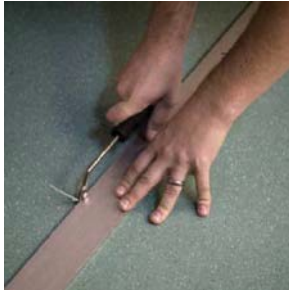


**Heat Welds:** Heat welding is the process of heat fusing two sheets of resilient sheet vinyl flooring together at the seam. A properly executed heat welded seam offers impervious, reinforced seams recommended for areas of high traffic, including those subjected to heavy rolling or wheeled loads, areas exposed to excessive moisture (frequent washing), healthcare applications (sanitation), laboratories, and clean rooms. The Greatmats welding thread is 4 mm in diameter and is meant to be used with a 4 mm nozzle. Use of a larger nozzle will cause improper bonding or permanent damage to the flooring, including burning or glazing of the vinyl wear layer surface.



#### Grooving

Using a grooving tool and a straight edge, groove the seam to a consistent depth of approximately 2/3 the thickness of the floor or half the thickness of the welding thread, whichever is less. Take care not to groove completely through the backing layer.



#### Welding

Using a heat gun set between 650 °F – 700 °F, insert the welding thread into the standard speed nozzle as it comes into contact with the grooved seam. Keeping the nozzle perpendicular to the floor, apply slight downward pressure, and draw it along the seam at a smooth and constant speed. If stopping at any point along the seam, pull the heat gun away from the flooring, and cut the welding thread. This will prevent the heat gun from scorching the surface of the flooring and welding thread.

Test seam strength by tugging a length of welding thread. If fused properly, it should break before pulling away from the seam.



#### Trimming

After allowing the thread to cool to room temperature it may be trimmed and skived. This must be done in two passes. The first pass is done using a trim plate and crescent knife, which will trim off the top half of the thread.



The second pass is done using the spatula knife only, and will trim the thread flush with the surface of the flooring. Note that for embossed products, the thread can only be skived to the top of the embossing.



#### Glazing

Using a heat gun with the nozzle attached, draw it along the seam with the nozzle approximately 1/4" above the thread. Move the gun slowly enough to melt the surface of the thread, but fast enough to avoid damaging the flooring on either side. Note that glazing of the thread after trimming is required, and will ensure correct color matching of the thread to the material, and prevent the seam from collecting excessive soiling.

**Urethane Surfaced Products:** Use of the urethane nozzle is required for heat welding. Failure to use this nozzle may result in blistering and/or scorching of the urethane surface. When using the urethane nozzle, the same instructions will be followed as noted above, including glazing, but the temperature of the heat gun will be set between 750 °F – 800 °F, and moved at a slower pace.

Greatmats.com  
117 Industrial Avenue, Milltown, WI 54858

Toll Free: 877-822-6622 - Fax: 715-825-4928  
info@greatmats.com