

PATTERNED CARPET GUIDELINES

Patterned carpet has been designed to insure pattern matches when installed properly. Installation of patterned carpets does require more time and skill, which should be captured in cost estimates. The alignment of patterned carpet is best achieved by stretch-in installation. Glue-down applications may be used, however, the pattern match potential is decreased.

Always be sure to follow dye sequence indicated on roll goods for installation. Carpet should be cut and allowed to condition or acclimate before installing. Conditioning will improve the flexibility of the carpet. Matching points must be cut very carefully to allow for pattern match.

Some installers prefer to cut from the face, but that is strictly a preference. To correctly cut for seams an installer may also cut into the edge of the width to the match point, then cut into the length approximately one inch to form an "L". This should be done along both widths of the carpet at each match point for the length of the seam. This will allow the "L" to be used for alignment of a straight edge and the carpet can be cut from the back along that edge.

Pattern matching should begin in the center of the length. This insures the best possible pattern match. It may be necessary to use stay-nails and stretch the carpet at intervals to bring the carpet in to perfect match.

DETAILED PATTERNED CARPET INSTALLATION GUIDELINES

The most common types of pattern repeats are set match and half drop, which have been demonstrated on page iii of the introduction. Normal stresses experienced by the carpet through manufacturing processes may occur and can be stretched to match, within standard tolerances. Tolerances are as follows:

NOTE: Stop installation and contact mill if the following tolerances have been exceeded.

1. If bowing is greater than 1 inch in 12 foot width or 1 inch in 12 foot length.
2. If skew or squareness of pattern is greater than 1 1/2 inches in 12 foot width.
3. If pattern elongation is more that an average of 3 inches in 24 foot length.

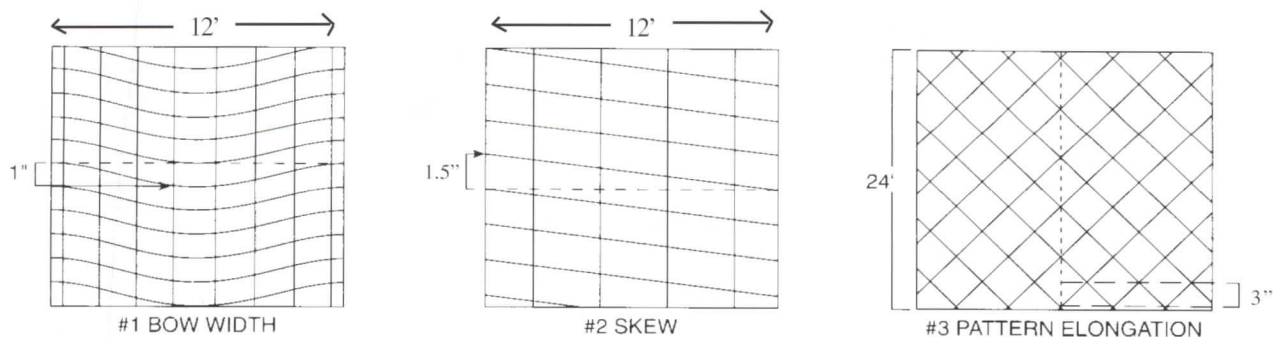


Figure 1

WE DO NOT GUARANTEE PATTERN REPEAT MATCH!

We have established our tolerance so that a match should be achievable by stretching the short side out to meet the long side.

HOW TO: Trim Printed Patterns

PRINTED CARPET is achieved by an overprinting process, that is, the patterns are actually printed on the face of the carpet yarns, **NOT TUFTED PATTERNS**. Because these patterns are printed on, not tufted, the row cutting method should not be used for trimming seams. **Rows and patterns do not run true.**

The following procedure should be used to trim seams and align patterns:

1. Using a razor knife, make slits into the face of the carpet on the exact point of the pattern you wish to follow. Make these cuts every 3 to 4 feet the entire length of seam and at the same point of the pattern.
Note: Always use center of diamonds for pattern match; for other patterns use heavy accent lines.
2. Fold carpet over and use straightedge to cut from the back. Following slits every 3 to 4 feet will assure patterns are trimmed at the same point on each pattern.
3. Trim second seam edge using the same procedure. Half diamonds will line up with half diamonds to form a complete diamond.

