



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**

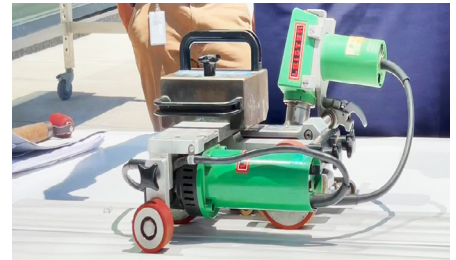
#### **Long RoofJoint Flange to Roofing Membrane**

- 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).

### **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.

**NOTE: These settings will vary depending on equipment & environment.**

**It's recommended to calibrate and test weld at start-up.**

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