

1. HEAT WELDING FOR ROLLS

The day after gluing

HEAT WELDING PROCESS:

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

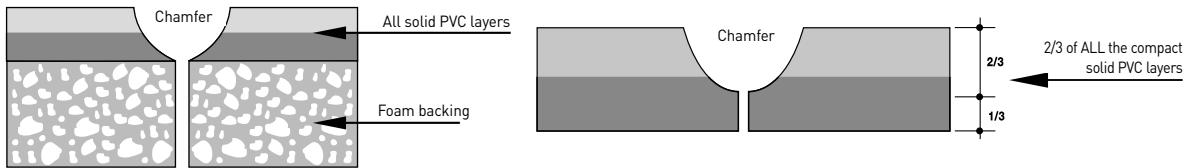
■ 1. A GROOVING OR ROUTING

FOR ISOPHONIC AND /OR FOAMBACKING PRODUCTS

Groove all the Solid PVC layers until the fibreglass

FOR HOMOGENEOUS AND COMPACT PRODUCTS

Groove 2/3 of ALL the compact solid PVC layers



For contract and Sport flooring, leave a gap of a badge or credit card (0.5 to 1 mm) between the strips, to allow the chamfering tool to be guided.

GROOVING and ROUTING TOOLS



Triangular Scraper, Ref. : 95185 by ROMUS



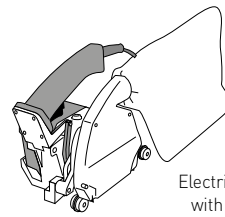
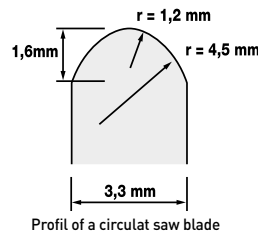
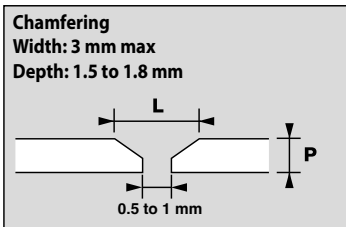
Linéa, Ref. : 95101 by ROMUS



Master Turbo, Ref. : 95200 by ROMUS



Swift groover Ref. : 262 611 400 by JANSER



ELECTRIC GROOVER / ROUTING MACHINE

Electric grooving machine equipped with a 3,3 mm width circular plate

■ 2. HEAT WELDING

Heat welding is done by fusing of welding rod.

Before welding, clean the chamfer from any dust.

Heat welding is a compromise between tools temperature, speed and pressure from the nozzle on the welding rod.

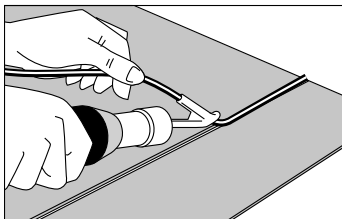
Always practice on a scrap piece of material first to assure proper temperature, speed and pressure. Doing so will prevent failures.

Usual temperature for reference is 450°C.

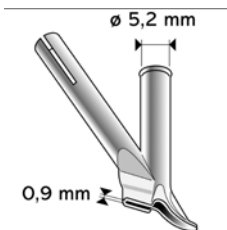
Suitable heat welding can be checked during its realisation by seeing material's bulge on both side of welding rod.

After welding, it's possible the check the suitable of welding rod bu rolling hand on it: welding rod must have opening line appearing with flooring.

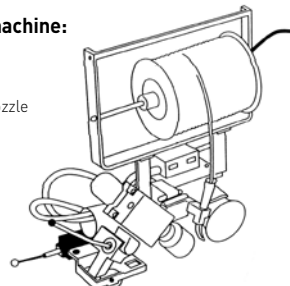
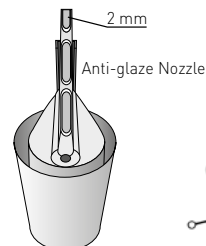
Manual welding:



Use of Leister «Triac-ST» electronic welding gun (Ref ROMUS: 95078) or Leister»Triac-AT» electronic welding gun (Ref ROMUS: 95075) adding anti-glaze rapid nozzle (Ref ROMUS: 95027).



Self-propelled welding machine:



Use machine as «Unifloor» Leister welding machine with anti-glaze nozzle (Ref ROMUS: 95250)

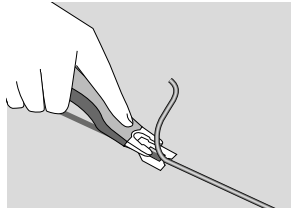
3. TRIMMING WELD ROD

Trimming must be done in two steps using Mozart «2 in 1» trimming knife.

