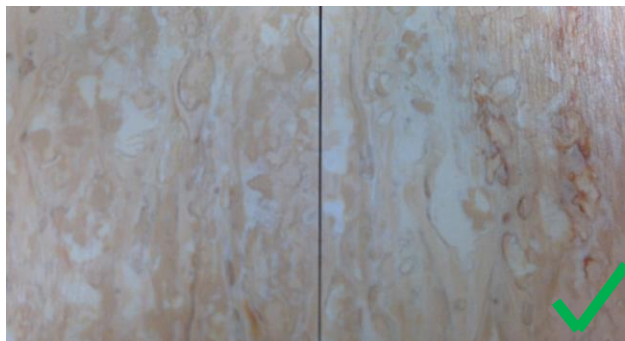


## HOMOGENEOUS SHEET VINYL HEAT WELDING GUIDE

### INTRODUCTION

These instructions are written as a guide to be used by professional installers when installing Tarkett products. These instructions, combined with our adhesives and flooring products, create a system. Utilizing this system will ease the installation process and provide the customer with a completed product that will perform to its intended purpose. Always visit [www.tarketta.com](http://www.tarketta.com) for the most current installation and maintenance instructions. Technical videos and tip sheets are also available. Contact Tarkett Technical Services at (800)-899-8916 with any questions.

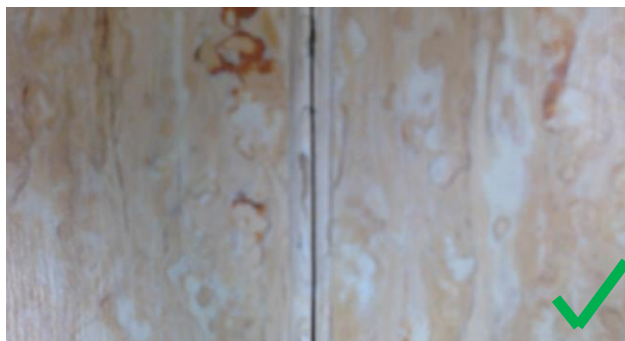
1. Prepare you seam by following the HO Sheet Vinyl Heat Weld Seam Construction instructions.
2. The seam should be cut a maximum of 1/64" gap (approximately the thickness of a business card).



3. Groove the material to 2/3 the thickness of the product.

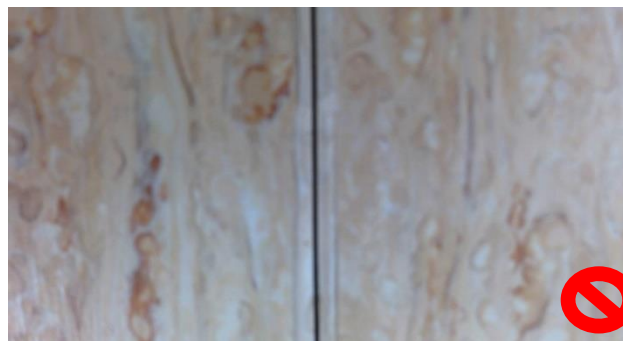
**\*\*Make certain the groove is equally aligned on each sheet and not off center. This will result in the weld rod pulling away from one sheet, causing a gap or void along one side. Moisture and contamination will collect in the seam and penetrate beneath the flooring.**

#### Correct Seam:



### Improper Seams Examples:

#### Grooved too little:



#### Grooved too much:



#### Grooved off center:



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

Weld not melting:



5. 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 decrease the temperature setting of the heat welding gun.

Excessive “Wash”:



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

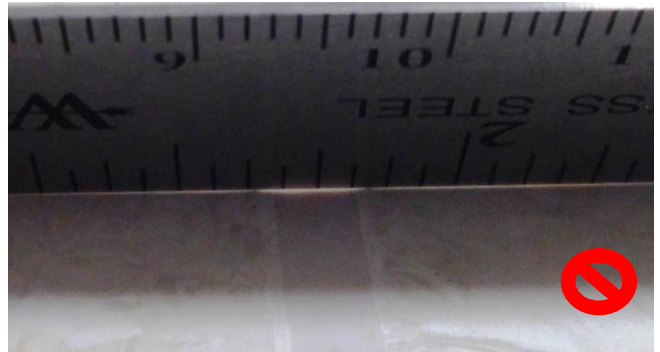
Correct “Wash”:



7. 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.



8. 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.



9. The finished seam will not show any wash and will be flush with both sides of the sheet vinyl.



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