

## Heat welding instructions

To obtain a state-of-the-art, correct weld, it is most important to observe the following conditions and procedures:

### Ambient conditions:

1. Welding should not be carried out earlier than 24 hours after the installation is completed.
2. The room temperature should not be lower than 16°C and the relative humidity between 30% and 70%.
3. The welding rod should have the same temperature of the floor covering. We recommend to condition the welding rod for approx. 24 hours at room temperature, which should not be below 16°C.

### Tools required:

1. Hot air welding gun. For large areas, we strongly recommend to use an automatic seam welding machine (not pictured here).
2. Quick welding nozzle for 4mm welding rods
3. Electric grooving machine with hardened metal grooving blade, 3.5mm wide
4. Hand grooving tool, for areas inaccessible with the grooving machine.
5. Trimming slide
6. A sharp crescent shape knife
7. Colorex welding rod Ø 4mm



### How to proceed with heat welding:

1. Groove the tiles along the seam lines with the grooving machine. Use hand grooving tool for difficult to reach areas. Pay maximum attention to stay on track. Groove shape can be either round or hexagonal, no triangular or square grooves. Standard groove width for 4mm welding rods is 3.5mm.

Correct grooving depth must be approx.  $\frac{3}{4}$  of the tile thickness:

- 1.3 - 1.6mm deep for 2.0mm tiles
- 2.0 - 2.5mm deep for 3.0mm tiles



2. Weld the Colorex welding rod into the clean groove by means of the automatic seam welding machine. Use the hot air welding gun and quick welding nozzle for difficult to reach areas. Welding temperature to be 400° - 450°C.



3. It is highly recommended that trimming is done in two phases. In the first phase, while the welding rod is still warm, trim off part of the excess welding rod with the crescent-shape knife and the trimming slide.



4. For the second phase, wait until the remaining excess is cold, then trim flush using a sharp crescent-shape knife. Tip: use a separate, clean and extremely sharp knife dedicated to that purpose.



#### **How to weld at crossing points:**

To obtain a visually perfect result, we recommend to groove, weld and slide trim one direction only at a time, instead of grooving both length- and crosswise in one go before starting to weld. Flush trim only when you are finished with welding and slide trimming of both directions.