

# [501] TILES AND ROLLS WELDING (HEAT AND COLD WELDING)

Minimum 12 hours after gluing

## 1. HEAT WELDING FOR ROLLS

Leave a small gap (thickness of a credit card) between the sheets during the gluing process

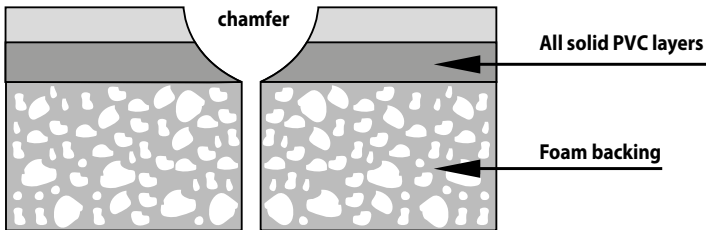
### HEAT WELDING PROCESS:

Heat welding is a three phases process after the flooring has been laid.

#### ■ 1 - A GROOVING OR ROUTING

FOR ISOPHONIC AND /OR FOAMBACKING PRODUCTS

Groove all the Solid PVC layers until the fibreglass



For contract and Sport flooring , leave a gap of a badge or credit card (0.8 to 1 mm) between the strips, to allow the chamfering tool to be guided.

FOR HOMOGENEOUS AND COMPACT PRODUCTS

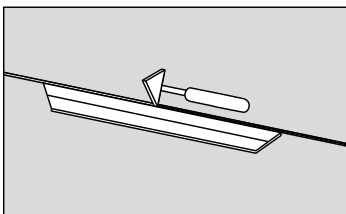
Grooving

Groove 2/3 of ALL the compact solid PVC layers

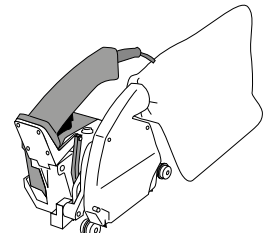
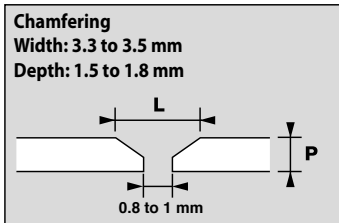
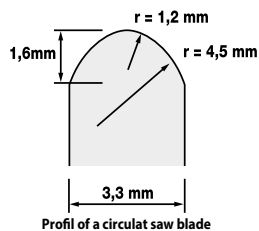


### GROOVING and ROUTING TOOLS

MANUAL GROOVE-CUTTING



Tools required: Triangular scraper and a steel rule

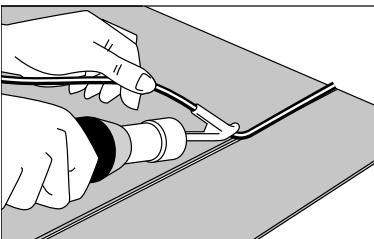


ELECTRIC GROOVER / ROUTING MACHINE  
Electric grooving machine equipped with a 3,3 mm width circular plate

#### ■ 2 - HEAT WELDING

**Note:** Always practice on a scrap piece of material first to assure proper temperature and speed. Doing so will prevent failures.

Manual weld with a SPEED NOZZLE



Weld with welding robot (required on large project)

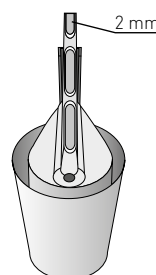
Use a Universal or Unifloor type Leister welder with electronically controlled hot air burner air with special multiple fine jets

Nozzle reference:

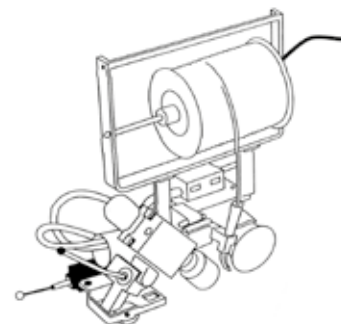
ROMUS : 95254

JANSER : 225 860 040

LEISTER : 105 407



Narrow Nozzle



For flooring with a photoreticulated surface treatment (ProtecSol®, PU), use the Rapid Ultra nozzle, diameter 5 mm, air inlet 0.9 mm, ref.: 224 800 007 from Janser or the narrow nozzle on the automatic welder.

