

Market: **Means of Transport**  
Object: **Laying and Hot Sealing Procedure**

**ARTIGO-MONDO rubber flooring**

Installation of rubber flooring in rolls with adhesive (permanent bonding).

**General recommendations.****Before laying rubber flooring:**

- a. Check the suitability of the substrate (flatness, resistance, strength, absence of cracks, of holes, of grease or oil, etc.)
- b. The surface of the substrate shall be clean, flat, plane, smooth (restore and smooth where needed).
- c. Clean carefully the substrate and the whole area of the installation.



1. The temperature on the installation area and the support should not be less than 15°C for at least 48 hours before the laying operation.

The humidity must not be above 70%.

At least 24 hours before beginning the work, you are advised to store the materials in the laying area, to obtain the laying temperature.

The sheets should be unrolled and left to rest flat before cutting and laying them.

The presentation of the material simulates the final effect, allowing you to check the regularity of the color across the entire surface.



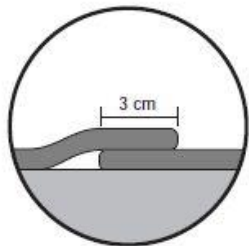
**Never mix floor covering of different batches in the same vehicle to avoid variation in colour and/or pattern.**



2. Spread out the sheets to carry out the longitudinal trimming.

Before trimming, check the overlap is sufficient to eliminate any thinning or accidental side deformation of the material.

If necessary, trim a roll using a steel template, then use the trimmed roll as a template for the adjacent roll.



3. After the side trimming, fix the rolls with the help of an adhesive tape (not too sticky as it must not leave any glue on the surface of the rolls; paper tape is suitable).



4. After rolling up a part of the roll according to the longitudinal axis of the carriage, clean the substrate again to ensure the removal of any debris created by the trimming or other means.

**Vacuum clean the subfloor and the back of the floor covering before applying the adhesive.**



5. Spread the recommended adhesive using a suitable trowel of about 1mm height (code A1) respecting the adhesive's open time and all adhesive's instructions. Make sure the adhesive is transferred properly to the backside of the floor covering,

For metal supports, you are advised (when the trowel is new) to file the ends in order to further reduce the quantity of adhesive, which is about  $300 \text{ g/m}^2$ .

This is enough to anchor them, and also allows you to avoid any denting during the laying phase, always avoid any smudging or use of excess adhesive.



6. After carefully unrolling the roll on the part of the floor with the adhesive, press onto the floor surface with a suitable cork board to ensure the adhesive is uniformly transferred from the substrate to the back of the sheet.

If you are using a polyurethane adhesive, it is a good idea to hold a large spatula in your free hand, to avoid accidentally resting your weight on the newly adhered surface

It is better not to tread on the freshly glued materials: you are advised to use loading tables, as shown in the photo.





7. Check the fit of the joint between the rolls.

Immediately load the longitudinal and head joints of the sheets with suitable weights; to guarantee perfect fit/levels and to better distribute the weight on the joints, we recommend you place off-cuts from sheet trimming between the weights and the newly laid floor.

When reaction adhesives in “two components” are used, it is recommended not to use rollers to press down the floor covering in order to avoid the formation of bubbles. Carefully press by hand the floor covering with a cork board.

The flooring can be normally walked 12/24 hours after the completion of the laying (please check with the adhesive instructions).



**When the installation is complete, make sure the floor covering is duly protected and covered with proper sheeting until final inspection and approval to avoid damages from other works in the vehicle.**

### Hot joint-sealing of Artigo-Mondo rubber flooring

- Flooring seams to be sealed with Artigo-Mondo hot welding rods.

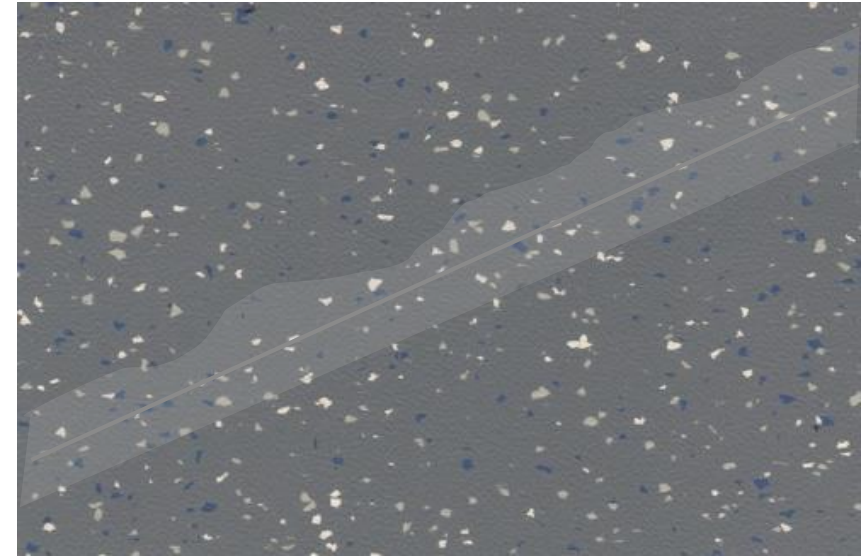
#### Tool checklist:

- Electric grooving machine or hand groover.
- Manual hot-air welding gun or automatic electric welding machine (teflon pressing wheel).
- Sharp crescent-shape knife with trimming slide (or Mozart weld rod trimming tool).
- Artigo-Mondo welding rod.

