



**Woven Carpet Installation
Procedures and Recommendations
2014**

**Nourison Hospitality Carpets
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1. Scope- This document establishes minimum manufacturer's installation standards for Nourison Hospitality Carpets

2. Documents & References

2.1 CRI Carpet Installation Standard 2011

2.2 ASTM F-1869-98 – *Test Method for Measuring Moisture Vapor Emission Rate of Concrete Sub-floor Using Calcium Chloride*, American Society of Testing & Materials, 100 Barr Harbor Drive, West Conshohocken, PA 19428- 2959. www.astm.org

2.3 Characteristics of Patterned Carpet Technical Bulletin*– The Carpet and Rug Institute

* Downloadable from The Carpet and Rug Institute web site

www.carpet-rug.com

3. Terminology- Throughout this document the general terms “must,” and “recommended” are used to compare and contrast the different levels of importance attached to certain practices. It is impractical to issue blanket rules intended to apply to every installation situation. In extenuating circumstances, deviation from portions of this standard may be appropriate. Carelessness is never acceptable and common sense should prevail in all cases.

Must: When the term *must* is used in this document, it means that the practice or procedure is required or mandatory.

Recommended: When the term *recommended* is used in this document, it means that the practice or procedure is advised or suggested.

4. Temperature and humidity- Carpet shall be installed when the indoor temperature is between 65-95°F (18-35°C) and the humidity ranges from 10% to 65%. If ambient temperatures are outside these parameters, the installation shall not commence until the HVAC system is operational and these conditions are maintained for at least 48 hours before, during, and 72 hours after completion.

5. Testing of Concrete Sub-floors- Prior to adhesive Installations the owner, the general contractor, or their designated testing agent must submit to the flooring contractor a written report on the vapor emission level and the surface alkalinity of the concrete. Testing must conform to ASTM standards.

Note: It is recommended qualified independent testing agencies be used for determination of vapor emissions and alkalinity of the floor surface. Testing by an independent specialist to determine the suitability for installation is a prudent and necessary safeguard for general contractors, owners, architects, flooring products providers and installation

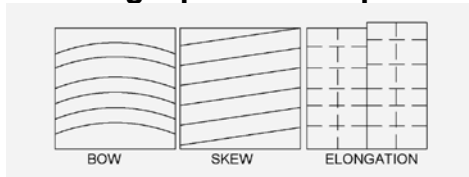
contractors. As a minimum testing agencies or individuals must demonstrate verifiable experience in vapor emission testing or be certified by recognized organizations, such as the Institute of Inspection, Cleaning and Restoration Certification (IICRC) or the equivalent.

6. Moisture Vapor Emissions Testing- Concrete floors, even with adequate curing time, can present an unacceptable moisture condition by allowing excessive amounts of moisture vapor to pass through to the surface. This can be a problem even on suspended concrete floors. All concrete floors should be tested for moisture emission rate by utilizing an anhydrous calcium chloride moisture test kit available from installation supplies and accessories distributors. This quantitative method must be conducted carefully with strict adherence to ASTM Test Method F 1869. Moisture emission rate is measured in pounds of moisture over a 1000 ft² area during a 24 hr period. Because the calcium chloride test for emission rate requires a minimum of 60 hours to conduct, proper installation planning is required. As a general guideline, an emission rate of 3.0 lbs. (1.4 kg) or less is acceptable, unless otherwise specified by the carpet manufacturer.

7. Alkalinity testing- A pH range of 5-9.0 is satisfactory; however, a reading above 9.0 requires corrective measures. Testing should be performed in accordance with ASTM Standard Practice F-710; or consult the adhesive manufacturer for recommended testing and corrective procedures. The test results obtained reflect only the condition of the concrete floor at the time. Further, the test site or building should be at the same temperature and humidity expected during normal use. These conditions must be maintained 48 hrs prior to, and during testing.

