

**PASSAGE<sup>®</sup>**

**Type - TBS 10, 11R, 16, 20S, 21 et Speedgrip**

This laying method concerns industry, sailing, the building industry, transport or leisure.

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The laying of the TBS non slip covering requires 4 stages, whatever the nature and the state of the support:

- Drawing the templates and cutting the TBS
- Preparation of the support
- Installation of the covering
- Application of an edge sealant

## **1) Equipment needed for the laying of the TBS non slip covering to glue:**

### **Tools :**

- A cutter or a pair of scissors
- White single-use latex gloves (sizes 7½, 8½, 9½)
- A felt-tip pen or a pencil
- Wide-width roller to smooth out the surface (Internal TBS reference - 59DIVERS6Z)
- Small-width roller to smooth out the surface (Internal TBS reference - 59DIVERS3Z)
- Pliers to pull the covering off the surface (Internal TBS reference - 59 DIVERS4Z)
- Pocket scraper (Internal TBS reference - 59DIVERS9Z)
- Scraper (Internal TBS reference - 59DIVERSAZ)
- Clean cotton cloths which do not fluff
- Corrugated scraper (Internal TBS reference - 59DIVERS1Z)
- A rubber
- A 19 mm radius ball
- A sandpapering block
- Manual or electrical cartridge gun

### **Products :**

- To lay the TBS non slip covering (10, 11R, 10 fire resisting, 10 transparent, 10 two-colour, 16, 20S, 21 or 65)
- Acetone
- Isopropyl alcohol
- Single-component polyurethane adhesive, type Sikaflex 291 (Internal TBS reference - 59COLLE\*1Z)
- White spirit

### **For the edge sealing :**

- MS Polymer elastomeric seal, type Terostat MS 935 (Internal TBS reference - 59COLLE\*2Z)
- Self-adhesive crepe paper band and self-adhesive splicing tape (used by electricians)

### **To draw the templates :**

- Thick and transparent stable polythene sheet
- Double-sided adhesive tape (not too strong)
- A coin or other round-shaped object ( $\emptyset$  between 22 and 45 mm)

## 2) Advice on how to peel off the TBS non slip covering :

Take the TBS non slip covering off with pliers (Internal TBS reference - 59DIVERS4Z)  
Then, remove the rest of the adhesive with acetone or ethanol and a scraper (Internal TBS reference - 59DIVERS4Z) to eliminate the last residues.

## 3) Drawing the templates and cutting :

### a) Templates

Using a thick and transparent polythene sheet, it is extremely easy to stencil out the templates. Use a double-sided adhesive tape to stick down your templates while drawing.

Aesthetic advice:

- Use the same radius for the angles and curves (a coin for example).
- Never butt edges together as these joints are always visible. Leave at least a 20mm gap between two pieces to have a better result.
- Do not draw sharp edges as it makes the corners more fragile.
- Make the pieces as long and thin as possible to avoid a draughtboard look.



### b) Cutting

After having taken the measurements and cut your templates, stencil around them on the back of the TBS non slip covering (smooth side) with a felt-tip pen. Carefully cut the panels with a sharp knife or scissors.

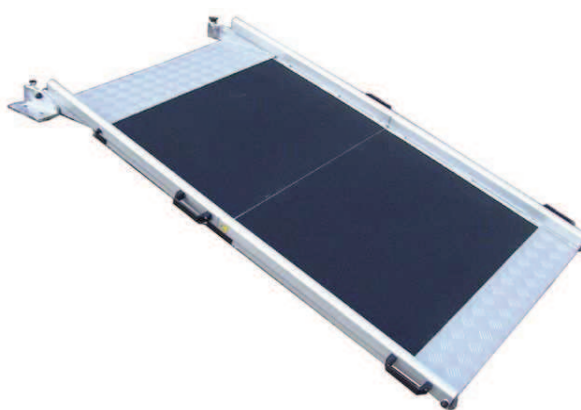
Soften the cut with a sandpapering block.

