

### Related Technical Data Sheets:

- #650 Two-Component, Solvent-Free Epoxy Adhesive
- #400 Contact Adhesive
- Lontape
- Welding Thread

### Application:

1. Prepare the approved substrate as detailed in the **Interior Flooring Manual**. Any plywood panels used must be untreated. See **Notes** below for additional information.
2. Ensure all products have been properly acclimated prior to installation. When installations are not performed in a controlled environment, dimensional changes with the flooring, and differing adhesive open, working, and curing times, must be taken into consideration. See **Notes** below for additional information.
3. Apply a full spread of the #650 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. The #650 is limited to horizontal applications. See **Alternate Adhesives** below for additional installation options.
4. Roll the flooring using a minimum 100 lb. (45.4 kg), three-section roller. Roll the floor again 2 to 3 hours later. If unable to utilize a large roller due to the size of the interior vehicle space or accessibility, a three-section laminate roller may be used. When using a smaller roller, the installer must put enough weight behind it to ensure strong, positive contact.
5. Heat weld all seams 24 hours after installation. See **Notes** below regarding products that cannot be heat welded due to their heavy embossing.
6. Perform initial maintenance 48 hours after installation. See **Maintenance** below for additional information.
7. The #650 will be fully cured 72 hours after installation.

### Alternate Adhesives:

- For non-horizontal installations, #400 should be used instead of the #650. #400 is applied to the back of the flooring and the substrate using a 3/8 in. (9.5 mm) nap roller or paint brush. After allowing for sufficient open time, place the flooring onto the substrate. The #400 should still be slightly wet. Do not allow the #400 to dry, as this will result in a poor bond. The #400 is also a good alternative to the #650 for smaller applications.
- Lontape may be used as an alternate to the #650 and #400. Lontape is applied full spread to the substrate. After removing the liner, place the flooring into the tape. Lontape cures in 12 hours and allows for immediate heat welding and trim installation.

### Maintenance:

1. Remove all gross soiling (food, gum, residues, etc.). Take care if using a scraper or putty knife to avoid permanently damaging the surface of the flooring.
2. Only use neutral cleaners intended for sheet vinyl to clean the flooring. Use of other types of cleaners, even diluted bleach or ammonia, could cause permanent damage, like discoloration or staining. If necessary, a scrubbing pad may be used to help loosen soiling prior to mopping. A blue pad may be used in most cases, but do not use anything more aggressive than a red pad for flooring with Topseal (e.g. C150TS) or a white pad with high gloss flooring (e.g. C150UV). See **Notes** below for more information.
3. If necessary, use a clean microfiber mop pad and clean water to remove any remaining residue.
4. Allow the floor to fully dry.
5. Initial maintenance is the best time to apply a finish, if one is desired. Refer to the appropriate **Maintenance Guide** if intending to apply a finish. See **Notes** below for more information.

## Notes:

- A. 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 its flooring that are 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 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. For all patterned flooring seams, it is recommended to match the pattern at the center of the installation or focal point, and work the pattern out toward the perimeter from there. Embossed patterns will not always side-match along the length of the entire seam. However, seams should appear balanced throughout the length, and not taper off into the seam. Vehicle Installation Guide LONSEAL® Page 2 of 2 Revised: 3.29.2019 Disclaimer: Printed documents are uncontrolled. Always refer to [www.lonseal.com](http://www.lonseal.com) for the most current technical information.
- D. Certain heavily embossed products are not able to be properly heat welded due to the height or spacing of the embossing. For these products, 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 products must be heat welded.
- E. MEK, acetone, and other abrasive solvents should not be used to clean the flooring. These substances could cause permanent damage or discoloration.
- F. Standard single-disc machines and auto-scrubbers may not be useable or logistically possible in some cases. For these instances, the 3M™ Doodlebug™ Pad Holder and the Rubbermaid® Upright Scrubber Pad Holder use small rectangular versions of the same pads used by the larger machines.
- G. It is understood that vehicle installations may be left unfinished. Be aware that the lack of a finish will require additional effort to maintain the floor properly.
- H. DFT and Lonsealer must not be used in vehicle installations.

## 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. Lonseal products installed with adhesives outside the Lonseal product line, installed on non-approved substrates, or otherwise installed in a manner not in accordance with Lonseal's technical documentation and instructions are not covered by Lonseal's warranty terms.