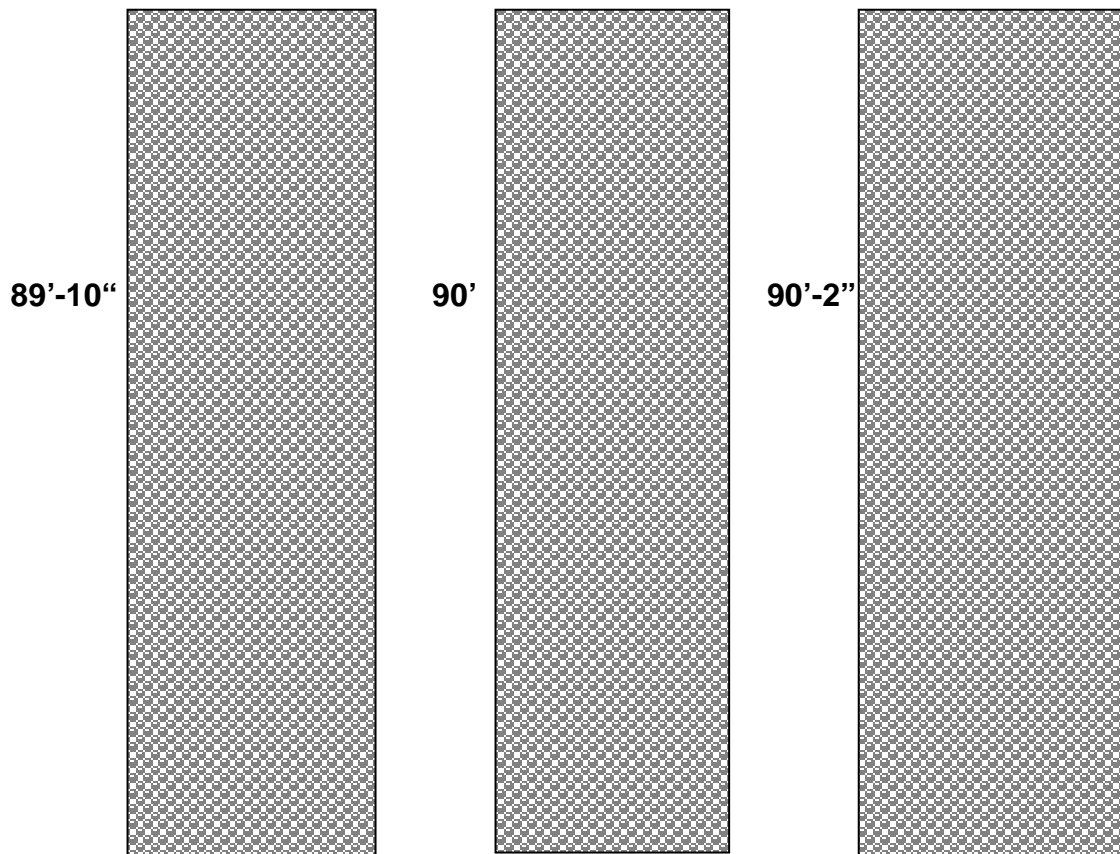
8. Planning- It is important to have all available resources at the job site. Check the availability of architectural drawings, layouts and seaming diagrams. Reconcile roll quantities with packing lists. Nourison Hospitality Carpets must be informed immediately of any discrepancies.

9. Pattern matching- It must be understood that carpet is a textile and cannot be made to exact specifications. All pattern carpet is subject to certain manufacturing tolerances, therefore, a perfect pattern match cannot be guaranteed without proper stretching and matching to align design elements. Tolerances for Patterned Carpet Are: Bow: 1-1/2 inch across the 13 foot width Skew (Bias): 1-1/2 inch across the 13 foot width Pattern Elongation: 2 inches in 12 feet in the length. If you are having trouble matching a pattern "stop" and consult the manufacturer.



Each roll needs to be measured and coded to help layout the best possible pattern match sequence. An equal amount of patterns need to be measured in each roll of carpet and recorded, to be able to pre-plan the installation roll layout sequence. The installer will know which rolls will match best to each other prior to install. The Codes are established by measuring the same number of patterns in the lengthwise direction of each carpet roll [approximately 30 repeats.] This measurement is recorded.

For instance, if we were working with a 36" pattern [3'-0"] and the patterns were made to the exact measurement, 30 patterns would measure exactly 90 ft. However, during the normal manufacturing process, the patterns may elongate or be slightly shorter than exact. This is why a system to code the rolls by lengths of each roll that have the same number of patterns each. This enables a plan for the best installation, eliminating most pattern matching problems. Always stretch short rolls to long rolls. As one can see, with pre-planning of the roll layout sequencing, the installation will be optimized and pattern matching will be simplified. However, if these codes are ignored, the effort to pattern match can be very difficult and extra labor will be incurred to match the patterns and may make matching very impossible.



10. Recommended Seam Cutting Techniques

Proper pattern matching and satisfactory seams in Woven carpets are best achieved when the carpet is cut along the manufacturing tuft rows. This is commonly known as “row cutting”.

When removing the selvage edges and/or waste yarns, care must be taken to ensure that none of the yarn that involves the pattern is removed.

- **Lengthwise seam cutting** - Define the tuft row to be cut by parting the pile with a row finding device such as; screwdriver, awl or comb along the length of the proposed cut. Start the cut by making a small incision on the edge with a carpet knife. Insert the cutter between the backing yarns and cut along the tuft row. The cutter blade should always be positioned on the proper side of the cutter to insure the best seam possible; this may require the installer to make some trial cuts to determine the best side of the cutter the exposed blade should be on.
- **Cross/Butt/End seams** - Most of our woven cut pile carpets can be row cut from the top side using a loop pile or cushion back cutter. Installers may find some products are easiest cut from the back side while following a “rib” tuft row utilizing a conventional carpet cutting knife.

