

# ETERNAL WELDING ROD TECHNICAL DATA

## 1. PRODUCT NAME / MANUFACTURER

### 1.1 Product:

Eternal vinyl welding rod

### 1.2 Manufacturer:

Forbo Flooring Systems  
Humboldt Industrial Park  
Hazleton, PA 18202

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### 1.3 Physical Characteristics: (dimensions are approximate)

Size ----- Approx. 0.157" (4.0 mm)

Roll Size ----- 165' (50 M)

## 2. INSTALLATION

### 3.1 General Guidelines:

Eternal welding rod is made of PVC which is melted and fused (by use of a hot air welding gun) into a joint that has been grooved in the material.

Heat welding Forbo vinyl sheet products is required for all seams, coving, and corner fill pieces. Heat welding provides for a strong, watertight and hygienic seam. It can also be used to provide an artistic touch.

Forbo vinyl products may be heat welded with either a matching colored welding rod or a contrasting colored welding rod.

Forbo requires net fit seams. A properly executed net fit seam will have no gaps or fullness

All welding should only be done after the flooring adhesive has set up or approximately 24 hours after installation.

The depth of the groove should be approximately 2/3 into the depth of the material.

The material should be grooved to a 3.5 mm wide U-shape.

Use a 5 mm welding tip.

To determine the optimal temperature setting for welding vinyl products, pre-heat the welding gun. Hold a piece of the vinyl welding rod in front of the welding tip.

The desired result is to melt the welding rod but **not** scorch it. If the welding rod scorches, lower the temperature until the welding rod melts with no scorching.

Always practice on a scrap piece of material first to assure proper temperature and speed.

Use only Forbo vinyl welding rod.

**NOTE:** The welding rod for Forbo vinyl products is made of pure PVC, which is designed to melt at the same temperature as the vinyl flooring. You should *never* use welding rods other than those specified by Forbo.

Material should always be visually inspected prior to installation. If there are any questions regarding the quality of material, contact your local Forbo representative or Forbo Product Support & Education Services PRIOR to installation.

**Any costs (including labor) associated with the replacement of material that was installed with visual defects that could have been seen prior to installation are not covered under warranty.**

Beginning the installation is an implied acceptance of site conditions by the parties involved and liability for any failure directly related to inadequate site conditions becomes the responsibility of the installer and/or flooring contractor.

### 3.2 Installation Guidelines:

Refer to Forbo Flooring's Installation Guide for complete installation guidelines.

## 3. AVAILABILITY AND COST

Available through authorized Forbo Flooring suppliers throughout North America. Contact Forbo Flooring or an authorized supplier for cost information.

## 4. WARRANTY

Limited warranty. For complete details, contact Forbo Flooring.

## 5. CARE AND CLEANING

After installation is completed, allow a minimum of 5 days for the adhesive to properly bond and cure before conducting wet cleaning procedures. See Forbo Flooring's Floor Care Guide for additional information.

## 6. SUPPORT SERVICES

Submittal samples for verification and approval are available upon request from Forbo Flooring. Samples shall be submitted in compliance with the requirements of the Contract Documents. Please fax all sample requests to +570 450 0229 or visit our website at [www.forboflooringna.com](http://www.forboflooringna.com). Accepted and approved samples shall constitute the standard materials that represent materials installed in the project.

For current installation and floor care guidelines, guide specifications, and other technical information, visit our website at [www.forboflooringna.com](http://www.forboflooringna.com).