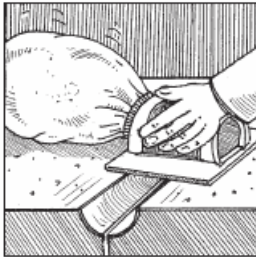
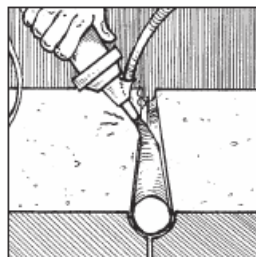




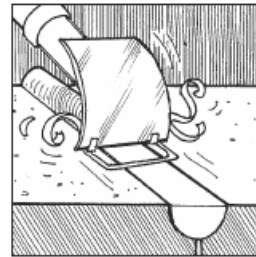
Heat Weld for Allstate Sheet Rubber



1. Route out channel



2. Melt weld into rubber



3. Trim the weld bead

1. After the flooring is installed, following the appropriate installation process, wait a minimum of 24 hours, for all “wet adhesives” to cure before beginning the head welding process.
2. To prepare the seam for welding, it must be grooved using either a mechanical goover or hand-grooving tool. The depth of the groove shall be approximately $\frac{2}{3}$ of the thickness of the flooring material. The width of the groove after cutting shall be no less than 3mm and no greater than 3.5mm.
3. After the groove is confirmed to be clean of any debris, pre-heat the welding gun to obtain the correct heat setting of $350^{\circ}\text{-}400^{\circ}\text{C}$ ($662^{\circ}\text{-}752^{\circ}\text{C}$). It is recommended to practice welding on a piece of scrap flooring material to determine the exact heat setting and speed.
4. Cut a length of heat weld rod sufficient to weld the entire length of the seam, plus approximately 6” extra.
5. Weld the seam starting at the wall and apply slight pressure to the gun nozzle to force the rod into the groove.
6. Properly inserted, the heat weld will have a slightly flattened portion on either side. Allow the rod to cool to the touch and begin trimming or “skiving” to remove excess weld. To help prevent scratching or scuffing of the flooring during skiving, it helps to use a 1 part liquid soap to 10 parts water solution and apply using a clean cloth to the welding rod and to at least 2” (1” each side).
7. Using the trim plate and skiving knife, make the first cut across the weld rod and allow the weld rod to fully cool to room temperature.
8. Next using only the skiving knife finish trimming the remainder of the weld. The finished weld should be smooth and on the same level as the floor covering.
9. Occasionally, there may be excess weld left after the final trim and it will be necessary to remove this using a “melting” technique. After heating up a non-sharpened metal putty knife, gently glide the putty knife (held as if scraping) along the seam weld. Excess weld material will collect on the knife and the result will be a smooth and flat seam weld.

All terms, conditions and directions are subject to change without notice.