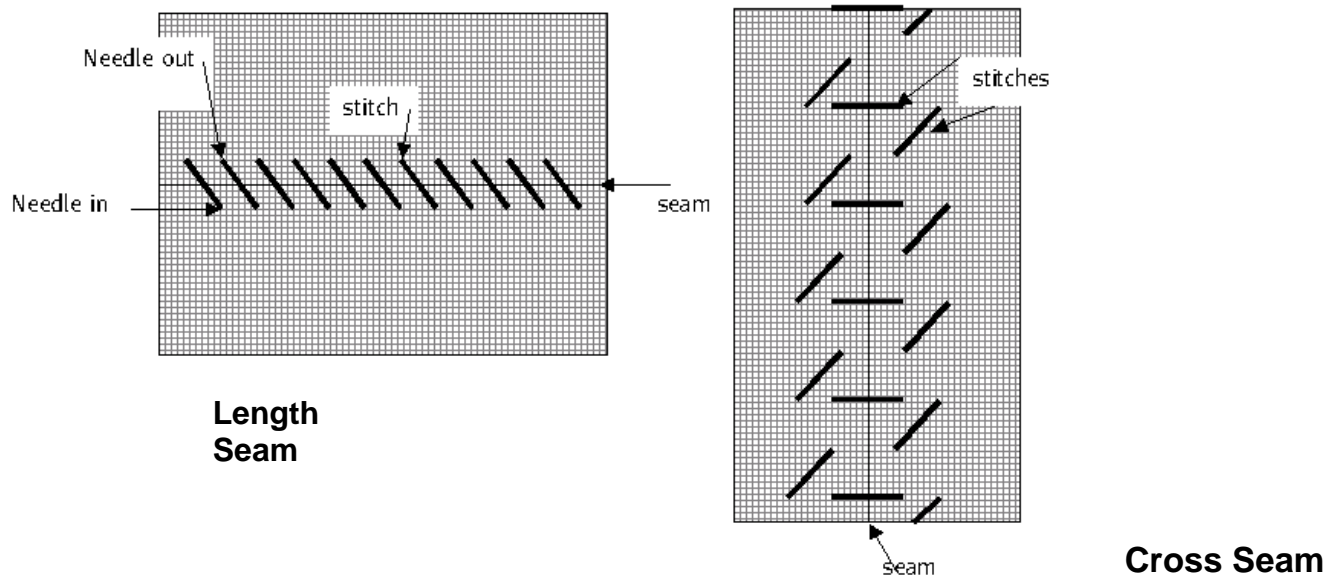
All cut edges to be seamed must be sealed with an appropriate edge sealer to prevent seam ravel. A water or acrylic based latex adhesive seam sealer is recommended, many installers are now sealing the edges with hot melt glue utilizing a special glue gun applicator tip. Proper and careful application is essential when using either method.



11. SEAMING

11.2 Hand Sewing

For stretch-in over separate cushion, hand sewing by a qualified craftsman is the best method of seaming woven Axminster carpet. It is our experience that hand sewn seams produce the best long-range performance and appearance retention in commercial installations, better than hot melt tape, and are a must in large open spaces and areas where wheeled traffic is experienced.



1. In sewing a “length seam” by hand you must pattern match the 2 pieces and join with a lock stitch or stay tack on a pole.

Insert the needle in between the weft threads and keep the needle in a straight line each time you take a stitch. Your stitches should be less than $\frac{1}{2}$ ” apart.

2. Reinforce the seam by applying the latex adhesive.

3. A “cross seam” may be hand sewn using a unique stitch which withstands power stretching. Cross seams are more pliable and receive less stress from the power stretching than “length seams” in Axminster installations. Because of this the tape seaming method needs to be used as follows. Though hand sewing is considered by many to be the best method to seam, few installers have the needed experience necessary to hand sew properly. If seaming tape is to be used follow the guidelines below.

11.3 Hot Melt Tape

***Orcon Super 3DS*, or equal, 6" wide seaming tape can be used. Even when the seams are properly constructed, most length seam failure is due to the tape splitting; not the releasing of the adhesive from the carpet back. Do test for adhesive "bond" before constructing the seams. Use a heat shield on your seaming iron at all times. You may want to test a piece of scrap carpet for heat resistance to make sure you will not distort the face fibers with too much heat in this process.**

1. Abut the two prepared runs, matching the pattern for the length of the seam. You will have to stretch both widths of the carpet runs at the seam and "stay nail" each piece before hot melting the seam with the tape. Note: Hot melt tape does reduce the amount of stretch at the seams. If prior stretching is not performed before the tape is applied, additional stretch in the middle of the carpet will cause a bowing effect across the pattern. 2. Roll out and center the seaming tape under the two pieces to be seamed. Apply the preheated iron to the tape at the starting point and allow time to adequately melt the adhesive on the tape. Whenever possible, start at the end of a seam, allowing the iron movement to go all in the same direction. If the seam is a long one you may find it necessary to have your starting point at the center of the seam and continue to the end. Return to the middle and proceed to the other end to finish.



