



BUILDING TRUST



HOT AIR WELDING GUIDELINES

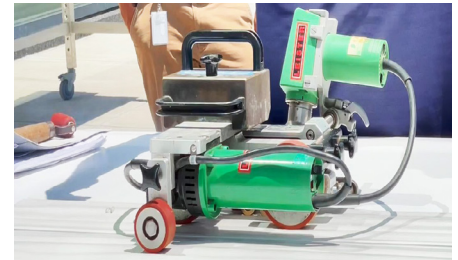
RoofJoint

Do not install this material until all members of your crew have read and understand these instructions. If you do not understand any part of these instructions CALL SIKA EMSEAL at 1-800-526-8365

Robot Welding

Long RoofJoint Flange to Roofing Membrane

- Machines designed for single-ply roofing typically work well.
- Heat should be set close to ~500°C (~932°F).
- Machine runs at 1.3-meters/minute (4.26-feet/min).
- These settings will vary depending on equipment & environment.
- It's highly recommended to calibrate and test weld at start-up.



Hand Welding

RoofJoint Flanges to Roofing Membrane

- 3/4-inch (20mm) or 1 1/2-inch (40mm) wide nozzle tips on hot air gun are effective. 3/4-inch (20mm) may produce more reliable results.
- Heat for PVC to RoofJoint PVC welding should be 400-500°C (752-932°F).
- Heat for TPO to RoofJoint TPV welding, 350-400°C (662-752°F).
- For heat calibration on welder with no specific temp reading, gun should be hot enough that, when held 1-inch (25mm) above membrane for 5-seconds, the material will melt, but not scorch/burn. Pressing the heating surface with a finger will readily demonstrate that. (Gloves recommended).
- Progress at 1 1/2-feet/minute (.46-meters/minute). Roll directly behind the tip of the hot air gun.



*Photos above shown with PVC membrane.

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