



# INSTALLATION INSTRUCTIONS No. 3

for tufted roll carpeting with textile backing  
(TR) and SonicWave

e.g.: Aera, Aera ONE, Aera Structure, Alba, Barolo,  
Barolo Deluxe, Barolo Extreme, Cara, Carlton,  
Delta, Delta ONE, Elysee, Grid, Join, Jungle,  
Lucca, Office 750, PEP, Plot 600, Resort,  
Rondo, Sixpack, Sphere, SUN, Viva (all)

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## 1.0 Introductory remarks

Please be sure to observe our “Supplementary Laying Information”, which you can access in full on our website [www.anker.eu](http://www.anker.eu).

### 1.1 Ambient conditions

To avoid damage, the carpeting must absolutely be allowed to adapt to the room climate before laying. For this purpose, it is laid out unworked in the room for 12 hours. Narrow parameters with respect to ambient conditions must also be observed when using dispersion adhesives with a high water content to glue carpeting.

## 2.0 Laying procedure

### 2.1 Preparing for laying

Only lay carpet lengths from the same batch together. To avoid difficulties in the event of any color deviation, carpeting should always be laid with the respective cut outer edges in contact. This is best achieved when the carpeting is laid continuously, i.e. as much as possible without regard as to where in the room the resulting seams will end up – however under consideration of German contract procedures (VOB)\* or national equivalent standards.

For tufted ANKER carpeting, the roll edges must be individually trimmed in the pile groove – for patterned floor coverings naturally under consideration of the repeat across. The Mittag seam cutter is recommended for simplifying this process. This tool is pushed against the carpeting to be cut through the groove with a light pressure. The cut should be made about 1.5 – 2 cm from the outside of the edge.

For velour and level-cut-loop grades, it is recommended that you push the tip of an awl through the groove of the velour surface before cutting. Right after this, proceed as described above with a Mittag seam cutter.

An overlapping cut (double cut) is only necessary for extremely dense tufting velours grades, in which no groove is visible; use a Mittag seam cutter for this as well.

The product “**Join by Marcel Wanders**” with patterned surface is also double-cut. Where possible, the two adjacent carpeting lengths are overlapped so that the patterns match and cut simultaneously using a Mittag seam cutter.

The cut lengths are then laid out on the prepared subsurface. The fabrication direction must be verified once more. Also be sure to check that the fabric appearance is uniform and that the lengths are in the correct order. Make rough cuts in the respective lengths as needed to accommodate wall projections, niches etc. so that the carpeting lies as flat as possible.

### 2.2 Laying

Carpeting is always laid using the folding method. In this method, the carpeting is folded back along its long sides across its width so that glue can be applied to the subsurface.

The carpeting length from which you start (length 1) is folded back approx. 2/3 and the length you are working toward (length 2) is folded back 1/3. Stand on the corresponding carpeting length so that this cannot slip.

Using a toothed spreader, spread the glue evenly on the subsurface in curves.

### We recommend

Manufacturer	Type	Designation	Toothings	Application qty.
<b>Bostik</b>	Glue	Power Tex	B1	approx. 350 g/m <sup>2</sup>
<b>Forbo-Erfurt</b>	Glue	Eurostaar Tex 509	B1	approx. 350 g/m <sup>2</sup>
<b>Mapei</b>	Glue	Ultrabond Eco 185	B1	approx. 300 g/m <sup>2</sup>
<b>Schönox</b>	Glue	EMICLASSIC	B1	approx. 300 g/m <sup>2</sup>
<b>Thomsit</b>	Glue	T 410	B1	approx. 350 g/m <sup>2</sup>
<b>Uzin Utz</b>	Glue	UZ 57	B1	approx. 350 g/m <sup>2</sup>
<b>Wakol</b>	Glue	D 3309	B1	approx. 350 g/m <sup>2</sup>
<b>Wulff</b>	Glue	Multi Coll	B1	approx. 350 g/m <sup>2</sup>

Exceptions to this recommendation are all carpets for which the product description calls for specific glues in order to meet the requirements for CE certification with respect to burn behavior. Additionally, for Germany, glues are recommended under the condition that these can demonstrate certification according to "Allgemeine bauaufsichtliche Zulassung" of DIBT, Berlin as required as of 1 January 2012.

Naturally, you can also use another, equivalent product of your choice – on your own responsibility.