3. Move your iron at an even speed, approximately 3 feet per minute, all the while pressing the carpet into the adhesive behind the iron with your hand or a seam roller (Smooth type, rather than spiked roller). Slide a flat, heavy object along the seam to keep the carpet flat as the tape cools. You must allow for sufficient cooling time before stretching.



Installers must check with the tool and seaming tape manufacturers for the proper heat settings and tapes. When seaming, we recommend working from the seam midpoint to the seam ends.

The KoolGlide Carpet Seaming System is another seaming process that is recommended.



12. DIRECT GLUE-DOWN INSTALLATION

12.1 Additional sub-floor requirements – Sub-floors must be clean, dry, and free from joints, cracks, depressions or protrusions that will show through the finished installation or cause premature wear. The floor should be free from contaminants that may interfere with adhesion.

Carpet, when bonded with an adhesive, will follow every contour of a substrate, essentially forming a skin. Seemingly insignificant imperfections in a sub-floor can become very obvious after the carpet is installed. Joints, cracks, depressions, bumps and other protrusions not properly addressed may be unsightly and cause premature wear. Dirt, dust, wax, oil, grease, moisture and other contaminants can prevent or otherwise destroy adhesion causing bubbles or widespread failure.

While some floor preparation is “normal,” it is not the floorcovering installer’s responsibility to correct deficiencies in the work of other tradesmen, such as carpenters and concrete finishers.

12.2 Trowel notch size - The recommended trowel notch size is 1/8 x 1/8 x 1/8. U - Notch

12.3 Floor adhesive application- The floor adhesive shall be spread uniformly over the sub-floor with the specified trowel leaving ridges of sufficient height to achieve full and complete coverage of the carpet backing. Trowel notches wear down during use. Maintain proper size throughout the installation. The carpet should be placed into the adhesive as soon as possible, allowing for any necessary pattern adjustments.

12.4 Alternative adhesive systems- Alternative systems such as spray adhesive or roll adhesive films are available for applying adhesive.

13- DOUBLE GLUE-DOWN INSTALLATION

Site, environmental and ventilation conditions become even more important when performing double glue-down installations. In double glue-down installation, a separate cushion is adhered to the sub-floor, and the carpet is glued to the cushion.

Installers’ Responsibility- Seaming methods on Double Stick installations must be determined by the Installation Contractor. It may be determined that the best method of seaming would include seaming tape along with the adhesives due to special conditions

such as extra heavy traffic and/or rolling carts. If this is the case, seaming tapes designed for this method must be used.

13.1 Preparation - The sub-floor is to be dry and free from contaminants that will prevent good adhesion. Surfaces shall be vacuumed and thoroughly cleaned before applying the adhesive. Refer to Section 6.0 of this Standard for additional floor preparation requirements.

13.2 Adhesives- For the application of cushion to floor and carpet to cushion, select the appropriate adhesive from the list provided by Nourison Hospitality Carpets in section 17 of this document.

The adhesive shall be spread uniformly over the cushion surface with the specified trowel. The carpet is to be placed into the adhesive as soon as possible, allowing for any necessary pattern adjustments.

Proper open time considerations are critical for a successful installation.

13.3 Rolling- Rolling should be performed with the lightest roller (35 pound) that will achieve proper transfer of the floor adhesive onto the carpet backing. Roll in both directions, but do not over roll.



13.4 Carpet on stairs: Properly secure carpet to tread and riser using appropriate adhesive. Stairs without a return (nosing) can be installed as one piece over the tread and riser. Stairs with a return should be cut and installed with the tread and riser being separate pieces. The stair return and nosing should be rounded 3/4 - 1 inch (19 to 25 mm) for proper carpet contact.

14. STRETCH-IN INSTALLATION

This method involves the installation of carpet under tension, utilizing tackstrip fastened at all walls and other vertical abutments around the perimeter of the area. A separate cushion shall be used.

14.1 Tackstrip –Tackstrip should be a minimum of 1 inch (25 mm) wide and ¼ inch (6 mm) thick. Architectural strip with 3 rows of pins, or 2 rows of conventional strip, should be used. To prevent possible injury to building occupants, the pins on the tackstrip should not protrude through the carpet being installed.

14.2 Installation of tackstrip – Tackstrip must be fastened securely around the perimeter of the area to be carpeted and at a distance of slightly less than the thickness of the selected carpet from all vertical abutments.

Tackstrip shall be placed with the pins angled toward the vertical abutment. The distance between the tackstrip and vertical abutments should not exceed 3/8 inch (9 mm).

Installation of tackstrip across door openings and/or sills should be avoided. Tackstrip should be cut to follow the contour of door casings and other irregularly shaped abutments.

