PROCESSING INSTRUCTIONS

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TYPE A – PVC-Cold-Welding Liquid
TYPE C – PVC-Cold-Welding Paste

44 g / 132 g

Only suitable for PVC-Floor Coverings / PVC-Wall Coverings and PVC-Wallpapers.

Use TYP T for PVC-Floor Coverings with textile backing.

For inside use only!

1. Important details

1.1 Please note

Please read the processing instructions before cutting and laying the PVC-floor covering!
Flooring works have to be carried out professionally and properly according to the specifications and recommendations of the floor covering- and adhesive-manufacturers. The details in this manual are based on our up-to-date knowledge and experiences. They do not set the installer free from own tests and checks, because of the mass of possible influences during handling and application. A legal and firm assurance regarding certain characteristics or applicability for a precise intend of use cannot be derived from our specifications. Use products only for the application as described in this working instruction!

1.2 Risk and safety Information

Contains: Tetrahydrofuran (75–95 %), CAS-Nr.: 109-99-9; PVC (5–25 %)

Danger. Highly flammable liquid and vapour. Harmful if swallowed. Causes serious eye irritation. May cause respiratory irritation. May cause drowsiness or dizziness. Suspected of causing cancer. May form explosive peroxides. If medical advice is needed, have product container or label at hand. Keep out of reach of children. Do not handle until all safety precautions have been read and understood. Keep away from heat, hot surfaces, sparks, open flames and other ignition sources. No smoking. Keep container tightly closed. Call a POISON CENTER/doctor if you feel unwell. Wear protective gloves/protective clothing.

Precautionary we recommend the use of safety gloves approved for Tetrahydrofuran for the prevention of skin contact (splash protection), e.g. Dermatril® P (Manufacturer: KCL) out of nitrile rubber, category III (EN 374), thickness of at least 0.2 mm, permeation time of approx. 2 min. These can be purchased at specialised trade shops for laboratories or at pharmacies.

Avoid breathing in of solvent vapors. Avoid contact with eyes and skin. During working ensure good ventilation / fresh air. Do not eat, drink, or smoke while working. Wash hands thoroughly after use.

To avoid injuries caused by the needle of tube TYPE A, please always close the tube by means of the lock cap when work is finished or interrupted!

1.3 First Aid Measures

Immediately remove contaminated clothing. If danger of loss of consciousness, place patient in recovery position and transport accordingly; apply artificial respiration if necessary. Helper pay attention to your own safety. If inhaled, keep patient calm, remove to fresh air; summon medical help if necessary. On skin contact, immediately wash thoroughly with plenty of water and soap; consult a skin specialist if necessary. On eye contact, rinse cautiously with water for several minutes. Remove present contact lenses if possible. Continue rinsing. If eye irritation perisists: get medical advice/attention. On ingestion: rinse mouth immediately and drink plenty of water. Do not induce vomiting, seek medical help if needed.

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1.4 Storage, handling and durability

Products are always to be kept dry, free of frost and not stored above 30 °C. Best temperature for use is from 16 to 25 °C. Close tube always tightly and wind it from the fold onwards. The last digit of the 6-digit code on the fold of the tube shows the year of manufacture, both digits before the last one show the month. The durability lasts 3 years from the date of manufacture (see fold of tube) if storage conditions are kept as described above.

1.5 Disposal

Give empty tubes and packaging for recycling.

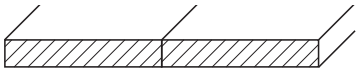
Hardened product remainders = Household-/Industrial waste. *European-Waste-Code: 08 04 10.*
Not hardened product remainders = Hazardous waste. *European-Waste-Code: 08 04 09.*

1.6 Manufacturer

Werner Müller GmbH
Rudolf-Diesel-Straße 7 · 67227 Frankenthal, Germany
Tel.: +49 (0) 62 33 / 37 93 - 0 · www.mueller-pvc-naht.de

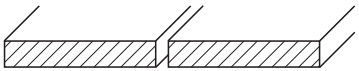
2. Which TYPE for which task?

TYPE A
PVC-Cold-Welding Liquid



Sketch 1: closely cut seam
– double cut – (see chapter 4)

TYPE C
PVC-Cold-Welding Paste



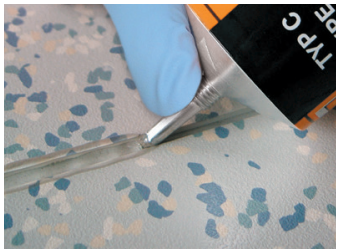
Sketch 2: gaps from 0.3 – 4 mm
– repair works – (see chapter 3)

3. PVC-Cold-Welding with TYPE C

Precautionary we recommend the use of safety gloves approved for Tetrahydrofuran for the prevention of skin contact (splash protection).