# FLOORS IN BUILDINGS

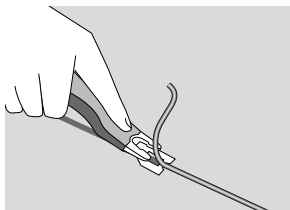
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### ■ 3 - TRIMMING WELD ROD

Trimming must be done in two passes. Using a trimming tool sharpened in the middle only, such as the Mozart, is recommended:

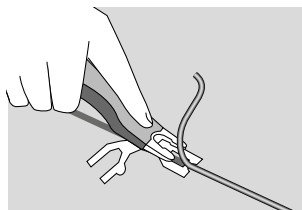
#### First stage:

Has to be done with the thickness guide.

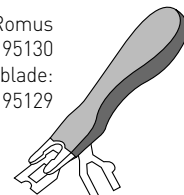


#### Second stage:

Second trim has to be done with the trimmer only. This method prevents concave welds and must be done when the rod is cold.



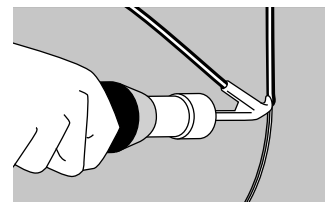
Available from Romus  
Réf. : 95130  
Spare blade:  
Réf. : 95129



### ■ 4 - COVING WELDING

We recommend the use of the elbowed Rapid Ultra nozzle:

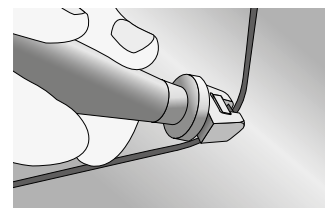
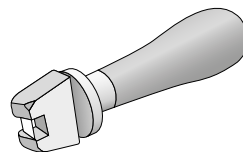
TOOLS	JANSER PART N°	ROMUS PART N°
Rapid Ultra nozzle	224 800 013	95028



### TRIMMER FOR FLASH COVING OR SITE FORMED

We recommend the use of a special trimmer for flash coving or site formed:

TOOLS	GERFLOR PART N°	ROMUS PART N°
Flash coving trimmer	0562 0001	95103



## 2. HEAT WELDING THE WALL COVERING

FIXING LENGTHS	Mural Ultra: Gap between lengths: 1 mm + 0.5 - 0 mm		
	TOOLS	USE	COMMENTS
<b>CHAMFERING</b>	Ensures that joints are uniform. Eliminates traces of adhesive that prevent the welding rod from fusing		
	Triangular scraper	Angle the triangular scraper so that each edge is chamfered separately and identically. Le chanfreinage peut nécessiter plusieurs passages. Chamfering may require several passes.	The recommended tools are available from GERFLOR, ROMUS, JANSER or WOLFF
<b>WELDING</b>	Hot Jet S or Leister Triac type fitted with a <b>Rapid Ultra</b> nozzle	<b>CR 40 rod: Air gun: Hot Jets: position 4 (80 l of air / mn) Leister Triac: 230 l of air / mn</b> Temperature: 450 to 500°, position between 4 and 5	
<b>TRIMMING</b>	Slim levelling spatula Mozart levelling spatula 1/4 moon cutter + cutting guide	A levelling spatula sharpened in the middle trim only the rod and avoids cutting the material	

