

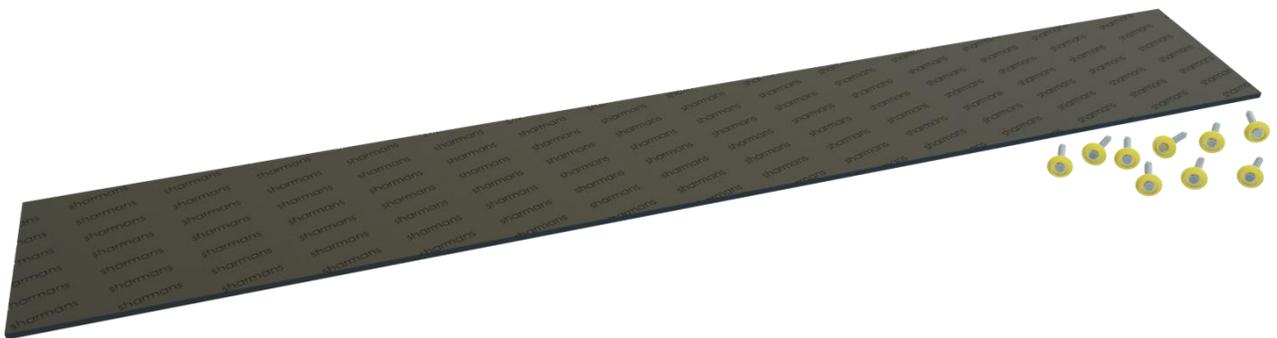
LJWS Fitting Guide

Welded Liner Joint Sealing Kit



Kit Contents

- 200mm Wide Weld Strap
- Anti-Puncture Yellow Capped Fixings



If you require any further support during your installation, please feel free to Contact the Technical Team on 01298 812371 - Alternatively, you can email us at technical@hdsharman.co.uk using your order number as the subject.



Weld Strap Size Guide

Weld Strap is supplied in set widths in line with the Plygene width brackets.

The below table outlines the widths and fixing quantities.

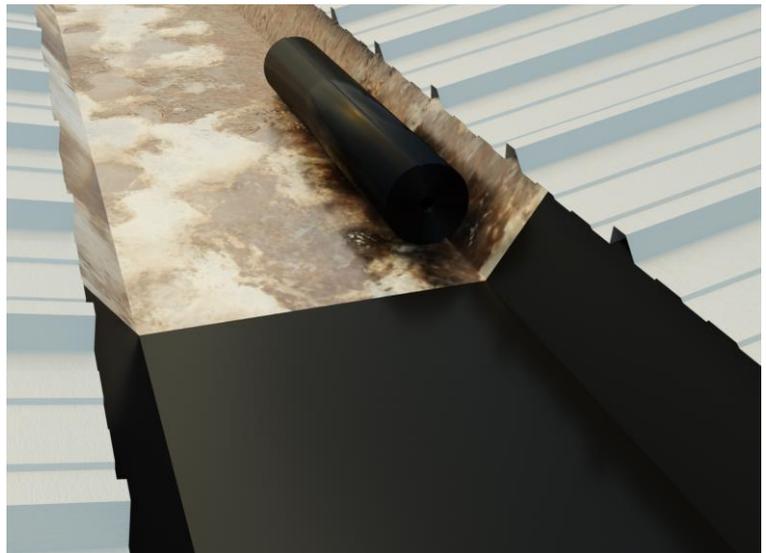
Plygene Width	Weld Strap Size	Fixings Quantity
< 460mm	460mm	5
460 - 710mm	710mm	7
710 - 890mm	890mm	9
890 - 1070mm	1070mm	11
1070 - 1370mm	1370mm	14
1370 - 1525mm	1525mm	15
> 1525mm	Custom	Custom



Please note: The quantities supplied are calculated during the order process by the Sharman's team to ensure the correct amount.