3.1 Gaps from 0.3 – 4 mm (Repair Works)

Clean the seam area (glue remainders, dirt et cetera); fix lose seams onto the ground. Go through the seam with the tube and dose the PVC-cold-welding paste in such a way that the gap is filled entirely. For smaller gaps use the aluminium nozzle which is included. Remove the plastic stopper; it is meant for cleaning the nozzle. The volume of the applied paste reduces about 75 % while drying. Depending on the width of the gap and the thickness of the floor covering the curing time is from 2 to 12 hours. The process can be repeated every 2 hours, in case the gap is not filled entirely after drying. Swellings in the seam area of the PVC-floor covering will decrease.



3.2 PVC-Wallpapers

PVC-Wallpapers can be welded by using the aluminium nozzle which is included. Remove the plastic stopper; it is meant for cleaning the nozzle. Bring the aluminium nozzle evenly and centred onto the seam and apply the PVC-cold-welding paste steadily, working from top to bottom alongside a straightedge. The volume of the applied paste reduces about 75 % while drying, therefore do not wipe off any paste but let it dry (about 30 minutes).

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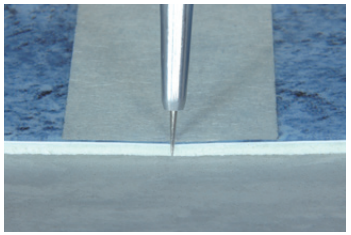
4. PVC-Cold-Welding with TYPE A

4.1 Explaining the Procedure



The patented needle system opens the seam area briefly and the cold-welding liquid runs along the needle into the whole cross section of the seam. The adjacent edges are moistened by the cold-welding liquid, temporarily dissolved and melted together, becoming strong and durable after a short period of time.

4.2 Proceeding with TYPE A

The overlapping laid floor layers (3 to 5 cm) will be cut in one step alongside a metal bar (double cut).

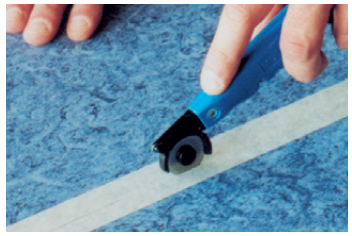
After the double cut remove the cut-offs of the upper and lower layer.

In case the PVC-floor covering is not glued holohedral on the floor (please consider the manufacturers recommendations), the seam area has to be fixed to the surface by using a proper double-sided adhesive tape. Press the floor layers, which have to be laid tightly, firmly onto the double-sided adhesive tape.

Clean the seam area and fix a **special**, even masking tape (article no. 50000), which is resistant against our cold-welding liquid, centred over the closely cut seam. This is absolutely necessary to avoid damage to the floor finish (e.g. made of Polyurethane) of the floor covering.

For user videos see: www.mueller-pvc-naht.de

Press the **special** masking tape firmly to the PVC-floor covering by using a seam roll (article no. 50020), ensuring that no cold-welding liquid penetrates beneath the masking tape.



Easily cut the masking tape with the rolling knife (article no. 50010) in the seam area. Alternatively a straight blade or a hook-blade can be used. It is important not to damage the edges of the floor layers while cutting the tape. This can be done effectively by pressing the knife deeply into the seam, resulting in a good guidance.

7. In case of hard and little flexible PVC-floor coverings (for instance Commercial Floor Coverings) warming up the seam area (to a maximum of 40 °C by using a blow dryer or an iron) before welding enables an easier and more even guidance of the needle in the seam.

Precautionary we recommend the use of safety gloves approved for Tetrahydrofuran for the prevention of skin contact (splash protection).

Shake the tube well before use. While opening the tube (screw-top facing upwards) make sure that no cold-welding liquid reaches uncovered areas of the floor covering. Clean the nozzle and the needle before use with a clean cloth. Always work with both hands! Hold the tube in such a way that the forefinger of one hand is on the nozzle and the other hand holds the tube. Press the needle **deeply** into the seam, so that the cold-welding liquid can flow into the forming opening. Go through the seam area steadily and control the rinse of the cold-welding liquid by lightly squeezing the tube. The dosage of the cold-welding liquid is at its best if an approximately 5 mm wide moistening in the form of a closed film appears on top of the masking tape.

After about 10 minutes the cold-welding liquid on the masking tape is dry and the tape has to be removed steadily backwards at an angle. Swellings in the seam area of the PVC-floor covering will decrease. The result is a barely perceivable seam with a high seam tensile strength. The seam can be walked on after about 30 minutes.