



Technical Services Bulletin

#54 Seam Weld for Powerbond® Application

Seam Weld 54 can be used on all seams of Powerbond Cushion and Powerbond Medfloor®. Proper application of the 54 Seam Weld is crucial to the seam integrity and long-term performance of these backing systems. All warranties are based upon following the applicable Tarkett Installation Instructions. This includes proper floor preparation, application of Tarkett C-36E Primer over new concrete, application of Tarkett C-56* over minimal residue of old adhesive, and application of 54 as defined below and as covered in the individual installation instructions for each product:

1. Fill application bottle with Seam Weld 54. If the 54 is cold it will be thick, difficult to pour into the application bottle and also difficult to apply at the seams.
2. Adjust nozzle opening to control flow so that a bead of 54 seam weld equal to the thickness of the vinyl backing is applied to the floor in contact with both the floor and the edge of the backing.
3. **The 54 seam weld will dry within approximately 5 minutes** to the point that it does not adequately transfer to bond and seal the two cut edges of the carpet at the seam*. One person should apply the seam sealer while a second person fits the two cut edges under compression and smoothes out the completed seam.
4. Care should be taken to avoid getting 54 seam weld on the face of the carpet. If the 54 seam weld does get on the face fiber it should be cleaned carefully with 77 seam cleaner so as not to remove or dilute the seam weld at the abutted edges of the seam.
5. To clean the 54 seam weld dampen a white absorptive cloth with the 77 Seam Cleaner and gently rub or blot along the seam to remove any seam weld that is on the face fiber. Do not pour the 77 on the carpet.
6. A final inspection along the length of each seam should be made to insure that no areas have been missed in the seam sealing process.

54 Seam Weld will not adhere and bond the cut edges of the carpet at the seams if allowed to dry for more than five minutes. Applying 54 along the entire length of a seam and then trying to adjoin the other edge of the carpet will not result in an adequate seam weld. Seams that are not properly welded can shrink away or separate over time. Strict adherence to the above instructions will assure a strong long-term seam weld and prevent seam separation. Shelf Life: One year if not opened.

* Improper floor preparation especially failure to remove old applications of pre-existing adhesive can result in failure of RS backed Powerbond to adhere to the C-56 primer and induce shrinkage.