

ATTENTION: Always refer to the most current technical information available at www.lonseal.com, and review completely prior to starting the job. Lonseal reserves the right to change its products' design and material, or to improve products or processes at any time without notice. Installation procedures and use of Lonseal products must be in strict accordance with Lonseal's technical documentation for warranty terms to be valid.

CHEMICAL WELDS: Chemical welding, also referred to as cold welding, is the process of chemically fusing two pieces of 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 its aesthetics. This type of weld is best used in areas of light traffic and not exposed to excess moisture (frequent cleaning).

IMPORTANT: Please refer to the **Lonsealer** Technical Data Sheet (TDS) for complete installation requirements and product information. If any discrepancy is found between this guide and the TDS, the TDS will supersede.

SEAM PREPARATION: All seams must use Lonseal Double-Face Tape (DFT) to ensure a "clean zone" at the seams, ensuring the seam is not contaminated with adhesive. Any adhesive or debris within the seam could prevent proper fusion. All seams must be double- or underscribe-cut to ensure the seams are as tight as possible. Do not attempt to chemically weld factory edges. Any gaps in the seam will prevent proper fusion and could result in seam failure.



Welding

Apply a piece of 1 in. (2.5 cm) 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. Alternately, a 2 in. (5.1 cm) 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.

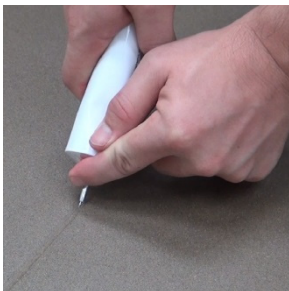
With the cap still on, shake the tube well. Holding the tube upright and away from the body and face, remove the cap and wipe away any escaping fluid with a clean cloth.

Note that the needle is offset within the nozzle and should be at the top of the nozzle when held correctly. Holding the tube in one hand, tilt it towards the seam and use the index finger of the other hand to fully insert the needle into the seam at a 45° angle to the flooring. Ensure full penetration of the needle into the seam, gently contacting the substrate.

Draw the needle evenly and slowly along the seam. Flow may be regulated by exerting light pressure on the sides 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 in. (3.2 to 6.4 mm) wide. As the needle is drawn along the seam, the sheets will separate slightly, allowing the fluid to flow between them.

After completion, wipe away any excess fluid off the needle and replace the cap immediately. If the tube is not closed immediately, a skin can form within the nozzle creating permanent blockage, 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 flooring. Do not wait until the sealer has fully dried to remove the tape.

Lonsealer will be fully cured after 48 hours.



Alternate Method

Follow the above directions, but do not apply tape along the seams. This method may be necessary for heavily embossed flooring. This method will also result in a permanent bead of sealer on the flooring. Do not wipe away this bead or permanent damage to the surface 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.

DANGER!: 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.