- A. With the aid of a rag spread a layer of liquid detaching agent (neutral wax type) over a width of ca 2 cm on the joints to be sealed.

The detaching product is used to remove sealing rod burrs from the surface and facilitate the trimming of the rod with the crescent-shape knife without cutting into the rubber surface.

Warning: the detaching agent must be applied before the grinding process is performed to prevent it from penetrating into the grooves, as this would undermine weld rod anchoring.

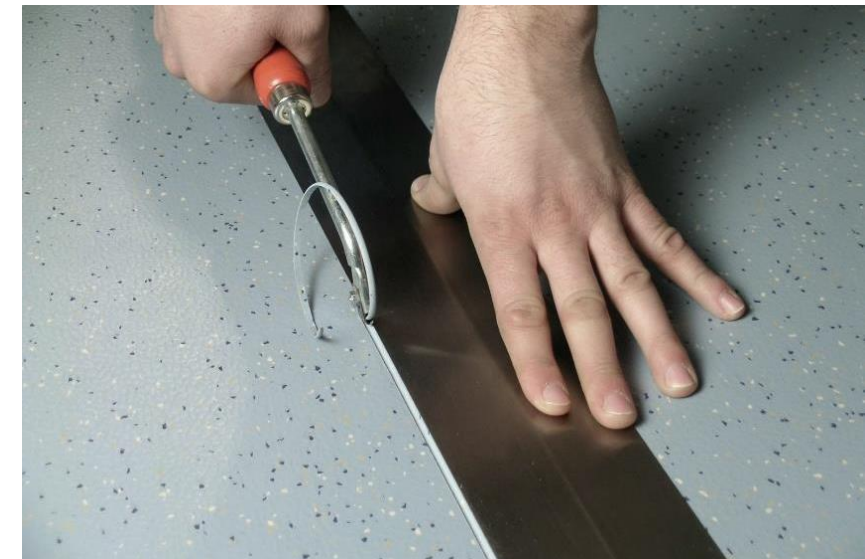


- B. Mill out the joints with the groover (round edge blade improves weld rod adhesion).

Finish off the grooves along the wall manually using a manual tool.

The width of the ground part must be ca 3.5 mm and recommended depth is 1.5 to 2 mm depending on the thickness of the material.

Clean thoroughly, eliminating dust and grinding residues.



- C. To achieve correct seam sealing, the rod must melt and slightly flow over the edges of the groove. The manual sealer must be equipped with a fast sealing nozzle.

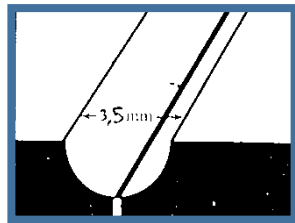
The temperature of the hot-air gun shall be selected and adapted on the base of the real conditions of use (floor to be sealed, sealing speed, air moisture, rod colour, etc), normal ranges can be 350/500 °C.



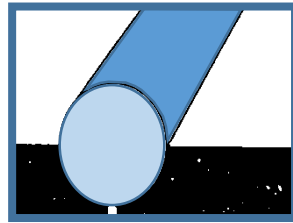
- D. Make a first cut with the sharp crescent-shape knife over the trimming slide (Mozart weld rod trimming tool with the distance sledge can also be used).



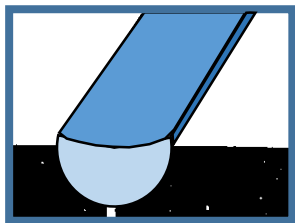
E. Make the final cut using the sharp crescent-shape knife without the trimming slide (or use the Mozart weld rod trimming tool without the distance sledge). Cutting the rod in two runs will achieve superior surface finish by reducing shrinkage of the material.



