

## Heat welder SOP

### Basic operating procedure

- Groove out the seam to two-thirds of the depth of the material with a hand groover or turbo groover.
- Select the correct welding tip and cable for the type of flooring being welded.
- Fit the tip to the welding gun and turn it on. Let it reach the set operating temperature. Cut the welding cable to length, and thread it through the nozzle.
- Weld the material, starting at the wall and moving away at a steady speed.
- Complete the weld and trim off the excess material down to about half a millimetre using a sharp spatula and slider. Do this while the cable is still warm so that it cuts smoothly without gouging. This first cut will also help the cable to cool more quickly.
- Wait until the material cools, and then trim the cable flush with the floor surface using a spatula angled slightly across the line of the cut.