



# nora<sup>®</sup> liquid wax

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## Product Description:

The nora<sup>®</sup> liquid wax is a solvent free wax emulsion used as a separation layer to ensure that during the norament<sup>®</sup> cold welding process the excess cold weld does not bond to the surface of the flooring. The nora liquid wax may also be used as a separation layer on tools like the adhesive trowels.

Always follow the nora<sup>®</sup> Installation Guide and Guide Specifications that are available on [www.nora.com/us](http://www.nora.com/us). nora systems, In. 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<sup>®</sup> 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 adhesives shall only be used under nora flooring.

## Technical Data:

1. Packaging: Green plastic bottle with a white lid
2. Bottle size: 16oz
3. Color: Beige
4. Shelf life: Use within 12 months of opening
5. Storage: Cool dry conditions
6. Freeze / thaw: Stable per ASTM D7149
7. Warranty: As detailed in the nora warranty
8. Application: Clean cloth
9. Coverage: ~ 675 linear feet at 4 inches wide
10. Drying time: Approximately 5-10 minutes
11. Cleaning: Removed during "Initial Cleaning"

## 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) for 48 hours before, during and 72 hours after the installation.

## Application of Liquid wax and Seam 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 depth of the groove shall be controlled at approximately 2/3rds 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 of cold weld:

Follow the nora Installation Guide for norament cold welding. 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.

#### Clean up:

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.

For more information please refer to the MSDS that must be read and fully understood prior to using the nora liquid wax. The MSDS, Installation Guide and Guide Specifications and videos are available on [www.nora.com/us](http://www.nora.com/us).

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