

## Installation Recommendations – Joint sealing of nora<sup>®</sup> floorings

In general, the joints of nora<sup>®</sup> floor coverings do not have to be sealed on the entire surface.

However, joint sealing is recommended with moisture sensitive subfloors and in rooms which are subject to intensive wet cleaning (e. g. hygienic areas/operating theatres in hospitals and laboratories).

Joint sealing is mandatory for:

- nora<sup>®</sup> floor coverings with a foam backing (noraplan<sup>®</sup> acoustic)
- noraplan<sup>®</sup> ed floor coverings using nora<sup>®</sup> 1-component cold weld
- joints between floor covering and skirting S 3003 using nora<sup>®</sup> 1-component cold weld

Execution 24 hours after installation at the earliest.

(Exception: nora nTx)

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 r.m./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

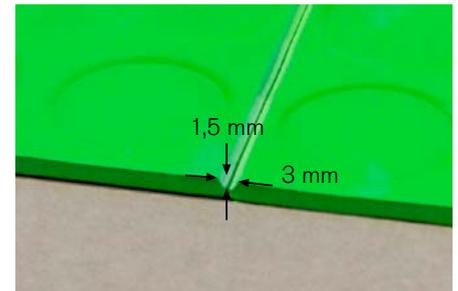


1. Apply nora<sup>®</sup> liquid wax to seam areas. Ensure that no wax penetrates the joints; if necessary, re-groove with the joint cutter. Leave liquid wax to dry completely!



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

Joint width approx. 3.0 mm  
joint depth max. 1.5 mm  
(exception: norament<sup>®</sup> 992 – joint depth 3.0 mm and norament<sup>®</sup> 945 – joint depth 5.0 mm)



3. For shockfree milling on high pastilles, a steel straight edge is placed under the running wheels of the milling machine.



4. Remove milling chips (vacuum cleaner).



5. 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.



6. 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.



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

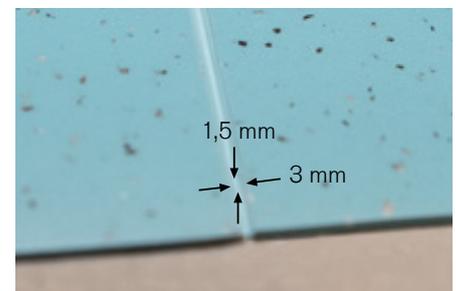
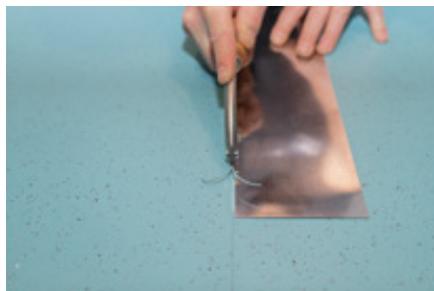


**Even if no initial cleaning is required after installation, wax residues must be removed approx. 12 hours after joint sealing and at least 48 hours after installation with a suitable basic cleaner or oil and grease remover and suitable method.**

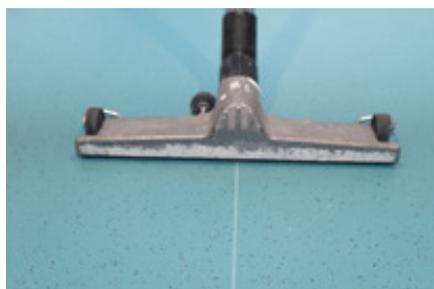
**As an alternative to nora<sup>®</sup> liquid wax, a suitable adhesive tape can be used when sealing the joints of noraplan and noracare with nora<sup>®</sup> 1-component cold weld. This alternative is not possible for norament floorings.**

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



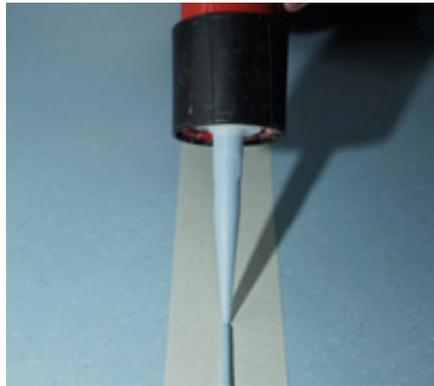
2. Remove milling chips (vacuum cleaner).



- 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 r.m., weight approx. 1.3 kg/roll

Consumption:

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

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

nora<sup>®</sup> hot welding rod is suitable for the joint sealing of all noraplan<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.

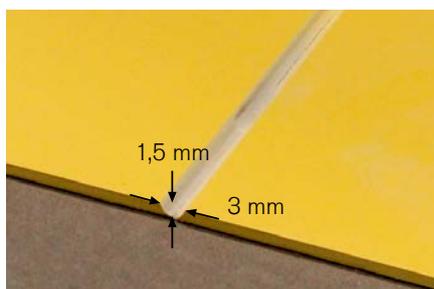
### Required tools for the joint sealing with nora<sup>®</sup> hot welding rod



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



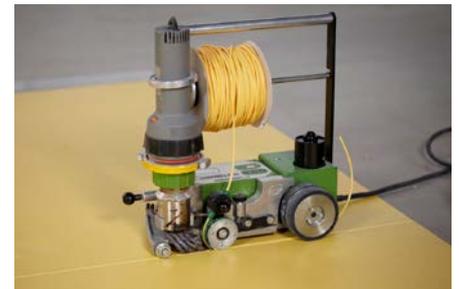
2. Joint width approx. 3.0 mm  
joint depth max. 1.5 mm



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 or a welding machine with Teflon roller. The operation temperature of the device is reached when the hot welding rod wells out slightly on the left and right edge of the joint.



5. The processing temperature is 350-400° C. When using a welding machine to process the hot welding rod, set the speed to 2 r.m./minute. The operating speed and temperature setting can be adjusted on most welding machines.



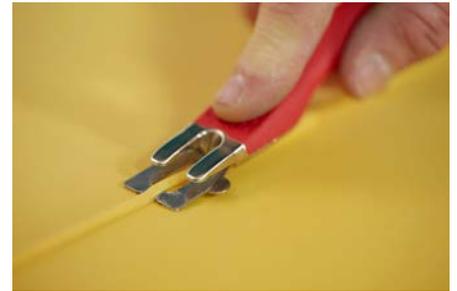
6. If the temperature cannot be set, adjust the operating speed accordingly.

**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.



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Link to the video:

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