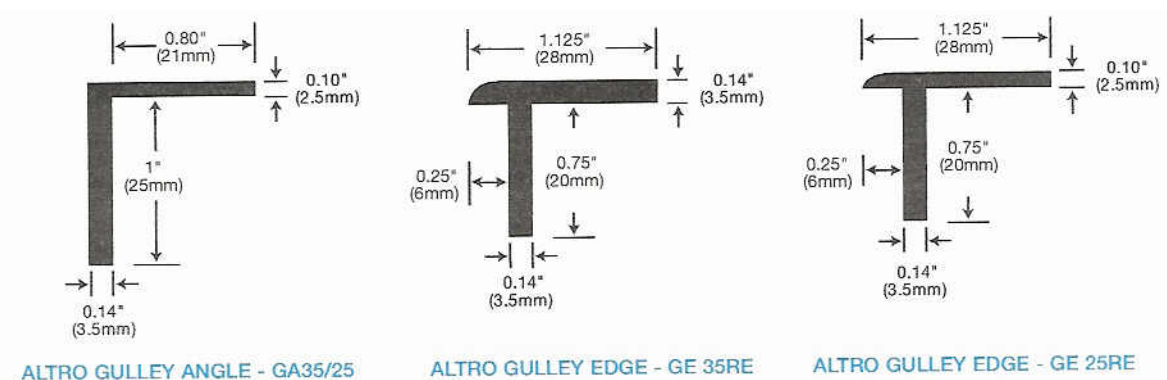




## How to Correctly Install SignaFlex Gulley Angle/Edge Moldings when Installing SignaFlex Aqua Safety Flooring



### Cutting the Concrete

- Using a small hand held electric grinder or circular saw equipped with a diamond saw blade (wet type preferred), cut a 1" deep x 3/32" wide saw cut in the concrete substrate to receive the Gulley Angle/Edge. Two (2) passes may be necessary to achieve the correct width of groove unless the saw blade is 3/32" wide. **(See Diagram A)**  
**Note: The use of a wet type saw blade would, if used correctly, reduce the amount of airborne dust created while cutting concrete. Dry sawing can be done if a dust recovery cutting system is utilized.**
- If the area to be saw cut is in a doorway or abutting a wall the saw/grinder will be unable to cut all the way to the door casing or wall. In this case a series of 1" deep holes can be drilled in the concrete substrate using a 1/4" masonry drill bit and then chiseled out to allow Gulley Angle/Edge to seat flush with the subfloor. **(See Diagram B)**
- If the area to be saw cut is at floor drains or trenches, the cut must be made directly up against the drain or trench. **(See Diagram C)**
- On all types of cuts, it's helpful to use some form of straight edge or guide to create a straight saw cut allowing for a professional fit and finish.
- All water and concrete silt must be removed/vacuumed from the saw cut. The area in and around the saw cut must be allowed to dry completely before gluing can take place.



Diagram A

Diagram B

Diagram C

## Gluing Process

6. Using masking tape or other suitable tape, tape the outside perimeters of where the Gulley Angle/Edge will be installed, this will aid with the clean up of excess adhesive after installing the Gulley Angle/Edge.
7. Apply adhesive (SignaFix 30/31 2-part polyurethane or equal) on the floor and in the saw cut.
8. Place the Gulley Angle/Edge into the saw cut making certain that it is completely embedded into the adhesive.
9. Using a small scraper or putty knife remove excess adhesive, if adhesive is on the surface of the Gulley Angle/Edge remove using a small amount of denatured alcohol on a clean white rag.  
**Note: Do not allow adhesive to dry on the Gulley Angle/Edge, once dry, the 2-part adhesive cannot be removed.**
10. It may also be necessary to weight down the Gulley Angle/Edge until the adhesive has a chance to set-up, this will insure that the strip is fully seated and without voids.
11. Always allow the Gulley Angle/Edge to set-up in the adhesive, (typically from 4 to 6 hours) prior to cutting and fitting the SignaFlex Aqua Safety Flooring to the newly installed strip. The flooring material should be scribe fit to insure a neat net fit seam for heat welding.

## Welding Process

12. Heat-welding must not be attempted until adhesive has cured (typically 24 hours on SignaFix 30, and 4 to 6 hours on the SignaFix 31)
13. Groove Gulley Angle/Edge and flooring as if it were a seam in the flooring material, Gulley Angle/Edge is made of vinyl and weld just like the flooring material.  
**Note: When hand grooving, always use a straight edge as a guide to achieve a straight groove.**



14. Clean all dirt and debris from grooved seam and weld as you would the Signature flooring material. If applicable, always weld mitered corners with black rod.  
**Note: Traditionally, a black rod is used to weld the flooring to the Gulley Angle/Edge. However, a rod color that matches the flooring material can also be used.**
15. Trim with a sharp trimming knife using a trim plate for the initial cut, once the welding rod is allowed to cool (typically 30 minutes) the final flush trim pass can be completed.
16. Touch-up can be done using a hot tip repair tool or bullet tip repair tool.

**Note: Gulley Angle/Edge must be fully adhered to the inside of the saw cut groove and onto the substrate. All joints, flooring to Gulley Angle/Edge, as well as the angled corners of the Gulley Edge must be welded, failure to do so may allow water to encroach under the flooring, thus compromising the integrity of the flooring and Gulley Angle/Edge.**



Finished Floor Drain