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General Installation Guidelines

This nora® nTx Installation Guide covers the typical projects and circumstances where nora® nTx rubber flooring is to be installed. If you need assistance or require a project specification, please contact the nora® Technical Department at 1-800-332-NORA. The procedures and recommendations described in this nora nTx Installation Guide were developed to offer the best opportunity for a successful nora nTx flooring installation. Any deviation from these guidelines may result in an installation failure.

All nora® flooring is to be installed by nora® Approved Installers, or INSTALL (International Standards & Training Alliance) resilient certified installers for the specific requirements of the project. All technical information, including installation and maintenance videos, and how to become a nora Approved Installer, are available on www.nora.com/us.

Note: nora® nTx 020 is not warranted for use under any other manufacturer’s flooring.

All appropriate Safety Data Sheets (SDS) and this nora nTx Installation Guide must be read and fully understood prior to installing any nora product. nora products are intended for indoor use only, in high stress commercial and industrial sectors, (e.g. hospitals, schools, labs, transportation, radiant heating and castor chair traffic).

Moisture testing is not required when installing nora nTx. Therefore, all existing products in the subfloor assembly that are NOT for use in high moisture applications must be completely removed. This includes, but is not limited to: patching and smoothing compounds, adhesives, sealers, and paint.

nora nTx is not suitable where concrete slabs have or/are suspected of having ASR (Alkali Silica Reaction) present or hydrostatic pressure. If these conditions are present do not proceed. Contact the nora Technical Department.

The prepared substrate must be smooth and ridge free. If required, use an appropriate patching compound or self-leveling underlayment following the manufacturer’s instructions. Patching or underlayment compounds must be moisture, mildew, and alkali resistant. The compounds must provide a minimum of 3000 psi compressive strength when tested in accordance with ASTM C109/C109M Standard Test Method for Compressive Strength of Hydraulic Cement Mortars - Using 2-in. or 50mm Cube Specimens or ASTM C472 Standard Test Method for Physical Testing of Gypsum, Gypsum Plasters and Gypsum Concrete. Warranties should be obtained from the manufacturer of the installed product.

Any specific requirement for level or flatness must be agreed upon by the owner, end-user, general contractor, and flooring contractor prior to the flooring installation.

Note: Tile “run off” may occur if the substrate is not flat

Warning

Do not sand, dry sweep, dry scrape, drill, saw, shot-blast, mechanically chip or pulverize existing resilient flooring, backing, lining felt, asphalt “cutback” adhesive or other adhesive, as these products may contain asbestos fibers and/or crystalline silica. Avoid creating dust. Inhalation of such dust is a cancer and respiratory tract hazard. Unless positively certain the product is a non-asbestos containing material, you must presume it contains asbestos. Regulations may require the material be tested to determine asbestos content. Various local, state and federal government agencies have regulations governing the removal of in-place asbestos-containing material. If you contemplate the removal of a resilient floor covering structure that contains (or is presumed to contain) asbestos, you must review and comply with all applicable local, state and federal regulations. The RFCI’s (Resilient Floor Covering Institute) “Recommended Work Practices for Removal of Resilient Floor Coverings” is a defined set of instructions that addresses the task of removing all resilient floor-covering structures, including adhesive and adhesive residues. For more information, contact RFCI directly at www.rfci.com or 706-882-3833.
The Occupational Safety and Health Administration (OSHA) has amended its existing standards for occupational exposure to respirable crystalline silica. OSHA has determined that employees exposed to respirable crystalline silica at the previous permissible exposure limits, face a significant risk of material impairment to their health. For more information go to https://www.osha.gov/silica/

