

UK Installation Guidance Note: Allura Colour Plus welding

General Advice

Where additional hygiene requirements or operational conditions require welding of the joints in Allura Colour Plus tile the following conditions and procedures should be observed to achieve the optimum finish.

Site Conditions

1. Welding should not be carried out earlier than 24 hours after the installation is completed.
2. The room temperature should not be lower than 18°C and the relative humidity between 30% and 70%.
3. The welding rod should have the same temperature of the floor covering. We recommend conditioning the welding rod for approx. 24 hours at room temperature of at least 18°C.

Tools Required

1. Hot air welding gun. For large areas, an automatic seam-welding machine (not pictured here) is strongly recommended
2. Speedweld nozzle for 4 mm welding rods
3. Electric grooving machine with hardened metal grooving blade 3.5mm wide
4. Hand grooving tool, for areas inaccessible with the grooving machine.
5. Trimming slide
6. A sharp Spatula (crescent shape knife) or Mozart trimming Knife (see Image below).
7. Allura Colour Plus recommended colour welding rod \varnothing 4 mm



Mozart Trimming Knife (recommended)



Procedure

Switch on the hot air gun and allow 5 to 7 minutes for it to reach the selected temperature. Allura Colour Plus should be welded at a temperature of approximately 400° C. (see weld gun manual for setting details). Fit the welding nozzle before switching on the hot air gun.

If the gun is resting on the floor, ensure that the nozzle is not directed at the floor surface or anywhere dangerous.

Weld guns will vary, so it is always advisable to practice weld techniques first on a piece of waste material to match the correct air gun temperature with welding speed.
Allura Colour Plus should be welded with a Speedweld nozzle.

Note: the following pictures show Colorex Plus tiles - this is for illustration of the technique purposes only as the same procedure is used for these and Allura Colour Plus tiles.

1. Groove the tiles along the seam lines with the grooving machine. Use hand grooving tool for difficult to reach areas. Pay maximum attention to stay on track.
Groove shape can be either round or hexagonal, no triangular or square grooves.
Standard groove width for 4 mm welding rods is 3.5 mm.



The correct grooving depth must be approx.:

- 1.6 - 1.8 mm deep for 2.0 mm tiles
- 1.8 - 2.0 mm deep for 3.0 mm tiles
- 1.8 - 2.0 mm deep for plus tiles

2. Weld the Allura Colour Plus welding rod into the clean groove using an automatic seam welding machine. Use a hot air welding gun and Speedweld nozzle for difficult to reach areas.

A good welded seam will be achieved using the correct combination of welding temperature and speed. The welding temperature should be approximately 400° C. To check that welding temperature and speed is correct, weld 10 cm of a spare tile then pull the rod to verify that the welded section resists more than the rod itself.



3. The first trim of the weld cable should be carried out while the cable is still warm.

Trim off the top half of the cable down to approximately 0.5mm using a sharp spatula and slide or Mozart knife (with the spacer in place under the trimming blade) which fits over the cable. This enables the cable to cool more quickly and enables a quick first cut to be made without risk of gouging the material.



4. The welding cable will dish slightly (concave downwards) as it cools. Wait until the material is completely cool before carrying out the final trim, trimming flush with the surface of the sheet with a sharp spatula angled slightly across the line of cut or a Mozart knife (with the spacer plate moved to one side).

Note: Making the final trim while the welding rod and material is still warm can result in the weld cable dishing of the weld cable. This may result in subsequent seam soiling problems or cause permanent damage to the surface of the flooring.



Welding at cross joints:

To obtain the best result, we recommend that the tile seams are **grooved, welded and trimmed in one direction only at a time**, instead of grooving all the seams (length and cross seams) at the same time before starting to weld.

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