

**ATTENTION:** Always refer to the most current technical information available at [www.lonseal.com](http://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.

**DESCRIPTION:** A liquid seam sealer that fuses the edges of vinyl flooring together.

**USE:** For chemically welding Lonseal flooring at the seams.

**ADVANTAGES:**

- ▶ Reduced or low visibility seams
- ▶ Can be used the same day as the flooring installation

**PREPARATION:**

- ▶ Ensure that all seams are free of contaminants such as dirt, dust, and moisture.
- ▶ Use Lonseal DFT under all seams
- ▶ All seams should be double- or underscribe-cut to ensure they are as tight as possible. Any gaps could result in seam failure.

**IMPORTANT:**

- ▶ Practice the methods noted below on scrap material prior to application to ensure familiarity with the materials involved.

**APPLICATION:**

1. Ensure that the seam area is clean and will remain clean during and after the welding process. Once the Lonsealer is applied to the seam, the solvents within are instantly evaporated and the curing process begins. Any soiling caught within the sealer will be permanently trapped and could result in seam failure.
2. 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. Failure to ensure a good bond between the tape and the flooring could result in fluid leeching beneath the tape and marring the floor. 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. 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.
3. Prior to welding, a heat gun without a nozzle, set at a low temperature, may be run above the seam to temporarily relax the flooring. This should allow for the needle to move easier along the seam. Be sure to keep the heat low, and the heat gun at an appropriate distance from the flooring, to prevent any surface damage. Do not use or keep the heat gun in the same vicinity as the Lonsealer. See the **Danger!** section below.
4. With the cap still on, shake the tube well.
5. Holding the tube upright and pointed away from the body and face, remove the cap and wipe away any escaping fluid with a clean cloth.
6. Note that the needle is offset within the nozzle and should be at the top of the nozzle when held correctly. This will ensure proper flow of the fluid.
7. Holding the end of 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. Topically coating the seam is not sufficient for successful bonding of the flooring and will result in seam failure.
8. 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.
9. Apply a uniform bead 1/8 to 1/4 in. (3.2 to 6.4 mm) wide centered on in the seam. As the needle is drawn along the seam, the sheets will separate slightly, allowing 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, an inadequate amount of sealer will be applied, and seam failure could occur. Adjust the flow or slow the movement along the seam as necessary.
10. After completion, wipe 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.
11. 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.
12. 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 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.

**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 flooring's surface is immediate and some marring will occur. This marring may become less visible on floors that receive a finish. **Cured sealer is impossible to remove from the surface of the sheet vinyl.**

**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.

**LIMITATIONS:** Do not freeze. For interior use only. Lonseal Double Face Tape (DFT) must be used with this product. Not for use with flooring installations over fiberglass or metal, or with epoxy or contact adhesives. Use with non-Lonseal branded flooring is not supported or warranted by Lonseal.

#### **PHYSICAL PROPERTIES:**

- ▶ **Color:** Clear
- ▶ **VOC:** 780 g/L
- ▶ **Shelf Life:** 3 years from date of manufacture\*, when stored properly
- ▶ **Storage Conditions:** 65 °F – 85 °F (18.3 °C – 29.4 °C); keep dry and out of direct sunlight in a well-ventilated area.
- ▶ **Application Conditions:** 65 °F – 85 °F (18.3 °C – 29.4 °C)
- ▶ **Available Size(s):** 5 fl. oz.
- ▶ **Coverage:** Approximately 200 linear feet

\*Date of manufacture can be found on the box in the format MM/DD/YYYY. It may also be found on the end of the tube in the form of a 6 digit lot number. The first three digits are the batch number, the next two digits are the month, and the final digit is for the year (ex. 043039 = Batch 043, manufactured March 2019).