Recommended Tool List

- Commercial floor sander with dust shroud and vacuum port
- 7 inch handheld grinder with dust shroud and vacuum port
- HEPA (High Efficiency Particulate Air) filter vacuum cleaner
- 25-grit and 100-grit Diamabrush™ grinding plates for floor sander
- Moisture resistant patching compound and/or self-leveler
- 4 inch razor scraper
- nora® knife
- Crain #340 Selvage Edge Trimmer
- Olfa 18 mm replacement blades for Crain trimmer (available at a home center paint department)
- Steel square and straightedge
- Heat welding gun
- Seam grooving tools (pull and push type)
- Mozart heat weld trimming knife
- nora® cold weld spatula
- nora® liquid wax
- Standard size caulk gun
- Utility knife with hook and straight blades
- 100 - 150 lb. three-section floor roller
- “J” roller
- Measuring tape
- 6 inch, 9 inch and/or 18 inch short nap microfiber roller covers
- Roller cage or adjustable roller frame and pole
- Roller tray
- 2 inch masking tape (tan)
- 70% Isopropyl alcohol
- Personal Protection Equipment (PPE) in accordance with OSHA guidelines

Conditioning

The flooring and accessories must be acclimated in the recommended environmental conditions for at least 48 hours prior to installation. Areas of the flooring subjected to direct sunlight, for example through doors or windows, must be covered using blinds, curtains, cardboard or similar materials for 24 hours before, during, and for a period of 72 hours after the installation to allow nora “wet” adhesives to cure.

The installation area must be fully enclosed, weather tight, and climate controlled between 63°F and 75°F and 40% to 60% ambient relative humidity (RH) for at least 48 hours prior, during and 72 hours after installation [do not use gas fueled blowers]. If this is not possible, contact the nora Technical Department.
Avoid conditions where dew point allows for the condensing of moisture on concrete substrates. The substrate must be at least 5°F above dew point to be considered acceptable.

Example: If the ambient conditions are 70°F and 65% RH, the dew point is 57°F; you must not proceed with the installation. The surface temperature must be a minimum of 62°F. Dew point calculation charts are available on the internet.

**Subfloor Preparation**

**CONCRETE**

Concrete subfloors must be structurally sound and conform to ASTM C33/C33M Standard Specification for Concrete Aggregates. Concrete subfloors must not be subject to shrinking, curling, cracking or moving in any way prior to the application of any nora products. nora systems, Inc. accepts no liability for a failure or complaint due to slab movement of any kind. nora products must not be installed over expansion joints; use an industry standard expansion joint assembly.

The concrete surface must be free of old adhesive residues, curing compounds, sealers or any other contaminate that could be considered a bond breaker. It must be clean and smooth enough to prevent any surface irregularities from telegraphing through the flooring. Shot-blasting or brush-blasting is the recommended method to prepare the concrete surface; however, Scrape-Away cutter blades on a rotary sanding machine may be required first to remove heavy accumulations of old adhesives. The use of a Diamabrush™ Concrete Prep Plus Tool to prepare the concrete surface is acceptable; however, it is a slower and more time-consuming method.

Surface cracks, grooves, depressions, control joints or other non-moving joints, and other irregularities must be filled or smoothed with a patching or underlayment compound with no moisture vapor emission limitations. These compounds must be designed to resist moisture in concrete subfloors up to 100% RH, be mildew, alkali-resistant and must provide a minimum of 3000 psi compressive strength when tested in accordance with ASTM C109/C109M Standard Test Method for Compressive Strength of Hydraulic Cement Mortars - Using 2-in. or 50mm Cube Specimens or ASTM C472 Standard Test Method for Physical Testing of Gypsum, Gypsum Plasters and Gypsum Concrete, whichever is appropriate. Warranties should be obtained from the manufacturer of the installed product.

**Note:** In areas that are not suspected of high moisture, it may be possible to use standard patching and smoothing compounds following specific guidelines which will include moisture testing of the concrete subfloor. Please contact the nora Technical Department for specific details.

Expansion, moving joints or moving cracks must not be covered with any nora product. Use a suitable industry standard expansion joint assembly system. In the event of moving cracks or joints, please contact the nora Technical Department for recommendations.

**WOOD SUBFLOORS**

All wood subfloors must be a total minimum thickness of 1-1/4 inch and overlaid with overlapping joints using APA (American Plywood Association) or EWA (Engineered Wood Association) plywood, single ply construction with fully sanded face grade A or B, or using APA/EWA underlayment grade. Wood panels must be a minimum of ¼ inch thick.

All wood subfloors must conform and be installed in accordance with ASTM F1482 Standard Practice for Installation and Preparation of Panel Type Underlayments to Receive Resilient Flooring.