#### 4) Préparation du support :

Aluminium, stainless steel, galvanized, electrogalvanized:

**⚠ It is very important that the preparation of each support is done correctly, and we strongly advise you to follow the technical instructions of each individual support and paint supplier.**

- Take off mechanically or chemically (phosphoric acid).
- Rinse with fresh water.
- Remove the grease with either isopropyl alcohol or acetone.
- Application d'un primaire d'accrochage époxydique.
- **⚠ Be careful with the waiting time of the covering → Vitrification.**
- Before laying them, apply a two-component polyurethane lacquer between the TBS panels (nautical field).
- Let the solvents degas. Follow the instructions of the paint supplier.




Steel:

**⚠ It is very important that the preparation of each support is done correctly, and we strongly advise you to follow the technical instructions of each individual product supplier.**

- Phosphatising or sanding.
- Rinse with fresh water
- Remove the grease with either isopropyl alcohol or acetone.
- Apply an epoxy primer.
- Apply a two-component polyurethane lacquer.
- Let the solvents degas (nautical field). Follow the instructions of the paint supplier.

#### **Polyester :**

 **It is very important that the preparation of each support is done correctly. We strongly advise you to ask for technical instructions from each individual product supplier and follow them carefully.**

The support is made of polyester gelcoat, with or without a non slip covering already drawn in the mould (diamond tip, marbling, etc...).

- Sand the areas that will be covered by the TBS covering until you obtain a flat, even and unsmooth surface.
- In case of cracks, delamination or deep stars in the gelcoat, make the necessary repairs (lamination, gap-filling, etc...).

If the gelcoat leaves white flour-like marks when you touch it,

We advise you to:

- a) Sand.*
- b) Dust*
- c) Remove the grease*
- d) Apply an epoxy primer.*
- e) Apply a first coat.*
- f) Apply 2 or 3 layers of lacquer.*

### Concrete with a smooth surface:

**⚠ It is very important that the preparation of each support is done correctly. We strongly advise you to follow the laying precautions of the CSTB (Centre Scientifique et Technique du Bâtiment) concerning wall-to-wall carpet.**

- New concrete :  
Let it age 6 months before applying TBS covering and then refer to the laying of old concrete.
- Old concrete :  
Apply a self-smoothing making good or epoxy paint with a smooth finishing.



**For every other support, we recommend you to make some tests beforehand or to consult us.**

### 5) Laying of the TBS non slip covering:

**Be careful:** before starting to glue the covering and during the process (also while painting), make sure that:

- The ambient temperature is between 10°C and 30°C.
- The temperature of the support is the same as the ambient temperature.
- The relative humidity ratio is below 65%.
- There is no trace of humidity on the support (condensation) or pollution (dust, paint vapours or release agent ...).



a) The paper protecting the TBS non slip covering has to be clean. Lay down the TBS covering flat on the support and leave it there until it reaches ambient temperature.



b) Dust with a dry cloth and remove the grease with acetone. Do not use White Spirit because it would leave a greasy film. Leave the solvent to evaporate (30 minutes).



c) Roll up the TBS non slip covering you want to apply, keeping the protection paper on the outside (make sure there is no dust). Lift the edge of the TBS non slip covering, take off and fold about 3cm of the protection paper, slowly apply the edge while making sure no air is trapped. Your TBS non slip covering is correctly positioned.

d) Unroll and remove the protection paper, apply the TBS non slip covering with a roller to make sure all air is chased away. It is very important that no air is trapped between the TBS non slip covering and the support to avoid bubbles appearing later. Take your time for this step.

