Installation instructions

WELDANO® INVEX 3D

Installation steps

1. Preparation

Remove any dirt present on the surface of SOLITEX WELDANO 3000 by wiping with a cloth, for example. Adhesion to frozen membranes is not possible. There must be no water-repellent substances (e.g. grease or silicone) on the membranes. Subsurfaces must be sufficiently dry and stable.

2. Cut to size

Cut WELDANO INVEX 3D down to the required strip length.

3. Weld the lower 3D sealing strips to the membrane

Weld the two lower WELDANO INVEX 3D sealing strips to the underlay membrane using either the WELDANO TURGA (HS) solvent welding agent or else hot air welding.

The effective joint width (area covered with solvent welding agent) must be at least 5 cm (2") wide and must extend as far as the edge of WELDANO INVEX 3D. Use a roller to secure the welded joints.

4. Weld the upper 3D sealing strips to the membrane

Weld the two upper WELDANO INVEX 3D sealing strips to the underlay membrane using either the WELDANO TURGA (HS) solvent welding agent or else hot air welding.

The effective joint width (area covered with solvent welding agent) must be at least 5 cm (2") wide and must extend as far as the edge of WELDANO INVEX 3D. Use a roller to secure the welded joints.

5. Weld the overlaps

Weld four overlap joints between the individual WELDANO INVEX 3D sealing strips using either the WELDANO TURGA HS solvent welding agent or else hot air welding.

The effective joint width (area covered with solvent welding agent) must be at least 5 cm (2") wide and must extend as far as the edge of WELDANO INVEX 3D. Use a roller to secure the welded joints.

6. Seal to skylight

Seal the WELDANO INVEX 3D sealing strips to the skylight using TESCON VANA.

Substrates

Suitable for installation over pressure-resistant subsurfaces, e.g. timber sheathing, wood-based panels and wood-fibre underlay panels. The subsurface must be dry, free of frost, clean and free of any sharp-edged or pointed objects.

General conditions

Membrane edges are to be welded using the WELDANO TURGA (HS) or WELDANO TURGA HS system solvent welding agents or a hot air gun. The welding area must be dry and free of frost, dust and grease. If dirt (e.g. oil) is stuck to the surface, moisten a cloth lightly with WELDANO TURGA (HS) / HS system solvent welding agent and use it to clean off this dirt.

Welding with a solvent welding agent can be carried out at temperatures above 0 °C (32 °F) for WELDANO TURGA or 10 °C (50 °F) for WELDANO TURGA HS. Please observe the hazard notices on the container.

If a hot air gun is being used, we recommend a temperature of around 220 to 280 °C (430 to 530 °F) depending on the ambient temperature and wind conditions. Test this setting by carrying out a test weld on a sample piece of membrane. A 40 mm (1 5/8") nozzle width has been found to be suitable in practice for welded joints between surface membranes. A 20 mm (3/4") nozzle may be more suitable in certain cases for more intricate joints.

As an alternative to the use of the WELDANO ROFLEX, WELDANO ROFLEX MODI, WELDANO INVEX, WELDANO INVEX 3D or WELDANO INCAV system shaped elements, these elements can also be made by cutting appropriate shapes out of SOLITEX WELDANO 3000 membranes.

The information provided here is based on practical experience and the current state of knowledge. We reserve the right to make changes to the recommended designs and processing or to make alterations due to technical developments and associated improvements in the quality of our products. We would be happy to inform you of the current technical state of the art at the time you use our products.

Further information about installation and design details is available in the pro clima planning documentation. If you have any questions, please contact [pro clima Technical Support](https://proclima.com/service/technical-support).

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