

**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, 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.**

**HEAT WELDS:** Heat welding is the process of heat fusing two sheets of resilient sheet vinyl flooring together at the seam. A properly executed heat welded seam offers impervious, reinforced seams recommended for areas of high traffic, including those subjected to heavy rolling or wheeled loads, areas exposed to excessive moisture (frequent washing), healthcare applications (sanitation), laboratories, and clean rooms. Please refer to the **Technical Data Sheet** for additional information regarding this product.

Lonseal's welding thread is 4 mm in diameter and is meant to be used with a 4 mm nozzle. Use of a larger nozzle will cause improper bonding or permanent damage to the flooring, including burning or glazing of the vinyl wear layer surface.



#### Grooving

Using a grooving tool with a 4 mm blade and a straight edge, groove the seam to a consistent depth of approximately 2/3 the thickness of the floor or half the thickness of the welding thread (2 mm), whichever is less. Take care not to groove completely through the backing layer.



#### Welding

Using a heat gun set between 650 °F – 700 °F, insert the welding thread into the standard speed nozzle as it comes into contact with the grooved seam. Keeping the bottom of the nozzle parallel to the floor, apply slight downward pressure, and draw it along the seam at a smooth and constant speed. If stopping at any point along the seam, pull the heat gun away from the flooring, and cut the welding thread. This will prevent the heat gun from scorching the surface of the flooring and welding thread.

Test seam strength by tugging a length of welding thread. If fused properly, it should break before pulling away from the seam.



#### Trimming

After allowing the thread to cool to room temperature it may be trimmed and skived. This must be done in two passes. The first pass is done using a trim plate and crescent knife, which will trim off the top of the thread.

The second pass is done using the crescent knife only, and will trim the thread flush with the surface of the flooring. Note that for embossed products, the thread can only be skived to the top of the embossing.



#### Glazing

Using a heat gun with the nozzle attached, draw it along the seam with the nozzle approximately 1/4" above the thread. Move the gun slowly enough to melt the surface of the thread, but fast enough to avoid damaging the flooring on either side. Note that glazing of the thread after trimming is required (except for those products listed under **Notes** below). This step will ensure correct color matching of the thread to the material, and prevent the seam from collecting excessive soiling.

**URETHANE SURFACED PRODUCTS (E.G. TOPSEAL):** Use of the urethane nozzle (Lonseal Part ZZ65) is required for heat welding. Failure to use this nozzle may result in blistering and/or scorching of the urethane surface. When using the urethane nozzle, the same instructions will be followed as noted above, including glazing, but the temperature of the heat gun will be set between 750 °F – 800 °F, and moved at a slower pace.

**NOTES:**

- Some products have welding thread specifically formulated to eliminate the need for glazing. This new thread is called RapidThread. The following products use RapidThread and do not need to be glazed (*xx* or *xxx* represents the product color number where the entire product line has been changed):

<b>Flooring</b>	<b>Welding Thread</b>
Loncourt I #38	ZTLP838
Loncourt UV #838	ZTLP838
Londante Topseal (all colors)	ZTLPxxx
Loneco Linen Topseal (all colors)	ZTLPxxx
Loneco Topseal (all colors)	ZT72xx
Lonfloor Galvanized Topseal (all colors)	ZT72xx
Lonmoire Topseal (all colors)	ZTLPxx
Lonspeck Topseal (all colors)	ZTLPxxx
Lonwood Dakota Topseal (all colors)	ZT70xx
Lonwood Madera Topseal (all colors)	ZTLPxxx
Lonwood Natural Topseal Lonwood (all colors)	ZT74xx
Lonwood Performa #547	ZT7097
Lonwood Performa #548	ZT7082
Lonwood Performa #549	ZT7467
Lonwood Performa #550	ZTLP550
Lonwood Performa #553	ZT7066
Lonwood with Foam #375	ZTLP550
Lonwood with Foam #382	ZT7082
Lonzebra Topseal (all colors)	ZT70xx

**Note:** Refer to the **Welding Thread List** Technical Bulletin for specific item numbers.