Technical Data & Installation Sheet
Impression™ Luxury Vinyl Stair Tread

Impression by Six Degrees Flooring Surfaces

Plank + Tile VINYL FLOORING

Product

Impression from Six Degrees is a pre-molded, one-piece luxury vinyl (LVT) combination tread/riser. Our unique and expertly engineered tread designs match perfectly with many of our top-selling, heavy-commercial rate styles, so the transition from floor to stairs flows smoothly.

The one piece tread/riser design is constructed from the same high quality, heavy commercial vinyl plank (28mil with ceramic bead finish) we produce in our US manufacturing facility.

Material is 100% recyclable and manufactured from premium raw materials, making it a beautiful and functional solution for your stair tread installations.

Ideal Installation Locations:

Commercial: hospitals, schools, municipal, corporate, churches

Multi-Level Housing: apartment complexes, student housing, assisted/independent living facilities

Features

- **Matched to Existing LVT Options with Same Print Film**
- **Ceramic-Reinforced UV-Cured Finish**
- **Enhanced with EnviroSDTM Anti-Bacterial Agent**
- **Extremely Durable**
- **Excellent Chemical Resistance**
- **FloorScore® Certified**

Technical Data

Nominal Tread Dimensions:	14 1/8" (35.88 cm)
Nominal Riser Dimensions:	8 1/4" (20.96 cm)
Nominal Length:	36" (91.44 cm) up to 108" (2.74 m) in 6" (15.24 cm) increments
Finish:	Embossed
Wear Layer Thickness:	28Mil (0.028")
ASTM F2169 – Resilient Stair Treads:	Type TV, Class 2
ASTM E648 - Critical Radiant Flux:	Class I, >.45 W/cm2
ASTM E662 - Smoke Density:	Passes, <450
ASTM D2047 - Slip Resistance:	> 0.60
ASTM F970 - Static Load Limit:	Passes, 250 PSI
ASTM F970 (Modified) - Max Weight:	1000 PSI
ASTM F925 – Chemical Resistance:	Excellent (chart available)
ASTM F1514 – Heat Stability:	Passes
ASTM F1515 – Light Stability:	Passes
Acclimation Time:	48 Hours
Storage & Acclimation Temperature:	65° - 85° F

Additional Information

Required Adhesives

- EN-610 Epoxy Nose Filler

Approved Adhesives

- AW-510 Acrylic Wet-Set Adhesive
- AP-520 Acrylic Pressure Sensitive
- TP-620 Pressure Sensitive Tape

Availability, Cost & Samples

Six Degrees Flooring products are sold through appointed sales representatives. To locate the nearest representative, contact Six Degrees Customer Service at (844)432-5885 or send an e-mail to support@sixdegreesflooring.com

Technical Documents & Support

Additional product resources and technical documents are available online at sixdegreesflooring.com.

For additional technical support, send an email to solutions@rhctechnical.com

1. PRE-INSTALLATION CHECKLIST

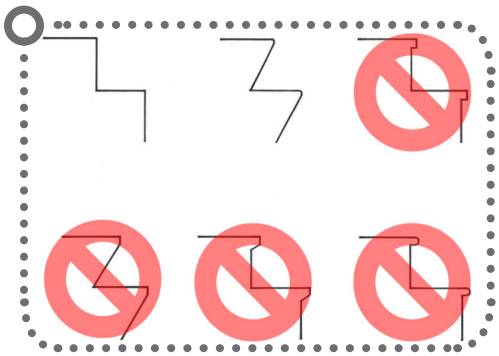
Consult all associated product literature concerning adhesive installation, maintenance and warranty prior to installation of flooring. Allow all trades to complete work prior to installation. Deliver all materials to the installation location in its original packaging with labels intact. Do not stack pallets to avoid damage. Remove any plastic and strapping from product after delivery. Inspect all material for proper type, color and matching lot numbers if appropriate. Ensure that all adhesives intended for installation are approved for use with stair tread, riser and/or stringer material. Ensure installation area

and material storage temperatures are between 65° F (19° C) and 85° F (30° C) for at least 48 hours before, during and after installation. Ensure HVAC system is operational and fully functioning at normal operating conditions. Protect installation area from extreme temperature changes, such as heat and freezing, as well as direct sunlight for at least 48 hours before, during and after installation. Ensure all substrate preparation and moisture testing requirements have been performed, read and/or understood by all interested parties. Do not proceed with installation until all conditions have been met.

