

TILES and ROLLS HEAT WELDING PROCESS

Minimum 12 hours after gluing

HEAT WELDING FOR ROLLS

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

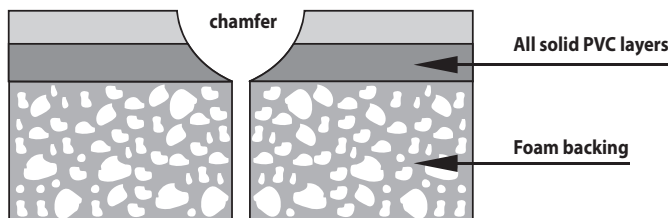
HEAT WELDING PROCESS:

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 HOMOGENEOUS AND COMPACT PRODUCTS

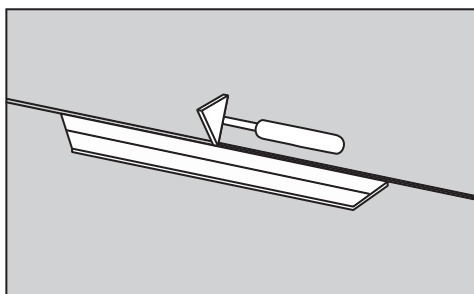
Grooving

Groove 2/3 of ALL the compact solid PVC layers

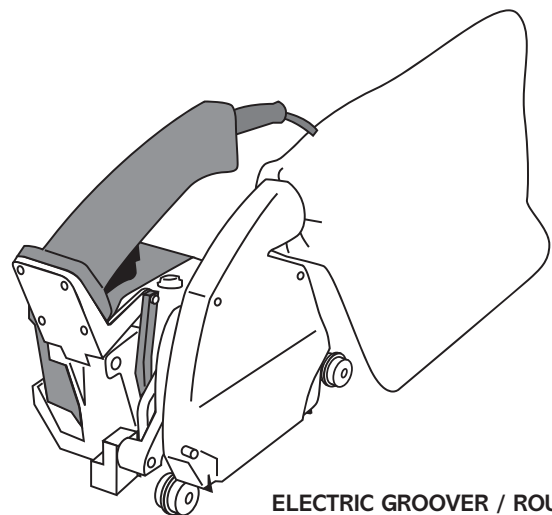
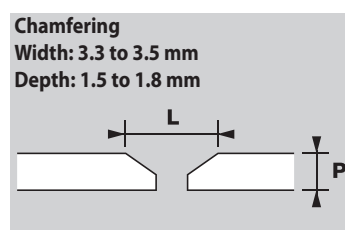
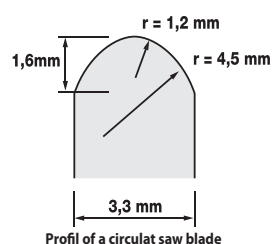


GROOVING and ROUTING TOOLS

MANUAL GROOVE-CUTTING



Tools required: Triangular scraper and a steel rule



ELECTRIC GROOVER / ROUTING MACHINE

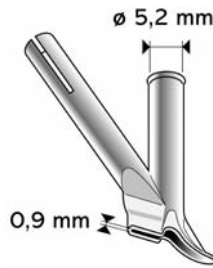
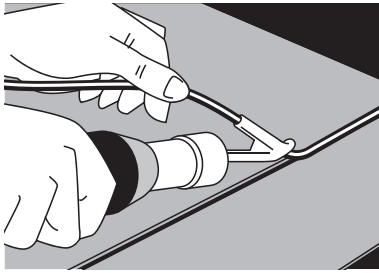
Electric grooving machine equipped with a 3,3 mm width circular plate

• 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

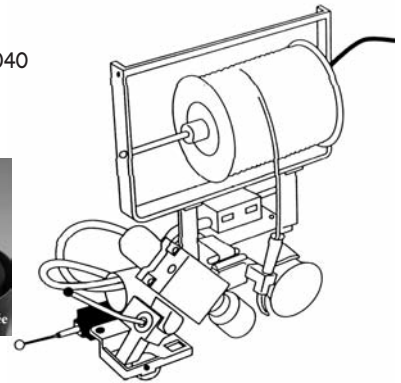


For flooring with a photoreticulated surface treatment (Protectsol®, PU), use the Rapid Ultra nozzle, diameter 5 mm, air inlet 0.9 mm, ref.: 224 800 007 from Janser or the narrow nozzle on the automatic welder.

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

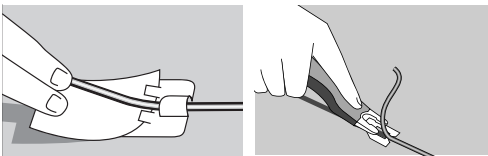


TRIMMING WELD ROD

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

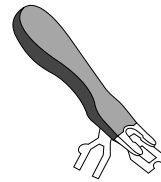
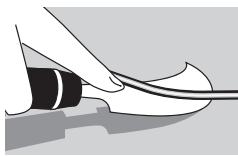
First stage:

Has to be done with 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 Gerflor
Réf. : 0561 0001
Spare blade:
Réf. : 0542 0001

HEAT WELDING THE WALL COVERING

Fixing lengths	Mural Ultra: Gap between lengths: 1 mm + 0.5 - 0 mm		
	Tools	Use	Comments
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.	The recommended tools are available from Janser, Romus or Wolff
Welding	Hot Jet S or Leister Triac type fitted with a Rapid Ultra nozzle	CR 40 rod: Air gun: Hot Jets: position 4 (80 l of air/ mn) Leister Triac:230 l of air / mn Temperature: 450 to 500°, position between 4 and 5	
Trimming	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	
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	Hot Jet S type fitted with a Rapid Ultra nozzle	CR 41 rod. 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.	
Making flush	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.	

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.