

nora[®] cold weld

Product Description:

nora[®] 1-component cold weld has been developed for color-matched welding of nora[®] floorings. Normally welding norament[®] and noraplan[®] floor coverings is not required as nora rubber floorings do not contain any volatile plasticizers, so there is no shrinking from the flooring off-gassing after installation.

Welding is however recommended for special applications:

- installation on moisture-sensitive subfloors
- areas with permanent intensive wet cleaning
- operating rooms or similar
- vertical external corners, or
- when specified.

Due to the multiplicity of requirements and regulations involved for transportation systems like buses, trains and ships, please check the individual installations for the necessity of cold weld. In coach and buses, for example, cold welding may not be required when 385 or 585 adhesives are used.

Always follow the nora Installation Guide and Guide Specifications that are available on www.nora.com/us. nora systems, Inc. is approved by Lloyd's Register Quality Assurance to the Quality Assurance Management System Standard ISO 9001:2000. Also ISO 14001 Environmental Management Systems Certified.

All nora products are intended for indoor use only, by professional floor installers. In high stressing commercial and industrial sectors; e.g. hospitals, schools, airports, shopping centers, radiant heating and castor chair traffic etc., nora cold weld shall only be used with nora flooring.

Technical Data:

1. Packaging: White tube with application nozzle
2. Size: 10 fl. oz. (300 ml)
3. Composition: Polyurethane prepolymer
4. Color: As selected
5. Odor: Weak
6. Form: Pasty
7. Hardness: ~ 75 Shore A
8. Shelf life: Minimum 1 years
9. Storage: Protect from sun light, cool and dry conditions
10. Flash Point: > 221°F (105°C)
11. Density (compound): ~1,6 g/cm³
12. Water soluble: Insoluble
13. VOC content: VOC content is <12 grams/liter; product is in compliance with the SCAQMD Rule 1168 Standard for Architectural Sealants, which has a VOC limit of 250.
14. LEED contribution: nora cold weld is in compliance with the VOC limits of SCAQMD Rule 1168 required by LEED and can contribute to LEED Credit 4.1-Low Emitting Materials, Adhesives & Sealants
15. Warranty: As detailed in the nora warranty
16. Coverage: Approximately 50ft – 60ft (15m – 18m)
17. Working temperature: Per the flooring requirements
18. Cure time: 8 -12 hours
19. Heavy foot traffic: After curing 8 -12 hours
20. Rolling loads: Suitable after 48 hours
21. Wet cleaning Suitable after 48 hours

Conditioning:

The area to receive welding shall be fully enclosed, weather tight and climate controlled at the normal service ambient temperature and humidity (except walk in freezers or similar) or 68°F ± 5°F and 50% ± 10% ambient relative humidity (RH). The flooring must be installed for at least 8 hours before heat welding unless nora[®] dryfix has been used to install the flooring, then heat welding can begin immediately the flooring is installed.

Tools:

Special joint cutter, and or joint suitable milling machine, smoothing spatula and masking tape or nora[®] Liquid Wax.

norament[®] (Liquid Wax):

Preparation:

To prevent bonding of the cold weld outside of the seam, apply a thin even layer of nora Liquid Wax using a clean cloth to both sides of the seam (~4 inch total), and allow to dry.

Groove the required seam with either a mechanical joint cutter or hand-grooving tool, ensuring all grooves are clean. The depth of the groove shall be controlled at approximately 2/3 the thickness of the flooring. For acoustic flooring, the groove shall be controlled at approximately 2/3 the thickness of the top layer. The width of the groove shall be ~1/8 inch for both.

For vertical seams, first apply the liquid wax to the entire seam area and allow it to dry. Use a small straight edge trim or groove the seam or sanitary base back, approximately 1/8 inch.

The use of gloves and safety glasses is recommended when using nora cold weld. Cut off the tip of the cartridge at the first thread, screw on the nozzle and place the cold weld cartridge into a cartridge gun. Cut off the nozzle tip at a slight angle.

Application:

Inject the nora cold weld into the groove without gaps until a small bulb develops above the seam (~size of heat weld rod). At the end of the seam, release the gun to prevent leaks. Any nora cold weld tracked or spilled on the flooring shall be removed immediately using 70% Isopropyl alcohol or liquid soap and a clean cloth, as cleaning at a later stage may not be possible.

Press the nora cold weld into the seam using a smoothing spatula, held nearly flat (~22° angle) resulting in a surface flush on the same plane as the surface of the floor. Excess cold weld must be pressed away on each side of the seam. It is important to develop a slight gap between the excess weld and the weld within the seam for easy removal once cured.