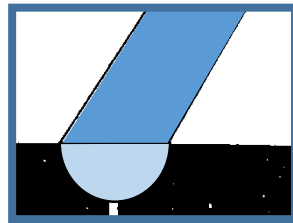
B - groove



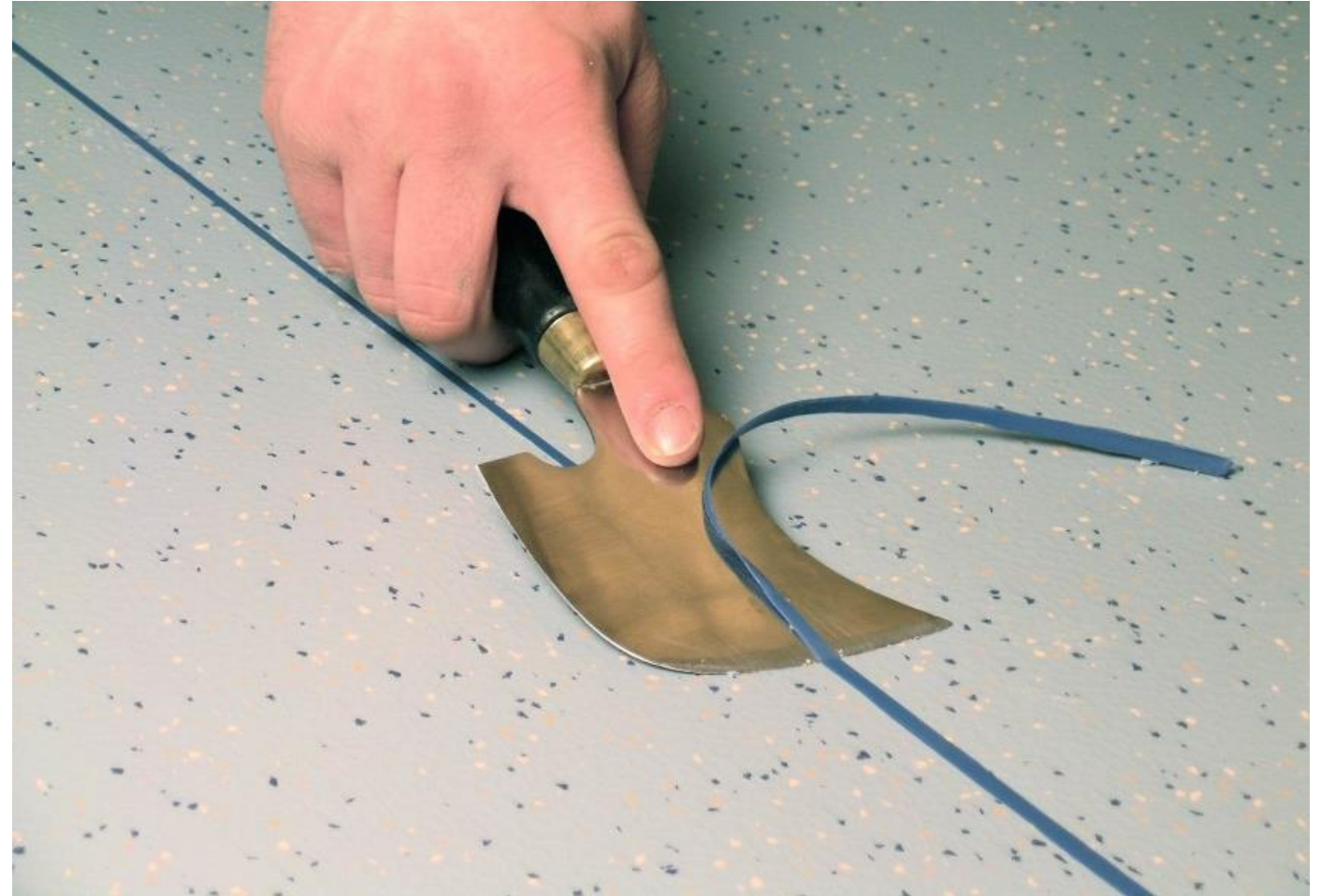
C - sealing



D - trimming with slide



E - final trimming



**LAYING AND WELDING TOOLS**  
 (JANSER Catalogue - [www.janser.com](http://www.janser.com) )

JANSER codes	Description
<b><u>Preparation for laying</u></b>	
112 455 000	Lapping machine, model type 135 SH
113 700 000	Extractor fan MULTI-VAC
112 317 000	Two-sided abrasive disks – grain no.100
111 231 000	Manual mixer with continuous adjustment
161 163 000	Agitator MM115
262 331 000	Spatula with interchangeable blades 18cm
262 316 000	Two-sided tothing inserts A1 of 18cm
<b><u>Laying</u></b>	
262 059 000	Silver-grey knife with case
262 059 600	Silver blade dispenser (without blade)
262 039 500	Half moon blade
262 038 500	Straight blade 60mm
262 231 100	Flexible convex T-square – 210cm
262 378 000	Expander hammer
262 380 000	Cork spatula
<b><u>Sealing of joints</u></b>	
223 870 000	Milling machine for joints, GROOVER type
223 800 030	Blade for semicircular milling machine
262 605 000	Manual bracketed grouting machine with 5 blades
224 819 000	Manual welder, LEISTER-TRIAC S type, complete with accessories
224 700 100	Nozzle for quick welding, 4-5mm diameter
262 621 000	Quarter moon knife
262 624 000	Leather case for quarter moon knife
262 625 000	Guide for quarter moon knife

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