nora® heat weld rod

Product Description:

nora® heat weld rod has been specially developed for use with noraplan® rubber floorings. Normally welding 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 a moisture-sensitive subfloors
- areas with permanent intensive wet cleaning
- operating rooms or similar, or
- when specified.

Heat welding is not recommended for vertical seams. When required use nora® cold weld.

Due to the multiplicity of requirements and regulations involved for transportation systems like buses, trains and ships, please check in each individual case whether heat welding is necessary or not. In coach and buses, for example, 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: Cardboard reel
2. Size: 328 linear feet (100 linear meters)
3. Composition: EVA-copolymer with pigments
4. Color: As selected
5. Odor: None
6. Form: Round welding rod
7. Shelf life: Minimum 5 years
8. Storage: Recommended storage temperature ~20°F
9. Flash Point: ca. 300°C (572°F)
10. Water soluble: Insoluble
11. Toxicity: None known
12. Warranty: As detailed in the nora Warranty
13. Coverage:328 linear feet (100 linear meters)
14. Working temperature: Pre-heat welding gun to 662°F - 752°F (350°C - 400°C).
15. Cure time: When cooled
16. Heavy foot traffic: When cooled
17. Rolling loads: When cooled
18. Wet cleaning: When cooled

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 12 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, suitable heat welding gun trim plate and skiving knife, or a Mozart trimming knife with the 0.7mm spacer.

Preparation:
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.

Application:
Pre-heat the welding gun to 662°F - 752°F (350°C - 400°C). It is recommended to practice welding on a piece of scrap flooring material first to determine heat setting and speed, as different heat guns and cable length will effect the temperature. Cut a length of nora® Heat Weld Rod sufficient to weld the entire length of the seam plus approximately 6 inches extra.

Proceed to weld the seam starting at the wall and apply slight pressure to the gun nozzle (nose) to force the melting rod into the groove. Properly applied, the heat weld rod will have a slightly flattened portion on either side. Allow the rod to cool to the touch and begin the trimming or skiving process to remove the excess weld. To help prevent scratching or scuffing of the flooring surface during skiving, first wet the weld rod and about 2 inch each side using liquid soap and water mixed to an ~1:10 ratio.

Using the trim plate and skiving knife, make the first cut of the weld rod. Alternatively, a Mozart trimming knife with the 0.7mm spacer claw can be used and allow the weld rod to cool to room temperature.

Next using only the skiving knife, or Mozart (without the spacer claw), finish trimming the remainder of the weld. The finished weld should be smooth and on the same plane as the floor covering.

If for any reason you still have any excess weld rod left after the final trim, it is necessary to remove this using the melting technique. After heating up a non-sharpened metal putty knife, gently push the putty knife down the seam weld. Excess weld material will collect on the knife resulting in a smooth and flat seam weld.

Precautions:
Local, state and national regulations shall be followed. Keep out of reach of children.

Disposal:
Dispose in accordance with local, state and national regulations.

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

Dated: August 2011

nora systems, Inc.
9 Northeastern Blvd.
Salem, NH 03079
Toll free: 800-332-NORA
Phone: (603) 894-1021
Fax: (603) 894-6615
E-mail: info-us@nora.com
www.nora.com/us