

SFS intec

System *isoweld*TM 3000

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English

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System components

☞ Ensure that you have all required system components at your disposal.

System components	Product identification
Stress plate FI-P	
Sleeves FI-R	
Fastener	
Setting tool FI80	
Induction tool <i>isoweld</i> TM 3000	
Magnets FI-Magnet	
Hand inductor FI-H	
Calibration template	
Pad for EPS/XPS application FI-Pad	

1. Deciding on installation strategy

- Familiarise yourself with the results of the wind load calculation and decide on the procedure for the installation.
- Consider how best to deploy personnel, materials and equipment. In this way you will achieve a fast, correct and efficient installation.



2. Preparing the roof for fastening

- Prepare the roof for laying out the waterproof membrane (e.g. prepare substrate, vapour barrier, thermal insulation, fleece etc.).
- It is important to observe local regulations and manufacturers' instructions.
- 👉 **We recommend that only so much roof area be prepared as can be fastened and welded on the same day.**
- Before rolling out the waterproof membrane, steps **3** and **4** have to be carried out.

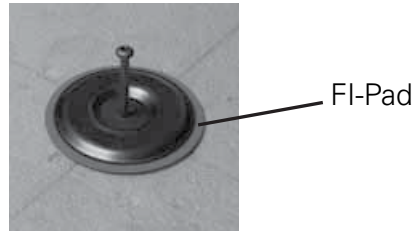
3. Measuring and marking fastening points

Measure the locations of the fastening points in accordance with the wind load calculation and mark these on the prepared roof surface using e.g. a chalk line.

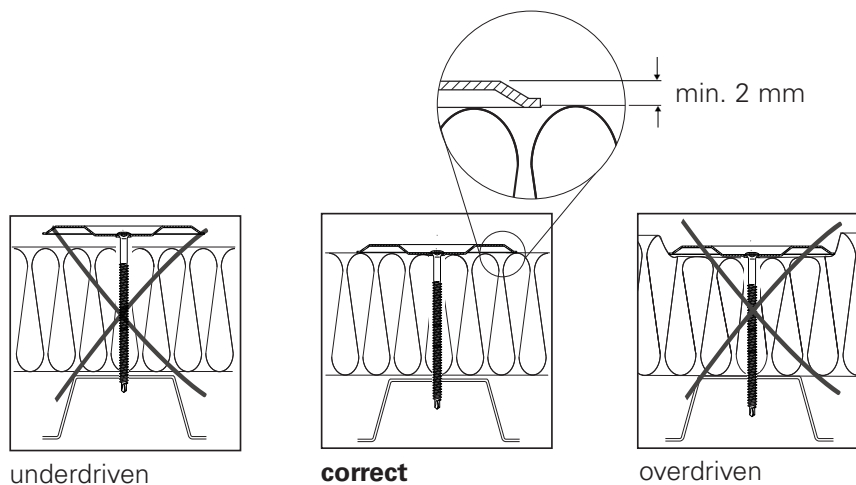


4. Fixing stress plates

- Fix the stress plates in accordance with the wind load calculation.
- Use the specified fastener and preferably the FI80 hand setting tool.
- 👉 **Only set as many stress plates as can be welded on that day.**
- Ensure that the stress plates are dry and clean, both in storage and during and after installation.
- When installing on EPS/XPS thermal insulation, an FI-Pad must always be used, even when a fleece is placed between the EPS/XPS thermal insulation and the waterproof membrane.
- The FI-Pad must be placed directly under the stress plate.



- Check the setting depth of the stress plates (see figure below).
- The stress plates must be set parallel to the surface.
- 👉 **Incorrectly installed stress plates adversely affect the quality of the weld.**



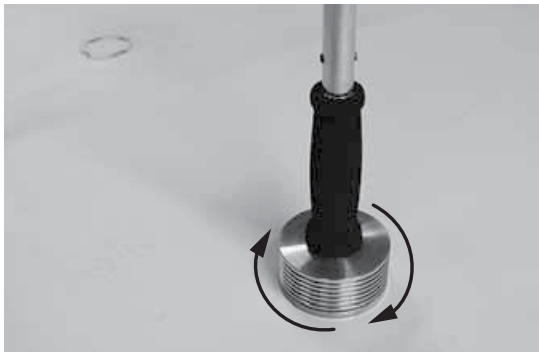
5. Rolling out the waterproof membrane

- Install the waterproof membrane in accordance with the membrane manufacturer's instructions.
- 👉 **Compared to seam fixing systems, the *isoweld*TM system makes it possible to reduce the overlap of the waterproof membrane.**
- Overlaps of the waterproof membrane in the area of the stress plate should be avoided. See also the *isoweld*TM3000 operating instructions.
- Ensure that the underside of the waterproof membrane is dry.



