

## Technical Bulletin

### Marmoleum® Conventional Fit Seams

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Forbo has been in continuous production of linoleum products for over 150 years. The process of welding linoleum was not introduced until the late 1980's and early 1990's as a preventative measure against topical moisture with the introduction of water-based (100% solvent free) adhesives. Due to the developments and advancements made over the last decades with the combination of Marmoleum® TopShield2™ (Forbo's factory finish for Marmoleum®), improvements in water-based adhesives and with our commitment to education of proper installation, care and maintenance procedures and environmental stewardship, welding is no longer necessary for most applications. For monolithic or seamless installations such as surgical/procedure areas or those areas required by code), Forbo Marmoweld ETU color-matched paste weld is the preferred seaming method.

It is always recommended to specify and contract flooring contractors and installers who are familiar with the installation guidelines of Forbo Flooring products to ensure a quality installation. Seams must be underscribed (a conventional fit with no gaps or fullness) and placed into wet adhesive and rolled immediately with a steel seam roller. It is also crucial to roll each drop, or cut, of the installed material immediately after placement into the adhesive with a 100 pound roller in both directions, first through the width and then the length, to achieve proper adhesive transfer. Additional rolling after the seaming is complete, as well as before you leave the room, or thirty minutes after the initial rolling, is suggested to ensure that the material is flat and fully adhered.

Forbo's current adhesives offer a high resistance to topical and subfloor moisture. When Marmoleum® is installed following the recommended installation guidelines with the recommended Forbo adhesive, the result will be a hygienic, highly water-resistant seam, which does not require welding. This can aid in reducing the cost and time required for installation. It also helps to reduce the environmental footprint of the installation. The developments in Marmoleum's® Topshield2™ factory finish reduce the need for additional care and maintenance procedures, which reduces the amount of water and chemicals required to care for the floor. Forbo refers to this as "occupancy ready".

A summary of the benefits of eliminating welding where it is not absolutely necessary are:

- ✓ Reduced overall installed cost;
- ✓ Improved aesthetics with no weld lines to disrupt the visual and accent the seams;
- ✓ Improved environmental performance with substantial reduction in CO2 footprint by eliminating the use of a high wattage heat gun for installation of weld rods; and
- ✓ Improved working environment for installers by eliminating fumes (emissions) of melting PVC based welding rods during installation.

Certain applications may still require welding, such as surgical or procedure areas, or those areas required by code. Forbo's preferred method for these applications is using Marmoweld ETU paste weld. Your Forbo Sales Representative can assist you in determining the best course of action for your project. Whether the specification calls for a conventional fit seam or a welded seam, Forbo Marmoleum®, the installed material is covered by Forbo's published product warranty when installed using Forbo's recommended procedures and adhesives.

For additional information, contact Forbo's Product Support & Education Services at 1-800-842-7839 or visit [www.forboflooringNA.com](http://www.forboflooringNA.com).