

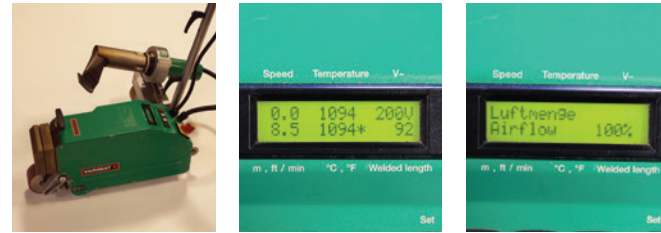
Recommended Auto-Welder Settings

EXPERIENCE THE CARLISLE DIFFERENCE



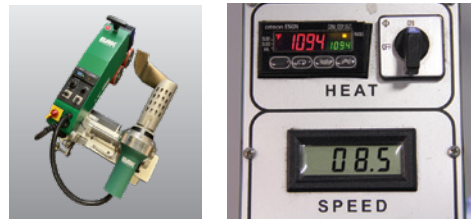
Leister Varimat

Welding Temperature	1094°F
Speed	8.5 feet per minute
Airflow	100%



BAK LarOn

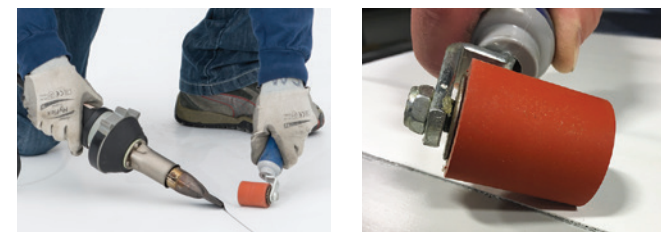
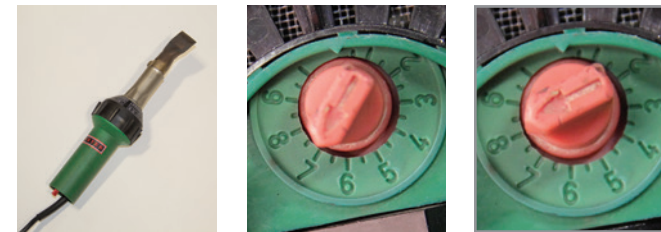
Welding Temperature:	1094°F
Speed	8.5 feet per minute
Airflow	100%



Hand-Held Welder Ideal Set-Up Parameters

Hand-Held Welder

Flashing	Set temperature setting at "7"
Membrane	Set temperature setting at "8"



CORRECT! » Hold hand roller flat to ensure proper weld.

INCORRECT!

TROUBLESHOOTING TIPS

- » Confirm Auto-Welder settings are correct
- » Confirm power supply is sufficient for welder
- » Confirm extension cords include adequate wire size for run length
- » Confirm Auto-Welder weights are in place (2 weights minimum)
- » Confirm membrane is not contaminated with dirt or moisture
- » Confirm nozzle opening and air outlet holes are not damaged or obstructed
- » Confirm air intake is unrestricted and free from debris

As a reminder, this guide is meant to address the equipment most commonly utilized in the field; however, not all products or types of welding equipment are discussed in this guide. Applicators are encouraged to contact their Carlisle Field Service Representative with any questions. **For additional information, refer to Carlisle's Spec Supplement: Heat Welding Equipment T-01-22.**



SURE-FLEX™ PVC and KEE HP WELDING GUIDE

Guide for all Carlisle PVC and KEE HP Membrane Thicknesses and Heat-Weldable Walkway Rolls

This guide is designed to provide information regarding common welder equipment settings to properly weld all thicknesses: 50-, 60-, and 80-mil Carlisle Sure-Flex PVC and KEE HP membranes, PVC heat weldable walkway rolls, and PVC flashing. As a reminder, this guide is not a substitute for good roofing practice. Test welds should be performed at the start of work each morning and afternoon using like material over the same substrate. Not all products or types of welding equipment are discussed in this guide. Applicators are encouraged to contact their Carlisle Field Service Representative with any questions. **For additional information, refer to Carlisle Spec Supplement: Heat Welding Equipment T-01-22.**