6. Marking the fastening points

- Use the *isoweld*TM3000 magnets (turning clockwise) or other suitable aids to mark the top of the waterproof membrane above the stress plate.
- 👉 **Careful marking contributes significantly to a fast welding process.**



7. Preparing the *isoweld*TM 3000 induction tool

 **Prepare the *isoweld*TM3000 induction tool for welding in accordance with the separate operating instructions.**

This includes in particular:

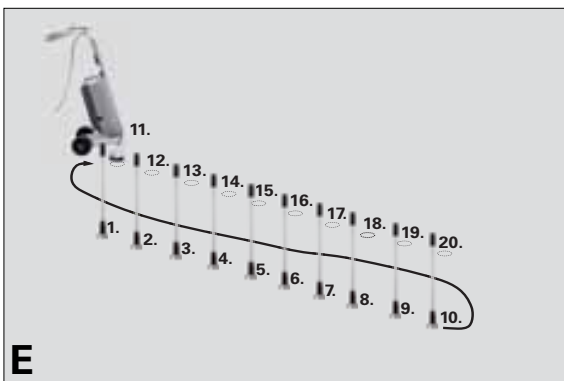
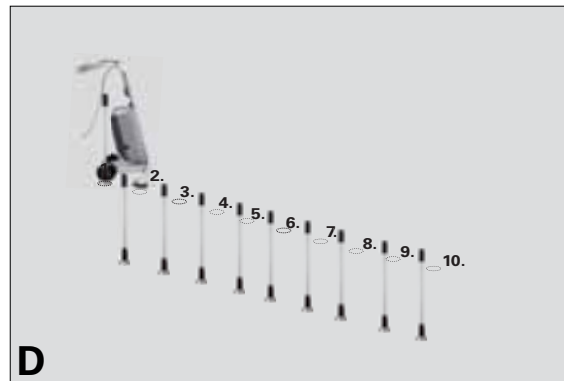
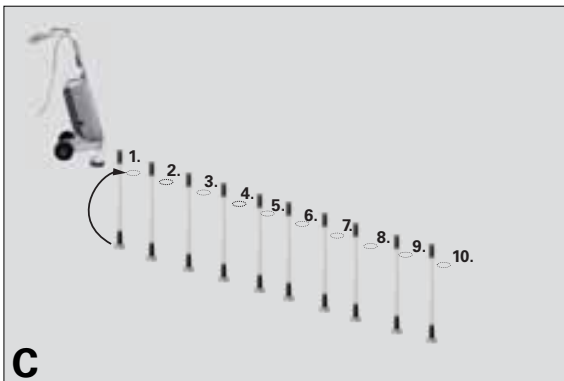
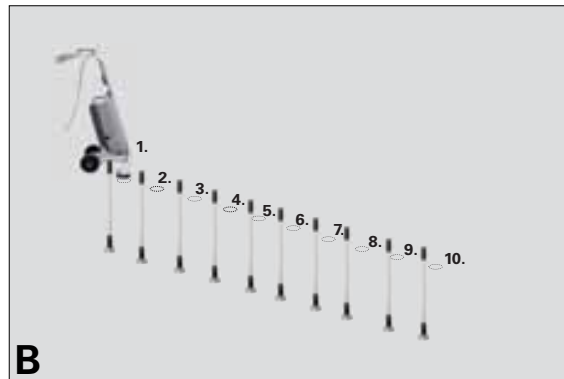
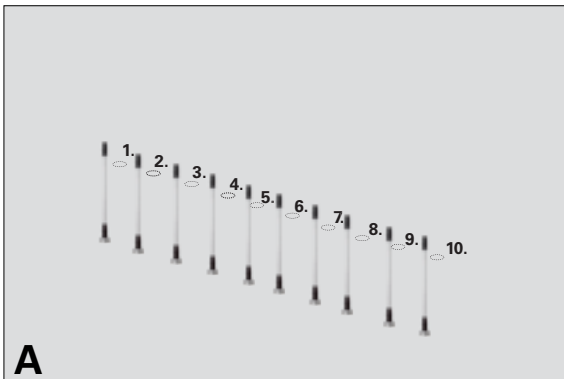
- unpacking and assembling the magnets
- unpacking and assembling the tool
- switching the tool on
- entering the waterproof membrane material
- entering the waterproof membrane thickness
- calibration
- test welding

8. Welding the membrane at the fastening points

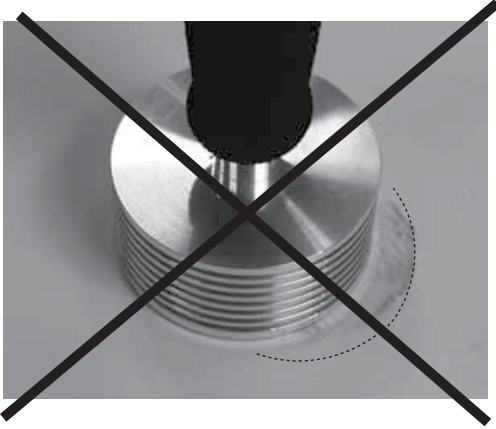
 Proceed with the welding process in accordance with the *isoweld*TM3000 operating instructions.

For an efficient process, we recommend the following procedure:

1. Place at least 10 magnets to the right of the points to be welded (**A**).
2. Weld the first of these points (**B**).
3. Place the magnet on to this fastening point within 3 seconds of completing the welding (**C**).
4. Proceed to weld the following points 2 to 10 as described in steps **2** and **3** (**D**).
5. Move the *isoweld*TM 3000 induction tool to the starting point of the next line (point 11) (**E**).
6. Proceed to weld points 11 to 20 of the line on the left, as described in steps **2** to **4**.
7. etc.



 **Fast and exact positioning of the magnet is a prerequisite for good welds.**



- Ensure that all fastening points have been properly welded.
- Should you be uncertain about whether some welds have completed properly, SFS intec recommends testing with a commercially available suction pad.

 **See also *isoweld*TM3000 operating instructions.**