

## 1. HEAT WELDING FOR COMMERCIAL RUBBER SHEETS

DISCLAIMER: Refer to page 4 of this document.

NOTE: Mondo rubber commercial sheet goods do not necessitate heat welding of the seams. However, it may be necessary to heat weld seams if required in the project specifications.

WARNING: If you have never heat welded rubber seams before, you should not attempt to do so without practice and qualified supervision on site. If you have never heat welded flooring before, then you must obtain the proper training and do multiple practice seams on scrap material before undertaking a task of this nature. Call the Mondo Technical Department for further details.

### 1.1 CUTTING SEAMS FOR HEAT WELDING

- A. Heat welding can only be performed a minimum of 24 hours after the rubber sheet flooring has been glued down.
- B. Material must be flat on both sides of the seam to achieve proper weld.
- C. Seams are fitted by the use of an underscriber or may be cut with a seam cutter for heat welding. Set the underscriber to produce a net fit maximum 1/32" (1mm) gap. Seams can be routed with an electrical groover or by hand using a straight edge and hand groover.
- D. Important: Specific seam gap must be accurate to leave proper space for the guide of the electrical groover. Trim off material at scribe mark with a hook knife, when using an underscriber. Roll seam area lightly, using a sectional roller or steel hand roller; gap must be even to ensure a proper heat welded seam.
- E. End seams are treated following the same recommendations as for the side seams. However, material wound up at the inside of a roll may require the end to be back rolled. Apply weights to the seams (sandbags) to relax curling.

### 1.2 SEAM GROOVING

- A. Before the electric grooving machine can be used, each end of the seam must be hand grooved with the hand grooving tool for a distance of approximately 6" (15 cm) to 8" (20 cm). It is recommended that a trial run be made on two pieces of scrap flooring fastened with double face tape (to simulate a seam) before grooving actual seams. Set blade depth equal to 2/3 of the material or wear layer thickness.
- B. Seams can be routed with an electrical groover or by hand using a straight edge and hand groover.
- C. Caution: Never adjust blade when machine is turned on or plugged into an electrical outlet. Place the grooving machine on floor in the hand grooved area, lining up the front guide and the back wheel in the groove. Turn on and begin pushing the machine along the seam. Do not apply excessive pressure.

- D. Inspect the depth of the groove after a few feet of operation and adjust if necessary. Use only the tapered type blade in the electric router.
- E. The width of the groove should equal approximately 2/3 of the width of the rubber weld rod itself. Mondo rubber weld rod is approximately 4 mm thick.
- F. Routed seams must remain free of dirt, adhesive and any other foreign particles before they are heat welded. Seams that cannot be welded the same day should be protected to keep them clean.

### 1.3 HEAT WELDING PROCEDURE

- A. Verify that the rubber weld rod on the job site corresponds to the specified color.
- B. Ensure routed seams must be free of dirt, adhesive and any other foreign particles before they are heat welded. Clean seam area thoroughly with a vacuum cleaner or soft brush.
- C. To determine the correct temperature setting on your heat welding gun and the correct pace, practice on a piece of scrap flooring until you are comfortable.
- D. Cut a sufficient amount of welding thread to seal approximately half of the seam length.
- E. Fasten a 5/32" (4mm) nozzle to the tip of the heat welding gun.
- F. Position excess thread so it will not interfere with the application. Insert welding thread approximately 3" (7.6cm) out through the hole in the welding nozzle. Hold the extended thread and immediately begin sealing the seam. The proper angle for heat welding is achieved when the tip of the welding nozzle is parallel to the flooring and not tilted to the right or left side of the seam.

*NOTE: Do not touch the nozzle or barrel of welding gun as it is very hot and a burn may result.*

- G. Pull the heat gun towards you, allowing the welding thread to feed through the nozzle. Approximately 2/3 to 1/2 of the welding rod thickness will bond in the seam. The excess will be trimmed off when cooled. Moving at too fast a pace will result in poor adhesion of the weld to the seam. Too slow a pace will melt the weld rod and can lead to difficulties in skiving/trimming afterwards. A slight melting (small bead) of the thread on each side of the seam indicates the proper angle and speed.
- H. Continue welding the seam up to the end of the precut thread.
- I. Use the trim knife and trim off approximately 3" (7.6cm) at the end of the heat welded thread flush with the flooring surface. This will allow for an easy overlap where the second half of the weld is fused to the remaining seam length.

- J. Cut an additional length of thread to complete the remaining length. Start at the wall and work toward the center. Overlap approximately 3» (7.6cm) where second length of weld joins the first. The second step is the final trim.
- K. Trimming off the welding thread is accomplished in two steps. The first step will remove most of the excess.
- I. Attach the trim plate to the quarter moon trim knife and remove 2/3 of the heat welded thread while the rod is still warm.
- M. Use the quarter moon trim knife (without trim plate) to remove the remaining welded thread protruding above the surface of the flooring at the seam once the rod has fully cooled. Apply moderate and continuous steady pressure while trimming the thread.

*NOTE: Inspect the seam after final trim. Re-trim any high areas carefully to avoid any damage to damage the flooring. Any spots where welded thread shows evidence of an incomplete seal, the seam should be re-welded.*

## DISCLAIMER

These instructions conform to commonly accepted installation techniques in use with Mondo floor coverings.

However, Mondo will not accept any liability whatsoever for any incorrect implementation of these instructions nor for any failure of equipment, paint & primers, leveling compounds, adhesives or other products not manufactured by Mondo that may be referenced in these instructions nor for any adverse handling, climatic or environmental conditions that may affect such installation.

The above installation recommendations are provided for general guidance only. Mondo assumes no responsibility neither for actual work performed nor for loss or damage that may result from the use of this information due to variations of processing or working conditions outside our control.

*Users are advised to confirm suitability of products by their own tests.*

**Warranty only extends to quality and performance of rubber flooring.**

**WARNING:** Should you have any concerns or be unsure about subfloor conditions or installation procedures, please call our Technical Department.

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