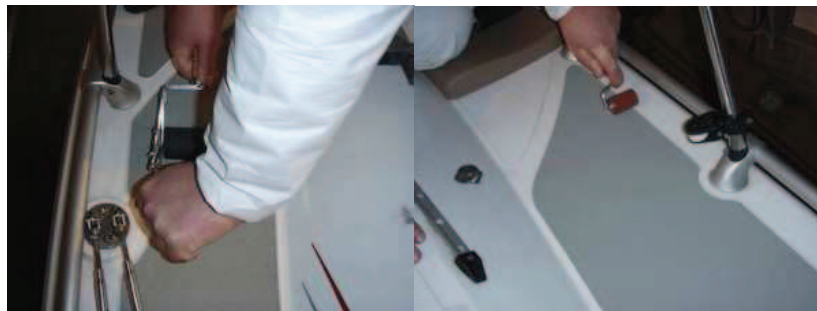




e) Once the TBS non slip covering is laid, make a firm and steady pressure one way and the other with a two-handle roll, insisting on the edges. The adhesive is pressure-sensitive and its mechanical gluing value depends on the pressure made in the beginning.



f) The laying of the TBS non slip covering is finished. The maximum characteristics of adhesive hold will be obtained after 72 hours. However, you can walk on the support immediately.



**⚠️ If there are air bubbles, remove them with the hypodermic needle of a syringe (do not use a cutter). Do not peel off large parts of the covering from the support to remove a bubble, or the adhesive film could be ruined and the TBS panel would become unusable.**

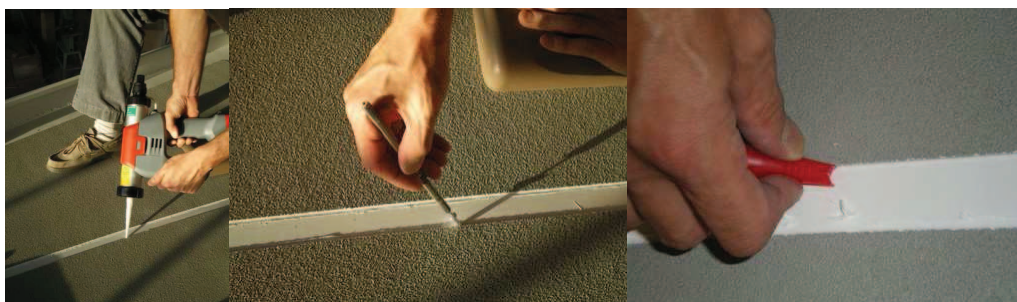


**⚠️ The TBS non slip covering 16 is very flexible, so you should make sure you do not generate stress zones which would create air bubbles when it comes back to its initial shape, or a temporary extension of the product. Also avoid direct sunlight and warmth during the laying, which would contribute to the extension of the product as well. For all the TBS non slip coverings (10, 11R, 10 fire resisting, 10 transparent, 10 two-colour, 16, 20S or 21), it is very important not to break the film on the surface because of bad handling, which could result in a premature ageing (photo below).**



## 6) Application of a seal :

The final step consists in applying an MS Polymer elastomeric seal, type Terostat MS 935, ultraviolet resistant (Internal TBS reference – 59COLLE\*2Z). This step is necessary to protect the edges of the TBS non slip covering and extend its lifetime. It prevents the edges from coming off after a while and makes the overall effect look better.



a) The seal should be applied as soon as possible after laying the TBS non slip covering to avoid having dirt and dust on the edges of the covering.

b) Place a crepe paper band 4 mm all around the TBS non slip covering, use a scouring pad to clean a little and remove the grease with acetone.

c) Leave it 30 minutes so that the acetone evaporates completely.

d) Apply a roll of seal matching the thickness of the TBS non slip covering. Smooth it out using a 19mm radius marble (or any other objet with similar shape).

e) Take the crepe paper band off immediately.

f) To take off the excess of seal on the TBS non slip covering, let it dry and take the surplus off in the next 10 hours after the application with a rubber or other.

#### **7) Storage of the rolls of TBS non slip covering to glue:**

The TBS non slip covering must be kept in its original wrapping and away from dust until it is used.

## Very important

The technical characteristics of a covering largely depend on the surface of the support being correctly prepared. In case of doubt, we recommend making some tests beforehand.

