

Roppe Rubber Accessories



Product Data

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Resilient Flooring



1. Product Nomenclature

Roppe Rubber Accessories
Vulcanized Homogeneous Rubber

2. Manufacturer

Roppe Corporation
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Sweets Catalog: 09 65 00/ROP



3. Product Description

3.1 Basic Application

Roppe Rubber Flooring Accessories make any project complete. No matter what the job, there's a rubber accessory to complement the work, including nosings, landing trim, cove caps, reducers, edge guards, thresholds, adapters, transitions and fillet strips.

3.2 Product Construction

Roppe Rubber Accessories are a synthetic rubber compound with 10% natural rubber blended with stabilizing fillers, color pigments, and processing oils. Roppe Rubber Accessories are non-conductive and resist scuffing, gouging, cigarette scorching, and most chemicals and common substances. Color is inherent throughout.

3.3 Product Type and Dimensions

Refer to Roppe Rubber Accessory Product Chart at www.roppe.com or Roppe Catalog for details. All gauges and measurements are nominal.

Raised Design Rubber Floor Tile

Slate Design, Hammered Design, Low Profile Raised Circular Design, Textured Design, Raised Square Design, Raised Circular Vantage Design and Dimensions Rubber Tile (Random, Stripe & Crackle Designs).

3.4 Features and Benefits



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- PVC Free
- Easy to Install
- Coordinates with Roppe's MatchMates color matching system.

4. Technical Data

4.1 Technical Data

4.1.1 Roppe Rubber Accessories were tested for Flame Spread Classification, Smoke, and Fuel Contribution – ASTM E 84 (NFPA 255), Surface Burning Characteristics, Flame spread:, Class C; Roppe accessory products are considered “incidental trim” and, if they are less than 10% of aggregate ceiling and wall Class C material, may be used where Class A or B are specified.

F-925 Resistance to Short-Term Chemical Exposure—When tested in accordance with Test Method F 925, the rubber floor accessory shall have no more than a slight change in surface dulling, surface attack, or staining when exposed to the following chemicals:

White vinegar (5% acetic acid)

Rubbing alcohol (70% isopropyl alcohol)

Sodium hydroxide solution (5% NaOH)

Hydrochloric acid solution (5% HCl)

Sulfuric acid solution (5% H₂SO₄)

Household ammonia solution (5% NH₄OH)

Household bleach (5.25% NaOCl)

Disinfectant cleaner (5% active phenol)

4.2 Architects' Material Specifications

Architects' Material Specifications: RUBBER ACCESSORIES

All Rubber Accessories shown in the finish schedule or listed in this specification for heavy traffic areas shall be Roppe's _____ (insert design name) RUBBER ACCESSORIES, manufactured by Roppe Corporation, Fostoria, Ohio. Rubber Accessories shall be homogeneously constructed of first-quality resilient rubber compound, and shall be free of objectionable odors, blister, cracks and other imperfections which will affect the serviceability of the accessories.



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5. Product Limitations/Precautions

Always dry-lay each rubber accessory before beginning to ensure the desired look is achieved. Roppe Rubber Accessories are designed for interior use only. Notice: It is the Flooring Installer's direct responsibility to inspect and loose lay all accessories in the room or area prior to installation to determine the proper layout and best overall appearance. Flooring Installer must inspect all material for manufacturing imperfections and irregularities prior to installation. All manufacturing imperfections or irregularities must be reported to the appropriate authority. Roppe Flooring Related Rubber Accessories must be installed using ROP535U "Universal" Two-Component Urethane Enhanced Epoxy Adhesive (All Rubber Stair Nosings & #57 Landing Trim must be installed in conjunction with ROPECC Epoxy Caulking Compound). Non-Flooring (Cove Caps) Related Rubber Accessories must be installed with the recommended adhesive noted within this document. **Caution:** DO NOT STRETCH the rubber accessories. The rubber accessories can be stretched while rolling and will later return to its original length resulting in gaps. Note: It is important to always hand-roll the rubber accessories in the direction toward the last piece installed. If only a single accessory is being installed, roll in one direction only. Do not roll material in two directions. This practice will ensure a tight fit. Bond the rubber accessories to approve substrates within 15 minutes after applying adhesive and lightly roll with a hand wall base roller. Periodically check the back of the rubber accessories to make sure good adhesive transfer occurs. At least 90% of the rubber accessories must be covered with adhesive. DO NOT clean, rub or apply lateral or vertical pressure to the rubber accessories for at least 72 hours after the installation is complete to allow the adhesive to properly cure. Rubber Accessories may be stained if it is allowed to remain in contact with other rubber products that may contain staining ingredients such as tires, casters, walk-off mats, and walk-off residue from asphalt driveways and sealers. Fading can occur from extensive exposure to heavy direct or glass-filtered sunlight, or unfiltered ultra-violet rays. Excessive heat from non-environmentally controlled areas, glass-filtered or direct sunlight or unfiltered ultra-violet rays can also have an adverse effect on the adhesive also, and should be avoided to prevent adhesive bond failure. Ensure any disinfectant, cleaning agent, dye, floor care product, pesticide, chlorine or other chemical (solid, liquid, or gas) that may come in contact with the flooring will not produce permanent discoloration and/or damage to the flooring. If any chemical that may come in contact with the flooring is not on the stain resistance chart, the rubber must be tested prior to installation. Roppe Rubber Accessories are not to be used in commercial kitchens or in areas exposed to animal fats, greases, oils, solvents, strong detergents, or where there is excessive topical moisture. DO NOT drag or move objects across the flooring or drop objects onto the flooring that may cause damage to the flooring. Use appropriate floor and furniture protection devices. Rubber Accessories are not to come in contact with direct heat, such as radiators, hot ovens, or other heated equipment. Ensure the proper product is used for the service application with regard to type and amount of traffic. Roppe Rubber Accessories is for indoor use only with temperatures maintained from 65°F (19°C) and 85°F (30°C). Color selections must be made from actual samples as exact matching of color or shade may vary. Rubber accessories may be installed over radiant heated floors provided the surface temperature is maintained between 65⁰



