

# Seam Welding Procedure

- 1 Read and understand the floor preparation of concrete, following the recommendations before installing. Choose the correct adhesive application for the condition of the floor. Let the floor dry 24 hours after the installation of your pre grooved tiles. Center the lay out for good visual appearance.  
Roll the flooring with a 150 lb roller, following the installation and maintenance recommendations.  
Remove the tile from the carton and store flat in small stacks at a temperature of at least 70°F  
This allows the tile to adjust to room temperature. The tile will then lay flat and conform to the contour of the sub-floor when installed.



These are the basic tools needed for seam welding, from the left a leister router and replacement blade, leister hot air welding tool. Height guide plate, spatula knife and 4mm bead nozzle.



Lay out the field so that the last section ends at least half the length of the tile from the wall to allow space for the use of a router and hot air welding tool around the room perimeter. Tiles can be purchased pre-grooved in 24" or 36" sizes and custom sizes too.



Do a test cut on the tile to check the depth of your router tool on a sample piece of tile. Hold securely in case the depth is set too low.



Check the depth of your router cut with a depth gauge and make an adjustment to remove .070 thousands of an inch. Roughly 1/2 the thickness of the tile.



Create a seam weld sample to experiment on achieving the optimum melt flow for your floor conditions



Practice using your floor spatula knife and floor height glide plate for trimming excess material away.

# Seam Welding Procedure



7  
Vaccum all seams to eliminate welding problems and open seams.



8  
Beginners may find it easier to work with a lower heat. However, with experience, welding will be faster with a higher heat. A lower heat is recommended for correcting mistakes or welding in awkward places. A good weld is achieved when a small amount of melted bead overflows along the edges of the groove.



9  
Router all field seams in one direction only, being careful to keep the groove centered on the seam as closely as possible. Using chamfering plane to router cove pieces where the route cannot be operated.



10  
Removing the excess bead from one direction before working the bead from the opposite direction.



11  
Angle cut or router your bead at the junctions to make it easier to weld in the opposite direction



12  
A lower heat is recommended for correcting mistakes or welding in awkward places. A good weld is achieved when a small amount of melted bead overflows along the edges of the groove.

# Seam Welding Procedure



After the weld has cooled, shave off the excess bead with a spatula and height guide. If the bead is shaved before it has cooled, it will shrink below the surface of the flooring. Keep the spatula sharp by periodic honing with a fine sharpening stone.



After welding and trimming all the seams in one direction, repeat the router procedure, welding, and trimming procedures on all seams running in the opposite direction.



While seamless installations are usually flash coved, top set cove base or other treatment may be used at the floor-wall junction. In these instances, use a chamfering plane to finish the groove close to the wall where the router cannot be operated.

Weld in the opposite direction let cool before trimming the extra away.



Wet the floor with green prep and conditioner let it sit for 5 - 10 minutes then use a maroon pad and clean the surface using a red pad above the maroon pad for a cushion. The pad will follow the contour of the floor better.



Run 3-4 passes back and forth with the maroon pad, then clean with clean clear water to remove the dirt and film from the floor. Let the floor dry.

# Seam Welding Procedure



If a floor glaze or finish is required use the correct finish for the type of floor tile installed, ask your local VPI distributor. ESD floors use Tech Spray 1720 and PRT uses Flex Shield or Satin Flex Shield.



This is a PRT Floor, apply 4-5 coats of PRT Flex Shield for a long lasting high gloss finish.

## PRE-GROOVED SECTIONS:

When installing pre-grooved tile, use the same general installation instructions as for square edge. Exceptions to these general instructions are as follows:

1. Take extra care to minimize adhesive seepage at the seams. Any adhesive allowed to remain in the grooves could prevent the vinyl bead and flooring from fusing together properly.
2. After the adhesive has cured overnight, use the chamfering plane to remove all excess adhesive that may have seeped into the grooves.
3. Weld and trim all seams in one direction only.
4. Use the chamfering plane to open each cross seam.
5. Weld and trim all remaining seams.