

ATTENTION: Always refer to the **Technical Manual for Interior Flooring Products** for complete installation information prior to using this product. Lonseal reserves the right to change our products' design, material, and/or to improve products or processes at any time without notice. Installation procedures and use of Lonseal adhesives must be in strict accordance with Lonseal's technical documents for warranty terms to be valid. **Please review the website for the most current technical information.**

CHEMICAL WELDS: Chemical welding, also referred to as cold welding, is the process of chemically fusing two sheets of resilient sheet vinyl flooring together at the seam. A properly executed chemical weld can provide the appearance of a seamless floor, and is chosen due to aesthetics. This type of weld is best used in areas of light to normal traffic and not exposed to excessive moisture. Please refer to the **Technical Data Sheet** for additional information regarding this product and its use.

Seam Preparation

All seams must use Lonseal DFT to ensure a "clean zone", which will allow the Lonsealer to properly bond the sheets together.

All seams should be double- or underscribe-cut to ensure they are as tight as possible. Do not attempt to chemically weld factory edges. Any gaps in the seam could result in seam failure.



Welding

Apply a piece of 1" wide masking or painter's tape at both sides of the seam, allowing no gap between them. Use a small hand roller to ensure strong, positive contact between the tape and the flooring. Failure to ensure a good bond between the tape and the floor could result in fluid leeching beneath the tape and marring the floor. Alternately, a 2" wide piece of tape centered on the seam may be used, but it must be cut at the seam to allow the needle to move freely along it. When cutting the tape, care must be taken to avoid cutting the flooring at either side of the seam, and the tape should be rolled again after cutting has been completed.

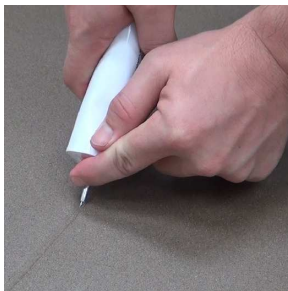
With the cap still on, shake the tube well. Holding the tube upright and pointed away from the body and face, remove the cap and wipe away any escaping fluid with a small cloth.

The needle is offset in the nozzle, and should be at the top of the nozzle when held correctly. This will ensure proper flow of the fluid. Holding the end of the tube in one hand, tilt it towards the seam, and use the index finger on the other hand to fully insert the needle into the seam at a 45° angle to the floor. Ensure full penetration of the needle into the seam, gently contacting the substrate. Topically coating the seam is not sufficient for successful bonding of the flooring, and could result in seam failure.

Draw the needle evenly and slowly along the seam. Flow may be regulated by exerting light pressure on the end of the tube. The angle of the tube may also be slightly adjusted to increase or decrease the rate of flow. Apply a uniform bead 1/8" to 1/4" wide centered on the seam. As the needle is drawn along the seam, the sheets will separate slightly which will allow the fluid to flow between them. The bead of sealer must flow back together around the needle after it has been applied to the seam. If the sealer is applied too thinly and does not flow back together, this could result in an inadequate amount of sealer being applied, and seam failure could occur. Adjust the flow or slow the movement along the seam as necessary.

After completion, wipe any excess fluid off the needle, and replace the cap right away. If the tube is not closed immediately, a skin will form and blockage can occur, making the tube unusable. Wait 10 – 15 minutes before removing the tape, allowing the bead of sealer time to set. The tape should be pulled away from the seam at an angle, and care should be taken to prevent any sealer from dripping onto the surface of the flooring. Removing the tape while the sealer is still viscous will make it more difficult to prevent the sealer from dripping onto the floor. Do not wait until the sealer has fully dried before removing the tape.

Lonsealer will be fully cured after 48 hours. While the seams may be walked on after 2 hours (essential foot traffic only), allow a minimum of 48 hours before any regular foot traffic or initial maintenance.



Alternate Method

Follow the above directions, but do not apply tape along the seams. This method will result in a permanent bead of sealer on the surface of the floor. Do not wipe away this bead, or permanent damage to the surface of the flooring will occur. Excess sealer may spill out upon initial insertion of the needle into the seam, and precautionary measures should be taken, such as starting on a portion of flooring to be removed later or applying tape as directed above at the start of the seam only. Ensure hands/gloves are clean, to prevent any transfer of dirt to the flooring and seams. Any dirt present will be permanently ingrained within the bead. The installation area must also be kept free of any activity which could result in airborne dust or particles settling on the bead while it cures. Ingrained dirt will be more noticeable in lighter colored flooring. Any swelling in the seam will disappear as it begins to harden. The bead will be high gloss, but this may diminish over time or with the application of a floor finish.

URETHANE SURFACED PRODUCTS (E.G. TOPSEAL): Lonsealer will not fuse to a urethane finish as well as vinyl. When using the Alternate Method, this may result in the bead of sealer de-bonding from the surface over time. Following all the above directions will ensure that adequate Lonsealer is used to properly fuse the seams.

CLEAN UP: While still wet, Lonsealer may be removed from tools with an absorbent cloth. If spilled on the flooring, wipe up immediately using mineral spirits applied to a clean, dry cloth. **Always use caution when working with mineral spirits.** Note that Lonsealer's effect on the surface of the flooring is immediate, and some marring will occur. This marring may become less visible on floors which receive a finish. **Cured sealer is impossible to remove from the surface of the sheet vinyl.**

WARNING! This product contains tetrahydrofuran, and is **EXTREMELY FLAMMABLE**. Always replace the cap when not in use. Please review the **Safety Data Sheet** prior to use, and observe all noted Hazard and Precautionary Statements to ensure safe use of this product.