If patterns are not cut in the proper fashion, they will not match. Chalkline, free-hand, or trace cutting is not recommended and will not achieve a match.

****HOW TO: Match Pattern (Correction for Pattern Elongation)**

Once the printed carpet has been trimmed in the proper fashion (always use center of diamond patterns or grout or accent lines in block patterns):

- *1. An easy way to determine which cuts will match best is to count off 30 patterns and compare the measurements to determine sequence.

Example:	Drop A	30 patterns measure 15' 0"
	Drop B	30 patterns measure 15' 2"
	Drop C	30 patterns measure 14' 11"
	Drop D	30 patterns measure 15' 1"

The proper judgement in this example is to place the drops as follows to diminish the pattern elongation; 14' 11", 15' 0", 15' 1", 15' 2".

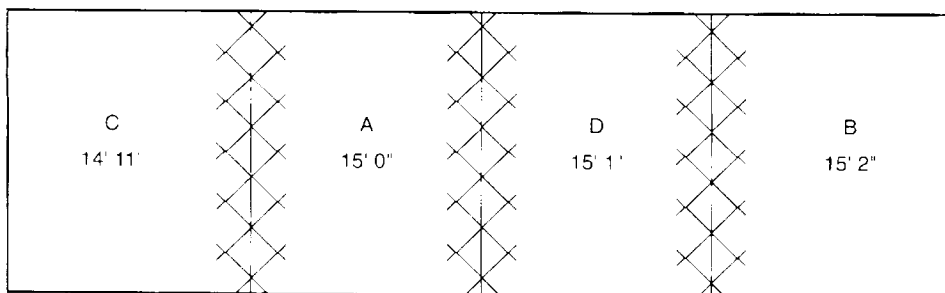


Figure 2

***In this example, the elongation from least to greatest is 3", or 1.5".**

Experience has shown that most carpets easily stretch 1 1/2" or 2% with a power stretcher. The deviation between Drop A and Drop C is only 1/2 of 1%.

- 2. Dry fit all pieces prior to beginning installation.**
- 3. Cut 24 hours in advance if possible. This allows the carpet to relax.**
- 4. If pattern is only slightly off, tightly rolling the (short side) drops face out and leaving rolled for 24 hours can help.**
- 5. Match all patterns in center of seam and work toward ends.**
- 6. If you are mixing dye lots, do not expect color or pattern to match.**

FOR STRETCH INSTALLATION

THE BEST WAY TO DETERMINE PATTERN MATCH IS TO STAND BACK AND SIGHT DOWN DIAGONALS FORMED BY PATTERN. *Remember, we can only stretch the short side (not shrink the long side). Lay out all work so this can be accomplished. Never glue the short side.