First step:

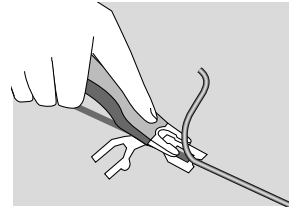
Has to be done with the thickness guide.

For linoleum, first trim must be done fastly after heat welding when rod is still hot.

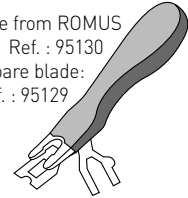


Second step:

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

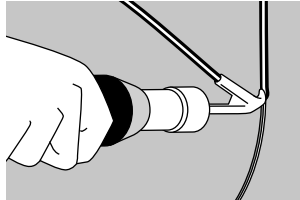


Available from ROMUS
Ref. : 95130
Spare blade:
Ref. : 95129

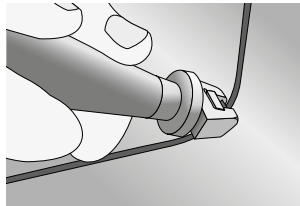
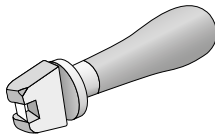


4. COVING WELDING

We recommend the use of the coving anti-glaze nozzle (ref ROMUS: 95028):



We recommend the use of a special trimmer as coving trimmer (ref ROMUS 95103):



2. HEAT WELDING THE WALL COVERING

FIXING LENGTHS	Mural Ultra: Gap between lengths: 1 mm + 0.5 - 0 mm	
	TOOLS	USE
CHAMFERING	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. Chamfering may require several passes.
WELDING (CR 40)	HOT JET S (REF JANSE: 224 815 000) or LEISTER TRIAC type fitted with a anti-glaze rapid nozzle or triangular rapid nozzle (ref ROMUS: 95030)	Temperature for reference: 450°C HOT JET S : air position 4 LEISTER TRIAC : air position between 4 and 5
TRIMMING	Mozart «2 in 1» trimming knife or 1/4 moon cutter + cutting guide	A levelling spatula sharpened in the middle trim only the rod and avoids cutting the material

FIXING LENGTHS	MURAL CALYPSO: Gap between lengths: 1 mm + 0.5 - 0 mm	
	TOOLS	USE
CHAMFERING	Ensures that joints are uniform. Eliminates traces of adhesive that prevent the welding rod from fusing	
	Triangular scraper	The thikness of this material requires each selvedge to be chamfered separately with a triangular scraper
WELDING (CR 40)	HOT JET S (ref JANSE: 224 815 000) or LEISTER TRIAC type fitted with anti-glaze rapid nozzle or triangular rapid nozzle (Ref ROMUS: 95030)	Temperature for reference: 450°C HOT JET S : air position 4 LEISTER TRIAC : air position between 4 and 5
MAKING FLUSH	Mozart «2 in 1» trimming knife or 1/4 moon cutter + levelling guide	A levelling spatula sharpened in the middle trim only the rod and avoids cutting the material.

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. WELD REPAIR PROCEDURE

GAP BETWEEN THE ROLLS (measurement on substrate)	SPACE GAP MAXI 2.5 MM CR 40	SPACE GAP BETWEEN 2.5 AND 3 MM CR 50	SPACE GAP BETWEEN 3 MM AND 4MM CR 60	GAP MORE THAN 4 MM
PVC COMPACT Maxi 2,4 mm	YES	YES Special order	NO Apply a piece of 15 cm width Product thickness can't accept a big diameter rode	Apply a new piece of 15 cm
PVC ON FOAM Maxi 3,6 mm	YES	YES Special order	YES Special order	

	CR 40 & CR 50	CR 60	
TYPE OF NOZZLE	ROMUS Ref. 95027 Anti-glaze rapid nozzle 	ROMUS Ref. 95250 Automatic welding machine UNIFLOOR  <p>For a CR 60 welding rode, please control the gap between the welding rode guide and the nozzle. May need to be adjusted.</p>	ROMUS Ref. 195 033 «Universal Precision» Quick Nozzle 4-8mm 
	TRIMMING TOOLS	ROMUS Ref. 95130 	ROMUS Ref. 95140 and 95155 

NB: tools used for welding rod CR 60 can be used for welding rod CR 40 and CR50.