FIXING LENGTHS	Taradouche Mural: Gap between lengths: 1 mm + 0.5 - 0 mm		
	TOOLS	USE	COMMENTS
<b>CHAMFERING</b>	Ensures that joints are uniform. Eliminates traces of adhesive that prevent the welding rod from fusing		
	Triangular scraper	The thickness of this material requires each seldge to be chamfered separately with a triangular scraper	
<b>WELDING</b>	Hot Jet S type fitted with a Rapid Ultra nozzle	<b>CR 41 rod.</b> Hot air: position 4 (80 l of air/mn). Temperature: 450 to 500°, position between 4 and 5.	
	Leister Triac fitted with a special nozzle	Hot air: 230 l / mn. Temperature: position between 4 and 5. The nozzle should be cleaned after every weld.	
<b>MAKING FLUSH</b>	Slim or Mozart levelling spatula 1/4 moon cutter + levelling guide	A levelling spatula sharpened in the middle trim only the rod and avoids cutting the material.	

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### 3. HEAT WELDING FOR TILES

Tiles must be tight.

Tiles must be hot welding as soon as they have a format more than 500 x 500 mm.

For welding tiles, proceed as follows:

- Chamfer, weld and trim all in the same way eg: crossway before starting again to groove, weld and trim on the other side.eg: lengthway. This method avoid weld missing at the cross tiles.

### 4. SG 916 - COLD WELD (MAY BE USED AFTER ONLY 2 TO 4 HOURS AFTER LAYING)

**ONLY FOR MULTILAYERED PRODUCT  
NOT FOR HOMOGENEOUS PRODUCT**

#### ■ 1 - TECHNICAL SPECIFICATION

- S G 916 is a heat free welding system suitable for foam backed floorcoverings
- S G 916 is colourless and can be used on all colours of the material.
- S G 916 is packed:

#### ■ 2 - CONDITIONING

- 1 x 500 ml cannister of cold welding liquid
- 1 x measuring cup
- 2 feed nozzle for floorcoverings
- 3 rolls of 50 ml adhesive paper
- A cartridge - 300 ml



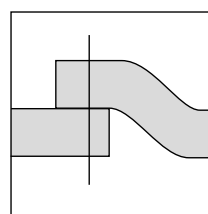
#### ■ 3 - INSTRUCTIONS FOR USE

- For thin floorcoverings (cold processing)
  - Apply 3 mm width of welding liquid to joint - no need for protective paper
  - Apply using backward motion drawing the hand smoothly over the entire length of the joint
- For thick floorcoverings (cold weld)
  - Lay the flooring such that the edges overlap by 3-4 cm, then cut through both thicknesses to ensure an accurate butt joint.
  - Allow the joint to relax for 2-4 hours, then follow the instructions given in the diagrams.

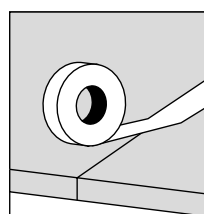
This technique ensures an excellent standard of finish without any apparent joint.

It is imperative to allow the flooring to fully cure for 24 hours prior to the floor being put into service.

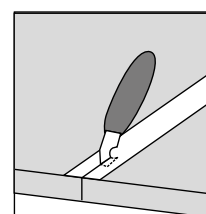
**WARNING:** Do not smoke or allow a naked flame near to the installation. SG 916 contains a flammable solvent.



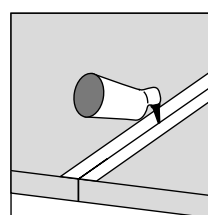
1 - Overlap cut



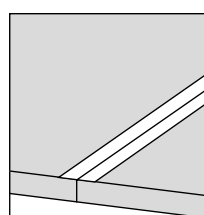
2 - Apply masking tape



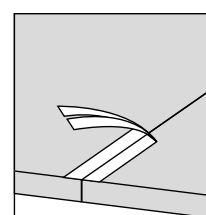
3 - Cut through the masking tape to excess



4 - Inject the solution deeply and tape



5 - Leave to dry 60 seconds



6 - Pull off the masking tape