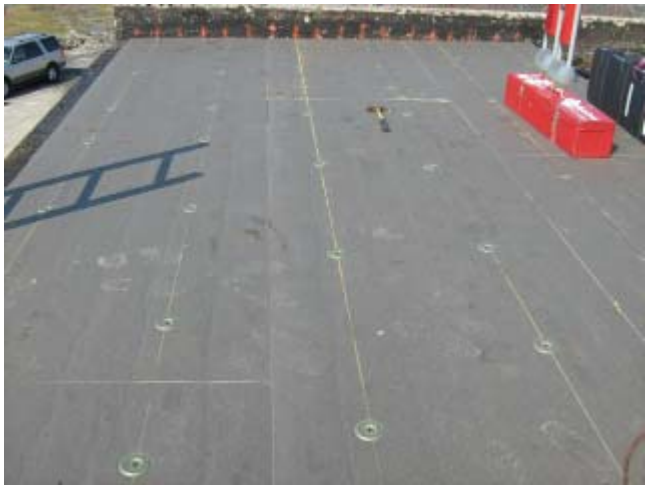
Thermoplastic Single Ply and Multi-Ply Roofing Systems

RhinoBond®

How to Run a Rhino Job

Remember these keys:

Fasteners MUST be in a straight row in at least one direction. The more even the spacing, the easier they are to find once covered, and the faster everything goes.



Straight - Good

Random – Harder to Find

Fasteners must not be overdriven. They should be tight enough that you can not turn the plates with your hand. Overdriven fasteners are harder to find.

Proper Installation

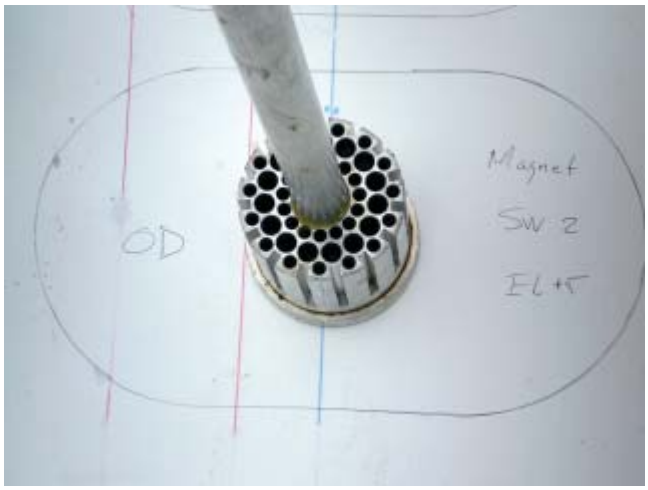
Overdriven

Power is important. Each tool should be plugged into its own 20A circuit, and no more than 100 feet of good quality extension cord per tool. Do not plug the tools into a pigtail, and do not plug them into a 15A GFCI adapter. Generator power usually works better than house power because house power often requires longer extension cords. The tools are designed to run on 105-130V. If the cycle times are lasting over 8 seconds, check the power source. The more power the tools get, the faster they run.

One Cord per Circuit & Per Tool

Do Not Use Pigtails

Tool alignment is important. The plate needs to be centered under the red dot within 1 inch. This is not hard to do if the operator pays attention. Best practice is for each operator to have a grease pen, and outline the base of the tool on every 10th plate or so, to check his alignment. After checking like this several times, they get the hang of it.



Magnet alignment is also important. Operators should take care to make sure the magnet covers the plate. Misalignment will result in less than perfect welds.

Keep the magnets clean. If a piece of metal or anything else from the roof gets on the magnet, it will make a mark in the membrane on every weld. Again, as long as the operator and foreman are paying attention, this is easy to catch.

Always calibrate the tools, at least once in the morning, and once after lunch, or whenever the temperature changes more than +/- 15°F. Use a grease pen to check alignment when calibrating. Use the up and down arrows to change the power level, and look for the lowest setting that yields a complete bond. Be sure to allow test assemblies to cool completely before evaluating bond strength.

Consider staging the Rhino welding operation in straight lines. The first operator lines all of the magnets up on the first row. The second operator begins work on the adjacent row after the first operator completes the first five welds. This procedure helps make sure that the magnets remain on the plates for at least one minute. This method also minimizes motion and increases productivity.

If there is a radio on the jobsite, and you hear interference (static) when the tool is operating, don't worry. This is normal. The tool meets FCC transmission requirements for industrial tools, but can cause static interference under certain circumstances, especially if the radio is plugged into the same circuit as the tool.

If you have any questions or need more information, contact:

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