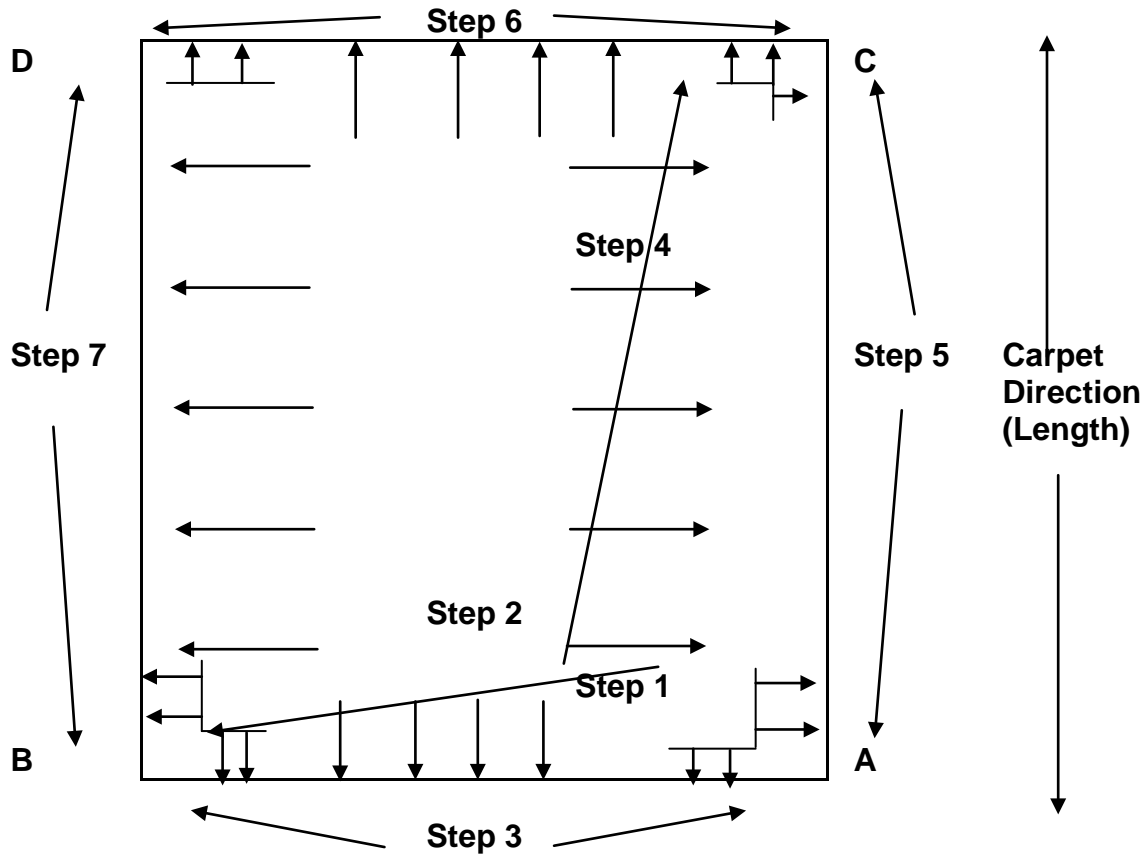
14.3 Separate cushion selection – see section 16 of this document.

14.4 Installation of separate cushion – Carpet cushion should be installed in the longest continuous lengths possible, with the seams placed at right angles to the carpet seams or at least 6 inches (150 mm) to one side. Cushion shall be trimmed flush with the inside contour of the tackstrip and securely fastened to the sub-floor with staples or non-flammable cushion adhesive at the seams and around the perimeter of each room. With the exception of fiber cushions, seams should also be secured with appropriate cushion tape.

14.5 Seaming- Refer to Section 11.

14.6 Power stretching – Carpet must be properly power-stretched and firmly hooked onto the tackstrip in accordance with the seven-step procedure described in *Figure 2*.

FIGURE 2 - Stretch Diagram for Axminster Carpet



Reminder – All stretch in Axminster carpet is in the length direction.

Step 1 – Hook onto tackstrip, approximately three feet in both directions, along corner A.

Step 2 - Power stretch from corner A to corner B and hook onto tackstrip at corner B.

Step 3 - Hook and secure onto tackstrip with knee kicker along wall from A to B, while aligning the pattern to the wall.

Step 4 - Power stretch the carpet “drum tight” at an approximate 15° angle from wall A-B and hook onto tackstrip at corner C.

Step 5 - Hook and secure onto tackstrip with knee kicker along wall from A to C, while aligning the pattern to the wall.