Wooden substrates must not be in direct contact with concrete subfloors, even if built on sleepers. All suspended wood floors must have adequate under-floor ventilation and a permanently effective vapor retarder or membrane placed directly on the ground beneath the air space. Do not install over any oriented strand board (OSB), particleboard, Masonite, lauan, fire retardant treated plywood, or any similar unstable substrates.
The plywood must be clean, and free of any bond breaking contaminants, this can be achieved by sanding or replacing the plywood with new APA/EWA plywood. Any gaps or voids must be filled and smoothed with a flexible joint filler. Any ridges must be sanded smooth.

**GALVANIZED/STAINLESS STEEL AND ALUMINUM SUBFLOORS**

Abrade the existing galvanized/stainless steel or aluminum by using mechanical systems (i.e. disk sander with 40-grit sandpaper). Clean the galvanized/stainless steel, or aluminum by sweeping and then wiping with 70% isopropyl alcohol.

**REGULAR STEEL SUBFLOORS**

All rust must be removed by sand blasting or other mechanical methods. To prevent the steel from rusting again, nora nTx 020 bond enhancer must be applied to the steel subfloor. Any questions, please contact the nora Technical Department.

**OVER EXISTING FLOOR COVERINGS**

When nora nTx is used over existing flooring, nora systems, Inc. accepts no liability for any failure due to other manufacturers’ flooring products, or the possible breakdown of that flooring bond from the subfloor for any reason.

It is the installer’s responsibility to determine if the existing flooring is well-bonded, and confirm the current subfloor RH% levels will not affect the existing installed flooring. Providing both the moisture test and bond test have acceptable results then the installation may continue. If the RH% in the subfloor exceeds the limits of the existing flooring, nora systems, Inc. recommends complete removal of the existing flooring, and prepare the subfloor as outlined in the concrete section of this guide.

nora nTx can be installed over existing, non-cushioned backed, and securely bonded floor coverings, (e.g. VCT, rubber, linoleum, and vinyl). nora nTx can also be installed over properly prepared terrazzo, ceramic and quarry tile floors.

**Note:** Installations over existing resilient flooring may be more susceptible to indentations.

To fill voids or surface irregularities, use a patching compound that is suitable for bonding to existing floor coverings. Sand the surface to a smooth finish as needed. A primer may be required, so it is important to check with the patch manufacturer for specific mixing and installation instructions. Any product warranties or performance guarantees are the responsibility of the selected manufacturer.

**Bond Test**

It is the responsibility of the installer to determine the compatibility of the subfloor, and how many bond tests need to be performed. Bond tests are required to confirm compatibility of the nora nTx 020 to all specified components of the subfloor.

To conduct a bond test, use a 6 inch microfiber roller and apply the nora nTx 020 in a 1 foot square area. The purpose of this test is to evaluate the nora nTx 020 with the subfloor. nora does not require bond testing of the nora nTx adhesive with the nora nTx 020.

After the nora nTx 020 is fully cured (~1 to 2 hours) use a 4 inch razor scraper and attempt to remove it from the substrate. If the nora nTx 020 can be removed in 1/4 inch sized pieces or greater, contact the nora Technical Department immediately (please forward photos.) If the nora nTx 020 is very difficult to remove then it can be considered a successful bond test, and the installer may proceed with the installation.
It is mandatory to use nora nTx 020, which is a surface bond enhancer, for all nora nTx installations. Bond tests are required for nora nTx 020 (refer to the Bond Test section of this guide.)

APPLICATION

Coverage ~ 1000 - 1200 sq./ft. per unit

Use a microfiber paint roller and paint tray. Do not pour the nora nTx 020 directly on the substrate. Pouring directly on the subfloor will cause the nora nTx 020 to foam in the poured areas, and then require mechanical removal and reapplication of the affected areas.

Apply a very thin, even layer of nora nTx 020 avoiding thick applications, puddling, voids and roller lines. The applied nora nTx 020 should have an opaque and smooth appearance. If the nora nTx 020 has an orange peel textured surface do not proceed, as the nora nTx 020 is applied too thick. Immediately, using a dry microfiber roller, go over the surface again while it is still wet to remove the excess. Thick applications will need to be mechanically removed if left to dry.

