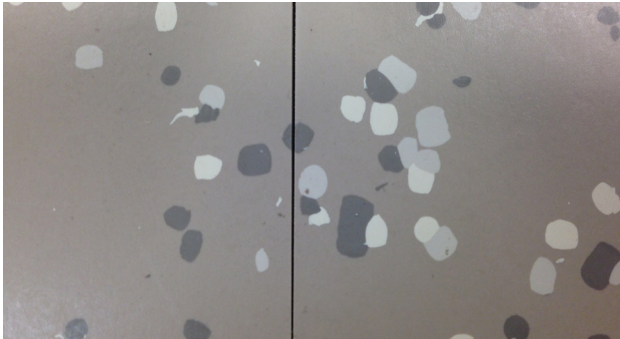


Arcade™ Rubber Sheet Heat Welding Guide



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



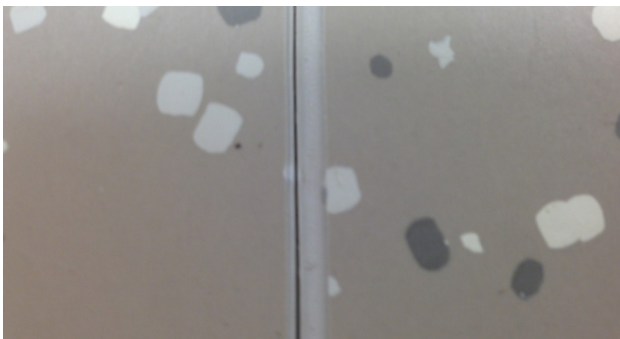
Groove depth should be 2/3 the thickness of the product.



Example of a seam that has not been grooved deep enough. This will result in failure over time.



This seam has been grooved too deep and 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.



Excessive melting and weld rod breaking are two symptoms of a heat welding gun that is too hot for the pace the operator is moving. The operator will need to increase speed or lower the temperature setting of the heat welding gun.

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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.



This weld rod has been properly melted. The operator should practice on a piece of scrap material to learn his comfort level when heat welding rubber sheet. The best results are achieved when the welding gun temperature setting is 1100°F (580°C).



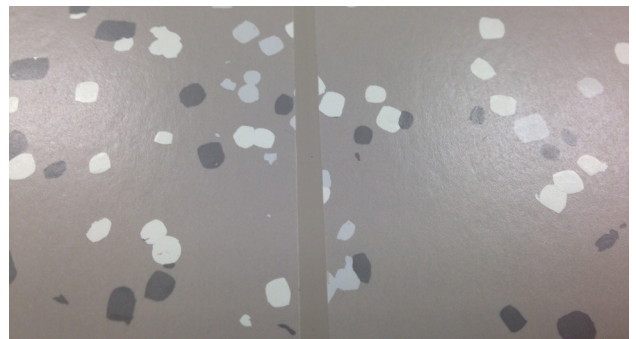
When making the first trim of the weld rod utilize a Mozart knife equipped with a trim plate. Add a soap and water solution to the surface of the rubber to prevent scratching or scuffing.



Scuffing/Scratching along the seam edge when trimming the weld rod are symptoms of trimming the weld rod too soon or that a soap/water solution is not being used.



Utilize a Mozart knife to make the final trim of the weld rod after it has cooled for a minimum of 20 minutes. Apply a soap and water solution to prevent scuffing and scratching. If a final trim is performed before the weld rod has cooled for the recommended time the seam may become concave. A concave seam will collect dirt once the flooring is in use.



Example of a successfully heat welded seam using Arcade Rubber Sheet