

# Gold Stix®

PREMIUM MULTI-PURPOSE ADHESIVE

SOLVENT FREE • FAST TACKING • LOW ODOR



**Gold Stix®** is a solvent-free, fast-tacking, low-odor adhesive successfully used for double bond carpet installations. With the double bond installation system, a separate cushion is adhered to the substrate and then the carpet is installed over the cushion.

A double bond installation improves the comfort and durability of the carpet, as well as the acoustic and insulation properties. The following standard guidelines and procedures will help prevent costly and unnecessary problems or job failures.



# GoldStix Double Bond Carpet Installations

## PREPARATIONS:

The first requirement is to have the jobsite acclimated to a temperature between 65°F and 95°F and humidity from 40% to 60% for at least 48 hours before and permanently after the installation. This should also be done before any substrate moisture testing is performed, otherwise the test results will not be reliable.

## ACCLIMATION:

Broadloom carpet should be un-rolled and allowed to relax during this period. Any remaining wrinkles or creases in the carpet should be inspected and steamed out before installing. To minimize wrinkling and buckling and to facilitate installation, it is highly recommended that carpet be un-rolled and allowed to relax in the installation area for a time period that conforms to the requirements of the manufacturer of the product being installed. This time period will vary up to 72 hours, but should not be less than 24 hours at a temperature between 65-95°F (18 -35°C). Protect carpet adequately from soil, dust, moisture and other contaminants. The cushion and adhesive should be acclimated to the same conditions as well. If these conditions are not attainable, contact the flooring manufacturer for applications to warranty.

Note: The allocation of time for the relaxation period should be included in the planning of the job by all interested parties.

## SUBSTRATE PREPARATION:

A clean, well-prepared substrate is crucial to any flooring installation. Make sure the substrate is free of incompatible sealers and curing agents, old adhesives, loose paint, dirt, dust, oil or grease, plaster, efflorescence, or any other contaminant that could interfere with the adhesive bond. Remember, the adhesive bonds to the material it touches. If it is applied over old adhesive residue or coatings that are soft, brittle, or not otherwise physically sound or well bonded to the substrate, the entire installation is compromised. Such residues, if not removed, become the substrate onto which the new carpet will be adhered. High traffic areas are commonly seen to be the first areas to show delamination over substrates not properly prepared.

## SUBSTRATE TESTING:

Moisture and pH testing must always be performed on concrete substrates on every grade level. Even suspended floors should be tested. Acceptable moisture readings should be obtained for the installation using ASTM F2170 (90% RH or less). Concrete substrate pH readings must be between 8.0 – 9.0.

## CUSHION TO SUBSTRATE:

Install cushion in the longest continuous lengths possible with consideration to traffic patterns and carpet seam placement. It is required that cushion seams be at right angles (90°) to carpet seams or offset at least six inches. Butt cushion seams net without compression, leaving no gaps. Do not tape or staple cushion seams for double glue down installations. Apply Gold Stix Premium Multi-Purpose Adhesive to the substrate using a 1/16" x 1/16" x 1/16" square-notch trowel and allow the adhesive to become tacky before carefully laying the cushion into position. Lightly smooth out any wrinkles or bubbles in the cushion using a broom or empty carpet core. Trim the cushion edges to the walls.



(1/16" x 1/16" x 1/16" Square notch trowel image)

## CARPET TO CUSHION:

For carpet to cushion, make certain to use the recommended trowel, and that the trowel is in good condition, not worn down, to apply the proper amount of adhesive. Use a 1/8"x1/8"x1/16" U-notch trowel for most commercial broadloom carpets. This will provide a coverage rate of approximately 5 square yards/gallon. Excessive trowel pressure should not be used when spreading the adhesive as this will reduce the adhesive spread rate. Spread the adhesive uniformly over the cushion and allow sufficient open time before placing the carpet into the adhesive as it becomes tacky. Seal the seams with appropriate edge sealer and heat bond tape, and roll with the lightest roller possible to make sure the carpet has made good contact with the adhesive.



(1/8"x1/8"x1/16" U-notch trowel image)

## TRAFFIC:

Follow the flooring manufacturer's installation guidelines; otherwise restrict foot traffic for 24 hours after installation. No heavy traffic, rolling loads, or furniture placement for 72 hours after installation. Additional time may be necessary if the installation is over a non-porous substrate. The use of plywood sheets is highly recommended to protect the installation when moving heavy loads across the floor. Protector sheets are required under chairs with castors. Allow at least five days following the installation before conducting cleaning procedures or initial maintenance. Cleaning methods for double bond installed carpet should be done using dry methods as recommended by the carpet manufacturer. Wet extraction and steam cleaning should be avoided.

References:

- CRI Carpet Installation Standard 2011, [www.carpet-rug.org](http://www.carpet-rug.org)
- Tred-MOR Dubl-STIK, Sponge Cushion, Inc., [www.sponge-cushion.com](http://www.sponge-cushion.com)
- Cushion Guidelines for Double Glue Installation of Commercial Carpet (<http://www.carpetcushion.org/pdf/double-glue-2014.pdf>), Carpet Cushion Council

XL Brands and Gold Stix are registered trademarks of Bostik, Inc.

## DISCLAIMER:

This document is provided for informational purposes only and is believed to be accurate and reliable. However, XL Brands/Bostik assumes no responsibility for any errors and is not liable for any damages of any kind resulting from the use of, or reliance on, the information contained herein.

198 Nexus Drive | Dalton, GA 30721 | tel: 800.367.4586 | fax: 706.272.5801

[WWW.XLBRANDS.COM](http://WWW.XLBRANDS.COM)