For areas that are being flashed covered, apply a thin and even coat of nora nTx 020 to the wall beneath the cap strip using a small microfiber paint roller. If installing nora® wall base and/or sanitary base it is not necessary to apply the nora nTx 020 to the wall.

PREPARATION FOR FLOORING

When fully dried to a tack free state (~ 60 to 90 minutes), use a standard patch trowel or similar, and back trowel the installation area removing any loose contaminants or debris bonded to the nora nTx 020 surface.

REPAIRING

If the surface of the nora nTx 020 is compromised or damaged, the area will require reapplication. Only after the nora nTx 020 is known to be completely dry, sand the affected area smooth and reapply. If patching is required, remove the nora nTx 020 completely in the affected area, apply patch, sand smooth and remove any residual patching compound off the surface of the surrounding nora nTx 020. Patching and smoothing compounds will not bond with the nora nTx 020 surface. Clean the repaired area and apply a very thin, even layer of nora nTx 020 avoiding thick applications, puddling, dry spots and roller lines.

Installation

The material layout should be decided by the architect, designer and end user; however, nora recommends that tiles are installed point to point (corner to corner). The tiles and sheet flooring have arrows on the backside and these should always be pointed in the same direction. The exceptions being norament® arago and noraplan® valua planks, which can be installed in multiple directions and patterns.

Note: Avoid chalk lines on the prepared nora nTx 020 as chalk residue will inhibit the adhesion of the nora nTx flooring.

TILES AND PLANKS

After the area is prepared, locate your center and start lines using the 3/4/5 method or a carpenter’s square. Balance the layout and use a pencil to mark your starting lines. Begin installing from the center of the room following the start lines.
For the starting row, peel back the protective film 12 inches along the starting side of the tile (image 1). Place the exposed adhesive portion of the tile into position, then fold back the tile and remove the remaining protective film (image 2). Finally, place the remaining section into position. Do not stretch or distort the tile during placement. It may be helpful to remove the protective film in 3 sections if placement is difficult. The starter row should be a least 5 tiles to allow for a pyramid installation. This method will keep the edges of the tiles aligned and minimize tile run off.

To continue the installation, start with a corner of the tile and peel the protective film as needed, 12 inches from the corner is typical (image 3).

**Note:** Tile corners must be lined up together. nora nTx tiles will not always fall exactly in line with the adjacent tile without manipulation of the edges due to the immediate grab of the nora nTx adhesive. It is not uncommon to require slight stretching or compressing of the tile to keep tile corners in line. Warmer conditions will make the nora nTx adhesive bond faster. Removing the protective film in smaller sections will help with placement of tiles in these conditions.

Install the exposed adhesive corner first, and then remove the film from one half and align the edge with the previously installed tile (image 4). Finally, remove the remaining film and position the opposite edge of the tile to meet the adjacent installed tile (images 5, 6, and 7). When completed, roll the entire area using a 100 – 150 lb. roller.

**SHEETS**

Seams are prepared using the edge trim and trace cut method. Do not cut the excess protective film from the sides of the flooring. The film must be folded over the surface of the flooring during edge trimming.

To prepare the flooring, remove one side of the nora nTx sheet using a Crain #340 Selvage Edge Trimmer or similar and trim off ~ 0.5 inches (image 1). Use breakaway blades in the trimmer to make cleaner cuts (image 2). Velcro must be added to the underside of the trimmer to avoid marking the flooring. A second layer is required under the blade side to give the trimmer the correct angle required for unwelded seams (image 3).
Dry-lay the sheet flooring with all arrows on the back facing the same direction and overlapping all seams. Do not reverse sheets. Trim or cut down sheets and fit to the walls. The trimmed edges will overlap the untrimmed edges and measure a maximum of 48 inches to the next trimmed edge. Make relief cuts as required so the sheets lay flat and to avoid tears.

Using a nora® knife with a straight utility blade set to the thickness of the flooring (image 4), carefully trace cut the entire seam (image 5). A utility knife (used vertically) with the same type of straight blade is needed to finish the cut at each end of the seam at the walls. Seams can also be cut in a larger area prior to bringing flooring into the installation area. This will avoid hand cutting at walls and result in a clean even seam. Finish cutting the seam using a hook blade utility knife to provide a very slight undercut. Do not cut into the nora nTx 020 (image 6). Carefully remove the excess material. The finish dimension on the width should be 48 inches after seam cutting. Continue this process one sheet at a time until the area is completed.

