

## Installation Recommendations for nora dryfix™ 750

The **subfloor** must fulfil the requirements of the country-specific standards regarding the readiness for installation.

At the time of installation, the subfloor temperature must be **at least 15° C**. Ensure that the nora<sup>®</sup> floor covering has the required subfloor temperature. Especially in winter time, nora<sup>®</sup> floor coverings have to be stored on site for several days.

The subfloor may need to be primed, e.g. with nora<sup>®</sup> PRP 101\*, and levelled completely, e.g. with nora<sup>®</sup> L 1000\*. Prime polished or smoothed surfaces with nora<sup>®</sup> PRP 101\* diluted with clear water in a mixing ratio of 1:1 to bind any remaining dust particles. Allow primed surface to dry.

nora dryfix™ 750 can also be laid on smooth existing coatings. These, however, must be permanently and securely bonded to the subsurface and must not have any cavities.

**Please make sure the material is properly stored on site. Rolls have to be stored upright! Tiles all have to be stacked accurately, face to face and back to back.**



All floor coverings installed with nora dryfix™ 750 must always be sealed, execution immediately after installation.

Material defects which are visible before installation cannot be acknowledged when claimed after the installation.

We recommend to install noraplan<sup>®</sup> tiles and square norament<sup>®</sup> tiles in broadloom fashion.

Please also see our **“General remarks** for the installation of nora<sup>®</sup> floor coverings, stairtreads and accessories” as well as the installation recommendations norament<sup>®</sup> and noraplan<sup>®</sup>.

### Required cutting tools



### Required tools for the installation



**Observe the direction of the arrow on the back of the floor covering and always lay the sheets and tiles in the same direction**



\*or comparable product by a different manufacturer. The suitability and processing as well as the consumption of the chosen adhesive can be gathered from the build-up recommendation and the technical data sheet.

**Proceeding**

1. Install nora dryfix™ 750 on the surface, making sure to overlap the seams of the 75 cm wide strips by approx. 1–2 cm.

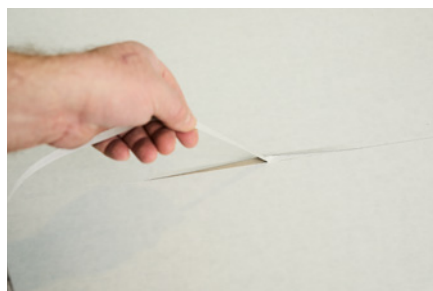
**Tip:** It is best to work in pairs. First unroll 1 – 2 linear metres of nora dryfix™ 750 precisely into position. One person can then continue unrolling the tape while the other person can press down the nora dryfix™ 750 onto the substrate, using a brush to remove any air bubbles.



2. Continue to install nora dryfix™ 750 this way until the entire surface is covered.



3. You can either trace-cut (using a ruler as a guide) or double-cut the seam between two nora dryfix™ 750 strips. Take care not to leave any gaps wider than 2 mm.



4. Cover the entire area with noraplan<sup>®</sup> sheets or tiles, or norament<sup>®</sup> tiles. You can find detailed recommendations on how to install nora<sup>®</sup> floor coverings at [www.nora.com](http://www.nora.com).



5. For sheet flooring, fold back half of its length; for tiles arranged in a row, work your way from the center and lift each tile up as required.



6. Cut and remove the protective paper of nora dryfix<sup>™</sup> 750, leaving an approx. 10 cm length from the flooring. Fold this 10 cm length underneath the flooring that has been folded back. This is meant to keep dirt particles away from the adhesive layer.

**Tip:** Do not crumple up the waste protective paper, but rather lay them on each other and roll them together after work has completed to minimize the volume of waste.



- 7.** Vacuum the back of the flooring and position the tile or sheet.



- 8.** Apply pressure to the flooring and roll it using a roller.



- 9.** Repeat steps 5 to 8 for the rest of the surface.

## Installation Recommendations – Joint sealing after installation of nora dryfix™ 750

All floor coverings that are installed with nora dryfix™ 750 must always be sealed:

- noraplan<sup>®</sup> with nora<sup>®</sup> hot welding rod or nora<sup>®</sup> 1-component cold weld
- norament<sup>®</sup> with nora<sup>®</sup> 1-component cold weld

Execution immediately after installation.

If joints have to be sealed longitudinally as well as transversely 12 hours have to pass between the two work steps.

Joint sealing is not equivalent to a mandatory sealing according to any country specific standard.

We recommend nora<sup>®</sup> 1-component cold weld for the sealing of joints between nora<sup>®</sup> floor coverings and rising elements like masonry, door frames etc.

### A. nora<sup>®</sup> 1-component cold weld

A 300 ml cartridge with approx. 450 g nora<sup>®</sup> 1-component cold weld will produce approx. 20-25 linear metres/cartridge, depending on the joint width.

