

XIONGXING GROUP

(PVC Flooring Construction Process and Technical Requirements)

1. Flooring Inspection

- 1). Use the temperature and humidity meter to detect the temperature and humidity, indoor temperature as well as the surface temperature to 15 °C is appropriate, should not be below 5 °C and above 30 °C construction. The relative air humidity suitable for construction should be between 20%-75%.
- 2). Use moisture content tester to test the moisture content of the grass-roots level, the moisture content of the grass-roots level should be less than 4%.
- 3). the strength of the grass-roots level should not be less than the requirement of concrete strength C20, and the surface hardness of the grass-roots level should not be less than 1.2Mpa using hardness tester.
- 4). grass-roots leveling should be less than 5 mm difference in height within the range of 2 meters straightedge, such as direct laying of PVC flooring without self-leveling ground leveling difference in height should be less than 2 mm.
- 5). Use a small steel hammer to knock on the surface of the grass-roots level to check whether there are empty drums; visually inspect the surface of the grass-roots level to see whether there are cracks.

2. Flooring Pretreatment

- 1). Use a floor polisher of 1800 watts or more with appropriate abrasive pads to polish the floor as a whole to remove paint, glue and other residues, raised and loose pieces of ground.
- 2). Use industrial vacuum cleaner of not less than 2000 watts to vacuum and clean the flooring.
- 3). For the cracks on the flooring, stainless steel reinforcement and quartz sand can be used to repair the surface of polyurethane adhesive; those with empty drums need to be shoveled out and repaired.

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3. Self-levelling construction - priming

- 1).absorbent grass-roots leveling layer such as concrete, cement mortar should first use multi-purpose interface treatment agent for closed priming.
- 2).non-absorbent grass-roots level such as tile, terrazzo, marble, etc., must use dense (non-absorbent) interface treatment agent for priming.
- 3). such as grass-roots moisture content is too high (> 4%) and need to immediately construction, can use epoxy interface treatment agent for priming, but the premise is that the moisture content of the grass-roots level should not be greater than 8%.
- 4).The construction of the interface treatment agent should be even, no obvious accumulation of liquid. After the interface treatment agent is dry, the next step of self-leveling construction can be carried out.

4. Self-levelling construction - Mixing

- 1).Weigh the water according to the water-cement ratio on the self-leveling bag, pour the self-leveling cement into the mixing bucket with the weighed water, and mix while pouring.
- 2).To ensure even mixing of self-leveling, use high power and low speed electric drill with special mixer for mixing.
- 3).Stir until there is no lump of uniform slurry, leave it to ripen for about 2 minutes, then stir it again briefly.

Note: The amount of water added should be strictly in accordance with the water-cement ratio (please refer to the corresponding self-leveling instructions). Too little water will affect the fluidity. Too much will reduce the strength after curing.

5. Self-levelling construction - Laying

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- 1).Dump the mixed self-leveling slurry on the floor to be constructed, and use the special self-leveling scraper (tooth rake) with suitable rack for scraping.
- 2).Afterwards, let the construction personnel put on nail shoes and enter the construction ground, and use the self-leveling defoaming roller to gently roll on the self-leveling surface to release the air mixed in the mixing, so as to avoid bubble pockmarking and interface height difference.
- 3).Please close the site immediately after the construction is completed, prohibit walking within 5 hours, avoid heavy impact within 10 hours, 24 hours after the laying of PVC flooring.
- 4).Winter construction, the laying of flooring should be carried out 48 hours after the construction of self-leveling.
- 5).If you need to fine polish the self-leveling, it is appropriate to carry out after 24 hours of self-leveling construction.

6. Flooring - pre-paving and cutting

- 1).Either coil or block should be placed on site for more than 24 hours to make the material memory restore and the temperature consistent with the construction site.
- 2).Use special trimmer to cut and clean the raw edges of the coil material.
- 3).block laying, two pieces of material should be tightly and no joints between.
- 4).coil laying, the lap of two pieces of material should be cut using overlap, generally is required to overlap 3 cm. Note to keep a cut.

7. Flooring - Paste

- 1).Choose the corresponding glue and scraping board suitable for PVC flooring.
- 2).When the coil is paved, one end of the coil is rolled and folded up. First clean the floor and the back of the coil, and then scrape glue on the floor.

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- 3). block paving, please turn up the block from the middle to both sides, the same will be the ground and the back of the floor clean after gluing sticky.
- 4). The requirements of different laminating agents will be different in construction, please refer to the corresponding product instructions for construction.

8. Floor covering - exhaust, rolling

- 1). After the flooring is pasted, the surface of the flooring is first pushed and pressed with a cork block for leveling and squeezing out the air.
- 2). Subsequently, use 50 or 75 kg steel roller to roll the floor evenly and promptly trim the warped edge of the splice.
- 3). The excess glue on the surface of the floor should be wiped away in time.
- 4). After 24 hours, then carry out slotting and welding seam.

9. Floor covering-open seams

- 1). Grooving must be carried out after the glue is completely cured. Use the special groover to groove along the seam, in order to make the welding firm, the groove should not penetrate the bottom, and it is recommended that the depth of grooving is 2/3 of the floor thickness.
- 2). In the end part where the groover cannot groove, please use manual groover to groove the seam with the same depth and width.
- 3). Before welding the seam, the residual dust and debris in the groove must be removed.

10. Floor coverings - welded seams

- 1). Manual welding torch or automatic welding equipment can be used for welding seam.
- 2). The temperature of the welding gun should be set according to the type of welding rod, generally about 350 degrees.

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- 3). With the appropriate welding speed (to ensure that the welding rod melts), squeeze the welding rod into the open groove at a uniform speed.
- 4). When the welding rod is semi-cooled, use the welding rod trimmer or moon cutter to roughly cut away the part of the welding rod above the floor plane.
- 5). When the electrode is completely cooled, use the electrode leveler or moon cutter to cut off the remaining raised part of the electrode.

11. Cleaning and maintenance of flooring

- 1). PVC series flooring is developed and designed for indoor places, not suitable for use in outdoor sites.
- 2). Please choose the corresponding cleaning agent for regular cleaning and maintenance according to the method recommended by the factory.
- 3). should avoid toluene, banana water and other high concentration of solvents and strong acid, strong alkali solution poured on the surface of the floor, should avoid using inappropriate tools and sharp tools scraping shovel or damage the surface of the floor.

12. Related Tools

- 1). Flooring treatment: Surface humidity tester, surface hardness tester, floor polisher, high-power industrial vacuum cleaner, wool roller, self-leveling mixer, 30-liter self-leveling mixing bucket, self-leveling tooth scraper, nail shoes, self-leveling deflator.
- 2). Floor laying: floor trimmer, cutter, two-meter steel ruler, glue scraper, steel pressure roller, grooving machine, welding gun, moon type cutter, welding rod trimmer, combination scribe.

Notes:

This description is based on our long experience and extensive testing. However, the actual application of the product is also related to the actual conditions of application and the method of use. The success or failure of the product is also determined by the user's technical judgment and proper use according to the appropriate industry specifications. And these are not factors that we can control.