**Note:** Underscribe tools are not recommended for seam cutting.

Fold back a workable section of the flooring (normally half of the area) over itself. Then, carefully vacuum the exposed nora nTx 020. Next, remove the exposed protective film from the sheet being installed. Finally, using a flat steel trowel, back trowel the surface of the nora nTx 020 to remove any bumps and debris. Best practice is to remove the protective film one sheet at a time to avoid allowing dirt and debris to become trapped under the flooring. Repeat this process for the opposite half of the area.

**Note:** Do not allow the nora nTx adhesive to contact itself. The adhesive cannot be separated and the flooring will need to be replaced.

Continue this process until the area is completed. Trim or "cut-in" the entire perimeter to complete the installation. Do not pressure fit the flooring. Finish by rolling the entire area using a 100 – 150 lb. roller. Heat or cold welding can be performed immediately, if required.

**Flash Coving (Boot Method)**

At the intersection between the wall and subfloor, all gaps and voids should be smoothed with a suitable filler before installation. Ensure that the wall is dry, smooth and clean.

Install any required cove cap strip following the manufacturer’s instructions. Ensure that the opening is sufficient to accommodate the thickness of the flooring material.

Install the specified cove stick using one-inch wide double sided contact tape or staple to the walls and miter all corners (no need to adhere to the substrate.)

Once the cove cap and cove stick have been installed, apply nora nTx 020 to walls using a 4 inch or 6 inch small microfiber roller.

Dry-lay slightly longer than required lengths of flooring as detailed within this guide for sheets making relief cuts to avoid tears at all external corners.
Push the flooring into the internal corner as far as possible without damaging the flooring. Cut a straight line in the flooring from the fold to the top edge of the flooring at a 45° angle (image 1). This cut should extend past the cove stick onto the subfloor when the material is in place. Cutting the rubber exactly to the bottom of the cove stick can result in tearing of the rubber.

Cut all the external corners using the Boot Method. Do not trim the perimeter or internal corners until the field flooring is adhered.

Note: Installation videos are available on www.nora.com/us.

**EXTERNAL CORNERS**

Using a pencil and small straight edge, mark the flooring where the cuts are required for each boot. Begin at the outside corner at the top of the cove stick and draw a line at a 45° angle to form the toe of the boot, then ~2 inch perpendicular to the wall, and then complete the boot up the vertical. Using a small straight edge and a straight blade utility knife, accurately cut and remove the excess flooring (in one piece) from the external corner following your pencil marks (image 1). Keep the excess for use as a template (image 2).

Note: Butterfly corners are not acceptable with nora products.

Trace and cut the removed section onto a new piece of flooring. The front edge must be left long enough to cover the exposed wall surface. The excess will be trimmed after installation to be flush with the wall corner (images 3 and 4).

**INTERNAL CORNERS**

Place one side into position and trim off the excess material, resulting in a straight cut down the center of the corner and extend past the base of the cove stick. Repeat the process with the second side. A slight gap is acceptable, as all internal seams must be cold welded (image 1).

**WALLS**

Carefully fold back the flooring while being cautious not to crease or tear it. Remove the release film from the backing up to the cove stick keeping the floor tight to the cove stick. Once in position, remove the remaining film and push tightly against the wall. Trim the flooring to fit the cap strip and insert the flooring into the cap. Finish the walls by hand rolling.
BOOT

Carefully remove the protective film from the boot and accurately place into the correct position; press and roll firmly into place. Trim the boot to fit the cap strip and insert. Trim the vertical edge of the flooring using a small straight edge. The end result will be a clean, straight edge that is flush with the wall and ready to be cold welded.

Note: All external seams must be cold welded.

Sanitary Base

At the intersection between the wall and subfloor any gap cannot be more than ~ 1/2 inch. If a larger gap exists, fill and smooth the gap using a suitable filler. Ensure that the wall is dry, smooth and clean. If dusty prime using nora nTx 020. Apply using a small roller or paint brush.

