



Welding cord 4 mm

Recommended processing instructions for thermal bonding

In thermal bonding, the abutting edges of the floor covering are bonded together under the influence of hot air using a round PVC welding cord of the same material to produce a homogeneous unit.

In this way, floor coverings, skirting boards and skirting strips made from the floor covering can be bonded together without any seams and all from the same material. Thermal bonding should be used for all synthetic floor coverings in areas subject to heavy use.

Crucial factors for a correct, durable bond include:

- PVC welding cord made of the same material
- Correct grooving
- Adequate bonding temperature
- Coordinated bonding speed and pressure
- Random sampling of bond strength
- Suitable tool

Grooving

Thermal bonding should be carried out at the earliest 24 hours after adhering the floor covering. A parabolic grooving blade for grooving the seams is a key prerequisite for obtaining the optimum bond.

- Grooving blade width 3.3 mm for bonding cord with 4 mm diameter
- Grooving depth $\frac{3}{4}$ of the homogeneous floor covering depth

Bonding

Large areas are usually bonded with bonding machines. Here on-going monitoring of the bond is necessary because of the negative impact of site-dependent influences on the quality of the bond, such as power drop in the power supply, draught, soiled grooves, etc.

Bonding machine setting:

The temperature and speed should be coordinated in the correct ratio to obtain the correct bond with sufficient tensile strength.

Indicative values

Speed	4 m / min	6 m / min
Temperature	450°C - 500°C	550°C - 650°C

After bonding the seam, the protruding welding cord is cut off in hot condition using a welding cord slide, leaving approx. 1 mm welding cord material over the floor surface. Once the seam has cooled out completely, the remaining protruding material is cut off smoothly with a sharp quarter-moon knife. This prevents the seams from collapsing and spoiling the smoothness of the floor covering surface.