

# Installation Instruction

for solidcore skirting EP 60/13 flex life

## 1. General Instructions

The abovementioned solidcore skirtings can be installed using this installation instruction in conjunction with the specifications of DIN 18365 "Flooring", including the corresponding comments and explanations, and the most recent technical bulletin brought out by the Federal Association of Screed and Floor Covering (Bundesverband Estrich und Belag e.V, BEB) titled "Assessment and preparation of substrate – installing elastic and textile flooring, laminates, parquet and wood-block paving – heating and unheated floor construction" as well as the updated version of bulletin no. 8 of the Technical Commission for Construction Adhesives (Technische Kommission Bauklebstoffe, TKB) titled "Assessment and preparation of substrates for flooring and parquetry". Furthermore, established standards of the industry and technology must be fulfilled. When choosing and installing the skirting boards, factors such as the substrate type, the intended use as well as the respective cleaning and maintenance requirements and, in particular, the conditions onsite must be taken into consideration.

## 2. Tools / Installation

**Only a retrofitted (accompanied by a corresponding reversion kit) Döllken mitre tool device for skirtings or the new universal mitre tool type 1001 may be used for punching these solidcore skirtings. The clamp must be inserted into the rear pocket of the mitre tool (11 mm) before clamping to prevent damaging the mitre tool!**

When installing the solidcore skirtings, it is best to begin with one doorframe and stop at the next corner. About 1.2 m before the cut point, a line is drawn on the wall and extended congruently to the top on the upper edge of the solidcore skirting. The actual distance up to the corner must be measured and added/marked on the skirting. This measurement yields the exact cut point for the inside corners. For the outside corners, the thickness of the skirting (ca. 11 mm) must be added to the yielded measurement.

**Before the solidcore skirtings are cut, it is important to ensure that they were installed stress-free. Therefore a so-called "plus tolerance" must necessarily be avoided when measuring the solidcore skirtings.**

The locating surface behind the clamping device is 80 mm wide for the mitre tools. The cut point is located at the centre of the mitre tool. Now add 40 mm to the cut point marked on the skirting and again mark the top edge of the skirting. Place the skirting into the punch. The most recent marking must be aligned with the right vertical edge on the locating surface. As a result, the base plate does not need to be marked. Close the clamping device and punch. These instructions are applicable when installing from left to right, but this can be done from both sides. The condition of the punch significantly affects the quality of the profile corners. Please do not sharpen a blunt or a damaged or broken knife of your mitre tool yourself. Send the complete device to Döllken-Weimar through your retailer. That way the sharpened knife will also be calibrated. The Döllken solidcore skirtings can also be punched and assembled in the conventional manner, either blunt (with preforms) or for mitring. The flexible, yellow measuring gauge ensures that the right spot is punched. That means: you only need to mount the measuring gauge with a "green" side "S 40" on/in the corner, hold it steadily at the solidcore skirting and transfer the mark on the inside and outside corner to the top edge of the solidcore skirting. Then inlay the skirting board with the mark on the left corner of the locating surface horizontally into the punch, close the clamping device and punch. These instructions apply when installing from left to right, but is possible from both sides. In order to avoid potential complaints at a later stage, it is recommended that the markings on the top edge of the



solidcore skirtings be removed after the installation is completed. The profile ends of EP 60/13 flex life can be formed from the profile without additional parts using the Döllken mitre tool device for solidcore skirtings.

Please proceed as follows:

Allow the profile to protrude 11 mm at the end. Measure 51 mm from the trailing edge and mark the profile. Then place the profile with the marking congruently at the edge of the locating surface. Close the clamping device and evenly punch an outside edge. Then fold down the heel and glue the core areas together.

## 3. Modes of installation:

### Gluing

Our recommendation for Döllken solidcore skirting is the hot-melt adhesive systems (hot glue applicator HKP 220, hot-melt glue KSK 18/300), for which this installation instruction applies. In order to safeguard the tightly fitted profile section joints even under less than ideal conditions (e.g. wall unevenness), the profile ends must additionally be fastened using steel pins. The skirtings can also be fastened with a suitable mounting adhesive. Currently, following mounting adhesives are recommended by the manufacturers (Version 10/11):

- Uzin Fondur MK, Uzin MK 97 cartridge, Uzin GN 222.
- Henkel Sista M700 Flextec,
- MAPEI ULTRABOND ECO 575

The areas to be glued must be dry, clean and free of grease. Loose wall surfaces, such as wallpaper, colour coatings, etc. are not appropriate for gluing the skirtings

Skirtings may also not be glued on to wall coatings.

