



nora[®] cold weld

WELD

1 Product Name / Manufacturer

1.1 Product

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

1.2 Manufacturer

nora systems, Inc.
9 Northeastern Blvd.
Salem, NH 03079
800-336-5096
603-894-1021
www.nora.com/us

2 Technical Data

2.1 Unit: 10 fl. oz. (300 ml)

2.2 Packaging: White tube with application nozzle.

2.3 Shelf life: Minimum 1 year.

2.4 Storage: Room temperature, away from direct sunlight and dry area. 41°F to 77° F (+5°C to +25 °C).

2.5 Freeze/Thaw stable: No

2.6 Cure time: 8 -12 hours

2.7 Moisture in concrete tolerance: Per the flooring requirements.

2.8 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.

2.9 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.

2.10 Coverage: Approximately 50ft – 60ft (15m – 18m)

2.11 Warranty: See nora[®] Limited Warranty. For complete details go to www.nora.com/us.

2.12 Ideal Working Temperature: 68°F ± 5°F (17-23°C)

2.13 Foot Traffic: Prevent any traffic on the seams until the nora cold weld has cured for approximately 8 hours.

2.14 Castor Chairs: After 72 hours.

2.15 Heavy Foot Traffic: After 24 hours.

2.16 Heavy Rolling Loads: After 24 hours.

2.17 Wet Cleaning: Wet mopping – after 8 hours, Machine scrub after 24 hours and if required to buff floors – after 72 hours.

3 Installation

3.1 NORAMENT COLD WELDING (liquid wax method):

After the installation wait a minimum of 8 hours before cold welding, unless nora dryfix tape or nTx flooring was used, in these cases welding can be performed immediately. nora cold weld must be used on all vertical corners, flash coving and when required for sanitary base, or if specified.

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

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

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

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 a slight angle.

Inject the nora cold weld into the groove without gaps until a small bulb develops above the seam (about 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 must 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 and 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 approximately 10 minutes for the weld to skin over. Wet your fingertips using nora liquid wax, 70% Isopropyl alcohol or water and finish the weld by lightly smoothing it to a slightly rounded acceptable finish.

3.2 NORAPLAN COLD WELDING (masking tape method)

After the installation wait a minimum of 8 hours before cold welding, unless nora dryfix tape or nTx flooring was used, in these cases welding can be performed immediately. nora cold weld must be used on all vertical 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 (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, ensure all grooves are clean. The depth of the groove must be controlled at approximately 2/3 the thickness of the flooring, or for acoustic flooring, 2/3 of the top layer, and the width of the groove must be approximately 1/8 inch.

For vertical seams, use a small straight edge to 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 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 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.

Inject the nora cold weld into the groove without gaps until a small bulb develops above the seam (about 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 must 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 and 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.

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 approximately 10 minutes for the weld to skin over. Wet your fingertips using nora liquid wax, 70% Isopropyl alcohol or water and finish the weld by lightly smoothing it to a slightly rounded acceptable finish.

The masking tape may be removed carefully now or after it has cured, this will be approximately 8 hours depending on thickness, temperature and ambient humidity. This can be done by simply peeling it off with your fingertips.

Prevent any traffic on the seams until the nora cold weld has cured for approximately 8 hours. Do not wash or perform any maintenance of the floor for a minimum of 72 hours and do not high speed burnish for at least five days.

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

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.

Disposal: Dispose in accordance with local, state and national legislation

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