

# TECHNICAL BULLETIN

## Marmoleum® Net Fit Seams

Forbo has been in continuous production of linoleum products for over 150 years. The process of heat 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® TopShield™ (Forbo's factory finish for Marmoleum®), improvements in Forbo's water-based adhesives in respect to both topical water exposures and concrete vapor emissions, heat welding is no longer necessary when properly installed with Forbo adhesives.

It is always recommended to specify and contract Forbo Certified Installers, who are trained and familiar with the installation guidelines of Forbo Flooring products to ensure a quality installation. Seams must be underscribed, net fit with no gaps or fullness and placed into wet adhesive and rolled immediately with a hand 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 highly water resistant seam, which does not require heat 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® Topshield™ 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 heat 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 CO<sub>2</sub> 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 heat welding. Your Forbo sales representative can assist you in determining the best course of action for your project. Whether the specification calls for heat welding or not heat welding Forbo Marmoleum®, when installed using Forbo's recommended procedures and adhesives, the installed material is covered by Forbo's published product warranty.

For additional information, Forbo's Installation and Floor Care Guidelines are available for download at [www.forboflooringNA.com](http://www.forboflooringNA.com), or contact Forbo's Product Support and Education Services at +800 842 7839.