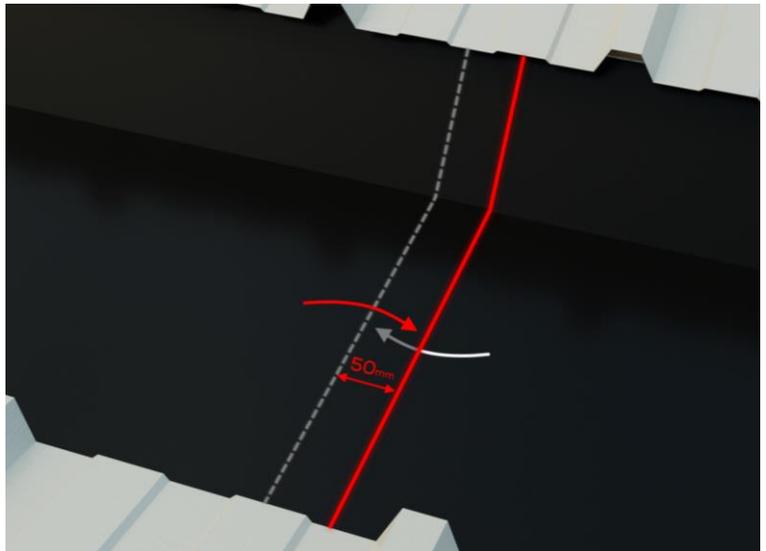


Install the Plygene Liners up to the area where the joint will be made.



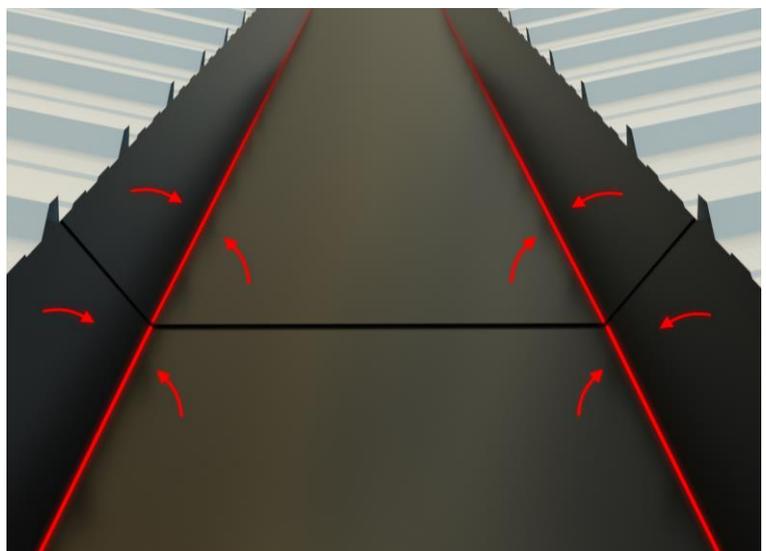
Overlap the two lengths of Liners, so that one is lay on top of the other.

Ensure a minimum of 50mm overlap is present.



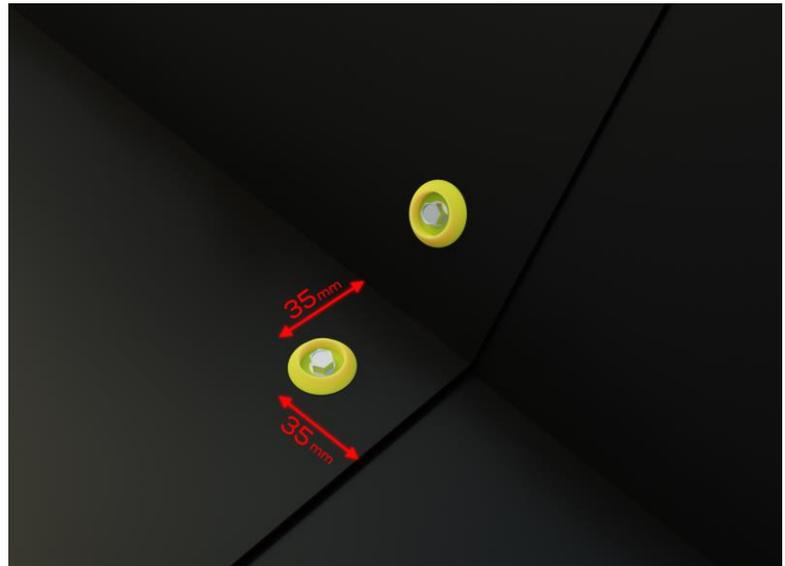
Fold the Plygene liners firmly along their crease lines.

