



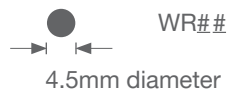
Altro Transport

Altro Transport profiled PVC welding rod

Special welding profiles

Different PVC welding rod profiles have been developed to meet varying customer needs, including round and mushroom profiles.

Standard round profile



Mushroom profile



Grooving

A 3mm groove must be centered over each floor seam using a hand or automatic rotary grooving tool.

Heat welding equipment

Tools you will need

- Altro weld rods to weld seams (check all profiles and colors before welding).
- Hot air welding gun and 4mm weld tip for round profile or HB weld tip for mushroom profile weld rods.
- Spatula to trim welding rod flush with flooring surface.
- Trim plate for initial trimming of welding rod.
- X-ACTO handle and blades to trim welding rod on coved surfaces, hard to reach areas and corners.

Heat welding seams

Preparation

Ensure that there is no gap between one section of flooring and the next. Potentially, seams are the weakest points and most likely source of water ingress, causing the flooring to detach from the subfloor. The Altro heat

Heat welding seams

welding method, correctly followed, eliminates this risk. Seams must be grooved and clear of debris before welding.

Clean hot air welding nozzle with wire brush. Turn gun on, set temperature to between 4-6 depending on local voltage and leave to heat for 10 minutes. Test weld on a scrap piece of flooring. Weld rod should fuse without burning or discoloring.

Welding

When heat setting is correct, cut the right color of weld rod to the required seam length. Start at one end, put rod into nozzle and begin. Carefully move gun along seam at constant speed.

NOTE! Ensure fusion between the weld rod and floor covering on either side without leaving a gap beneath the rod. Such a gap results in a weak spot which is easily damaged and allows water to penetrate. If welding is too fast, rod will not fuse properly. Keep speed nozzle at right angles to the floor. Do not lean gun to left or right. You may need to weld half the length of the seam and trim off, then weld from the opposite end overlapping onto the trimmed weld at the center. Regulate heat and speed to make a “wake” on either side of the welding rod. If “wake” turns dark, lower heat setting, or go a little faster.

Wheel arches and verticals

Grooving is not always needed where walls and floor form a natural 90 degree angle. Weld around wheel arches and verticals with mushroom or bus weld rod to avoid the need to trim or caulk (mastic). Round rod will require trimming.

Heat welding trimming

Trimming

Only when the weld rod has cooled should it be trimmed with a spatula. If excess rod is trimmed while hot, the weld will contract as it cools, thereby leaving a concave seam. On flat seams, trim weld rod in 2 stages.

Place trim plate over weld rod and trim top layer of thread with spatula knife. Thread can be warm or cold.

Once the rest of rod cools, use spatula knife, without trim plate, to trim excess weld flush with flooring surface. If defects are present after trimming, regroove and reweld affected area, then trim flat once cool. In coved areas where seams run up the wall use X-ACTO blades to trim, once weld rod has cooled. Altro strongly recommends that weld in buses be checked at regular intervals, at least annually.

Before using this product, users should refer to the MSDS (Material Safety Data Sheet) available from Altro.

In the case of contact with eyes rinse immediately with plenty of water and seek medical advice.

Product for professional use.

Although the technical details and recommendations contained in this product datasheet correspond to the best of our knowledge and experience, all the above information must be taken as merely indicative and subject to confirmation after long-term practical application: for this reason, anyone who intends to use the product must ensure beforehand that it is suitable for that task: in every case, the user alone is fully responsible for any consequences deriving from the use of the product.

For further information consult the installation guide at altro.com/us/transport/technical or call 800.382.0333 x3530 for technical advice. or email transport@altro.com

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