2. PRODUCT LIMITATIONS

Do Not install materials over improper step format, verify shape of step prior to ordering as material cannot be formed onsite to other step styles.

Due to the rigidity of this product all sides and edges need to be scribed or cut with precision. Impressions Luxury Vinyl Stair Treads are not as flexible as traditional rubber/vinyl treads, imperfections will be noticeable when fitting.



Do not install materials over LVT, cushioned vinyl, hardwood flooring, cork, rubber, asphaltic materials or existing resilient stair treads. Do not install stair tread materials in outdoor areas or in and near commercial kitchens. Do not install in areas that may be subjected to sharp, pointed objects, such as stiletto heels, cleats or spikes. Do not allow product to be directly exposed to extreme heat sources, such as radiators, ovens or other high-heat Equipment. May be susceptible to staining from rubber tires, casters or rubber-backed walk-off mats, as well as harsh disinfectants, cleaning agents, dyes or other harsh chemicals – ensure all chemicals and materials that may come in contact with tread surface will not stain, mar or otherwise damage the stair tread material prior to use.

3. SUBSTRATE PREPARATION

All substrates must be prepared according to ASTM F710, as well as applicable ACI and RFCI guidelines. Substrates must clean, smooth, permanently dry, flat, and structurally sound. Substrates must be free of visible water or moisture, dust, sealers, paint, sweeping compounds, curing compounds, residual adhesives and adhesive removers, concrete hardeners or densifiers, solvents, wax, oil, grease, asphalt, visible alkaline salts or excessive efflorescence, mold, mildew and any other extraneous coating, film, material or foreign matter.

All substrates must have any and all existing adhesives, materials, contaminants or bond-breakers mechanically removed via scraping, sanding or grinding. Mechanical preparation must expose at least 90% of the original substrate. Following cleaning and removal, all substrates must be vacuumed with a flat vacuum attachment or damp mopped with clean, potable water to remove all surface dust. Sweeping without vacuuming or damp mopping will not be acceptable.

All non-wood substrates must be tested per ASTM F3191 to confirm porosity. Use a pipette or equivalent to conduct three tests by placing a .05 mL (1/4" wide) droplet of clean, potable water onto the surface. If the substrate absorbs water within 60 seconds, the substrate is considered porous. Conduct at least one per stair well. All other substrates that do not meet this requirement are considered non-porous. Ensure that all non-porous substrates are not contaminated with any aforementioned contaminates.

It is recommended that all substrates have a floor flatness of FF32 and/or a flatness tolerance of 1/8" in 6' or 3/16" in 10'. Substrates that do not meet this requirement should have a compatible cementitious patch (such as the Excelsior CP-300) installed to flatten the installation area.

Do not use solvent/citrus based adhesive removers prior to installation. Follow The Resilient Floor Covering Institute's (RFCI) "Recommended Work Practice for Removal of Existing Floor Covering and Adhesive", and all applicable local, state, federal and industry regulations and guidelines. When removing asbestos and asbestos containing materials, follow all applicable OSHA standards.

CONCRETE SUBSTRATES

All concrete must have a minimum compressive strength of 3500 PSI and be prepared in accordance with ASTM F710. When stair treads are installed directly over concrete, concrete surfaces that have an ICRI Concrete Surface Profile (CSP) over 4 should be flattened with a patching compound to prevent imperfections from telegraphing through stair tread materials.

