Welding and grooving tips for Altro flooring

Grooving depth based on flooring

<table>
<thead>
<tr>
<th>Non-PUR</th>
<th>75%</th>
</tr>
</thead>
<tbody>
<tr>
<td>Altro Stronghold 30 - 3.0mm</td>
<td>75%</td>
</tr>
<tr>
<td>Altro Atlas 40 - 4.0mm</td>
<td>75%</td>
</tr>
<tr>
<td>Altro Classic 25 - 2.5mm</td>
<td>75%</td>
</tr>
<tr>
<td>Altro Aquarius - 2.0mm</td>
<td>90%</td>
</tr>
<tr>
<td>Altro Reliance 25 - 2.5mm</td>
<td>90%</td>
</tr>
<tr>
<td>Altro Walkway 20 - 2.0mm</td>
<td>90%</td>
</tr>
<tr>
<td>Altro Tungsten - 2.0mm</td>
<td>90%</td>
</tr>
<tr>
<td>Altro Symphonia</td>
<td>75%</td>
</tr>
<tr>
<td>Altro Cantata - 2.0mm</td>
<td>70%</td>
</tr>
<tr>
<td>Altro XpressLay - 2.2mm</td>
<td>70%</td>
</tr>
<tr>
<td>Altro Orchestra</td>
<td>30-40%</td>
</tr>
<tr>
<td>Altro Operetta</td>
<td>30-40%</td>
</tr>
<tr>
<td>Altro Serenade</td>
<td>30-40%</td>
</tr>
<tr>
<td>Altro Wood</td>
<td>30-40%</td>
</tr>
<tr>
<td>Altro Wood Comfort</td>
<td>30-40%</td>
</tr>
<tr>
<td>Altro Wood Acoustic</td>
<td>30-40%</td>
</tr>
<tr>
<td>Altro Zodiac Smooth</td>
<td>30-40%</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>PUR treated</th>
<th>70-75%</th>
</tr>
</thead>
<tbody>
<tr>
<td>Altro XpressLay - 2.2mm</td>
<td>70%</td>
</tr>
</tbody>
</table>

**Welding tips**

- Allow 24 hours between installation of floor covering and heat-welding.
- Use correct tools as outlined in the Altro sheet flooring installation guide.
- All seams, including corners, must be grooved and heat-welded.
- Take care that seams are not grooved too wide.
- 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.
- 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 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.
- 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 welds slightly differently. Please read welding tips and groove depth chart before proceeding.

1. Use correct tools
2. All seams to be cut in net
3. Groove to the correct depth
4. Heat weld
5. Using trim plate and spatula, trim weldrod
6. Final trim of weld rod using spatula knife
7. Completed seam

Installation quickfacts, installation and maintenance guides are available online at [altro.com/techdocs](http://altro.com/techdocs)