

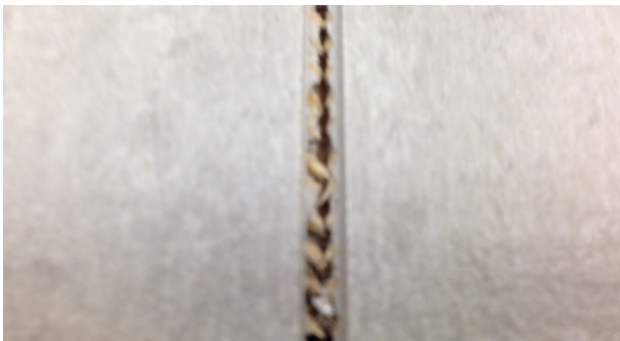
Linoleum Heat Welding Guide



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



Example of properly grooved linoleum seam. Always groove deep enough to expose the jute backing.



This seam has been grooved too deep. The jute backing has been cut through. This will result in seam failure.



This seam has not been grooved deep enough. The jute backing has not been exposed. The weld rod will likely pull out when trimming or after installation resulting in 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 floorcovering.



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 heat setting.

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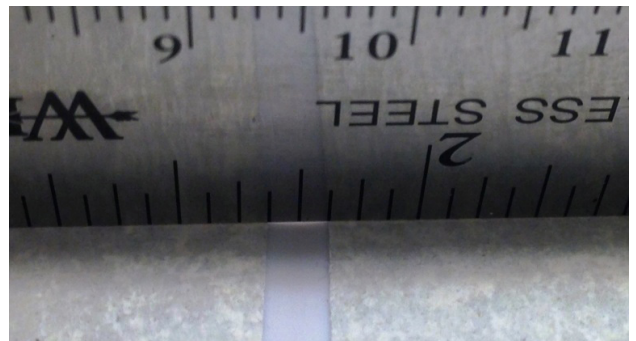
If the weld rod does not melt it could be a symptom of a heat welding gun that is too cool or the operator is moving quickly. The operator will need to decrease speed or raise the temperature setting of the heat welding gun.



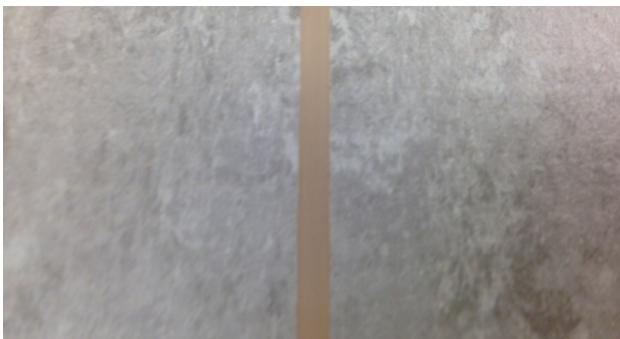
This weld rod has been properly melted.



Utilize a trim plate when trimming the weld rod for the first pass. This **MUST** be done when the weld rod is still warm.



Final trimming the weld rod before it cools to room temperature will create a concave seam.



Once the weld rod has cooled for a minimum of 20 minutes perform a final trim. Final trimming the weld rod before it has cooled for the recommended time may result in a concave seam which will collect dirt once the floor is in use.