RESINOUS SUBSTRATES

When installing directly over a resinous products, such as an epoxy coating, ensure that coating is dry to the touch and has cured for the prescribed length of time. Substrate must be clean, dry, sound and free of contaminates. Ensure to follow installation procedures and trowel sizes for non-porous substrates.

WOOD SUBSTRATES

Wood substrates must be constructed per federal, state and/or local building codes. Wood substrates should have a minimum thickness of 1". If plywood is being used, ensure plywood is Underlayment Grade with a minimum thickness of 1/4" and is fully sanded prior to installation. When stairs may be subjected to moisture, use an APA approved exterior grade plywood.

Other wood materials, such as OSB, lauan, particleboard, chipboard, fiberboard or cementitious tile backer boards, are not acceptable substrates. Avoid preservative-treated and fire-retardant plywood, as some may be manufactured with resins or adhesives that may cause discoloration or staining of materials. Do not install stair treads, risers or stringers directly over solid or engineered hardwood flooring without first installing plywood or a suitable cementitious repair product at a minimum thickness of 1/4" over the hardwood flooring.

Wood substrate deflection, movement, or instability may cause stair tread installations to release, buckle or become distorted. As such, do not use plastic or

resin filler to patch cracks. Do not use cement or rosin coated nails and staples or solvent-based construction adhesives to adhere the plywood.

METAL SUBSTRATES

Metal substrates must be thoroughly sanded/ground and cleaned of any residue, oil, rust and/or oxidation. Substrate must be smooth, flat and sound prior to installation. When installing in areas that may be subject to topical water or moisture and/or high humidity, an anti-corrosive coating must be applied to protect metal substrate. Contact a local paint or coating supplier for coating recommendations. Install stair treads within 12 hours after sanding/grinding to prevent re-oxidation. Any deflection in the metal floor can cause a bond failure between the adhesive and the metal substrate. Be sure to follow installation procedures and trowel sizes for non-porous substrates.

EXISTING STAIR TREAD SUBSTRATES

The suitability of existing stair treads as a substrate depends on the specific requirements of the adhesive being used to install the material. As such, refer to the adhesive requirements for existing flooring substrates and ensure all adhesive requirements and guidelines are followed.

Do not install over existing resilient rubber or vinyl stair treads.

4. PRODUCT INSTALLATION

Ensure substrate is suitably prepared prior to installation, as manufacturer is not responsible for substrates that have not been properly prepared.

For the installation of this product we highly recommend the use of the Proknee Treadman installation jig and One Piece Tread/Riser Template Kit.

https://www.proknee.com/treadman

Other recommended tools for installation include a comfortable raised table or work surface and a heat gun to assist in the cutting of the material, always heating the underside of the material.

If a Treadman is not available, we will describe an alternative method to fit the treads to the steps prior to installation. If not using the Treadman, it is necessary to order an additional tread to use the ends for pattern scribing.

PREFERRED METHOD FOR PATTERN SCRIBING OF TREADS

Watch the One Piece Step/Riser installation video for the Treadman at www.proknee.com/treadman#video1

Even though this video accommodates for the tread and riser going up, we will adapt the Treadman to install the tread and riser going down. For this reason the Treadman will need to be modified.When installing the Template Kit extension tabs they will need to be reversed from the video. The tab that would have been applied on the top left plate will now be applied to the bottom right plate (as per

the pic) and the top right will now be the bottom left plate.

Because the tabs are being used on the bottom riser (usually shorter that the top) the length of the tabs might need to be cut.

Apply the tape over the extension tabs as per the video.

Be sure to place spacers under Treadman to adjust for the thickness of the material.

Adjust the Treadman plates on the top for the tread and the bottom for the riser to ensure a tight fit.

Mark down the width of the step on Treadman for reference.

