defined as the normal setting of the HVAC in the environment in which the material is installed, i.e., typically 70° - 72° F in most commercial applications.
- **Temperature** must be maintained between 60° F (15° C) - 85° (26° C), preferably at the **desired service temperature**.
- **Relative Humidity** must be maintained between 35% - 65%, understand that Relative Humidity does not affect the installation of the material, but it can affect the functionality of the adhesives. Outside of the ranges, the stated information regarding open times, flash times, & dry times will vary.
- Facility must be fully enclosed, sealed and weather tight.
- Building HVAC must be up and running in permanent operation prior to installation (if temporary systems or systems other than the permanent HVAC systems are utilized it must be capable of maintaining the same conditions as the permanent HVAC and/or service conditions).



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- Maintain all products and adhesives in installation area at the **desired service temperatures** for a period of 48 hours prior to installation, during the installation and for the service life of the installation.
- It is recommended to utilize a cloud-based or similar **data logging system** during installation to provide temperature & humidity data in the event of a warranty issue.

While we do our best to provide quality products and workmanship in our manufacturing facilities, quality installation is the responsibility of the installer. Inspect all material for proper type, color, and matching lot numbers if appropriate. We ask that we are notified of any inaccuracies or defects prior to installation as **we do not pay labor for or material costs on installed materials with visual defects.**

Users are advised to confirm suitability of these products by their own tests and ensure that all adhesives intended for installation meet the requirements of the end user.

By covering a substrate, underlayment, or existing surface, you have indicated acceptance of substrate and installation environment.

If there are concerns regarding this information or the service temperature, substrate temperature or installation environment will not meet these requirements, please contact Technical Services for recommendations prior to installation at solutions@rhctechnical.com, we will be happy to discuss and provide direction or confirmation of the project at that time.

SUBSTRATE PREPARATION

All substrates must be clean, smooth, permanently dry, flat, and structurally sound. Substrates must be free of visible water or condensation, dust, sealers, water-based / acrylic paint, residual adhesives and adhesive removers, solvents, wax, oil, grease, asphalt, gypsum compounds, visible alkaline salts or excessive efflorescence, mold, mildew and any other extraneous coating, film, material, or foreign matter.

- Substrate must be a structurally sound interior wall surface, such as dry plaster, cured drywall, fiber-reinforced plastic (FRP) panels, hygienic wall cladding, fiberglass, exterior grade plywood (Group 1, CC type), concrete, metal, and/or masonry.
- Fiber-reinforced plastic (FRP) panels, hygienic wall cladding, fiberglass, metal, and/or painted masonry surfaces should be treated as non-absorptive or non-porous and C-631 Contact Adhesive should be utilized for successful installation.
- Any cracks, voids, divots, grout lines and imperfections should be filled with a patch or filler suitable for the substrate.
- **Gaps** at the bottom of a wall shall not exceed 1/2" when installing a base with a toe and not exceed 1/4" with toeless base, although it is preferred to have substrate backing all the way to floor with toeless base.
- When installing directly over a resinous product, such as epoxy paint, ensure that coating is dry to the touch and has cured for the prescribed length of time. These installations are recommended only with the C-631 Contact Adhesive.
- Metal substrates must be thoroughly sanded/ground and cleaned of any residue, oil, rust and/or oxidation. When installing in areas that may be subject to topical water or moisture and/or high humidity, an anti-corrosive coating must be applied to protect metal substrate. Contact a local paint or coating supplier for coating recommendations. These installations are recommended only with the C-631 Contact Adhesive.
- It is also recommended when installing on **very smooth or glossy substrates such as smooth FRP or metal**, to abrade the substrate to improve the bond of the adhesive.
- Do not install over **expansion joints, isolation joints**, or other **moving joints** in the substrate. These joints must be honored and not filled with products that are not intended for that purpose.
- **Construction joints, saw cut joints, voids**, and/or **cracks** that are not moving may be covered. These should be prepared appropriately to ensure they do not telegraph through the flooring. Should the slab move and cause the preparation to move, the flooring will telegraph the preparation product. Any resulting visual changes or damage to the flooring resulting from this movement is not covered by the product warranty.

Regarding substrate preparation when mechanical sanding, grinding, shot blasting, and vacuuming always follow the Resilient Floor Covering Institute's (RFCI) "Recommended Work Practice for Removal of Existing Floor Covering and Adhesives," and all applicable local, state, federal and OSHA requirements regarding Asbestos and Silica containment regulations.

NON-APPROVED SUBSTRATES

Existing Wall Base products or Concrete substrates that have been abated or prepared with chemical adhesive removers, solvents, or chemical cleaners.

Existing Wallpaper or other coverings that are not permanently secured to the structure. Wallpaper and vinyl wall coverings are not suitable for bonding and need to be removed prior to the installation of the wall base. It is acceptable to leave 1/8" – 1/4" behind the top of the base to ensure a clean edge.



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ADHESIVE BOND TEST

An **adhesive bond test** must be performed using actual wall base and adhesive materials being installed to determine adequacy. Test areas should be a minimum of 36" and remain in place for at least 72 hours prior to evaluation for bond strength to the substrate. This will help to ensure application of the adhesive and the bond achieved is adequate for the project to continue.

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With Health Design Wall Base we do recommend that corners are created on the jobsite with the wall base materials being installed.

- Apply adhesive to the back of the wall base or wall surface **within 1/4" of the top** of the wall base to prevent oozing.
- Install wall base to substrate within 10 minutes of adhesive application without stretching or over-compression during installation. Stretching material or over-compressing seams and corners may cause wall base to shrink and/or curl/delaminate, respectively.
- Periodically lift material to ensure proper adhesive coverage, **adhesive should cover 75%** of material when rolled into place.
- Using a suitable hand roller, carefully **roll material in the direction of the last piece installed** with a hand roller to ensure contact with adhesive within 30 minutes of installation.

