

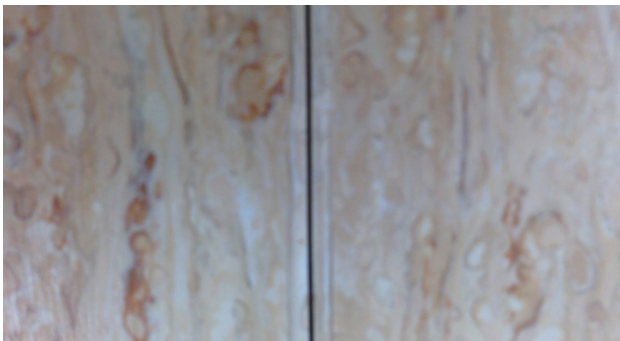
Homogeneous Heat Welding Guide



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.



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.

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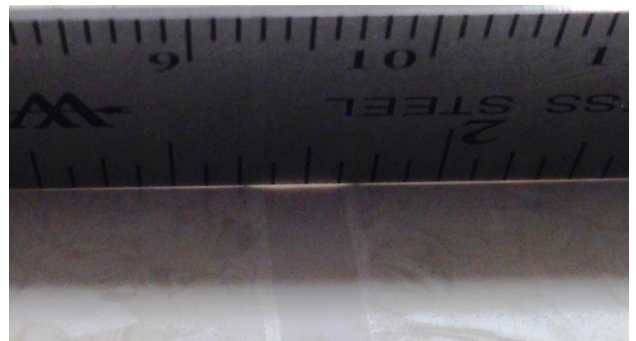
Burning, excessive “wash” and weld rod breakage are symptoms of a heat welding gun that is too hot for the pace the operator is moving. The operator will need to increase speed or lower the temperature of the heat welding gun.



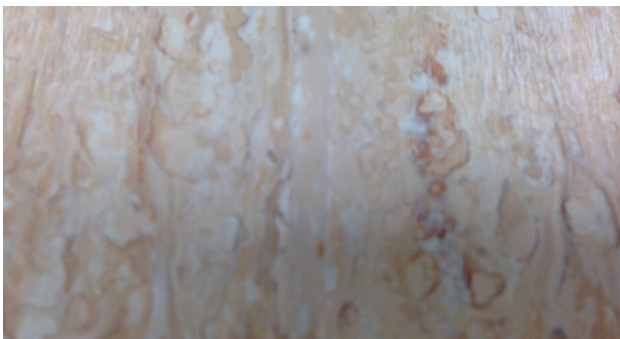
Weld gun temperature and operator speed are correct when the “wash” from the melted floorcovering and weld rod is visible along both sides of the seam.



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



If the installer performs the final trim before the weld rod has been allowed to cool, the weld rod will become concave and the surface of the floorcovering can appear scratched. A concave seam will collect dirt when the floor is in use. Always allow the welded seam to cool for a minimum of 20 minutes prior to final trim.



The finished seam using iQ™ Optima® and Multi Colored weld rod.