Using nora® profix 145 tape, leave the wax paper on the sides of the roll and place the roll on the cardboard disk (supplied). The disk will help keep the tape at the correct height when applying it to the wall. Install nora profix 145 tape directly to the wall (~ 1/4 inch from the floor), pressing firmly into place (image 1). Then install nora profix 50 tape directly to the floor, tight to the intersection between the wall and floor, pressing firmly into place (image 2).

Install the nora nTx flooring, ensuring that it is left large enough to cover the edge of the nora profix 50 tape, following the appropriate installation section within this guide (image 3).

Use a small section of sanitary base to mark the flooring prior to cutting (image 4). Cut back and remove the flooring at the wall where the sanitary base will be installed using a straight edge with a sharp utility knife. Keep the line as straight as the wall will allow. A small section of nora sanitary base can be used to check suitability of the width prior to cutting.

Wipe down the backside of the sanitary base with 70% isopropyl alcohol prior to installation. Dry cut the nora sanitary base to size, miter the foot (image 5) and ensure a tight fit at all seams unless welding is specified. When welding is specified, leave an even gap between all sections (~ 1/8 inch) and, when ready, follow
the cold welding section within this guide. Remove the wax paper from the nora profix 50 tape on the floor and press the sanitary base firmly into place, keeping it tight to the flooring (image 6 & 7). Next, fold down the wall sections of sanitary base. Remove the wax paper from the nora profix 145 tape on the wall and press firmly into place (image 8). Tap the sanitary base with a rubber mallet or roll with a rubber hand roller to ensure a good bond. Do not use metal rollers. Heat welding is not an option for nora sanitary base.

Wall Base

At the intersection between the wall and subfloor, gaps cannot be more than ~ 1/2 inch. If a larger gap exists, fill and smooth using a suitable filler before installation. Ensure that the wall is dry, smooth and clean.

APPLICATION

nora wall base must be adhered using a suitable cove base adhesive and applied following the manufacturer’s instructions. After cutting to fit and preparing the corners, adhere the base to the wall, and press or roll (hand roller) to obtain a strong bond. Do not stretch the wall base during installation or it may shrink back later. To help avoid possible shrinkage, slightly compress the wall base during installation.

INTERNAL CORNERS

These can be cut and tightly fit, scribed or completed in one piece by scoring the back at the wall corner, and then while folded over itself, remove a section of the toe directly under the score line, slightly less than a 45° angle.

EXTERNAL CORNERS

These must be well heated using a hot air heat gun, held in the creased position, then allowed to cool. nora systems, Inc. does not recommend shaving the back as this will weaken the corners.

Heat Welding

Heat welding can be performed immediately after installation. Heat welding should not be used on vertical corner seams or when welding to nora sanitary base.

Groove the seams with a mechanical joint cutter or hand-grooving tool, ensure all grooves are clean. The depth of the groove must be a minimum of 1.5 mm. The width of the groove must be ~ 1/8 inch (3 mm).

Preheat 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 the heat setting and speed, as different heat guns and cable length will affect the temperature.

Note: If the weld rod comes out during trimming, then either you welded too fast or the gun is not hot enough. The weld must melt at a lower temperature. Turning up the heat too high can burn the edges of the grooved seam. The best method is to run the heat gun slower and at a lower temperature.

Cut a length of nora heat weld rod sufficient to weld the entire length of the seam. 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 (image 1). The heat weld rod must have a flattened top and small bead on both sides.
While the weld rod is still warm, use a Mozart trimming knife with the 0.7 mm spacer claw to make the first pass (image 2).

Once the weld rod has cooled to room temperature, use the Mozart trimming knife without the spacer claw to finish trimming the remainder of the weld. The finished weld should be smooth and on the same plane as the floor covering.

If after the final trim you still have excess weld rod, it can be removed using the melting technique. To perform this, heat up a non-sharpened metal putty knife and gently push it down the seam weld. The heat gun can be held on the top of the putty knife to keep the knife warm. Excess weld material will collect on the knife.

Cold Welding

NORAMENT® (LIQUID WAX METHOD)

Cold welding can be performed immediately after installation. nora cold weld must be used on all corners, flash coving, and when required for sanitary base, or if otherwise specified.