Scribe both sides of the riser to the stringers, and the bottom edge to the tread or flooring below with the scribe plate (provided) or dividers onto the tape.

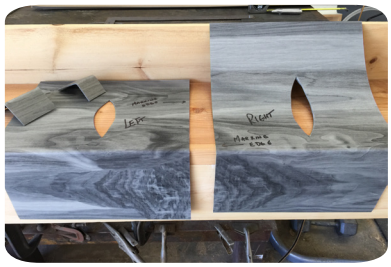
Remove the Treadman from the step and place over the Impressions Luxury Vinyl Stair Tread and transfer lines from the jig.

If using the J-Channel Transition piece between the Tread and Riser portions, allow 3/8" to 1/2" gap at the bottom of the riser.

OPTIONAL METHOD FOR PATTERN SCRIBING TREADS

Cut two strips off of extra tread, roughly 3" wide. Trim material from the tread and riser portion so they will fit well onto the step and use for spacers. These will be used to place under the Left and Right Pattern Pieces to account for the thickness of the actual treads when scribing.

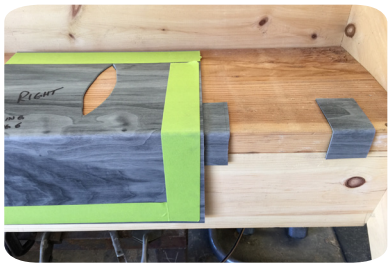
Cut remainder of the extra tread in half making sure the center cut is straight and square, these straight and square



edges will be used as "marking edges". These will now be referred to as Left and Right Pattern Pieces. Cut openings in the tread portion of the patterns, these will allow them to be taped into place when scribing.

Measure the average depth of each tread and height of each riser then cut the pattern pieces approximately 1″ shorter. If the depth is 12″ and rise is 7", then cut the patterns 11" and 6″.

Apply scribing tape along three sides of each pattern piece. Place spacers under first pattern piece and tape material through cut-out so it will not move while scribing.



Mark a clean, crisp pencil line along the "marking edge" of the pattern piece on the step surface. Proceed with scribing the first pattern pieces on three sides.

Repeat this process on the second pattern pieces, remember to use the spacers. Make sure to mark a clear, crisp pencil line along marking edge.

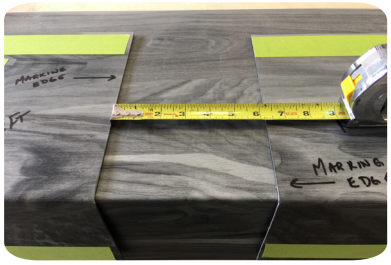
It is important to make sure the pencil lines are clearly marked as they will determine the proper measurement when using the pattern pieces to cut the tread.

If the rubber transition piece is going to be used at the bottom of the tread, allow 3/8″ to 1/2″ gap at the bottom of the riser.

After scribing both sides, remove pattern pieces from step.

Place full size tread piece on work surface and transfer pattern pieces onto full size tread without the spacers.

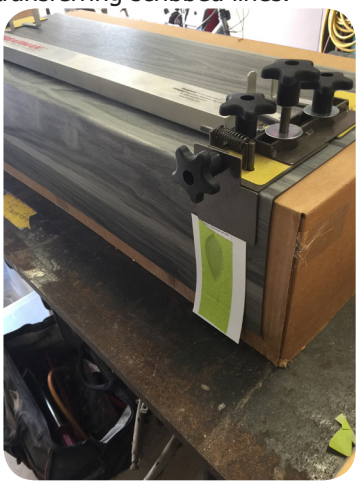
Measure the distance on the step between your marking lines of the left and right pattern pieces.

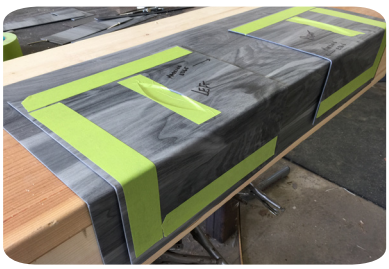


Secure pattern pieces with tape at the proper distance between patterns, ensureing the patter pieces are tight to the tread. Allow enough space on each side for scribe distance.