Ensure the liners are flush to the profile of the Gutter.



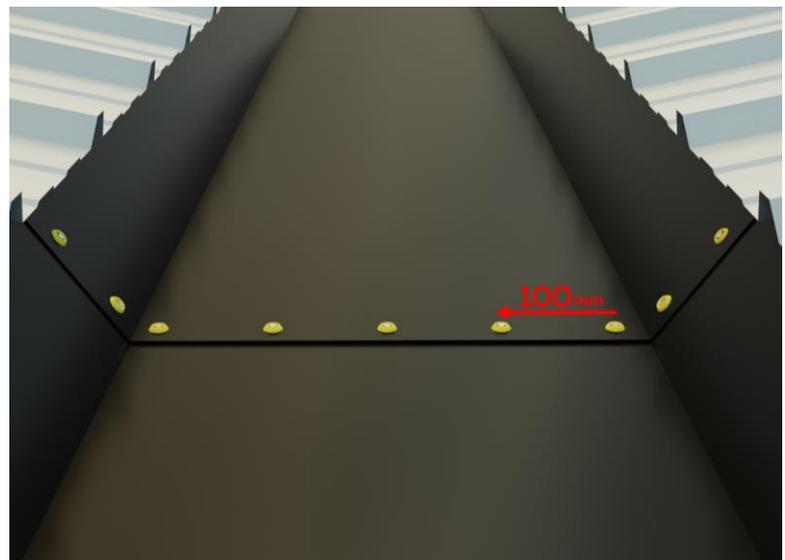


Using the supplied Yellow Capped Fixings apply fixings 35mm about the crease line, positioned 35mm away from the leading edge.



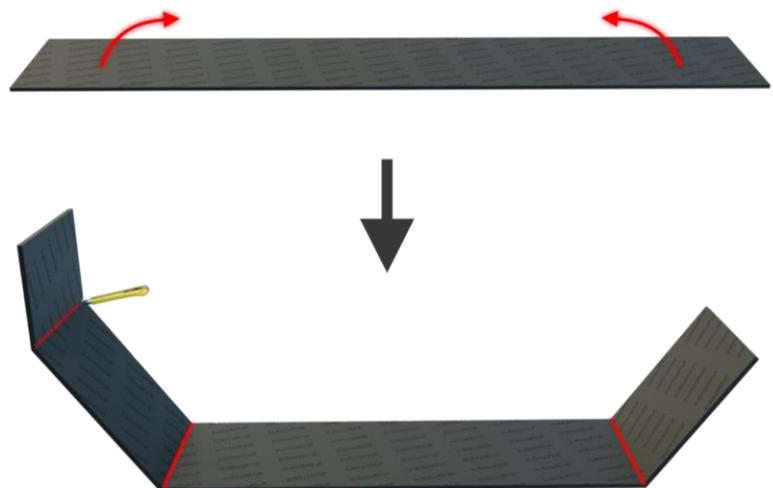
Apply Yellow Capped Fixings at 100mm centers to complete fixing the Liners.

Maintain the 35mm distance from the leading edge of the liner – to result in a straight line of fixings.



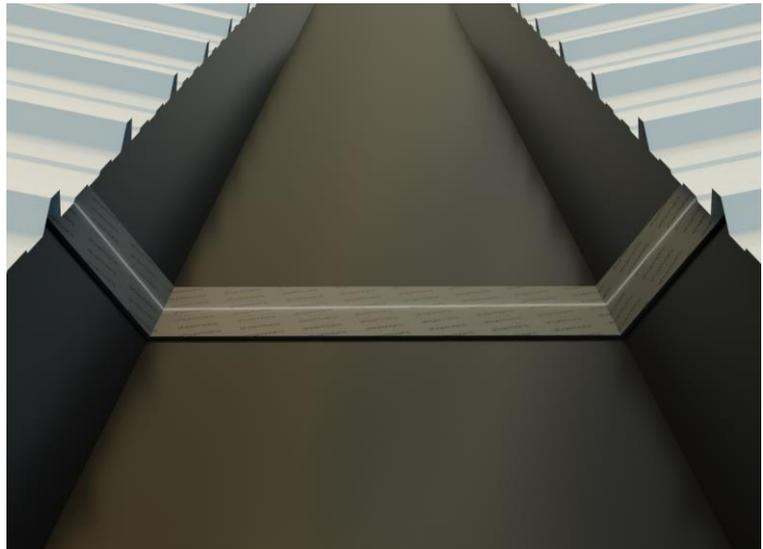
Crease the supplied Weld Strap to match the gutter profile.

