

**Section 9**  
**Resilient Flooring**  
**Rubber Welding Rods**

**1. Product Nomenclature**  
**Rubber Welding Rods****2. Company Information****Flexco Corporation**1401 East 6<sup>th</sup> Street

P.O. Box 553

Tuscumbia, AL, USA 35674

Telephone: (256) 383-7474; (800) 633-3151 Facsimile: (256) 381-0322; (800) 346-9075 Internet:

[www.flexcofloors.com](http://www.flexcofloors.com)Sweet's Catalog: 09650/FLE; Buyline 0254; [www.sweets.com](http://www.sweets.com)**3. Product Description****3.1 Basic Application**

Flexco® Rubber Welding Rods are designed to “weld” or fuse the seams of two properly prepared rubber tiles or sheets together with a bead of rubber to provide a seamless unitized installation. This Unitized Installation System inhibits dirt and other particulate from building up in the seams creating a more hygienic environment, especially when the installation requires flash coving. The Flexco® Unitized Installation System is ideal for operating rooms, laboratories, clean rooms, home health care, medical clinics, or other application requiring the additional benefits of the seamless installation. The Rubber Welding Rods are available in the Retro Rubber Blends® background colors. For 24” x 24” tiles, divide the total square footage of tile required by 400 to obtain the number of rolls Rubber Welding Rod required. For 36” x 36” tiles, divide the total square footage of tile required by 600 to obtain the number of rolls of Rubber Welding Rod required. For heat welding, the 1/8” thick Retro Rubber Blends® Smooth Rubber Tile can be pre-grooved at the factory at no extra charge. Custom color matching is available. The heat weld gun and the 4mm welding tip are also available from Flexco®.

**3.2 Product Construction**

Flexco® Rubber Welding Rods are solid, homogeneous, non-conductive rubber rods manufactured using first quality, virgin polymers and raw materials. Its high rubber content provides excellent abrasion resistance, chemical resistance, impact resistance, tear strength, resiliency, and bond strength.

**3.3 Product Type****3.3.1 Rubber Welding Rods**

Diameter: 0.160” (4 mm)

Roll length: 400 linear feet

Colors: Retro Rubber Blends® background colors; Custom color matching available.

**4. Product Limitations/Precautions**

Flexco® Rubber Welding Rods must be installed in accordance with Flexco®’s recommendations in order for the product warranty to be in effect. Flexco® Rubber Welding Rods may be stained if it is allowed to remain in contact with other rubber products that may contain staining ingredients such as tires, casters, and walk-off mats. Fading can occur from extensive exposure to heavy direct or glass-filtered sunlight, or unfiltered ultra-violet rays. Ensure

any disinfectant, cleaning agent, dye, floor care product, pesticide, or other chemical (solid, liquid, or gas) that may come in contact with the flooring will not produce permanent discoloration and/or damage to the flooring. If any chemical that may come in contact with the flooring is not on the stain resistance chart, the rubber must be tested prior to installation. Contact Flexco® Customer Service for a stain resistance chart and for assistance in conducting stain testing. Flexco® Rubber Welding Rods must not be used in areas that may be subjected to sharp spikes, cleats, sharp wheels, or other objects that could damage the flooring. DO NOT drag or move objects across the seams or drop objects onto the flooring that may cause damage to the flooring. Use appropriate floor protection devices. The flooring is not to come in contact with direct heat, such as radiators, hot ovens, or other heated equipment. Ensure the proper product is used for the service application with regard to type and amount of traffic. Rubber Welding Rods are for indoor use only with temperatures maintained from 55° F to 95° F. Color selections must be made from actual samples, exact matching of color or shade may vary. Follow all local, state, and federal safety standards and practices.

## 5. Installation

### 5.1 General Preparation and Conditioning

Read the literature concerning the product description, product limitations, product installation, adhesive information, product maintenance, and warranty of the specific product being heat welded before installation. All materials are to be delivered to the installation location in its original packaging with labels intact. Store products in a dry area protected from the weather on a smooth, flat, dry surface with temperatures maintained between 65° F and 85° F. The installation area, tile, and adhesive are to be maintained between 65° F and 85° F for at least 48 hours before installation, during installation, and 48 hours after the installation. Maintain room temperatures between 55° F and 95° F thereafter. **Notice:** The flooring product should be loose laid in the room or area prior to spreading of adhesive to determine the proper layout to ensure the best overall appearance. Inspect all material for proper type and color. Conduct the proper moisture emission and pH testing on the substrate. Proceed with the installation only when the conditions are proper and correct. A heat weld test should be performed on a sample piece of flooring to establish the proper requirements for a successful bond. Close the area to traffic during flooring installation. Install tiles and accessories after other finishing operations, including painting, have been completed. **Warning:** Follow all local, state, and federal standards and practices for the proper removal and disposal of flooring, adhesives, or other materials and respective safety standards for the use of all products and equipment.