**The cold weld paste must be allowed to settle and fully cure prior to being walked upon. Any spilt cold weld paste must be removed immediately as cleaning at a later stage is not possible.**

#### Required tools for the joint sealing with nora<sup>®</sup> 1-component cold weld

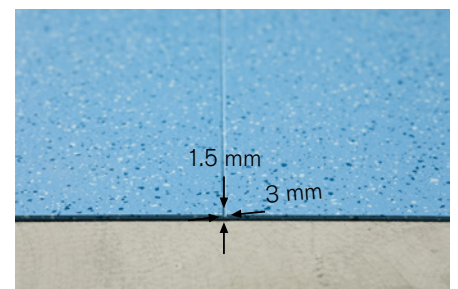


1. Apply nora<sup>®</sup> liquid wax to seam areas.  
Leave liquid wax to dry completely!



2. Cut open or mill out joints centrally with the joint cutter or electric milling machine.

Joint width approx. 3.0 mm  
joint depth max. 1.5 mm

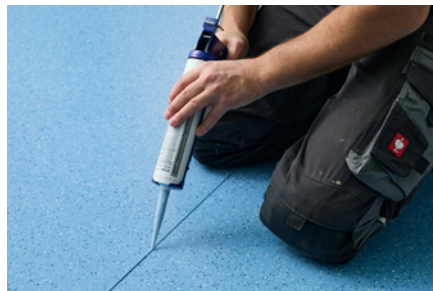




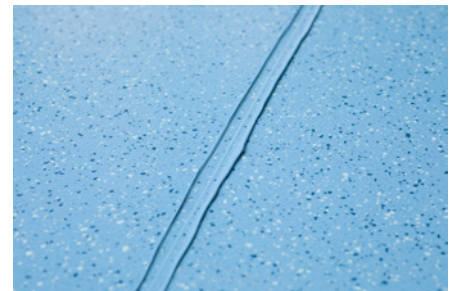
3. Remove milling chips (vacuum cleaner).



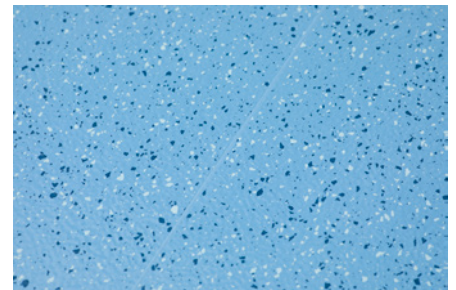
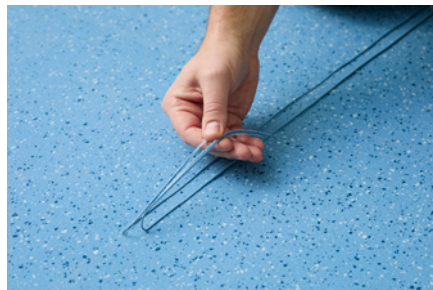
4. First seal the joints in one direction. After the cold weld has cured, seal the seams in the other direction. To do so the 1-component cold weld is spread into the joints without leaving any gaps until a small bulge develops above the seam.



5. Immediately after application the cold weld is pressed into the joint with the nora<sup>®</sup> smoothing spatula by running this evenly over the joint. Thereby, the surplus cold weld is pressed to the left and right of the joint. You have to make sure that the cold weld pressed to the sides is entirely separated from the compound in the joints. Hold the spatula in a position as flat as possible to avoid the development of hollow joints.



6. The surplus cold weld pressed to the sides can be removed after approx. 12 hours.

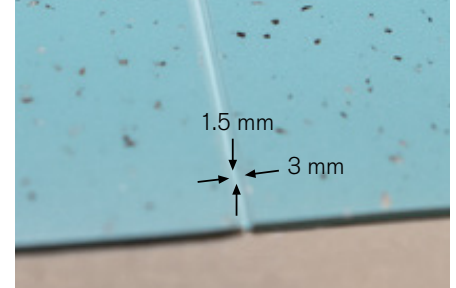


**Even if no initial cleaning is required after installation, wax residues must be removed approx. 12 hours after joint sealing and at least 48 hours after installation with a suitable basic cleaner or oil and grease remover and suitable method.**

As an alternative to nora<sup>®</sup> liquid wax, a suitable adhesive tape can be used when sealing the joints of noraplan<sup>®</sup> and noracare<sup>™</sup> with nora<sup>®</sup> 1-component cold weld. This alternative is not possible for norament<sup>®</sup> floorings.

1. Cut open or mill out joints centrally with the joint cutter or an electric milling machine (for noracare<sup>™</sup> uneo a diamond milling blade is advisable).