**NB :** The recommendations are given as an indication. They do not imply any form of guarantee on our side nor engage our responsibility in the use of our products.

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The laying of the TBS non slip covering requires 4 stages, whatever the nature and the state of the support:

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- Preparation of the support
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- Application of an edge sealant

## **1) Equipment needed for the laying of the TBS non slip covering to glue:**

### **Tools:**

- A cutter or a pair of scissors
- White single-use latex gloves (sizes 7½, 8½, 9½)
- A felt-tip pen or a pencil
- Wide-width roller to smooth out the surface (Internal TBS reference - 59DIVERS6Z)
- Small-width roller to smooth out the surface (Internal TBS reference - 59DIVERS3Z)
- Pliers to pull the covering off the surface (Internal TBS reference - 59 DIVERS4Z)
- Pocket scraper (Internal TBS reference - 59DIVERS9Z)
- Scraper (Internal TBS reference - 59DIVERSAZ)
- Clean cotton cloths which do not fluff
- Corrugated scraper (Internal TBS reference - 59DIVERS1Z)
- A rubber
- A 19 mm radiusing ball
- A sandpapering block
- Manual or electrical cartridge gun

### **Produits :**

- To lay the TBS non slip covering\_(16, 20S or 21)
- Acetone
- Single-component polyurethane adhesive, type Sikaflex 291(Internal TBS reference - 59COLLE\*1Z)
- White spirit

### **For the edge sealing:**

- MS Polymer elastomeric seal, type Terostat MS 935(Internal TBS reference - 59COLLE\*2Z)
- Self-adhesive crepe paper band and self-adhesive splicing tape (used by electricians)

### **To draw the templates:**

- Thick and transparent stable polythene sheet
- Double-sided adhesive tape (not too strong)
- A coin or other round-shaped object ( $\emptyset$  between 22 and 45 mm)

## **2) Advice on how to peel off the TBS non slip covering:**

It depends on how the original TBS non slip covering was glued:

- **With epoxy glue:** take the TBS non slip covering off with pliers (Internal TBS reference - 59DIVERS4Z) and sand off the rest of the glue.
- **With two-component polyurethane adhesive:** take the TBS off with pliers (internal TBS reference - 59DIVERS4Z) and sand off the rest of the adhesive.
- **With single-component polyurethane adhesive:** take the TBS off with pliers (Internal TBS reference - 59DIVERS4Z), and leave the adhesive in the open for 24 hours. Then, take it off with a scraper.

### 3) Drawing the templates and cutting:

#### a) Templates

Using a thick and transparent polythene sheet, it is extremely easy to stencil out the templates. Use a double-sided adhesive tape to stick down your templates while drawing.

#### Aesthetic advice:

- Always use the same radius for the angles and curves (a coin for example)
- Never butt edges together as these joints are always visible. Leave at least a 20mm gap between two pieces to have a better result.
- Do not draw sharp edges as it makes the corners more fragile.
- Make the pieces as long and thin as possible to avoid a draughtboard look.



#### b) Cutting

After having taken the measurements and cut your templates, stencil around them on the back of the TBS non slip covering (smooth side) with a felt-tip pen. Carefully cut the panels with a sharp knife or scissors.

Soften the cut with a sandpapering block.

### 4) Preparation of the support:

Aluminium, stainless steel, galvanized, electrogalvanized:

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- Take off mechanically or chemically (phosphoric acid).
- Rinse with fresh water.
- Remove the grease with either isopropyl alcohol or acetone.
- Apply an epoxy primer.
- Be careful with the waiting time of the covering → Vitrification
- Before laying them, apply a two-component polyurethane lacquer between the TBS panels (nautical field).

- Let the solvents degas. Follow the instructions of the paint supplier.