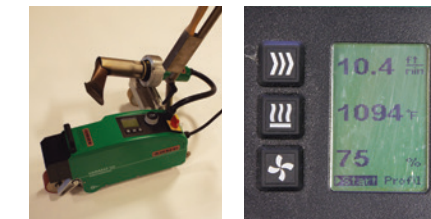
BAK LarOn 21

	Smoke Reduction	Standard
Welding Temperature	900°F	1100°F
Speed	9.5 feet per minute	13.5 feet per minute
Airflow	100%	100%



Leister V2

Welding Temperature	1094°F
Speed	10.4 feet per minute
Airflow	75%



Carlisle's Best Practices

EQUIPMENT SETUP

Use Proper Generators

Use commercial-grade generators only.
Required generator wattage follows:

- » 6,500 watts – 1 Auto-Welder
- » 3,000 watts – 2 Hand-Welders



Use Proper Gauge Extension Cords

- » Auto-Welders: 10 Gauge Wire- 100' maximum length
- » Hand-Welders: 12 Gauge Wire- 100' maximum length

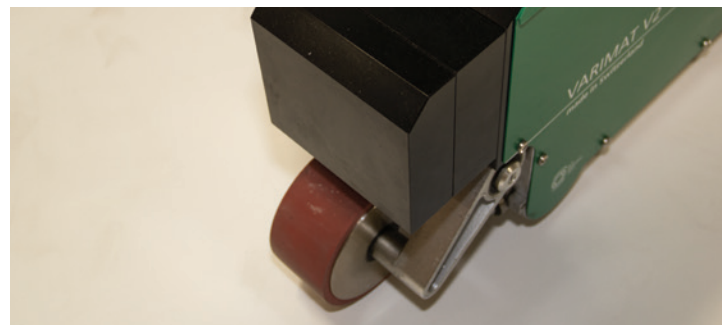


10 GAUGE WIRE

12 GAUGE WIRE

Auto-Welder Weights

- » Confirm weights are in place when using the auto welder (minimum 2 weights as shown).



CRITICAL WELDING STEPS

Conditions That Affect Welding Set-Up Parameters:

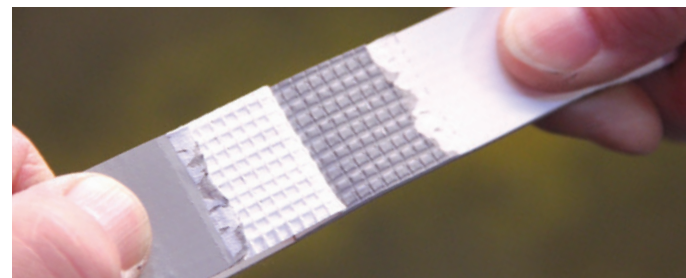
- » Cold/hot ambient temperatures
- » Sun versus shade
- » Substrate – i.e. concrete vs. polyiso insulation
- » Level of wind

These conditions may be alleviated by varying the speed of the welder to adapt to environmental factors.

Check Test Welds Several Times Per Day:

- » Weld splice with recommended welder setting
- » Cut 1" wide splice sample across the seam
- » Pull 1" wide sample until failure

Note: MUST BE COMPLETELY COOL



GOOD WELD



BAD WELD

To Repair Aged and New Sure-Flex PVC and KEE HP Membrane

1. Clean all residue from the weld area utilizing PVC and KEE HP Membrane Cleaner and a Splice Wipe or clean natural fiber (cotton) rag
2. Weld the new membrane to the cleaned area using standard welding procedures.



If membrane becomes dirty during initial installation, Sure-Flex PVC and KEE HP Membranes can be cleaned using a Splice Wipe and PVC and KEE HP Membrane Cleaner.