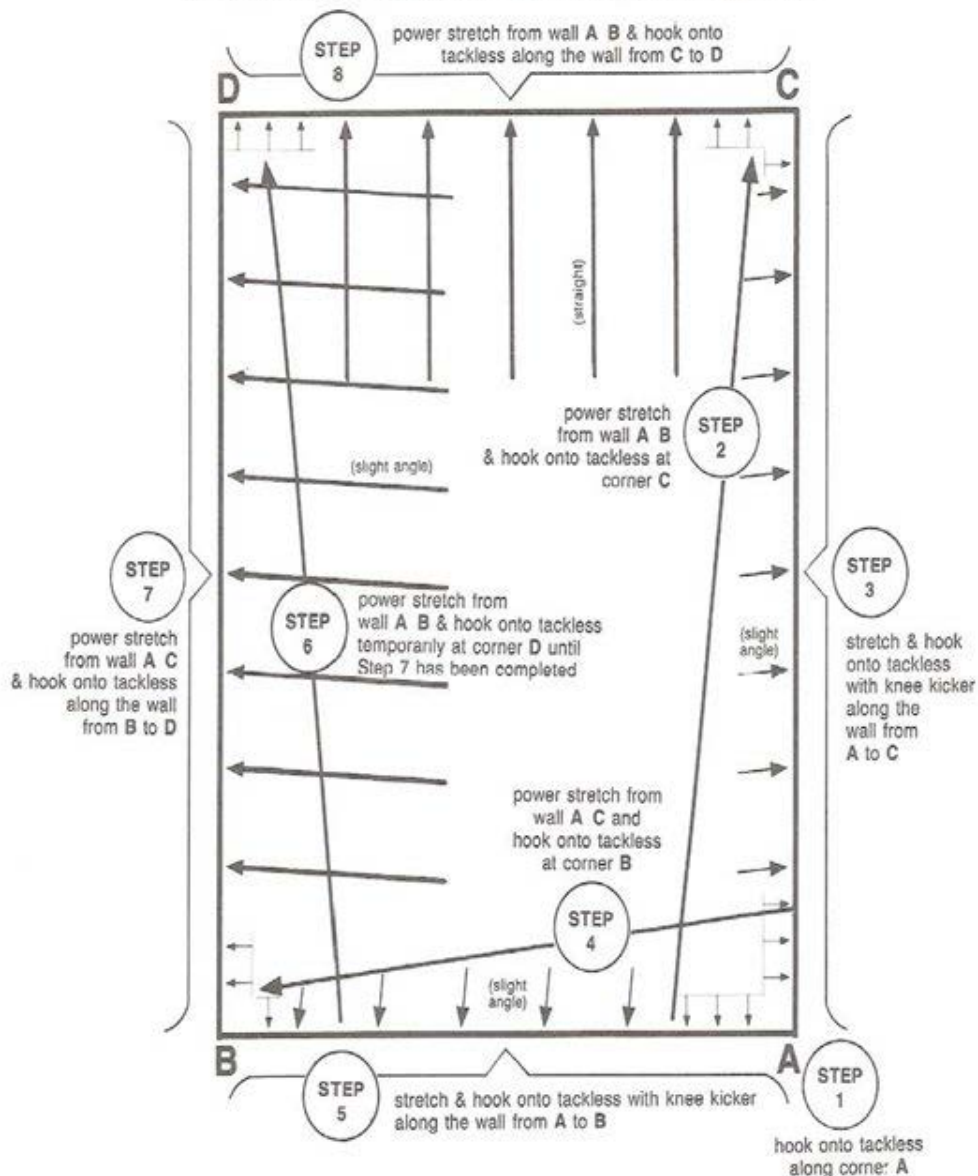
Step 6 - Power stretch the carpet in a straight line and “drum tight” from wall A-B to wall C-D starting at corner C moving toward corner D, aligning the pattern to the wall as you stretch and hook on to tackstrip.

Step 7 - Power stretch straight from wall A-C to wall B-D and hook along wall from B to D.

FIGURE 2

WILTON OR VELVET

Amount of Stretch as per the Carpet Manufacturer's Recommendation
In Absence of Carpet Manufacturer's Recommendation, Use Diagram Below



STRETCH:

| | Length | Width |
|---------|--|--|
| Wilton: | equal stretch in length and width (drum tight) | equal stretch in length and width (drum tight) |
| Velvet: | snug | more stretch in width than length |



The use of a power stretcher is mandatory. Devices used as a substitute for, or an attachment to, a power stretcher may cause injury, damage carpet, sub-floors, or result in an inadequate amount of stretch and are not acceptable.

| |
|---|
| <p>Failure to power stretch a carpet may result in: Wrinkling and buckling over time Localized damage to the carpet</p> |
|---|

Note: For patterned carpet, care must be exercised to ensure pattern alignment along walls. The use of a power stretcher, stay-nails, and a “dead man” may be necessary to achieve proper pattern match at seams and alignment along walls.

14.7 Amount of stretch – Even though *all the stretch is in the length of Axminster carpet, with no actual stretch in the width*, it is necessary that the installation be power stretched both lengthwise and widthwise with a *Roberts’ Senior Stretcher #10-222* or equal to obtain adequate tension.

