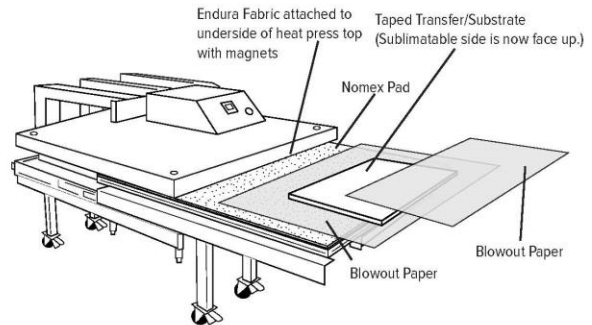


ChromaLuxe Flooring Panels

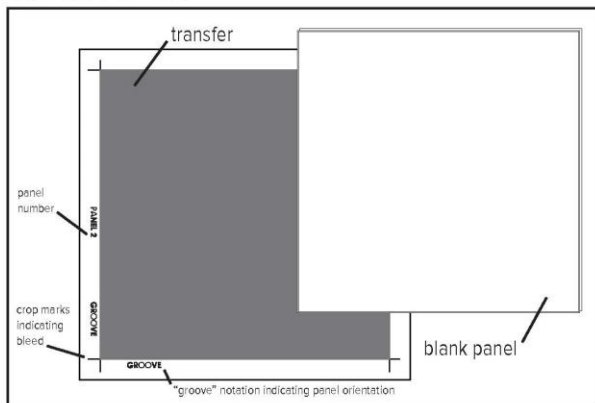
ChromaLuxe Sublimation Tip Sheet

MATERIALS NEEDED:

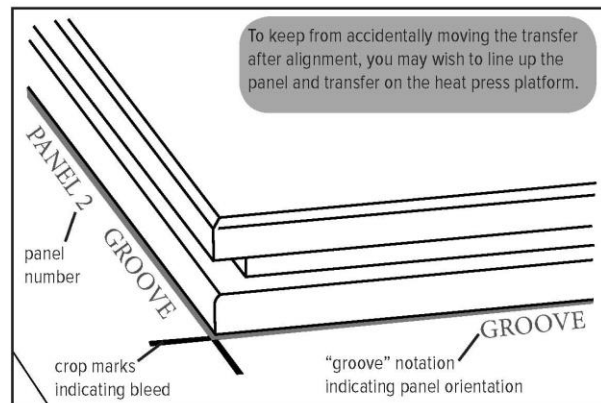
- Blank ChromaLuxe Flooring Panel and Printed Transfer
- Sublimation Printer (RIP Printing Software)
- Large Format Pneumatic Heat Press (Nomex Pad, Heat Gloves and Heat Tape)
- Cloth for Cleaning and All-Purpose Cleaner
- Blowout Paper
- Permanent Marker



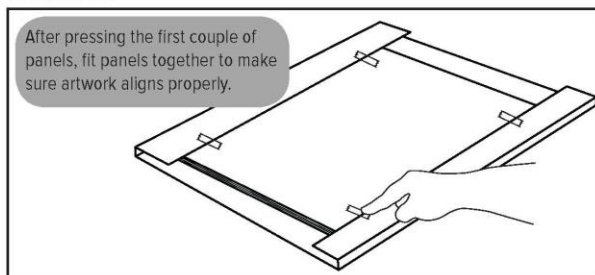
INSTRUCTIONS



Step 1: Set pneumatic heat press to 400° F and 60-70 PSI. Clean panel with all-purpose cleaner, a cloth, and compressed air. Place the transfer on the heat press platform. Before lining up the panel with the transfer, verify the setup style and bleed of your artwork. Our transfer is labeled with the panel number, crop marks that indicate bleed, and notations for the location of the grooved sides of the panels. The following instructions assume your artwork is similarly constructed.

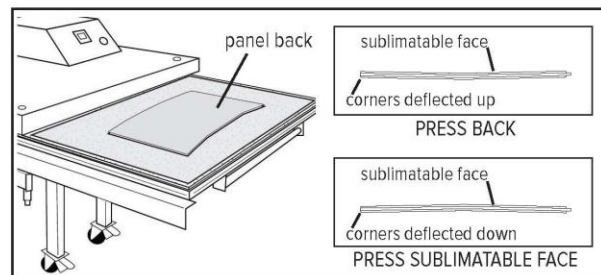


Step 2: With sublimatable side facing down, orient panel so that the grooved sides line up with the "groove" notations on the transfer. Place panel on transfer, aligning the grooved sides with the crop marks indicating bleed. Tight bleeds make it difficult to see artwork underneath the tongue side, but you can be sure your panel is aligned as long as you carefully check the groove sides.



Step 3: Wrap transfer sheet around panel and tape to the back. Carefully flip panel and transfer sheet so that the sublimatable side is facing up. **Press at 400° F for 2 minutes.** Remove from heat press. Use marker to label panel back with panel number. Allow panel to cool and settle completely.

Step 4: When cool, check panels for flatness. 1/16" deflection or less at the corners is acceptable.



