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# Welding Tips

## For products incorporating Altro Easyclean Maxis PUR™ Technology

Altro products with Altro Easyclean Maxis PUR Technology are manufactured using a different composition to that of standard Altro safety flooring. Due to their makeup, the welding is slightly different to that of standard Altro safety flooring.

We normally recommend welding at 2 to 3 metres per minute with standard Altro safety flooring, with the gun temperature set at 300-360°C. See *Image 1* for necessary tools.

### Guide to Welding

For all Altro safety flooring products incorporating Altro Easyclean Maxis PUR Technology, we would recommend the following points be followed:

- **Cutting in joint;** do not butt or gap the joints. All joints must be cut in before grooving – *Image 2*
- **Grooving;** it is important to ensure that all joints are grooved correctly to a depth of at least 75-90% of the thickness of the product to fully expose the PVC edges of the sheet – *Image 3*
- **Internal mitres;** unlike standard Altro safety flooring, all internal mitres should be grooved as above.
- **External mitres;** for external mitres care should be taken not to open the vertical joint too wide.
- **Test sample;** 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 settings and speed – *Image 4*
- **Speed/Temperature;** it is recommended that all hot welding is carried out with the welding gun set to a slightly higher temperature than for standard Altro safety flooring. If the test piece shows scorching, turn down the heat and progress more slowly. Alternatively use an anti-glaze nozzle – *Image 5*
- **Trimming;** unlike standard Altro safety flooring, the weld should be trimmed off whilst it is still slightly warm. We would also recommend that a sledge is used, holding the spatula at a low angle, to trim off approximately 1mm of the rod, before finally trimming and finishing the remaining rod flush to the floor surface with the spatula – *Images 6, 7 and 8*
- **Do not use solvents;** solvents should not be used to repair any defective welds as these could attack and damage the Altro Easyclean Maxis PUR Technology.

Image 1

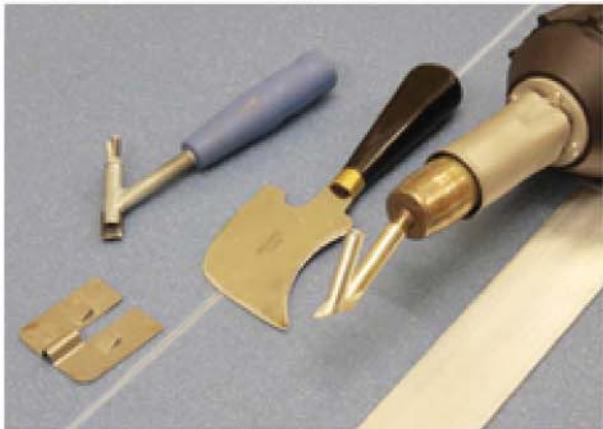


Image 2

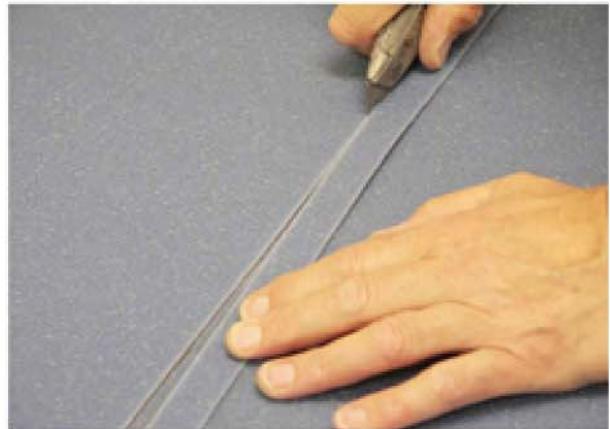


Image 3



Image 4



Image 5



Image 6



Image 7



Image 8