Using a knife or scissors, trim the Weld Strap to remove any excess.





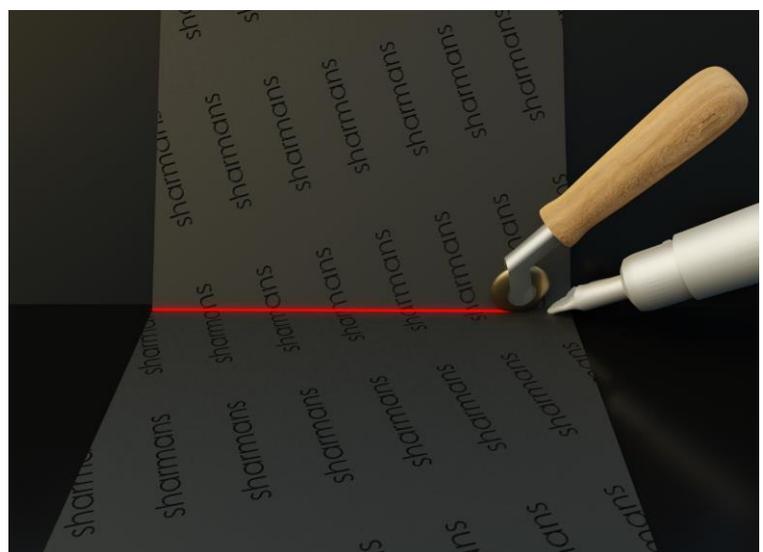
Position the Weld Strap centrally over the Yellow Capped Fixings to the full profile of the gutter.



Using the Heat Gun, tack the Weld Strap at its centre point to attach it to the Liner and stop any movement.

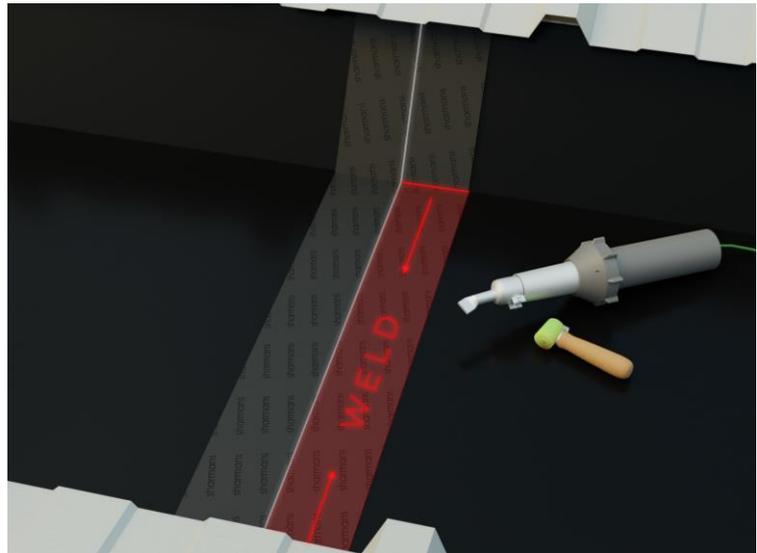


Using a Penny Roller, Weld the Strap along its crease lines on both sides, ensuring no air gaps are present.