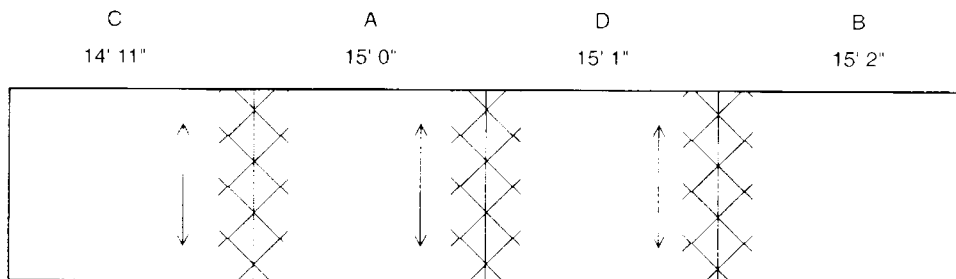


Figure 3

- 1. Loose lay all drops in place in proper sequence (see #1 Pattern Elongation Determination Procedure). Allow to relax for 24 hours if possible.**
- 2. Trim and prepare seams per instructions.**
- 3. Once long and short side is determined, use two-head power stretcher on short side to match pattern.**
- 4. As always, begin pattern matching in center of drop. This divides the pattern elongation and makes for less work.**
- 5. Seal seam edges with good quality latex seam adhesive. Apply latex sealer at base of primary backing. (THIS IS A MUST).**
- 6. Run hot melt seam making minor adjustments with knee kicker. Run short lengths of seam if necessary. Allow to cool and readjust as needed.**
- 7. The best way to determine pattern match is to stand back and sight down diagonals formed by pattern.**

CORRIDOR PATTERN GUIDELINES

Splitting rolls

In corridor patterns it will be necessary to split the carpet down the center of the roll making two corridor sections. This is best accomplished by straight-edging along the cut line. Please follow the cut line exactly.

The carpet can be shop-cut to designated lengths at the same time rolls are being split, but the dye sequence from the mill must be followed precisely to assure uniform sidematch.

Handling

Carpet should not be bundled, bent or unnecessarily folded. Mishandling of carpet can create installation problems.

CORRIDOR CENTERING BY WIDTH

Measuring the width of corridors at intervals down the length will help reduce potential problems. If substantial variances appear, these points should be considered when centering the carpet.

When centering carpet in the width of the corridor, it will be necessary to keep an equal distance between the edge of the pattern on both sides and the walls.

To properly measure the distance between the edge of the pattern and the wall, each side of the carpet will need to be notched. In a stretch installation it will be necessary to offset centering approximately one-quarter inch toward the wall from which you will stretch the carpet across the width. Glue down installations would not require offset measurements since no stretch will be put on the carpet.

CORRIDOR CENTERING BY LENGTH

The carpet should also be centered by length so that equal distance is left at each end of the corridor, if caps are being used. This allows your end caps to match with linear pattern.

Seaming

Irons for hot melt seaming should be set no higher than a 2 1/2 setting. Avoid using narrow tapes with open stitching through the scrim or tapes with high melt temperatures.

Pile direction should be considered in rooms adjoining the corridor and should be kept uniform if at all possible.

A better seam can generally be obtained along the edge of the width by straight-edging from the back of the corridor pattern and the room carpet or the fill piece it will adjoin.

CAP INSTALLATION

Caps will have to be top cut in order to assure precise cuts along the edge of the pattern. Some constructions may allow running an awl along the straight edge to separate the pile and avoid cutting across yarns.

Stretch-In

It is generally necessary to anchor the carpet and stretch in opposite directions from the anchored area. 1% to 1 1/2% is desirable for stretching.

Glue Down

NOTICE: We do not recommend the installation of Pattern Carpets using direct glue down installations. This is due to the difficulty of power stretching and matching the side pattern on direct glue down installation. NO PATTERN MATCH CLAIMS WILL BE ENTERTAINED ON DIRECT GLUE INSTALLATION.

All glue-down installations should be seamed properly with a medium to best multi-purpose adhesive. Rolling the carpet provides a smooth and even contact with the adhesive.

DETAIL CORRIDOR PATTERN INSTALLATION GUIDELINES

All printed carpet is subject to certain industry tolerances. We feel our tolerances are more stringent than standard industry tolerances. Our tolerances are as follows:

NOTE: Stop installation and contact mill if the following tolerances have been exceeded. Make sure you inspect this carpet prior to installation. No claim will be honored if carpet is installed with visible defects.

1. If bowing is greater than 1/2 inch in 6 foot width or 1 inch in 12 foot length.
2. If skew or squareness of pattern is greater than 3/4 inch in 6 foot width.
3. If pattern varies more than an average of 1/4 inch on each side or 1/2 inch total when cap is centered to field section.

