

Heterogeneous Heat Welding Guide



The seam should be cut with a maximum 1/64" gap. Approximately the thickness of a business card.



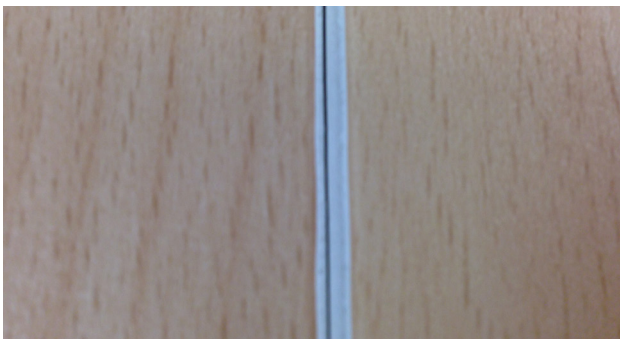
The depth of the groove should be two-thirds the thickness of the wear layer. Do not groove through the backing.



This seam has been grooved too deep. This will result in seam failure over time.



This seam has not been grooved deep enough. This will result in seam failure.



An off center groove will result in the weld rod pulling away from one sheet. This will result in a gap, or void, along one side of the seam that allows moisture and contamination to collect inside the seam and under the flooring.



Example of a heat welded seam that has been burned. The heat welding gun may have been too hot for the pace the operator was moving.

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If the rod does not melt it could be a symptom of a heat welding gun that is too cool or the operator is moving too quickly. The operator will need to decrease speed or increase the temperature setting of the heat welding gun.



The heat welding gun temperature and operator speed are correct when the "wash" from the melted floorcovering and weld rod is visible along both sides of the seam.



Utilize a trim plate when making the first trim of the weld rod. This can be done while the weld rod is still warm or after it has cooled to room temperature.



Once the weld has cooled for a minimum of 20 minutes perform a final trim. Final trimming the weld rod before it has been allowed to cool will result in a concave seam which will collect dirt after the floor is in use.