Flattening: If, relative to the sublimated face of the panel, the corners are deflected upwards more than 1/16", place panel face down in heat press and press the back of the panel for 5-10 seconds (depending on the severity of the deflection) at 400° F. If, relative to the sublimated face of the panel, the corners are deflected down (middle is raised), press panel face up, between fresh sheets of blowout paper, for 5-10 seconds at 400° F. Allow panels to cool and settle completely. When cool and flat, panels may be stacked and palletized.

Your times and temperatures may vary based on equipment.

Acceptable installation methods

- Glue-down
- Floating installation: Glue tongues to grooves

Important notes

- Must install moisture barrier
- Foam underlayment is highly recommended
- Carpet must be removed
- Joints must be staggered
- Must maintain a minimum of 3/8" expansion gap allowance around floor perimeter
- Must be installed in dry, climate-controlled area with humidity below 14%

Supplies needed for installation

- | | | |
|--------------------------------------|--|--------------------------|
| - Results of humidity test | - Floor panel design schematic | - Tapping block |
| - Flat, clean, dry installation site | - Sublimated panels | - Pull bar |
| - Moisture barrier | - Appropriate adhesive for your chosen installation method (e.g. Tongue-and-groove glue) | - Painter's tape |
| - Foam underlayment | - Mallet | - Double-sided tape |
| - Wedges for perimeter gap | | - Transitions (optional) |

Site Inspection and area preparation

- Assess humidity and flatness of installation area
- Humidity must be below 14%
- Fill any holes

Graphic design

- Measure area for floor installation and create floor plan
- Decide on panel layout and create floor panel design schematic, assigning each panel a number
 - Joints should always be staggered at the midpoint
- Create and approve graphic design for floor
 - Each panel will need a 0.1" bleed on each edge (This bleed may change depending on how you choose to prepare your artwork for sublimation)
 - Designate tongues and grooves in (or just outside) the bleed area to facilitate quicker sublimation
 - Pay special attention to bleed lines for any images stretching across multiple panels
 - Recommend oversizing the floor design by (1) panel around the perimeter of the floor (Remember, installers will need overage to cut panels to fit room elements such as doorways, perimeters, etc.)
 - Recommend 150-300 resolution for raster graphics
- Output individual panel design files for sublimation, along with floor panel design schematic
- Order appropriate number of panels
- Add at least 10% to allow for cutting and sublimation errors
- For a design template please visit: www.chadhuughes.com/fillintheblank.html

Sublimation of panels

Heat press variance and environmental factors may impact your sublimation process. Transfer images into panels, making sure each panel is labeled with its number.

Phase 1 (image transfer)

- Carefully orient image to align correctly with tongue and groove configuration
- Wrap sides of transfer around panel and tape to back
- Place in center of heat press with sublimatable side facing up
- Set temperature to 400° F and pressure to 60-70 PSI*
- Press for 2 minutes*
- *Times and temperatures may vary based on equipment and process

Phase 2 (cooling)

- Remove panel from press (Mark the back of each panel with corresponding number on floor panel design schematic)
- Allow to cool and settle completely

Phase 3 (flattening)

- When cool, check panels for flatness (1/16" deflection or less at the corners is acceptable)
- If, relative to the sublimated face of the panel, the corners are deflected upwards more than 1/16", place panel face down in heat press and press the back of the panel for 5-10 seconds (depending on the severity of the deflection) at 400° F



Figure 1 Sublimatable side face up, corners deflected up

- If, relative to the sublimated face of the panel, the corners are deflected down (middle is raised), press panel face up, between fresh sheets of blowout paper, for 5-10 seconds at 400° F



Figure 2 Sublimatable side face up, corners deflected down

- Allow panels to cool and settle completely
- When cool, panels may be stacked and palletized
- Times and temperatures may vary based on equipment and process

Acclimatization

- Let panels rest in installation area 24-48 hours before installation

Installation preparation

- Make sure installation area is clean
- Install moisture barrier (if using) according to manufacturer's instructions
- Install foam underlayment (if using) according to manufacturer's instructions
- Install wedges along edge of room to maintain 3/8" perimeter gap
- If further cuts to panels are needed, cut panels to appropriate sizes/shapes to fit room geometry (Use a sharp saw blade, such as a thin-kerf 80-100 tooth, carbide-tipped blade, suitable for laminate floors to help prevent chipping. Also, try to plan for cut edges to go under quarter-round or other moldings.)