CREATING CORNERS ON THE JOBSITE

The preferred method of finishing the corners with the Health Design Wall Base is to miter the corners on site and heat weld or finish them acceptably to the facility owner. It may be necessary to use installation tape or some other type of instant grab adhesive at the corners to help hold the material while making cuts. This method works for all inside and outside corners of any angle. The measurements would need to be adjusted of course for the different angles such as the 135° corners.

When corners are being considered, it is imperative they are square and not rounded or radiused. Rounded corners are more difficult to create with the Health Design Wall Base and they are more difficult to keep bonded in an environment that may be abusive. If installing on a rounded substrate corner, it is recommended to create two angles roughly 1" apart to soften the radius. Create these angles by cutting @ 22.5°.

Inside Corners

- Finish the base square into the corner in either direction.
- To prepare for the other piece, trim the base from the top of the base to the top of the cove portion at a rough 45° bevel.
- Trim from the top of the cove portion to the end of the floor section at a less than 45° angle to the end of the floor section, you will need to double-cut this section after the second piece of the corner is installed.
- Take the end of the piece to make the other side of the corner and ensure it is square.
- Trim the base from the top of the base to the top of the cove portion at a rough 45° bevel top fit the corner.
- Trim back some of the material from the top of the cove to the end of the floor section at a less than 45° angle.
- Place the material into the corner and align the top, double cut the cove portion to fit into the corner, trying to keep the seam as tight as possible to make the welding or finishing easier.
- After trimming the cove, you can double cut the floor portion to fit tight and finish the corner.
- Follow the same guidelines for the application of adhesive to the wall base or substrate for the corners as well.

Outside Corners with Straight Wall Base

- Run either side past the corner long enough to allow for double cutting the floor section to create the corner.
- Trim back some of the material from the top of the base to the top of the cove portion at a rough 45° bevel.
- Trim from the top of the cove to the end of the floor section at a less than 45° angle, you will need to double cut this section after the second piece of the corner is installed.
- For the other piece of the corner, place the section just longer than the previous side piece and start trimming from the top of the base to the top of the cove to fit tightly.
- Trim the cove section so that it lines up with the other side of the corner, and then double cut the floor portion to finish the corner.
- Follow the same guidelines for the application of adhesive to the wall base or substrate for the corners as well.



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HEAT-WELDING HEALTH DESIGN WALL BASE

Health Design Wall Base may be heat-welded vertically and horizontally. Ensure that adhesive has cured for recommended period prior to beginning heat-welding.

All vertical (base-to-base) seams must be heat-welded with **Flexco Vinyl Weld Rod** and must be welded prior to welding the horizontal seams.

Horizontal (flooring-to-base) seams must be welded with the **Flooring Weld Rod** that is recommended for welding the flooring material being used.

- Prior to cutting heat-welding groove, ensure gap between seams is free of adhesive, dust, dirt, debris and contaminants.
- When using a hand grooving or electric grooving machine, test groove depth on scrap material to ensure proper depth is achieved.
- While grooving, ensure removal is split between each side of the materials, 50% per side.
- Hand-grooving may be required near walls, protrusions, and other obstacles.
- Remove all loose pieces of material, as well as any other debris from groove prior to welding.
- Using a hot air welding gun, insert the Welding Rod through the welding tip and into the center of the routed groove or seam.
- **Prior to welding, test weld on scrap material to ensure temperature settings and welding speeds are correct and achieve a successful bond on both products.**
- Do not allow foot traffic or trim welding beads until welding bead has completely cooled.
- To trim seam, use a clean, sharp quarter-moon spatula knife and a clean trim plate or a Crain Mozart trimmer.
- Use an X-Acto Trimmer with a round blade when trimming cove areas and use extreme caution.
- **After one-hour**, trim seam again with a quarter-moon spatula knife to create a smooth, level seam surface.
- **The use of a mild household dish soap and water mixture in a spray bottle can assist in easier and smoother final skiving of the weld rod. Be sure to not spray water into open seams.**
- After final skiving of Weld-Rod, **glaze the trimmed seam with a heat gun to achieve proper color.**

POST INSTALLATION WALL BASE PROTECTION

We recommend that the installation of wall base be performed after all other trades have completed their work. If this is not possible, properly protecting the new wall base is essential to prevent damage. So, the following should be considered immediately following the installation process.

- Protect newly installed wall base with construction grade undyed kraft paper or protective boards, such as Ram Board, ThermoPLY, 1/8" Masonite panels, or other materials to prevent damage by other trades.

SUPPORT & ADDITIONAL RESOURCES

Product Support Phone & Email	(800) 633 – 3151 / info@flexcofloors.com
Technical Support Phone & Email	(844) 393 – 4044 / solutions@rhctechnical.com
Product Technical Documentation	www.flexcofloors.com
Associated or Related Documentation	Excelsior WB-600 Wall Base Adhesive Excelsior C-631 Contact Adhesive Referenced Standards within Technical Documents Technical Bulletin Wall Base & Accessories Care & Maintenance

The contents contained within this Installation Sheet may be utilized or copied into another projected related document, but this original document will remain in effect at the time of product installation, this TDS shall not be supplemented or replaced by the resulting project documentation. **Any alterations to the wording or requirements contained in or derived from this document shall void all related warranties.**

Prior to acceptance of this document refer to the product website to confirm that you have the most current revision.

These products are intended for installation by professionals, prior to use the user must determine the suitability of our products for the intended use, and the user alone assumes all risks and liability.