



TB0002

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# Technical Bulletin



## **ROBERTS HEAT BOND SEAMING TIPS**

Making a perfect seam is one of the most demanding tasks for the flooring installation craftsman. It is important to remember that the visibility of seams will vary with each type of carpet, and that carpet seams cannot be guaranteed to be invisible.

### **TIPS FOR REDUCING SEAM PEAKING**

- Stretch the carpet tighter in the direction parallel to the seam, and a little less in the direction perpendicular to, or across, the seam. This will relieve pressure in the seam, and reduce peaking.
- Use high quality seaming tape such as Roberts Max 500, GT 350, or XTRA 340 Heat Bond Tape.
- Locate the seam away from a window, glass door or other strong light source, where light may cast a shadow across the seam. Even the smallest peak will be accentuated and become more noticeable.

### **MINIMIZING SEAM SPLITTING**

- Placing the seam in the proper location is the best way to avoid seam splitting. Avoid high traffic and pivot areas where the constant up, down, and twisting movement will increase the likelihood of a split.
- Use a low profile, high-density cushion such as a 10-lb. ¼" pad under the carpet. This minimizes the up and down movement at the carpet seam, and the likelihood of splitting.
- Make sure you have complete adhesive transfer to the carpet backing. Press the carpeting into the melted adhesive. Using a seam roller to assure complete transfer.
- When seaming, place a seaming board, such as ¼" thick plywood, beneath the seaming tape. This will create a firm, flat base to help force the adhesive into the carpet backing.

### **PREVENTING SEAM UNRAVELING**

*(Seam unraveling can result in a dangerous tripping hazard as well as an unsightly seam.)*

- Cut cleanly between the rows of carpet tufts with Roberts' 10-146 or 10-152 Loop Pile Cutter to avoid fraying and shearing of the tufts.
- Seal the carpet edges with Roberts 8015 (7015) Seam Sealer or 8502 (0502-USA, 812-Canada) Carpet Latex. Press the seam sealer into the raw edge at carpet to bind the carpet tufts to the backing. This is the only way to prevent seam unraveling and delaminating. See TB003 for more detail.

### **PREVENTING SEAM DISCOLORATION**

- The most common cause of discoloration is a seaming iron that is too hot. Roberts 482G Air Cooled Heat Bond Iron is the optimum solution. It features a double heat shield that reduces the temperature of the top shield, which comes in contact with the carpet backing. Iron setting should be at 3 or 4. If using non cool-top irons, use a plastic heat shield to shield polypropylene carpet backings from excessive heat.
- Always seam with the direction of the nap. Seaming against the grain can reverse the pile in the seam area. This area will reflect light differently than the rest of the carpet and appear discoloured.
- Metal trays and other weights constructed of plastic, glass, marble, etc. prevent residual heat and moisture of freshly made seams from escaping. Trapped heat can cause carpet tufts to lose their pre-set twist and trapped moisture can cause tufts to swell, resulting in discoloration and pile reversal. Use a seam weight that is designed to absorb and release built up heat and moisture.

**PREVENTING UNSIGHTLY SEAMS.**

- Using a row finders, such as Roberts' 10-517, open a row. Be sure to cut only between the rows, and change to a new, sharp blade often.
- Pre-stretch the seam area of the carpet. Seams made with heat bond tape will not stretch at the same rate as the carpet. Failure to pre-stretch the seam may cause wrinkles adjacent to the seam.
- Use a smooth surfaced roller such as Roberts 10-102 on a plush carpet to disperse the hot melt adhesive evenly up into carpet backing. Rollers with star wheels may leave indentations in the carpet that can't be repaired. However manufacturers recommend these rollers for some Berber carpets as well as glue down installations. Remember, smooth for hot seams, star for cold seams.
- Always discuss the seam location with the customer prior to installation. An agreement should be obtained before any work starts.

**HEAT BOND TAPE APPLICATION CHART**

Roberts manufactures a full range of quality Heat Bond Tapes designed to perform on every type of carpet installation --from the lightest residential to the heaviest commercial installation. No matter what your carpet installation requirements, Roberts has the tape that's right for you.	VARIOUS CARPET BACKINGS (New & Existing)					Double-Bond (Action-Bac®, Jute, Woven, AdBac®, SoftBac®, U.P.S.®, Lifespan®)	R – Recommended H – High Traffic M – Moderate Traffic L - Light Traffic N – Not Recommended
	Lifespan® (Polyurethane Coated)	Polypropylene Backed (Action-Bac®, AdBac®, SmartBac®)	Jute	SoftBac® (Shaw)	Woven (Axminster, Wilton, Knitted)		
	H	H	H	H	H	N	<b>50-500</b> Max GT
	R	R	R	R		N	<b>50-360</b> 6" Wide Bead
	H	H	H	H	H	N	<b>50-350</b> Premium GT
	M	M	M	M	M	N	<b>50-340</b> Xtra +
	H	H	H	H	H	N	<b>50-330</b> Super GT (Foil)
						R	<b>50-325</b> Doublebond Tape
	M	M	M	M	L	N	<b>50-315</b> Deluxe GT
	L	L	L	L	L	N	<b>50-305</b> D.I.Y.(Step-On)-CN <b>50-090</b> - USA
		L	L	L	N	N	<b>50-240</b> XTRA Value
	M	M	M	M	L	N	<b>50-9T</b> Max Track, 9 Bead
	H	H	H	H	H	N	<b>50-11T</b> Max Track, 11 Bead

**ROBERTS HEAT BOND TAPE FEATURES:**

**HIGH PERFORMANCE HOT MELT ADHESIVE**

- Environmentally safe, 100% pure adhesive for maximum bonding strength(no fillers). Virtually odorless when used with a clean iron.

**HIGH QUALITY PAPER**

- High quality, release treated paper that moves with the carpet and won't stick to the pad.
- Lay-flat paper that is heavy and ultra quiet – eliminating crinkling underfoot and unsightly wrinkling at the seams.

**PATENTED TUFF-LOCK® SCRIM**

- Completely surrounded by adhesive for flexible strength - guaranteed not to split.
- Designed with a perfect 90° alignment of yarn to reinforce and strengthen the scrim and prevent from moving under pressure.
- Scrim won't lift off paper. It stays in place when you iron it.
- Colored center yarn for easy, accurate alignment under seams.