Floating installation

- Check your schematic to make sure you understand the design and how the panels need to be oriented and aligned. (**IMPORTANT NOTE:** Your floor design will drive your starting point. You may wish to start in the middle of the room, instead of at a corner, and work outward if your design features a strong central image stretching across the middle of your floor.) If you are starting in a corner, install first panel with tongue facing into room (unless contraindicated by the panel schematic)
- It is helpful to use glue or double-sided tape on the back of the panels to create a more permanent first column (provides gives you some stability as you seat panels on subsequent rows)
- Apply glue to groove of panel being installed
- Place groove onto tongue of first panel
- Use mallet and tapping block if needed to seat tongue all the way into groove
- Continue installing panels up the column
- Immediately wipe up any seeping glue with a damp rag
- Making sure sublimation lines up, install next column of panels
- Joints should always meet at the midpoint of the panel in the previous column
- Place a piece of painter's tape across glued joints to help hold them together as you progress into the room



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Start-to-finish Instructions for UW Sublimatable Flooring Product

Glue-down installation

- Check your schematic to make sure you understand the design and how the panels need to be oriented and aligned
(IMPORTANT NOTE: Your floor design will drive your starting point. You may wish to start in the middle of the room, instead of at a corner, and work outward if your design features a strong central image stretching across the middle of your floor)
- If you are starting in a corner, install first panel with tongue facing into room (unless contraindicated by the panel schematic)
- Follow glue manufacturer's instructions to apply glue (Most commercially-rated flooring adhesives advise troweling glue onto the floor)
- Place groove of next panel onto tongue of first panel
- Use mallet and tapping block, if needed, to seat tongue all the way into groove
- Continue installing panels in the column
- Immediately wipe up any seeping glue with a damp rag
- Making sure sublimation lines up, install next column of panels
- Joints should always be staggered
- Check your schematic to make sure you have the appropriate stagger
- Place a piece of painter's tape across joints to help hold them together as you progress into the room
- To avoid shifting panels after they have been placed, do not walk on panels until glue is dry
- Check your adhesive instructions for details, but 24 hours is sufficient for most glues

Post-Installation

- Let panels dry 24 hours or according to adhesive instructions
- Install quarter-round or other molding to hide perimeter gap according to manufacturer's instructions
- Install any needed transitions to other flooring according to manufacturer's instructions

Cleaning

- Vacuum to remove loose dust and dirt
- Damp mop when necessary
- Do not use vacuum beater bars or wet mops
- Wipe up spills as quickly as possible
- Remove scuffs or spots with a multipurpose surface cleaner
- Install a mat in entryway or other convenient location to help trap sand and gravel (This will help prolong Image life)

Appropriate installation areas may include

Business offices: entryways*, lobbies, hallways, offices, conference rooms, break rooms

Retail: entryways*, sales floor/showroom, checkout, break rooms, dressing rooms, offices, storage rooms

Hotels: entryways*, lobbies, hallways, guest rooms, conference rooms, break rooms

Restaurants: entryways*, lobbies, hallways, offices

Educational: entryways*, lobbies, hallways, offices, classrooms, storage rooms, residence halls, common areas

Multi-family housing: entryways*, lobbies, common areas, hallways, offices, storage rooms, individual housing units

Home Décor/ Exhibits

Not suitable for high-volume commercial areas.

*Walk-off mats required at all entryways.





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Flooring Accessories

GLUES/ADHESIVES

Any commercial glue that is rated for wood or laminate floors will work well with ChromaLuxe flooring.

Floating installations: Recommended "tongue and groove" wood glues:

- Taylor 2049 Tongue & Groove Flooring Adhesive <http://www.wftaylor.com/index.php/3635/2049-16/#.Vr3vSfrKUK>
- Roberts 1406 Tongue and Groove Adhesive <http://www.homedepot.com/p/Roberts-1406-16-oz-Tongue-and-Groove-Adhesive-in-Pirt-Applicator-Bottle-1406-P/100645277>

Glue-down installations: Recommended "glue-down" wood glues:

- Taylor Meta-Tec 20/1 <http://www.wftaylor.com/index.php/445/20/1/#.Vr3vcvkrKUK>
- Roberts 1407 Engineered Wood Glue Adhesive <http://www.homedepot.com/p/Roberts-1407-4-Gal-Engineered-Wood-Glue-Adhesive-1407-4/100574569>

Note: Some jobs may require a water based adhesive due to environmental reasons. In this case, we recommend an adhesive that has high solids and low water.

TRANSITIONS/MOLDING

Commercially-rated transitions designed for 3/8" thick laminate product will work well with ChromaLuxe flooring. It is important to make sure that the gap clearance is a full 3/8" (some transitions listed at 3/8" reflect the overall height of the transition, not the gap).

Example (note drawing of side view):

<http://www.tmsdirect.com/products/floormoldings.html>

<http://www.kottlersales.com/p/wheeled-traffic-transitions.asp>

<http://www.lowes.com/pd/FLEXCO-Wood-3-8-in-Overlap-Reducer-Clove-Maple/3428066>

Transitions can be nailed on or attached with a high bond tape such as vinyl flooring tape.

UNDERLAYMENT

Installers can recommend commercially-rated underlayments that work well with your space and are suited to your specific needs in terms of cushion, sound, etc.

Example:

- TrafficMASTER Standard Polyethylene Foam 2-in-1 Underlayment http://www.homedepot.com/p/TrafficMASTER-Standard-100-sq-ft-Rolls-25-ft-x-4-ft-x-080-in-Polyethylene-Foam-2-in-1-Underlayment-100779555/203956730?MERCH=REC_-NavPLPHorizontal1_-_-NA_-203956730_-N

