

# Welding and grooving tips for Altro flooring

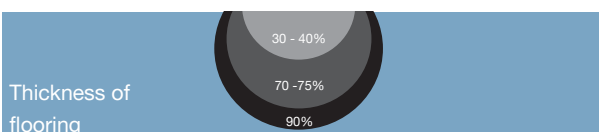
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## Grooving depth based on flooring

Grooving depth based on flooring		
Non-PUR	Altro Stronghold 30 - 3.0mm	75%
	Altro Atlas 40 - 4.0mm	75%
	Altro Classic 25 - 2.5mm	75%
PUR treated	Altro Aquarius - 2.0mm	90%
	Altro Reliance 25 - 2.5mm	90%
	Altro Walkway 20 - 2.0mm	90%
	Altro Tungsten - 2.0mm	90%
	Altro XpressLay - 2.2mm	70%
	Altro Cantata - 2.0mm	70%
	Altro Symphonia	30-40%
	Altro Orchestra	30-40%
	Altro Operetta	30-40%
	Altro Serenade	30-40%
	Altro Wood	30-40%
	Altro Wood Comfort	30-40%
	Altro Wood Acoustic	30-40%
	Altro Zodiac Smooth	30-40%

## Welding tips

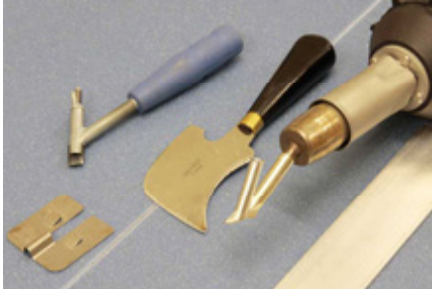
- Allow 24 hours between laying and heat welding.
- Use correct tools as outlined in the Altro sheet flooring installation guide.
- All seams, including corners, must be heat welded.
- When possible, Butterfly or V-plugs should be used on external corners. However, boot corners can also be acceptable; in either case check the specifications for the specified type corner required and do a mock up for approval processes.
  - Do not groove internal mitres with Altro Stronghold 30, Altro Atlas 40, or Altro Classic 25. These floorings do not have PUR.
  - Internal mitres must be grooved with PUR floorings.
  - Take care that seams are not grooved too wide.
- As individual welding guns can vary in their heat output and external factors on site can vary, it is recommended that test welds are carried out on samples of flooring to determine the correct heat-settings and speed. If test piece shows scorching, lower temperature of the gun and progress slower.
  - Altro Stronghold 30, Altro Atlas 40, Altro Classic 25 will require a lower heat than other Altro floorings as they DO NOT have PUR.
  - PUR floorings will require a slightly higher temperature. Additionally, a narrow flow tip may be used.
- Do not gap the seams. All seams must be cut in net before grooving.
- Ensure all seams are grooved to the correct depth, but not through the backing. (See chart and visual on left).
- After heat welding, use a trim plate while holding the spatula at a low angle. Trim off approximately 1mm of the weldrod before final trimming of the remaining weldrod flush to the floor surface with the spatula knife.
  - Altro Stronghold 30, Altro Atlas 40, Altro Classic 25 you must wait for the weldrod to cool before trimming as they DO NOT have PUR.
  - PUR floorings require that you trim off the top 1mm of weldrod while warm. Once cooled, then trim the excess weldrod flush with the flooring using a spatula knife.
  - For seams and corners on the walls and cove, use X-Acto blades to trim.
- Solvents should not be used to repair any defective welds. Do not use any solvents or tapes.



## Visual guide to heat welding Altro flooring

Flooring with PUR weld slightly differently. Please read welding tips and groove depth chart before proceeding.

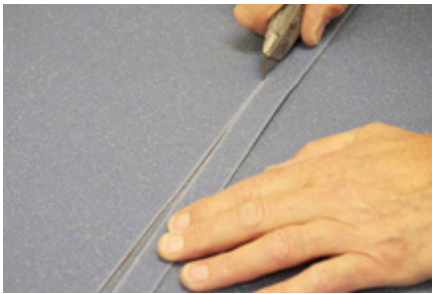
1. Use correct tools



5. Using trim plate and spatula, trim weldrod



2. All seams to be cut in net



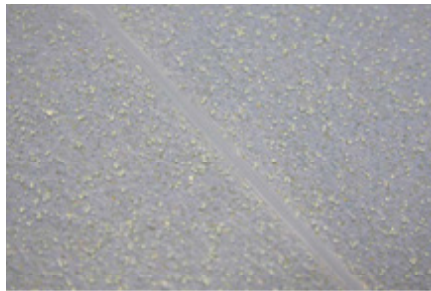
6. Final trim of weldrod using spatula knife



3. Groove to the correct depth



7. Completed seam



4. Heat weld



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