It is imperative to adhere to updated versions of recommendations for gluing and the manufacturer's installation instructions.

### Nails

The skirtings can be installed in the conventional manner with galvanised steel nails that are staggered in reverse order. Here, the cho-

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sen length of the steel nails must correspond to the substrate to secure a steady and enduring link. The distance between the nails or the mounted parts must measure 40 cm. The distance between the nails and the edges and the projections should not exceed 5 cm. Additional nails are required if the wall surface is uneven within the permitted tolerances. If using nails / pins for mounting, we recommend combining that with adhesives in order to ensure a firm and lasting connection, especially considering fluctuations in the atmospheric conditions.

#### 4. Inspection of the substrates before mounting the skirtings

Before mounting the skirtings, the suitability of the wall must be checked for the chosen mode of mounting. Substrate checks as those specified for flooring installation pursuant to DIN 18365 "Flooring" also apply. The substrate must be inspected to ensure the following:

- evenness and angularity of the substrate,
- no substrate level humidity,
- adequately solid, non-porous or rough substrate surfaces,
- no contamination on the surface area of the substrate, e.g. with oil, wax, varnish, residual paint, etc.,
- appropriate temperature of the substrate,
- appropriate room temperature,
- no cracks in the substrate.

The tolerances applicable to flooring per DIN 18202 "Tolerances in superstructure", Table 3, Line 3 also apply to evenness.

Room temperatures should not fall below 18°C and nor exceed 23°C at a relative air-humidity of 40% to a maximum of 65%. These requirements apply when storing, acclimatising or installing the skirting boards. The surface temperature of the substrate should not fall below 15°C.

The following experienced data apply for the residual moisture of different substrates when mounting the solidcore skirting boards:

- Stucco < 0.5 weight-%
- Cement mortar < 2.5 weight-%
- Lime mortar < 2.0 weight-%
- Concrete < 3.0 weight-%

Loose/unstable substrates that are porous or have a rough surface must be primed using appropriate base coats and, if necessary, scraped (follow the manufacturer's instruction) before installing the solidcore skirtings.

#### 5. Conclusive remarks

All Döllken solidcore skirtings are subject to serious quality control. The skirtings must be inspected immediately upon delivery. Once the punching/installation takes place, the problems that were discernible before the punching/installation, will no longer be accepted. If problems persist, please provide your wholesaler / Döllken employee with a piece of the skirting measuring 1 m, bearing a signature on the reverse side of the defective product and the head label of the packaging. Please also follow these additional instructions:

- White elongation at the outside edge can almost fully be removed by rubbing with an edge (knife handle or hammer peen).
- When inserting the profile into the punch for the skirting board, please ensure that the wall panel at the locating surface of the punch does not drop down.
- Acclimatisation: before being processed, the profiles must have lain flat for 48 hours on a plane surface at temperatures spanning between a minimum of 18°C and a maximum of 23°C, at air humidity levels suitable for acclimatisation ranging between a minimum of 40% and a maximum of 65%. Without adequate acclimatisation, the profile can detach from the wall owing to distention.
- When forming the outer edge, fasten the skirting using the soft

lip only so far from the floor that it still touches the coating at the recesses.

- Cleaning and maintenance: Special cleaning and maintenance instructions apply (request online or directly). Profiles must be free of foreign matter, such as sealings, priming coats on the wall, solvents, solvents containing cleaning agents, etc., else they could be damaged. Cleaning agents and disinfectants that, for instance, contain alcohol and alcohol-like components must be advance tested on a sample. We recommend making these cleaning and maintenance instructions available to the end users without undue delay. If the room temperature or the wall quality is not appropriate, such concerns must be brought to the attention of the client or the builder and notification obligations, if any, must be fulfilled.

**Previous versions are no longer valid once this version is published.  
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