The pattern must be aligned and squared during the initial layout and this effort continued through the process. Begin the stretching by stay nailing or securely attaching the starting point in a straight line. Continue and finish the installation with the pattern parallel to the same straight line by which you began.

Recommended: The carpet installer should not attempt to stretch more than 36 feet at a time in either direction.

CAUTION: Wrinkling and buckling are most often caused by the failure to adequately stretch the carpet using a power stretcher, the use of an inappropriate cushion, adverse temperature and humidity conditions, or inadequate conditioning time.

14.8 Finishing at wall line – The installation shall be finished along the wall line, leaving a smooth, neat, and secure transition. The carpet shall be trimmed without damaging baseboards or moldings, leaving sufficient material, so the backing can be securely tucked into the gully without protruding face or backing yarns.

Note: Minor scratching of surface finish on baseboards and moldings may be unavoidable during the tucking process.

14.9 Transition molding – Where carpet meets other floor coverings, the edges must be adequately protected with an appropriate transition molding.

Sealing – Edges placed into transitional moldings may require sealing to prevent raveling.

14.10 Carpet on Stairs

Preparation - Stair nosing and return must be rounded 3/4-1 inch (19 to 25 mm) to prevent sharp stair edges from cutting the carpet and/or cushion, and to provide proper carpet contact for adhesive installations. When carpet is installed over a separate cushion, the cushion must extend over the stair nose.

14.10.2 Stretch-in installation on stairs – Tackstrip is to be installed on each tread. Pins on the tread point toward the riser. On a waterfall type stair installation, tackstrip must be installed on risers. Pins on the risers point down to the tread. The gully between the strips is slightly less than double the carpet thickness. Where a turned finish is desired, tackstrip and cushion are about 1½ inches (38 mm) less than the carpet width, allowing for a turn under on each side of the stairs. Some stairs require

tack strip on the sides to maintain the proper tension. When using a cap and band or upholstered technique, tackstrip is not used on riser.

14.10.3 Carpet direction on stairs– Carpet length should be installed parallel to length of stairs.

15. PROTECTION OF INDOOR INSTALLATIONS

15.1 Curing of Adhesive - Traffic over adhesive installations should be restricted for a minimum of 48 hours to allow proper adhesive cure. Premature traffic can cause installation failure. Exposure to water from cleaning or other sources should be restricted for a minimum of 30 days.

15.2 Materials for Protection - If required to protect the finished floor covering from dirt or paint, or if additional work is to be done after the installation, cover it with a non-staining building material paper. Protect the installation from rolling traffic by using sheets of hardboard or plywood in affected areas

Caution: Plastic sheeting should not be placed over any carpet installation because it may present a slip hazard. In addition, it may trap moisture, retarding adhesive cure and/or promoting mold and mildew growth. Care should be used when using protective films with tack-adhesive; some have been found to leave residual deposits, resulting in rapid soiling after removal of protective film.

Maintain Temperature - Temperatures of indoor carpeted areas should never fall below 50° F (10° C), regardless of the age of the installation.

16. CUSHION RECOMMENDATIONS

Recommended Cushions – Stretch-In installation method.

Proper cushion will play a key role in achieving satisfactory results and prolonging the life of the carpet. A proper cushion is firm and uniform in thickness. For all Nourison carpets, we recommend a commercial rubber or frothed polyurethane pad that does not exceed 3/8" inch in thickness and has a minimum density that will support the carpet to prevent excessive flexing of the backing yarns. A hair and jute, or synthetic fiber cushion ranging in weight from 40 to 56 ounces per square yard may also be used. Cushions that are too soft or have an uneven or non-uniform density (including pads that contain deep bubbles or ripples or have a high profile i.e. waffle pads) are not recommended.

Recommended Cushions – Double-Stick installation method.

Special cushions are required for the Double-Stick installation method. The proper cushion may depend on the specific use requirements of the end-user. There are varying thicknesses and densities for different usage such as: heavy, moderate or light foot traffic. To get the maximum carpet performance and monetary value these conditions should be considered when choosing a cushion. We recommend Tredmore 2580 or equal pad.

Recommended Cushions – Area Rugs and Runners.

Special cushions are manufactured for Area rugs and Runners. Many of these products have rug/runner placement holding properties built in. Runners and Rugs often lose their original shape when exposed to concentrated foot traffic. These special cushions will help hold the carpet in place, as well as help the carpet to maintain the original shape.

17. Adhesive Recommendations

Nourison recommends using a premium multi-purpose adhesive.

On double stick installation pressure sensitive adhesive is recommended to glue the cushion to the floor, using a 1/16"x1/16"x1/16" square notch trowel. Carpet to cushion trowel should be 1/8"x3/16"x1/8" u notch.

Other carpet installation resources.

For more information refer to CRI and/or CFI installation guidelines.

Natural fiber Flooring Installation Certification (NFIC) 770-720-4537

www.nficnet.com is another resource for information.