FINAL CUTTING AND INSTALLATION OF TREADS

Be sure you have a solid full size box or table to place LVT blank on while working and transferring scribbed lines.





After transferring lines, score and cut material. Due to the thickness and durability of the product, do not try to cut through material in one pass. Multiple passes will be required.

A heat gun can be used to help soften material during the cutting process. Be sure to heat material from the back side.

When cutting is finalized, fit tread to step and fine tune from there. Sometimes a slight under bevel cut along edge will help.

If the J-Channel Transition piece is going to be used at the bottom of the tread, allow 3/8″ to 1/2" gap at the bottom of the riser.

Once tread is properly fitted, remove the green tape from the extension tab on the Treadman or Pattern Pieces, apply new tape for new scribe marks of next tread.

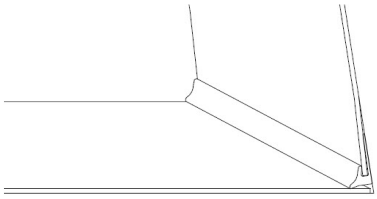
All treads will not be the same and new tape will be required.

J-CHANNEL TRANSITION INSTALLATION

The J-Channel Tranistion is a trim piece that transitions from the riser of one step to the tread of the step below. It can assist with slight deflections or gaps caused from substrate imperfection at the transition point.

Lay a straight edge across the width of the step to see exactly how flat treads are from side to side. The riser above of the Impression Stair Tread needs to have an allowable gap (usually 3/8" – 1/2") at the bottom for installation of the J-Channel Transition.

Cut the J-Channel slightly longer with a little compression upon installation. It is recommended to estimate how many "steps per piece" you will need rather than estimating "linear feet required" to save from unnecessary end seams. Refer to the diagram for material placement.



ADHESIVE APPLICATION

When using the Excelsior TP-620 Stair Tread Tape be sure to clean dusty and/or cementitious substrates with a damp mop or sponge prior to installation to remove dust, dirt and debris.

Ensure adhesive is approved for use with stair tread material and that proper trowel type and size is used, as manufacturer is not responsible for any and all adhesion issues related to improper adhesive selection or usage. Prior to installing adhesive, ensure all stair treads and risers have been trimmed, cut, pre-fit and all stringer materials have been installed. Clean the underside of the stair tread with a clean rag or towel. Apply adhesive according to instructions on the data sheet for the adhesive used. Be sure to follow instructions based on substrate porosity (porous or non-porous).

All stair treads must have the Excelsior EN-610 Epoxy Nose Filler installed in the stair nose. Failure to do so may result in premature wear and damage which could compromise egress safety.

When installing adhesive on steps, be sure to leave a 1/2" to 3/4" space on either side of step nose to accommodate the Excelsior EN-610 Epoxy Nose Filler and avoid adhesive cross-contamination. Prior to installing the stair tread into adhesive, apply a 1/4" to 1/2" bead of the EN-610 to the interior nose of the stair tread. The size of the bead required will be directly related to how tight the LVT tread fits the actual step profile. The bigger the gap at the leading edge the more material will be required. Keep in mind the EN-610 is not designed to restructure the design of the step, but just an added support at the leading edge. If there are any questions as to whether the tread and step profiles are compatible, please take pictures and contact the technical department.