### 5.2 Unitized Heat Weld Procedure

Read this entire section before proceeding. DO NOT heat weld the seams until the adhesive has cured, approximately twenty-four (24) hours after the installation of the flooring. **Notice:** Practice the welding technique by using a piece of scrap flooring to determine the temperature setting of the heat gun and welding speed to achieve a successful bond. Using an electric grooving machine, set the blade to cut the groove approximately 66% of the total thickness of the flooring (.82" deep if the flooring is 1/8" thick). During the grooving process, ensure approximately 5% of material is removed from each side of the adjoining pieces of the flooring that is being grooved. Practice on a piece of scrap flooring to obtain the proper depth. Temperature of the flooring and welding rod prior to and during installation is to be between 65° F and 85° F. It may be necessary to hand groove some of the seams using a hand grooving tool with a narrow blade near the walls or other obstacles. While grooving, pre-heat the welding gun as recommended by the manufacturer. After the grooving is complete, use a hot air welding gun, insert the Flexco® Rubber Welding Rod, .16" in diameter, through the opening of the 4mm welding tip into the center of the routed groove in the flooring. Ensure the groove and welding rod are clean and free of any contaminant that may prevent a successful bond when heat welded together. Follow the recommended welding procedures provided by the welding gun manufacturer. Begin welding at the wall and move toward the center. You can see the flooring and rod flowing together while welding if the settings are correct. Welding too slowly may char or burn the flooring. An excessive welding speed will not allow the rod and flooring to reach the proper temperature for a successful bond. Ensure sufficient downward pressure is applied to fill the groove. Work with seams in one direction at a time, cut a "V" groove in installed rod at seam intersection, and then complete the procedure in opposite direction. Allow the rod to completely cool and trim the excess rod with a clean, sharp quarter moon spatula knife with an attached clean, sharp trim plate. After one hour, perform a second trim using only the quarter moon spatula knife to create a smooth, level surface. If the heat welded seam is trimmed before it is completely cold, and/or, if the seam is first cut with only the quarter moon spatula knife without trim the trim plate, the a concave skive can result. If the welded seam is not allowed to properly cool before trimming, the welded seam can shrink and allow particulate and liquids into the seam. After trimming, carefully glazing the surface of the heat welded seam with the hot air from the gun may

smooth out any imperfections.

## **6. Technical Services**

### **6.1 Technical Assistance**

Technical service information and assistance may be obtained by calling Flexco® Customer Service or by visiting [www.flexcofloors.com](http://www.flexcofloors.com).

### **6.2 Samples**

Samples may be obtained by calling Flexco® Customer Service or by visiting [www.flexcofloors.com](http://www.flexcofloors.com).

## **7. Availability and Cost**

Products are available through Flexco® distributors. Contact Flexco® Customer Service or visit [www.flexcofloors.com](http://www.flexcofloors.com) for a list of distributors.

## **8. Limited Warranty**

Flexco® Corporation manufactures and markets its floor products under the trade name Flexco®. Flexco® Rubber Welding Rods are warranted for a period of one (1) year from date of installation to be free of defects in material and workmanship, and a five (5) year Limited Wear Warranty, if installed, maintained, and used strictly in accordance with Flexco®'s written instructions. Instructions may be obtained from a Flexco® distributor or by writing Flexco®, Attention: Sales Service Manager, P.O. Box 553, Tuscumbia, Alabama, 35674. Notice of any defect must be made in writing to Flexco® within thirty (30) days after buyer learns of the defect. No merchandise is to be returned prior to Flexco®'s inspection and written approval. Buyer's sole and exclusive remedy against Flexco® and Dealer for claims arising hereunder for any and all losses and damages resulting from any cause shall be a pro rata credit based on the period remaining in this Limited Warranty toward the purchase of new Flexco® Rubber Welding Rods. Replacement credit shall be equal to the proportion of Limited Warranty time remaining multiplied by the current price of Flexco® Rubber Welding Rods. In no event shall Flexco® be liable for incidental or consequential damages, even if some other provision of this Limited Warranty is unenforceable. Buyer waives all other claims and remedies of any nature. Flexco® shall have no liability whatsoever to Buyer in the event the goods become defective if such defect is caused in whole or part by cuts, tears, vandalism, fire, willful destruction, damage from high heels, spiked footwear, improper installation, improper maintenance, subfloor and/or substrate irregularities, accidents, natural causes, or acts of God. Flexco® will not be liable for labor costs or lost profits resulting from the use of or inability to use the product. Flexco® will not be liable for labor costs for material that is installed with obvious defects. Flexco® makes no warranties whatsoever, expressed or implied, with respect thereto, including warranties of merchantability or fitness for a particular use. *These warranties are expressly in lieu of any other warranties expressed or implied, including, but not limited to any implied warranty of merchantability or fitness for a particular purpose.* By retaining Flexco®'s merchandise for more than five (5) days after receipt of such merchandise, Buyer agrees that it accepts the terms of this Limited Warranty and that there are no warranties or rights beyond those contained herein. All claims must be made in writing and sent to Flexco®, Attn: Claims Manager, P.O. Box 553, Tuscumbia, Alabama, 35674. All claims for surface defects or variations in color or pattern must be delivered to Flexco® in writing before the product is installed. Flexco® will not accept the return of any product without prior written approval of the Flexco® Claims Department.