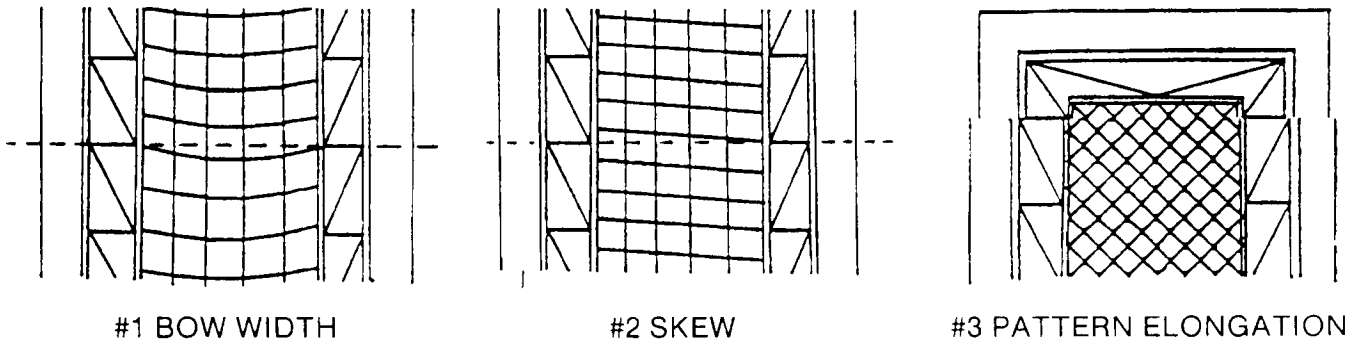


Figure 4

WE DO NOT GUARANTEE PATTERN REPEAT MATCH ON CAPS!

We have established our tolerance so that a match should be achievable by stretching the short side out to meet the long side.

HOW TO: Trim Printed Patterns

Corridor patterns are achieved by an overprinting process, that is, the patterns are actually printed on the face of the carpet yarns. **NOT TUFTED PATTERNS.** Because these patterns are printed on, not tufted, the row cutting method should not be used for trimming seams. Rows and patterns do not run true.

****The following procedure should be used to trim seams:**

1. **Loose lay cap sections onto field sections and shift cap as needed until both the inset field and border patterns are aligned before trimming seams. NOTE: If inset patterns have a repeat of 4 inches and border patterns have a 12-inch repeat, caps will only align with corridor section every 12 inches.**
2. **Using a razor knife, make a slit into the face of the carpet on the exact point of the pattern you wish to follow. Make a cut on each end of the corridor width and on the same point on each pattern. NOTE: Always use center of diamonds or heavy accent lines for pattern match.**
3. **Fold carpet over and use straightedge to cut from the back following slits. This method will assure seam edges are trimmed at the same point of each pattern.**
4. **Trim cap sections using the same procedure as above. Caps and corridor sections should line up with both inset patterns and border patterns.**