#### Steel:

**⚠ It is very important that the preparation of each support is done correctly, and we strongly advise you to follow the technical instructions of each individual product supplier.**

- Phosphatising or sanding.
- Rinse with fresh water
- Remove the grease with either isopropyl alcohol or acetone.
- Apply an epoxy primer.
- Apply a two-component polyurethane lacquer.
- Let the solvents degas (nautical field). Follow the instructions of the paint supplier.

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- Sand the areas that will be covered by the TBS covering until you obtain a flat, even and unsmooth surface.
- In case of cracks, delamination or deep stars in the gelcoat, make the necessary repairs (lamination, gap-filling, etc....).
- If the gelcoat leaves white flour-like marks when you touch it, We advise you to:
  - a) Sand
  - b) Dust
  - c) Remove the grease
  - d) Apply an epoxy primer.
  - e) Apply a first coat.



f) Apply 2 or 3 layers of lacquer.

**Concrete with a smooth surface:**

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- New concrete :

Let it age 6 months before applying TBS covering and then refer to the laying of old concrete.

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Apply a self-smoothing making good or epoxy paint with a smooth finishing.



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### 5) Laying of the TBS non slip covering:

**Be careful:** before starting to glue the covering and during the process (also while painting), make sure that:

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- The temperature of the support is the same as the ambient temperature.
- The relative humidity ratio is below 65%.
- There is no trace of humidity on the support (condensation) or pollution (dust, paint vapours or release agent ...).



The paper protecting the TBS non slip covering has to be clean. Lay the TBS covering flat on the support and leave it there until it reaches ambient temperature.



a) Dust with a dry cloth and remove the grease with acetone. Do not use White Spirit because it would leave a greasy film. Leave the solvent to evaporate (30 minutes).



b) Using a corrugated scraper n° 0, put less than 170g/m<sup>2</sup> of single-component polyurethane adhesive, type Sikaflex 291, on the support. If you put too much adhesive, there may be waves and bubbles when you try to evacuate the air trapped under the covering.

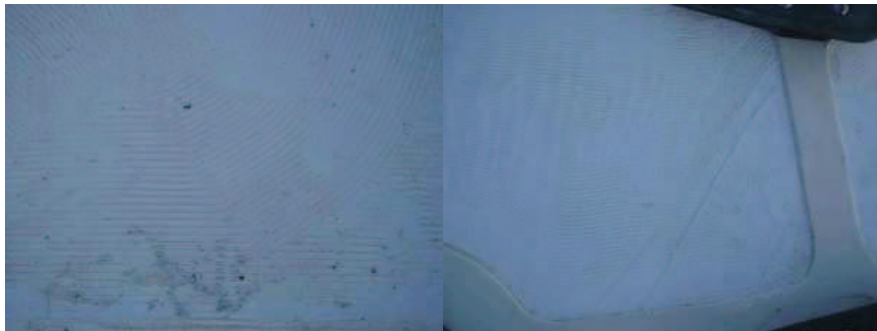


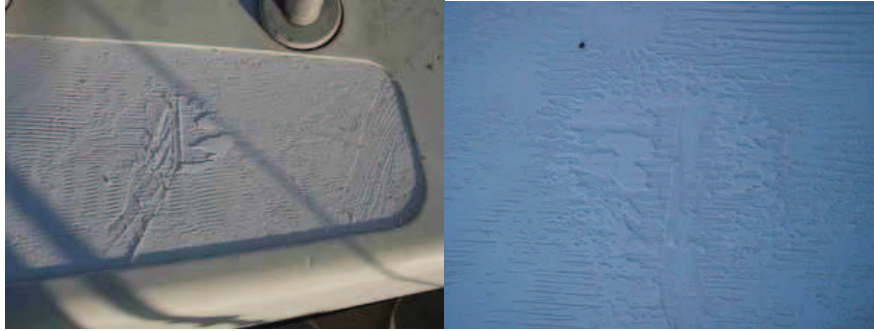


Tip: scrape the excess single-component polyurethane adhesive (figure 1) both ways (figure 2). Also scrape towards yourself (figure 3) with the scraper, giving it an open angle of 130°, depending on the support.