For vertical corners, use a smoothing spatula to remove the excess cold weld and smooth the surface to approximately the required finish, then wait for ~10 minutes for the weld to skin over. Wet your finger tips using nora liquid wax, 70% Isopropyl alcohol or water, then finish smoothing the weld by lightly manipulating to an acceptable finish.

Excess Removal:

The excess cold weld can be removed after ~8 - 12 hours, depending on thickness, temperature and ambient humidity. This can be done by simply peeling it off with your fingertips. If it is still connected anywhere, trim it off using a sharp skiving knife.

Prevent any traffic on the seams until the nora cold weld has cured for ~12 hours. Prevent any heavy rolling loads (chair castors, etc.) for ~72 hours for it to fully cure. nora cold weld develops a skin after approximately 20-30 minutes at 68°F (20°C) and an ambient humidity of 50%. The skin formation is accelerated by higher temperatures and humidity, and slowed correspondingly by lower values.

noraplan[®] Method (masking tape):

Preparation:

To prevent bonding of the nora cold weld outside of the required seam, use masking tape (not painters tape) to completely cover the seam that requires welding. Approximately center the tape with the seam. Use a hand roller to firmly press the tape down and ensure a good bond.

Groove the required seam with either a mechanical joint cutter or hand-grooving tool, ensuring all grooves are clean. The depth of the groove shall be controlled at approximately 2/3 the thickness of the flooring. For acoustic flooring, the groove shall be controlled at approximately 2/3 the thickness of the top layer. The width of the groove shall be ~1/8 inch for both.

For vertical seams, use a small straight edge trim or groove the seam or sanitary base back approximately 1/8 inch. Carefully apply masking tape onto the surface of each side of the flooring keeping the edge of the tape flush with the edge of the flooring, press or roll (hand roller) the tape and ensure a good bond.

The use of gloves is recommended when using nora cold weld. Cut off the tip of the cartridge at the first thread, screw on the nozzle and place the cold weld cartridge into a cartridge gun. Cut off the nozzle tip at an angle.

Application:

Inject the nora cold weld into the groove without gaps until a small bulb develops above the seam (~size of heat weld rod). At the end of the seam, release the gun to prevent leaks. Any nora cold weld tracked or spilled on the flooring shall be removed immediately using 70% Isopropyl alcohol or liquid soap and a clean cloth, as cleaning at a later stage is not possible.

Press the nora cold weld into the seam using a smoothing spatula, held nearly flat (~22° angle) resulting in a surface flush on the same plane as the surface of the floor. Excess cold weld must be pressed away on each side of the seam. It is important to develop a slight gap between the excess weld and the weld within the seam for easy removal once cured.

For vertical internal and external corners, use a smoothing spatula to remove the excess cold weld and smooth the surface to approximately the required finish, then wait for ~10 minutes for the weld to skin over. Wet your finger tips using nora Liquid Wax, 70% Isopropyl alcohol or water, then finish smoothing the weld by lightly manipulating to an acceptable finish.

Excess Removal:

The masking tape may be removed carefully now or after it has fully cured. This will be ~ 8 -12 hours depending on thickness, temperature and ambient humidity. This can be done by simply peeling it off with your fingertips. If it is still connected anywhere, trim it off using a sharp skiving knife.

Prevent any traffic on the seams until the nora cold weld has cured for ~12 hours. Prevent any heavy rolling loads (chair castors, etc.) for ~72 hours for it to fully cure. nora cold weld develops a skin after approximately 20-30 minutes at 68°F (20°C) and an ambient humidity of 50%. The skin formation is accelerated by higher temperatures and humidity, and slowed correspondingly by lower values.

Clean up:

Clean tools and any spilled cold weld using 70% Isopropyl Alcohol, liquid wax or liquid soap and a clean cloth immediately, as cleaning after the weld has cured may not be possible.

Do not wash or perform any maintenance of the floor for a minimum of 72 hours after cold welding to allow it to cure. The initial maintenance will remove the residue of the liquid wax.

Precautions:

Local, state and national legislation shall be followed. Keep out of reach of children.

First Aid:

Eye contact: Rinse for at least 15 minutes under running water with eyelids held open. If necessary consult a doctor.

Ingested: Immediately induce vomiting.

Disposal:

Dispose in accordance with local, state and national legislation. Unhardened product shall not be disposed of with household waste (hazardous waste). Always allow to fully cure prior to disposal.

For more information please refer to the MSDS that must be read and fully understood prior to using the nora cold weld. The MSDS, Installation Guide and Guide Specifications and videos are available on www.nora.com/us.

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