

Insert Repair Procedure (All grades)

The best repair method will be determined by the nature of the damaged area (size/location).

Circle cutter:

For Large Flat Areas (minimum circle diameter 300mm) that are easily accessible and visible.

Set the circle cutter to the appropriate minimum diameter for the repair patch. (add 50mm clearance around the damaged areas to ensure a good repair). Position the circle cutter onto the floor lino in accordance with manufacturer's instructions and then carefully rotate so that the damaged area is marked. Adjust the blade depth and continue to rotate the circle cutter until the cutting edge has fully penetrated the thickness of the Treadmaster.

Carefully remove the damaged piece of rubber flooring from the sub-floor by cutting the damaged material into approximately 30mm wide strips within the cut area. Using a chisel, push under the material in the centre of the damaged area and gently tap along the bond line to lift the material away from the subfloor. Take care not to lift or damage the good material at the edge of damaged area.

Aluminium floor panels:

Remove the original adhesive and then take back to bare metal using 80gt paper until the surface is smooth and then vacuum out all of the sanding dust before degreasing. When sanding take extreme care not to damage the square cut edge.

Plywood floor panels:

Remove original adhesive and ensure surface is dry, abrade with 100gt paper, vacuum out all sanding dust. Note: degreaser must NOT be used on plywood floor panels.

Using the pre-set circle cutter, set at the same diameter as the repair cut; cut a new piece of rubber flooring to the required diameter. Dry fit the repair patch to confirm a good tight fit is obtained. In some cases the circle patch diameter may have to be increased fractionally to allow for the blade thickness and width of cut, measure the finished cut circle and diameter to the blade point tip on the cutter to verify.

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1. Mix the Adhesive (Tiflex No 15 or No 7) to a ratio, by weight, of
 - Tiflex No 15 - 7.8 : 1 (Resin : Hardener)
 - Tiflex No 7 - 7.3 : 1 (Resin : Hardener)
 Mix either for approximately 4 minutes or until adhesive forms a uniform colour (no streaks). Use within 20 minutes of mixing.
2. Apply adhesive to prepared area, using Notched Adhesive spreader for larger sections, to both floor and flooring material.
3. The patch is then positioned onto the prepared floor panel, noting the direction of pattern (if applicable) and pressed firmly into position.
4. Using a rub board, smooth the repair area to ensure the adhesive fills the entire void evenly. Work from the centre outwards to ensure the surplus adhesive oozes out the joint, thus making a water tight seal. Any excess adhesive must be removed from the surface before it hardens.
5. The patched area should be covered with a polythene (or similar) sheet and then sandbagged or weighted using flat square edge weights.

Free hand templates:

Areas below 300mm diameter or where access for the Circle Cutter is restricted and cannot access.

1. Measure the minimum size of repair that is required (add 50mm clearance around the damaged areas to ensure a good repair). Produce a suitable square template from either thin gauge steel or aluminum sheet.
2. Position the square marking template onto the rubber floor covering and then using a sharp craft knife carefully score around the template, keeping the blade at 90 degrees to the flooring surface.
3. Mark a temporary reference point on the floor in relationship to the position of the template. Remove the square marking template and then using a straight edge as a guide continue to cut through the rubber floor covering using a craft knife until the thickness of the covering has been fully penetrated.
4. Carefully remove the damaged piece from the sub-floor by cutting the damaged material into approximately 30mm wide strips within the cut area. Using a chisel, push under the material in the centre of the damaged area and gently tap along the bond line to lift the material away from the subfloor. Take care not to lift or damage the good material at the edge of damaged area.
5. Remove all traces of the original adhesive from the floor panel:

Aluminium floor panels:

Remove the original adhesive and then take back to bare metal using 80gt paper until the surface is smooth and then vacuum out all of the sanding dust before degreasing. When sanding take extreme care not to damage the square cut edge. of cut, measure the finished cut circle and diameter to the blade point tip on the cutter to verify.

Plywood floor panels:

Remove original adhesive and ensure surface is dry, abrade with 100gt paper, vacuum out all sanding dust. Note: degreaser must NOT be used on plywood floor panels.

Using the square marking template cut a new piece to the required shape, remembering to mark one edge as a common reference point. Dry fit the repair patch to confirm a good tight fit is obtained.

1. Mix the Adhesive (Tiflex No 15 or No 7) to a ratio, by weight, of
 - Tiflex No 15 - 7.8 : 1 (Resin : Hardener)
 - Tiflex No 7 - 7.3 : 1 (Resin : Hardener)Mix either for approximately 4 minutes or until adhesive forms a uniform colour (no streaks). Use within 20 minutes of mixing.
2. Apply adhesive to prepared area, using Notched Adhesive spreader for larger sections, to both floor and flooring material.
3. The patch is then positioned onto the prepared wooden floor panel and pressed into position.
4. Using a rub board, smooth the adhesive to fill the entire void. Ensure surplus adhesive oozes out of the cut edge, thus forming a seal in the cut. Any excess adhesive must be removed from the surface before it hardens.
5. The patched area should be covered with a polythene (or similar) sheet and then sandbagged or weighted using flat square edge weights.

Curing procedure:

The cure time of the No15 is dependant upon the ambient temperature. At 16°C (minimum) the adhesive takes up to 24 hours to fully cure. At 25°C its takes up to 12 hours. Due to service demands, the curing time of the adhesive can be accelerated by using a Heat Bond Iron for a period of approximately 2 hours on setting No '1' (120° C approx.), when applied directly to the affected repair area.

Following curing, the affected patch repair area will require sanding, it must be left for sufficient time for the adhesive to fully harden (see above) before sanding.

Using a DA sander (or equal) with a P600 grade sanding disc blend in the repair area ensuring a smooth flat surface is present.

Wipe the sanded area clean and apply a coat of Treadmaster Maintainer.

If the patch repair area previously had a polish finish, this will need to be re-applied.

- Ensure area to be treated is dry and free from debris.
- Apply an initial thin coat of Sealer and allow it to dry completely.
- Apply a second and leave for 1 hour.

Tools required:

Circle Cutter & Heat Bond Iron



Supplier: Wolff

Notched Adhesive Spreader



Supplier: Tiflex

Disc Sander



Required Materials:

Item	Supplier
Treadmaster No 15 / No7 Epoxy Adhesive	Tiflex
Treadmaster Degreaser (SPF)	Tiflex

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