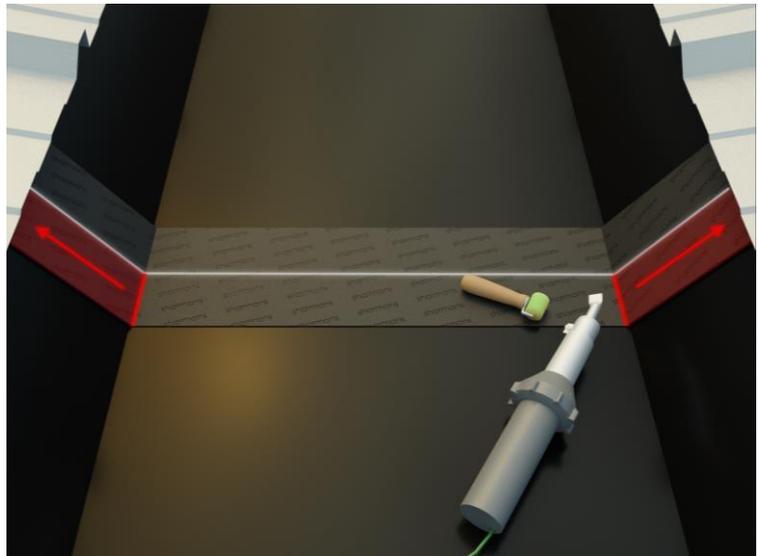




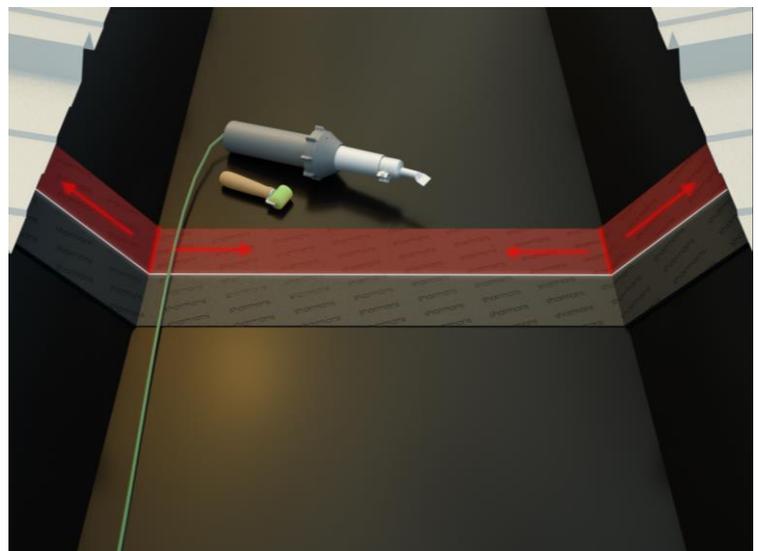
Weld half of the Weld Strap along its base - working from the crease line to the centre - creating a weld a minimum of 60mm from one edge.



Weld the upstand sections, as before, working away from the crease line.



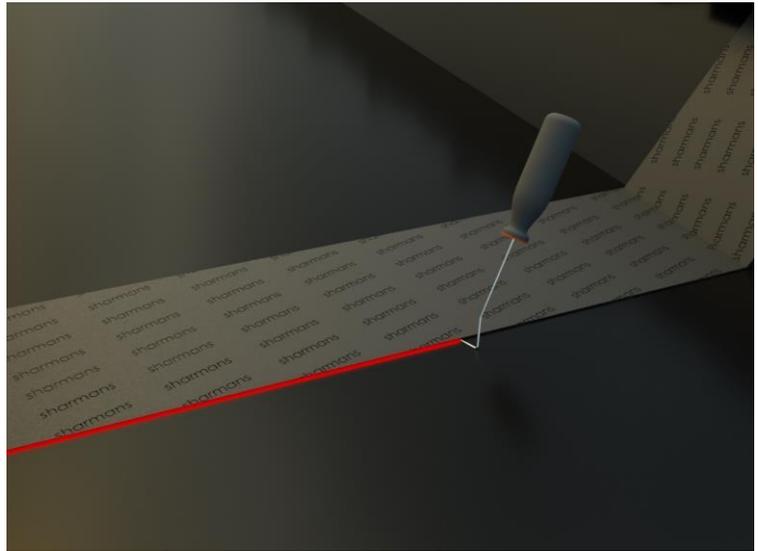
Repeat the previous two steps on the opposite side to fully weld the Strap to the Liner.





Allow the area to fully cool.

Test the welded area using a Probe / Seam Tool to ensure it is complete and free from any snags / openings or weld failures.



If any areas are found to have failed reweld them thoroughly - working towards the leading edge to prevent any air pockets from forming.