Joint width approx. 3.0 mm  
joint depth max. 1.5 mm



2. Remove milling chips (vacuum cleaner).



3. To prevent the nora<sup>®</sup> 1-component cold weld from adhering to the surface of the floor covering, apply the special masking tape (Werner Müller GmbH PVC-Kaltschweißsystem, Art. no. 50000) on the right and left side of the joint.



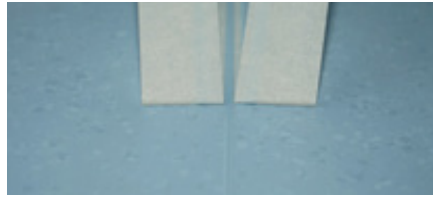
4. First seal the joints in one direction. After the cold weld has cured, seal the seams in the other direction. To do so, the 1-component cold weld is spread into the joints without leaving any gaps until a small bulge develops above the seam.



5. Immediately after application, the cold weld is pressed into the joint with the nora<sup>®</sup> smoothing spatula by running this evenly over the joint. Thereby, the surplus cold weld is pressed to the left and right of the joint. Hold the spatula in a position as flat as possible to avoid the development of hollow joints.



6. The adhesive tape can be removed immediately.



For further information regarding the procedure with the masking tape mentioned above, please visit the homepage of the manufacturer: <https://www.mueller-pvc-naht.de/en/products/type-a/>

When sealing joints with any cold weld paste it is state of the art that the compound will dip slightly during the curing process.

## B. nora<sup>®</sup> hot welding rod

Round, diameter approx. 4.0 mm

Packaging unit: Roll with approx. 100 linear metres, weight approx. 1.3 kg/roll

Consumption:

Sheets (1,220 mm wide) approx. 0.85 linear metres/m<sup>2</sup>

Tiles (610 mm x 610 mm) approx. 3.50 linear metres/m<sup>2</sup>

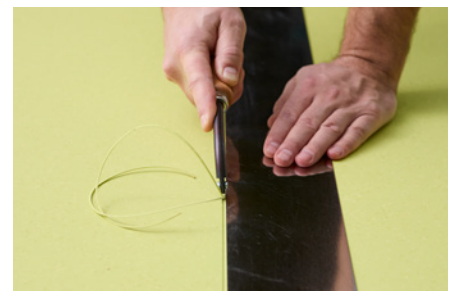
nora<sup>®</sup> hot welding rod is suitable for the joint sealing of all noraplan<sup>®</sup> and noracare<sup>™</sup> floor coverings except noraplan<sup>®</sup> ed floor coverings which have to be joint-sealed with nora<sup>®</sup> 1-component cold weld.

The same tools are used as when sealing the joints of plastic floorings.

### Required tools for the joint sealing with nora<sup>®</sup> hot welding rod

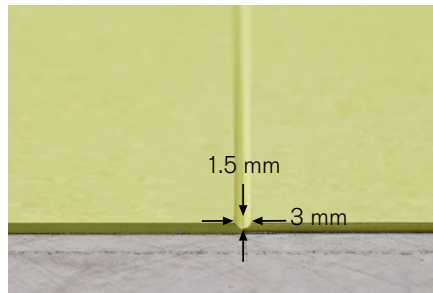


1. The joints are milled out or cut open centrally with an electric milling machine and/or the joint cutter.





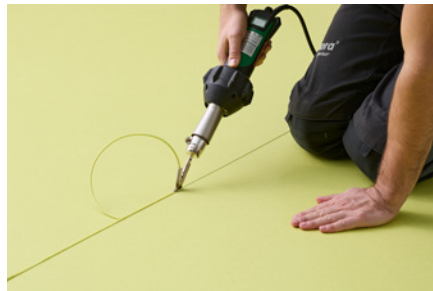
2. Joint width approx. 3.0 mm  
joint depth max. 1.5 mm



3. Remove milling chips (vacuum cleaner).



4. The hot welding rod is fitted using either the hand-operated hot welding gun with fast-welding nozzle (for noracare™ with small air vent) or a welding machine with Teflon roller. The operation temperature of the device is reached when the hot welding rod oozes out slightly on the left and right edge of the joint.



5. The processing temperature is 350-400° C (for noracare™ max. 300° C). Set the speed to approx. 2 linear metres/min. The operating speed and temperature can be regulated on most welding machines.



6. If the temperature cannot be set, adjust the operating speed accordingly.

**Attention:**

**The welding speed is slower than the one used with linoleum or PVC.**



7. Directly after welding use the Mozart knife with the 0.7 mm distance sledge to carry out the first cut.



8. After cooling down the second cut is carried out with the Mozart knife without the distance sledge.



**Contact:**

Contact details, local branches or authorised retailers, as well as other information can be found at [www.nora.com](http://www.nora.com).  
E-Mail: [info@nora.com](mailto:info@nora.com)

**Link to the video:**

[www.nora.com/installation](http://www.nora.com/installation)