APPENDICES

TABLE 1

SUGGESTED TOOLS AND EQUIPMENT CHECKLIST

**A. Tape Measures
Stretcher**

1. 25-ft. (7.6 m) Retractable
2. 50-ft. (15.2 m) Metal
3. 100-ft. (30.5 m) Metal

B. Straight Edges

1. Rigid
2. Flexible

**C. Chalk Line and White
chalk (Only)**

**D. Knives and Cutters
Spreader**

1. Utility Knife
2. Carpet Knife
3. Slotted Razor Blade

Shield

4. Cushion Back Cutter

Hot Melt

5. Loop Pile Cutter

Shield

6. Wall Trimmer - Conventional

Cord and Adapter

7. Wall Trimmer - Cushion Back

Squeeze Bottle

8. Carpet Shears
9. Nap Shears
10. Electric Rotary Knife

Moisture Test Kit

11. Hacksaw
12. Tin Snips

Roller

13. Tackless Strip Cutter

Seam Weight

**E. Hammers, Mallets, and Fasteners
Aid Supplies**

J. Power

K. Knee Kicker

L. Miscellaneous

1. Base Shoe Lifter
2. Drive Down Bar
3. Stair Tool
4. Awl
5. Nail Set
6. Sharpening Stone
7. Carpet
8. Pliers
9. 3-in. (76 mm) Hot Melt Seaming Iron and
10. 6-in. (152 mm) Seaming Iron and
11. Extension
12. Plastic
13. Hammer Drill
14. Metal Miter Box
- 15.
16. PH Paper
17. Carpet Seam
18. Non-Metallic
19. Door Pin Remover
20. First

1. Carpenter's Claw Hammer
Nails

2. Tack Hammer
Square

3. Rubber Mallet
and Note Pad

4. Electric Stapler

5. Hammer Tacker

F. Screwdrivers

1. Phillips

Coloring Sticks

2. Standard

Wood.

G. Trowels

Mover Devices

1/16"x1/6"x1/16" square notch

Dead man

1/8"x3/16"x1/8" U notch

stretcher

1/8"x1/8"x1/8" U notch

H. Files

1. Triangular

2. Flat

3. Round

I. Rollers

1. 35 lb. (16 kilograms)

21. Stay

22. Carpenters

23. Pencil

24. Chalk Stick

25. Marking Pen

26. Thimble

thread

28. Putty or

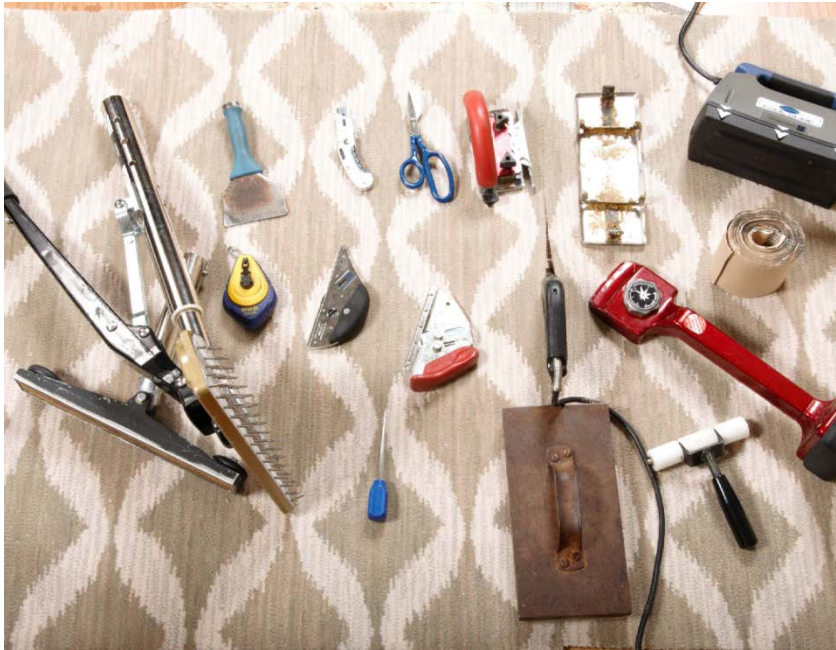
for Touchup of

29. Vacuum Cleaner

30. Fans or Air

31.

32. "Crab"



Examples of some of the tools needed for installing carpet

TABLE II

MATERIALS CHECKLIST

A. Metal and Vinyl Moldings

1. Binder Bars (applied after carpet is installed)
2. Cap Molding
3. Stair Nosing
4. Accent Molding
5. Metal Clamp-Down Gripper Bar (applied before carpet is installed)
6. Access Panel Molding
7. Combo Metal

B. Seaming Tape

1. Latex
2. Hot Melt

C. Tackstrip

1. Standard
2. Pre-Nailed (for wood)
3. Pre-Nailed (for concrete)
4. Acoustical
5. Commercial (or Architectural)