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Seam Construction For Heat  
Welding Homogeneous Sheet  
Vinyl

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Remove a minimum of 1/2" from the factory edge of the first sheet. When utilizing a knife and straight edge be sure to hold the knife perpendicular to the floor.

Move the sheet into position and mark a reference line onto the substrate following the edge of the first sheet.



Establish cross-reference points onto the substrate and the top of the sheet.





Fold the sheet back and use a white chalk line to establish a reference point onto the substrate.

Using the correct trowel, apply the Johnsonite adhesive onto the substrate. Follow the previously established reference lines when troweling adhesive.



After the adhesive is allowed the appropriate open time, lay the sheet into the adhesive. Use the previously established reference marks to help position the sheet during installation.



After laying the sheet into the adhesive, roll the floor in both directions using a 100 pound three-section roller.

Cut the second sheet and position it so that the factory edge overlaps the previously installed edge by a minimum of 1/2".

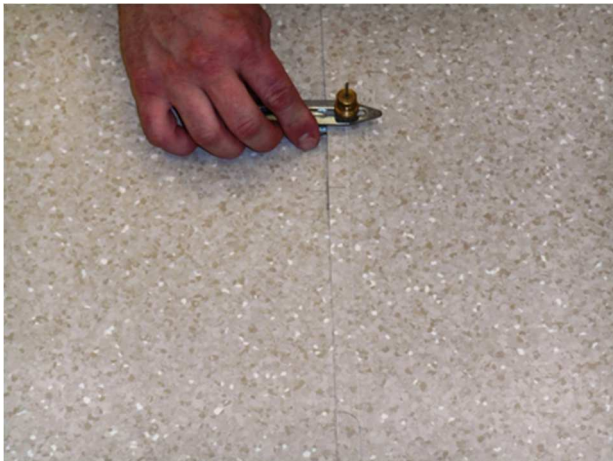


Using a pencil and small square establish reference points onto the top of both sheets. One mark should be placed perpendicular to the seam and another should follow the edge of the overlapping sheet.

**OR**



Using a recess scribe cut windows along the edge of the seam. At a minimum, one window should be made at each end of the sheet. After cutting the window, establish cross reference points on the top of both pieces.



After applying adhesive following the steps outlined above, lay the second sheet into the adhesive and roll the sheet in both directions with a 100-lb 3 section roller. Be careful to keep the roller approximately 3" from the seam. Using a recess scribe, scribe the second sheet. The recess scribe should be preset to the desired width of the seam (no greater than 1/64" for heat welded seams).



Place a piece of scrap material under the second sheet when cutting the seam. Utilize a utility knife with a sharp blade to cut along the scribe mark.

Roll the seam with a 2" steel hand roller. Then roll the entire floor in both directions with a 100lb 3 section roller.



Clean any excess adhesive with a clean white cloth, dampened with water, before it dries. Erase all reference marks. Use to Denatured Alcohol to clean.

You are now ready to heat weld the seam.



**“This is a reference guide to aid a qualified, professional flooring mechanic in the heat welding process of Johnsonite sheet products. This is not intended to replace our installation instructions or train a flooring installer on the process of heat welding. Please visit [Johnsonite.com](http://Johnsonite.com) for detailed installation instructions or contact your local Johnsonite distributor to schedule a training seminar.”**