REPAIR PROCEDURE WITH A WELDING RODE CR40 / CR50 / CR 60 (see table)

1st case: Repair on the entire welding length

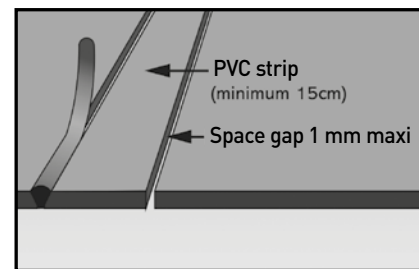
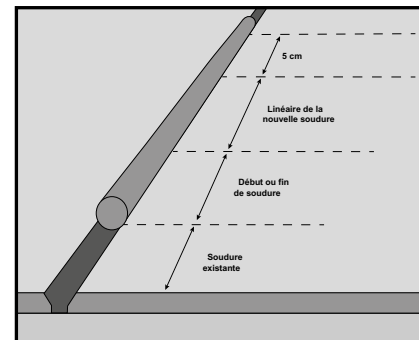
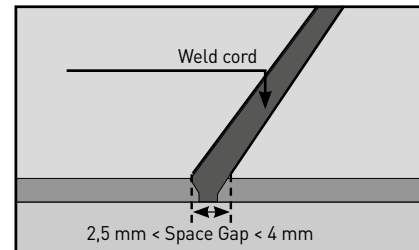
- Remove the cord, manually, or with a hook blade by cutting the cord on each side, and using a ruler as required.
- Clean the joint by sucking up the dirt and by using a triangular scraper, so as to remove all possible traces of adhesive.
- Groove flooring if necessary.
- Weld with a welding gun equipped with a nozzle suitable to welding rod as per the indications provided in the previous chapters.
- Trim in 2 steps.

2nd case: Occasional repair (in the middle of a weld)

- Remove the cord on the area to be repaired as before.
- Before and after the rod part removed, cut the welding rod in V on 3 cm in its length.
- Clean the joint by sucking up the dirt and by using a triangular scraper.
- Groove flooring if necessary.
- Weld with a welding gun equipped with a nozzle suitable to welding rod as per the indications provided in the previous chapters by starting with the already welded cord and ending with the same (approximately 5 cm).
- Trim in 2 steps.

3rd case: Total repair when the gap is more than 4 mm

- In this case, cut the flooring on a minimum width of 15 cm (7.5 cm on either side of the weld) and replace it.
- After drying of the subfloor, as required, ensure that the edges of the current flooring are bonded.
- The replacement strip should be cut so as to leave a space of 1 mm on each side, to allow for performance of the weld.
- Groove flooring.
- Weld with a welding gun equipped with a anti-glaze rapid nozzle.
- Trim in 2 steps.



5. COLD WELDING (MAY BE USED AFTER ONLY 2 TO 4 HOURS AFTER LAYING)

For homogeneous product, we recommend heat welding.

1 - TECHNICAL SPECIFICATION

- Cold welding is a heat free welding system suitable for PVC rolls on foam.
- Cold welding is colourless and can be used on all colours of the material.
- Cold welding is not recommended for Heterogeneous and Homogeneous products.

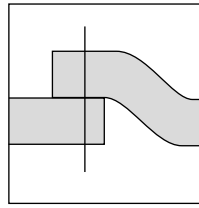
Choice of cold welding depends of product laying:

TYPE A	TYPE B	TYPE T
Cold welding liquid for overlap cut	Cold welding paste for joint from 0 to 4 mm	Cold welding paste for PVC on foam or textile
		
44g for 20 meters Ref ROMUS 95650	44g for 15 meters Ref ROMUS 95660	44g for 7 meters Ref ROMUS 95607

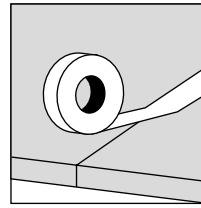
■ 2 - INSTRUCTIONS FOR USE

- Lay flooring according to its laying rules doing overlap cut and placing edge to edge
- Apply masking tape on the joint
- Cut the masking tape in the joint
- Inject the welding cold product into the joint to fulfill it by going backward
- Leave to dry 10 minutes
- Pull off the masking tape

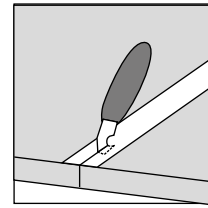
WARNING: Do not smoke or allow a naked flame near to the installation. Cold weld contains a flammable solvent.



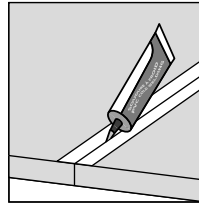
1 - Overlap cut



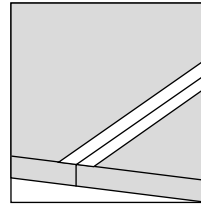
2 - Apply masking tape



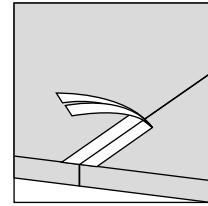
3 - Cut through the masking tape



4 - Inject the solution deeply



5 - Leave to dry 10 minutes



6 - Pull off the masking tape