When working ANKER carpeting with woven textile backing, the lengths are laid immediately in the fresh glue bed (within approx. 10 – 12 minutes). Pay attention to close seams!

You can eliminate any gaps appearing between the lengths by applying pressure using a knee kicker. Using a seam stretcher is preferable, however. Without a tool like this, an overlap of one pile row is more convenient when laying the carpeting in the glue bed, as the "excess" material can be pressed into the glue bed.

Length 2 is now folded back as far as the glue application, and length 3 is folded back approx. 1/3 its width. Now apply the glue, lay down the lengths, and press down and rub length 2 and then length 3 as described above. Then glue the rest of length 3, etc. It is extremely important to thoroughly rub down or roll the carpeting with a 50 kg wheel.

### 2.3 Repeat differences

Laying of repeat pattern carpeting is only possible using suitable stretchers. Without such tools, laying this kind of carpeting is **not** possible in practice.

As carpets as flexible, wide-area structures can show distortions on account of their special characteristic, it is highly recommended that the client and the contractor arrive at an agreement within the following parameters.

The annotations to the German contract procedures VOB (\*) enumerate what distortions the carpet-layer must accept on delivery of repeat pattern carpeting. According to these, repeat distortions may not exceed certain orders of magnitude either for woven or tufted carpeting.

#### Comparison between delivery according to DIN CEN/TS 14 159 and after laying

Type of pattern deviation	In delivered state DIN CEN/TS 14 159	After laying
<b>Pattern repeat deviation between two lengths</b>		
Repeat length ≤ 10 cm	≤ 2 % of pattern repeat	≤ 1 % of shortest repeat length
Repeat length > 10 cm ≤ 100 cm	≤ 1 % of pattern repeat	≤ 0,5 %
Repeat length ≥ 100 cm	Acc. to manufacturer's specifications	
Cumulative pattern shift over any length	≤ 0,5 %	> 0,2 %
<b>Bumps</b>		
Woven carpeting	≤ 10 mm	No distortion
Woven carpeting	≤ 20 mm	≤ 5 mm
Woven carpeting	≤ 0 mm	≤ 10 mm
Tufted carpet	≤ 1 % or roll width/ max. 1 cm/meter roll width	≤ 0,5 %
<b>Linear repeat distortion</b>		
Woven or tufted carpeting	≤ 10 mm for 2 m nominal length	No distortion
<b>Diagonal distortion</b>		
Woven or tufted carpeting	≤ 1 % or roll width/ max. 1 cm/meter roll width	≤ 0.5 % of roll width
<b>Deviation of bumps</b>		
Woven	≤ 0.5 % of piece length	No deviation
Tufted	≤ 0.3 % of piece length	No deviation
<b>Pattern deviation of patterned tiles, modules and punched blanks</b>		
	Not specified	± 0,5 %
<b>Zipper effect</b>		
	Not mentioned	For small patterns (cross-over). transverse ribs are unavoidable (typical feature of merchandise)

Table from VOB 2<sup>nd</sup> edition April 2010, floor coverings working group in Bundesverband Estrich und Belag e. V., Troisdorf

This means that for example a repeat difference of up to 5 cm may be present when laying in a 10 m length.

If the differences are greater, the carpet layer must cease work and contact the carpeting manufacturer. Once laying is completed, the carpet layer cannot under any circumstances complain that he received distorted merchandise in which the repeat was faulty.

#### 2.4 Zipper effect

The zipper effect is a characteristic that is typical of this product type. Experience has shown that carpeting with small patterns is impossible to match in the seam area, even with great effort and perfect technique. Both among

professionals and according to VOB (\*), such repeat errors in the seam area are considered the state of the art and thus must be tolerated by the customer. However, this effect depends mainly on the size of the pattern repeat. In other words, the smaller the repeat, the less it can and must be taken into account. If the pattern repeat is less than 10 mm, it may be ignored entirely.

The visibility of the zipper effect also depends greatly on the pattern and the color scheme. Differences are always more apparent on high-contrast carpet surfaces than low-contrast tone-in-tone combinations.

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(\* Source for VOB: Annotation for DIN 18365 Floor work, floor covering working group in the Bundesverband Estrich und Belag e.V. (BEB), Troisdorf-Oberlahr, 2nd updated and expanded addition (published April 2012).