Welding for Step-offs

1. Crease membrane into step-offs
2. Use 2" silicone roller
3. Complete immediately after auto-welder crosses seam intersection

Note: Prevents formation of a water channel

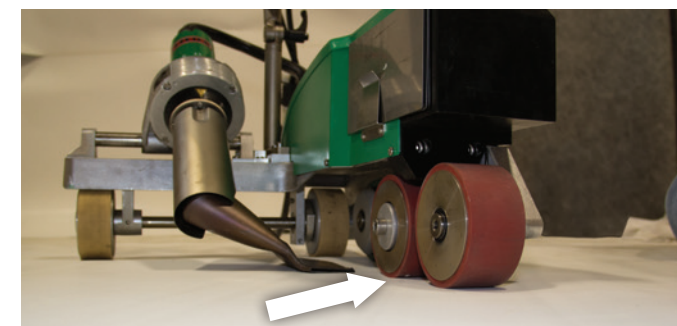


Probe All Seams at the End of Each Day



Inspect Silicone Pressure Wheel

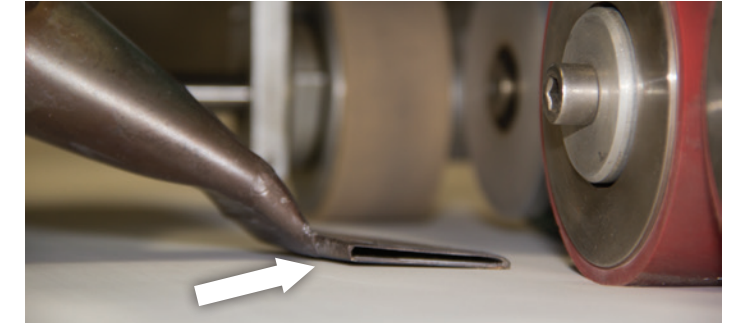
- » Regularly inspect silicone pressure wheel cover to ensure a fully intact wheel with no damage. Damaged silicone wheel will affect the integrity of the weld.



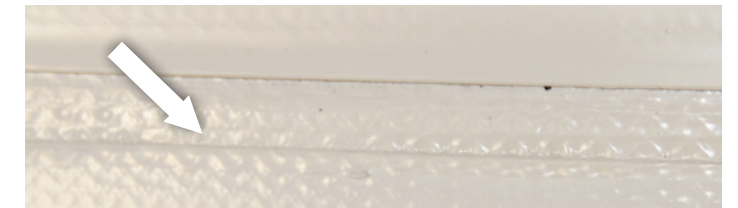
WELDER MAINTENANCE

Ensure Proper Nozzle Adjustment

- » Make sure you rotate the nozzle to eliminate heel drag



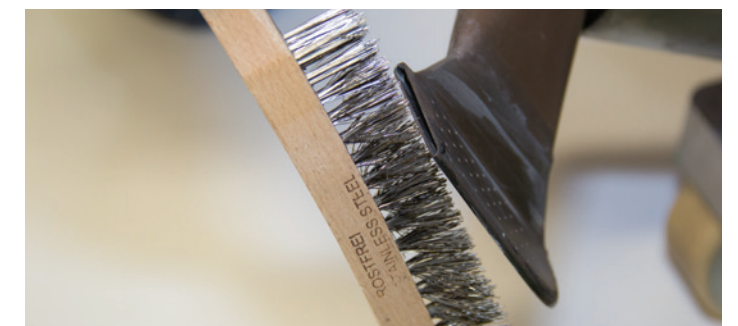
CORRECT!



INCORRECT. HEEL DRAG CAN CAUSE DAMAGE TO MEMBRANE.

Clean Nozzle Regularly with Brass Wire Brush

- » Confirm air outlet holes on top and bottom of nozzle are unobstructed.



Keep Air Intake Free From Debris

- » Clean dirt and debris from heat gun air intake daily. This allows for maximum airflow.



DIRT AND DEBRIS IN INTAKE



CLEAN INTAKE