**What not to do:**





c) Position one edge correctly, and unroll the TBS covering following the furrows made by the scraper, while removing the air as you are laying it.



d) With single-component polyurethane adhesive, type Sikaflex 291, you can reposition your sheet during 2 minutes.

**⚠ Make sure you respect the maximum covering time, which depends on the temperature and humidity.**



e) To make sure no air is left under the covering, you have to roll very hard on the covering and the edge, following the furrows made by the scraper, so that the air can evacuate correctly without creating air bubbles or surpluses of adhesive.



**⚠️ If there are air bubbles, remove them with the hypodermic needle of a syringe before the adhesive hardens (less than an hour). Do not use a cutter.**



f) With a soft white cloth and White Spirit, clean the surplus of adhesive on the edges. This will create an almost invisible little seal which will protect the edges of the covering. To remove the stains of adhesive on the covering, use White Spirit and a soft white cloth right away.

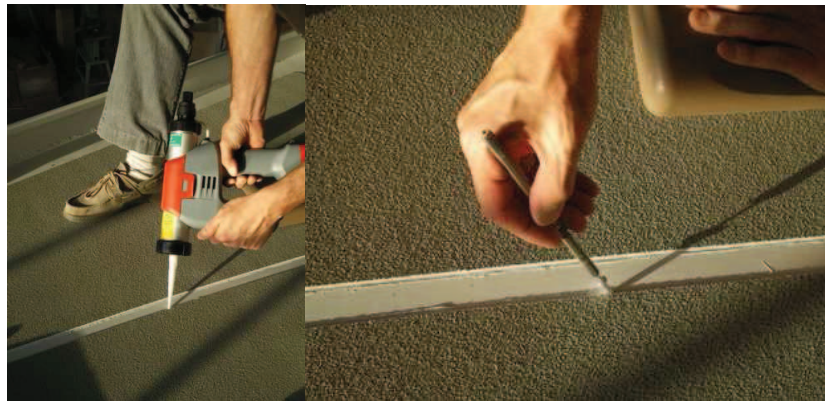
**Do not walk on the TBS non slip covering during 48 hours.**

**⚠️ Be careful:** The TBS non slip covering 16 is very flexible, so you should make sure you do not generate stress zones which would create waves and an extension of the covering, the TBS non slip covering would come out of its borders. For all the non slip coverings (TBS 16, 20S et 21), it is very important not to break the film on the surface by bad handling, which could result in a premature ageing (photo below).



## 6) Application of a seal:

The final step consists in applying an MS Polymer elastomeric seal, type Terostat MS 935, ultraviolet resistant (Internal TBS reference – 59COLLE\*2Z). This step is necessary to protect the edges of the TBS non slip covering and extend its lifetime. It prevents the edges from coming off after a while and makes the overall effect look better.



- The seal should be applied as soon as possible after laying the TBS non slip covering to avoid having dirt and dust on the edges of the covering.
- Place a crepe paper band 4 mm all around the TBS non slip covering, use a scouring pad to clean a little and remove the grease with acetone.
- Leave it 30 minutes so that the acetone evaporates completely.
- Apply a roll of seal matching the thickness of the TBS non slip covering. Smooth it out using a 19mm radius marble (or any other objet with similar shape)
- Take the crepe paper band off immediately.
- To take off the excess of seal on the TBS non slip covering, let it dry and take the surplus off in the next 10 hours after the application with a rubber or other.

## 7) Storage of the rolls of TBS non slip covering to glue:

The TBS non slip covering must be kept in its original wrapping and away from dust until it is used.

## Very important

The technical characteristics of a covering largely depend on the surface of the support being correctly prepared. In case of doubt, we recommend making some tests beforehand.

**NB:** The recommendations are given as an indication. They do not imply any form of guarantee on our side nor engage our responsibility in the use of our products.

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