Adhesive Traffic Limits

AW-510 Acrylic Wet Set Adhesive	
Foot Traffic:	24 Hours
Heavy / Rolling Traffic:	48 Hours
Maintenance:	72 Hours
AP-520 Acrylic Roll-On Pressure Sensitive Adhesive	
Foot Traffic:	Immediate
Heavy / Rolling Traffic.	Immediate
Maintenance:	72 Hours
TP-620 Pressure Sensitive Tape Adhesive	
Foot Traffic:	Immediate
Heavy / Rolling Traffic.	Immediate
Maintenance:	Immediate

Once adhesive is applied, slip transition piece on bottom of tread. Fit tread to step making sure that the leading edge of the nose is tight against the step. Roll treads with hand roller to ensure proper adhesive transfer on both tread and riser sections of the product. Do not roll the area of the treads where the EN-610 is applied as this could cause the epoxy to disperse too thin and not fully support the leading edge.

If using a wet set adhesive, continue to roll material periodically until adhesive has set up.

You can fine tune any gaps with a color match caulking.

ADHESIVE SPECIAL INSTRUCTIONS

When using Excelsior AP-520 Acrylic Pressure Sensitive the application on the riser section of the step needs to be teated like a contact adhesive. This means the AP-520 needs to be applied to both surfaces to create a more permament bond. The top (tread) surface of the step only needs the AP-520 applied to the substrate like a PS adhesive should be used. This is because the top of the tread will continually be walked on ensuring constant pressure into the adhesive where the riser will not. The use of a narrow roller is recommended for working on a smaller area.

When using Excelsior TP-620 Pressure Sensitive Tape Adhesive it is recommended to use the 9.5" tape on the tread section and a combination of the 4" and one or two strips of the 1" on the riser to accommidate for the typical 6" to 7" riser area.

Visually inspect installation to ensure that material has not shifted and that adhesive has not been squeezed out of joints or compressed onto surface.

Replace trowels and/or applicators at recommended intervals to maintain proper trowel ridge and spread rate. When installing into adhesive using a wet-set method, avoid walking, kneeling or working on material until adhesive has cured for light foot traffic. Working on material that is installed into wet adhesive could cause adhesive to displace. When working off of material is not possible, use a kneeling board or equivalent to disperse weight evenly and prevent adhesive displacement. Periodically lift material to ensure proper adhesive transfer and ensure adhesive has not surpassed the open time, adhesive should cover 90% of the stair tread and riser. Clean excessive

adhesive or adhesive residue from the surface of the material using a clean cloth or mop and a solution of warm water and a pH neutral cleaner. Do not use abrasive or solvent based cleaners.

5. STAIR TREAD PROTECTION POST-INSTALLATION

Protect newly installed treads with construction grade paper or protective boards, such as Masonite or Ram Board, to protect treads from damage by other trades.

Do not slide or drag pallets or heavy equipment up or down across the new treads. Limit usage and foot traffic according to the adhesive's requirements.

When moving appliances or heavy furniture, protect treads from scuffing and tearing using temporary floor protection.

Place walk-off mats at outside entrances. Ensure mats are manufactured with non-staining backs to prevent discoloration.

6. INITIAL MAINTENANCE

Ensure that adhesive has cured for recommended period of time prior to conducting initial maintenance. Remove any protective coverings prior to cleaning. Sweep, dust mop and/or vacuum stair tread to remove any dirt, dust or debris.

Mix 2-4 ounces of Excelsior NC-900 Neutral Cleaner per gallon of clean, potable. Use a clean microfiber pad or string mop to clean spills, dirt buildup and other debris. Rinse treads afterwards and allow floor to dry before allowing foot traffic.

For further information and complete precautions, recommendations and full maintenance procedures please consult the product care & maintenance document.

7. WARRANTY

Six Degrees provides a 10 Year Commercial Warranty Impression Luxury Vinyl Stair Treads. For additional information and full warranty guidelines please consult the product warranty document.

FOR PROFESSIONAL USE ONLY. PLEASE CONSULT ALL ASSOCIATED TECHNICAL DATA SHEETS, SAFETY DATA SHEETS, MAINTENANCE DOCUMENTS, WARRANTY INFORMATION PRIOR TO INSTALLATION.