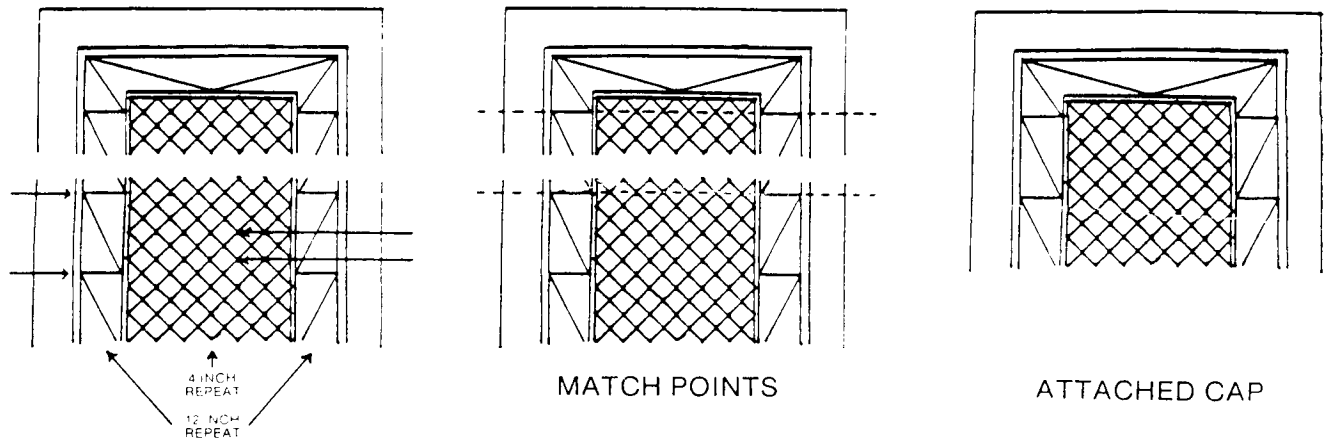


Figure 5

HOW TO: Match Pattern (Correction for Pattern Elongation)

****Same as in Detailed Patterned Carpet Installation Guidelines.**

GUIDELINES FOR GLUE DOWN INSTALLATION

First, determine whether the corridor or cap has the short patterns. Since there is no dependable way to shrink a synthetic tufted carpet, we must use a process we do know: stretching. We are very simply going to stretch the short pattern side out to meet the long pattern, so:

In Glue-Down Installations:

- 1. Set cap section into place and center with corridor section. Determine amount of elongation and amount of stretch required to align patterns. Remove cap and trowel adhesive in this area.**
- 2. Apply seam sealer at base of primary backing. (THIS IS A MUST.)**
- 3. Set cap section into adhesive and align patterns in the center of seam area.**
- 4. Using two-headed power stretcher, stretch short patterns out to meet long patterns. Knee kicker will be helpful for minor adjustments. Leave stretcher or stay nails in place until adhesive sets.**

Remember, we can only stretch the short side (not shrink the long side). Lay out all work so this can be accomplished. Never glue the short side first.

GUIDELINES FOR STRETCH INSTALLATION

- 1. Trim and prepare corridor and cap seams per instructions.**
- 2. Once long and short side is determined, use two-head power stretcher on short side to match pattern.**
- 3. As always, begin pattern matching in center of the seam. This divides the pattern elongation and makes for less work.**
- 4. Seal seam edges with good quality latex seam adhesive. Apply latex sealer at base of primary backing. (THIS IS A MUST).**
- 5. Run hot melt seam making minor adjustments with knee kicker. Run short lengths of seam if necessary. Allow to cool and readjust as needed.**

CUSTOM PRINT REQUEST FORM

CUSTOMER _____ DATE _____

CONTACT _____ PHONE _____

CARPET STRIKE OR PAPER STRIKE (CIRCLE ONE)

SHIP TO _____

SAMPLE # 1

PATTERN NUMBER _____ SCREEN ID _____ DATE NEEDED _____

BASE CODE _____ STANDARD _____

- | | |
|----|----|
| 1. | 2. |
| 3. | 4. |
| 5. | 6. |
| 7. | 8. |

SPECIAL INSTRUCTIONS _____

SAMPLE # 2

PATTERN NUMBER _____ SCREEN ID _____ DATE NEEDED _____

BASE CODE _____ STANDARD _____

- | | |
|----|----|
| 1. | 2. |
| 3. | 4. |
| 5. | 6. |
| 7. | 8. |

SPECIAL INSTRUCTIONS _____

SAMPLE # 3

PATTERN NUMBER _____ SCREEN ID _____ DATE NEEDED _____

BASE CODE _____ STANDARD _____

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| 1. | 2. |
| 3. | 4. |
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| 7. | 8. |

SPECIAL INSTRUCTIONS _____