The use of nitrile gloves is recommended when handling nora cold weld and liquid wax.

To prevent bonding of the cold weld outside of the seam, use a clean cloth to apply a thin, even layer of nora liquid wax to both sides of the seam (~ 4 inches) and allow to dry.

Groove the required seam with a mechanical joint cutter or hand-grooving tool. Ensure all grooves are clean. The depth of the groove must be a minimum of 1.5 mm and the width of the groove must be ~ 2.5 mm.

For vertical seams, the use of a small bendable straight edge can be helpful during the trimming or grooving process.

Cut the cone tip off the tube above the threads, screw on the nozzle and place the cold weld tube into a cartridge gun.

Inject the nora cold weld into the groove without gaps until a small bulb develops above the seam about size of the heat weld rod (image 1). At the end of the seam, release the gun to prevent leaks. Any nora cold weld tracked or spilled on the flooring must be removed immediately using 70% isopropyl alcohol 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 (~ 20° angle), resulting in a surface flush and on the same plane as the surface of the floor (image 2). 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 corners, use a smoothing spatula to remove the excess cold weld and smooth the surface to the required finish, then wait for ~10 minutes for the weld to skin over. Spray 70% isopropyl alcohol onto the cold weld, and finish the weld by lightly smoothing with your
finger to a smooth rounded acceptable finish.

The excess cold weld can be peeled off and removed after (~3 to 8 hours), depending on its thickness, ambient temperature, and humidity. This can be done by simply peeling it off with your fingertips (image 3). If the cold weld is still connected anywhere, trim it off using a sharp knife.

Prevent any traffic on the seams until the nora cold weld has cured for (~8 hours).

Maintenance can be performed using a wet mop after 8 hours, machine scrubbing after 24 hours, and, if required, buffing after 72 hours.

NORAPLAN® (MASKING TAPE METHOD)

Cold welding can be performed immediately after installation. nora cold weld must be used on all corners, flash coving, and when required for sanitary base, or if specified.

To prevent bonding of the nora cold weld outside of the required seam, use masking tape (tan, not painters tape - i.e. blue or green) to completely cover the seam that requires welding. Center the tape with the seam. Use a steel hand roller to firmly press the tape down and ensure a good bond.

Groove the seam with a mechanical joint cutter or hand-grooving tool, ensure all grooves are clean. The depth of the groove must be a minimum of 1.5 mm. The width of the groove must be ~2.5 mm.

For vertical seams, use a small straight edge to trim or groove the seam or sanitary base back ~2.5 mm.

Carefully apply masking tape to the surface of each side of the seam, 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 nitrile gloves is recommended when handling nora cold weld. Cut the cone tip off the tube above the threads, screw on the nozzle and place the cold weld tube into a cartridge gun.

Inject the nora cold weld into the groove without gaps until a small bulb develops above the seam about size of the heat weld rod (image 1). At the end of the seam, release the gun to prevent leaks. Any nora cold weld tracked or spilled on the flooring must be removed immediately using 70% isopropyl alcohol and a clean cloth, as cleaning at a later stage may not be possible.

Press the nora cold weld into the seam using the flat side of the nora smoothing spatula, held nearly flat (~20° angle), resulting in a surface flush and on the same plane as the surface of the floor (image 2). 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.

For vertical seams, apply masking tape to the sides of the seam. Apply cold weld as described previously and remove the tape.

For inside corners, clean the surface using 70% isopropyl alcohol and allow to dry. Carefully apply the cold weld to the corners. Do not apply more than is needed. Use the rounded end of the nora smoothing spatula to remove excess cold weld creating a rounded joint. Spray 70% isopropyl alcohol onto the weld and finish the weld by lightly smoothing it with your finger to an acceptable finish.

For outside corners, apply the cold weld and shape to a square corner by removing excess cold weld. Pull the cold weld to the side using the flat end of the spatula or a suitable putty knife. Wait for ~10 minutes for the weld to skin over. Spray 70% isopropyl alcohol onto the cold weld and finish the weld by lightly smoothing it with your finger to a smooth, rounded acceptable finish.