

### **Application Method for Other Accessories**

1. Make sure that all surfaces are dry and clean.
2. Position the accessory so that it can be easily worked on.
3. Position the welding nozzle between the flashing of the accessory and the ***hertalan*** and make sure the weld is a min 35mm.
4. During welding apply pressure to the joint with a silicone roller plus a brass roller around bonded joints, do not forget to apply the extra TPE strip.

### **Notes:**

- Do not use ***hertalan*** easy.weld for corners of skylights etc. as this can cause tension in the membrane.
- ***hertalan*** easy.weld can only be used with ***hertalan*** membranes manufactured after March 1997.
- Clean the welding nozzle regularly with a steel brush.
- Do not use ***hertalan*** ks87 as sealant for ***hertalan*** easy.weld joints.
- Do not apply ks 137, ks 143 or ks2000 to ***hertalan*** easy.weld.
- Do not use oily products for cleaning ***hertalan*** or ***hertalan*** easy.weld i.e. paraffin always use water or where necessary methylated spirits.
- Do not use ***hertalan*** easy.weld on and/or over joints made with ks137, ks87 or ks2000.

## **Application Method for CS Strips**

### **Tools**

- ✓ To apply ***hertalan*** easy.weld CS strips, use a Leister Triac or similar machine set to a temperature of 580°
- ✓ The Leister machine should be fitted with a special ***hertalan*** easy.weld welding nozzle as this is specifically designed for this application, other nozzles should **not** be used under any circumstances
- ✓ Pressure should be applied to the joint as welding proceeds with a 40mm silicone roller, in addition where "T" jointing is required a 5mm wide brass roller should also be used

### **Procedure**

1. The ***hertalan*** membranes and the ***hertalan*** easy.weld must be clean and dry.
2. Where it is necessary to join 2 ***hertalan*** membranes together using ***hertalan*** easy.weld, the membranes can be either butt jointed or overlapped, where overlapping is used the hot-bonded joints should be staggered.
3. The joint in the membranes should always be placed in the centre of the ***hertalan*** easy.weld CS strip.
4. Start by spot welding the ***hertalan*** easy.weld strip every metre
5. Position the welding nozzle between the ***hertalan*** membrane and the ***hertalan*** easy.weld CS and move the hot air gun down the length of the joint, this will melt the TPE and must give a joint of at least 35mm wide.
6. During welding pressure must be applied to the ***hertalan*** easy.weld with a silicone roller 40mm wide, this process is identical to techniques used with PVC or Hypalon materials.
7. The welding can be checked visually as work proceeds and should have a small green bead of TPE emitting from the seam, if the bead is too big then increase the rate of advance, **do not alter the temperature.**
8. Where "T" joints are necessary, take care around any hot bonding joints, in addition to normal procedures, place a narrow strip of pure TPE in the hot bonding joint (supplied with each roll of ***hertalan*** easy.weld) and remember that additional work with a brass roller is always required in such situations

## **Joint Inspection**

Do not inspect the ***hertalan*** easy.weld joint until it has completely cooled down, inspection/testing can be carried out with a blunt awl or similar.

## **Chapter 13**

## **hertalan easy.weld**

**hertalan easy.weld** is a combined product of **hertalan** EPDM with a green coating of TPE (Thermoplastic Elastomer), easy.weld is supplied in strips and the green TPE coating will ensure a permanent bond when heated with hot air. **hertalan** easy.weld is quick and easy to apply and does not contain solvents.

**hertalan easy.weld** is available as follows:

- ✓ **hertalan** easy.weld Basic and MF sections. These have a strip of TPE on one edge both top and bottom but on alternate sides, easy.weld Basic is suitable for ballasted and adhered roofing systems with sheet widths of 1400mm. and easy.weld MF is suited to mechanically fixed roofing systems and is available in widths of 1200 and 1700mm.
- ✓ **hertalan** easy.weld CS strips are available in widths of 100, 150 & 200mm. The underside of these strips is covered entirely in TPE.
- ✓ **hertalan** easy.weld rainwater outlets have the same dimensions as standard pre – fabricated outlets but are supplied with a TPE layer for hot air welding.
- ✓ **hertalan** easy.weld pre–fabricated internal, external and skylight corners, roof drains and sealing rings are also available with TPE layers.

### **Application Methods**

#### Tools

1. For application of **hertalan** easy.weld products hot air guns are required, we recommend the use of Leister Varimat or Triac machines set at position 9 or 580°C

#### Procedure

1. The **hertalan** easy.weld sections must be clean and dry.
2. Lay the **hertalan** easy.weld sections with the two TPE strips on top of each other
3. Position and fix the **hertalan** easy.weld sections together by spot welding
4. Place the welding nozzle between the two TPE layers and move along as the TPE melts
5. During welding check that the welding speed is correct, this is confirmed by a small bead of TPE coming out of the seam. **Do not change the temperature settings!!**
6. If it is necessary to make “T” joints or where transition is required between two roof sections, always reinforce the joint with **hertalan** easy.weld CS