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F (19°C) and 85° F (30°C). If radiant-heated floors have cooled after installation, a gradual increase in temperature is required to prevent adhesive bond from being adversely affected. Follow all local, state, and federal safety standards and practices.

6. Installation

6.1 General Preparation and Conditioning

Always dry-lay each rubber accessory before beginning to ensure the desired look is achieved. Roppe Rubber Accessories are designed for interior use only. Notice: It is the Flooring Installer's direct responsibility to inspect and loose lay all accessories in the room or area prior to installation to determine the proper layout and best overall appearance. Flooring Installer must inspect all material for manufacturing imperfections and irregularities prior to installation. All manufacturing imperfections or irregularities must be reported to the appropriate authority. Roppe Flooring Related Rubber Accessories must be installed using ROP535U "Universal" Two-Component Urethane Enhanced Epoxy Adhesive (All Rubber Stair Nosings & #57 Landing Trim must be installed in conjunction with ROPECC Epoxy Caulking Compound). Non-Flooring (Cove Caps) Related Rubber Accessories must be installed with the recommended adhesive noted within this document. **Caution:** DO NOT STRETCH the rubber accessories. The rubber accessories can be stretched while rolling and will later return to its original length resulting in gaps. Note: It is important to always hand-roll the rubber accessories in the direction toward the last piece installed. If only a single accessory is being installed, roll in one direction only. Do not roll material in two directions. This practice will ensure a tight fit. Bond the rubber accessories to approve substrates within 15 minutes after applying adhesive and lightly roll with a hand wall base roller. Periodically check the back of the rubber accessories to make sure good adhesive transfer occurs. At least 90% of the rubber accessories must be covered with adhesive. DO NOT clean, rub or apply lateral or vertical pressure to the rubber accessories for at least 72 hours after the installation is complete to allow the adhesive to properly cure. Rubber Accessories may be stained if it is allowed to remain in contact with other rubber products that may contain staining ingredients such as tires, casters, walk-off mats, and walk-off residue from asphalt driveways and sealers. Fading can occur from extensive exposure to heavy direct or glass-filtered sunlight, or unfiltered ultra-violet rays. Excessive heat from non-environmentally controlled areas, glass-filtered or direct sunlight or unfiltered ultra-violet rays can also have an adverse effect on the adhesive also, and should be avoided to prevent adhesive bond failure. Ensure any disinfectant, cleaning agent, dye, floor care product, pesticide, chlorine or other chemical (solid, liquid, or gas) that may come in contact with the flooring will not produce permanent discoloration and/or damage to the flooring. If any chemical that may come in contact with the flooring is not on the stain resistance chart, the rubber must be tested prior to installation. Roppe Rubber Accessories are not to be used in commercial kitchens or in areas exposed to animal fats, greases, oils, solvents, strong detergents, or where there is excessive topical moisture. DO NOT drag or move objects across the flooring or drop objects onto the flooring that may cause damage to the flooring. Use appropriate floor and furniture protection devices. Rubber Accessories are not to come in contact with direct heat, such as radiators, hot ovens, or other heated equipment. Ensure the proper product is used for the service application



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with regard to type and amount of traffic. Roppe Rubber Accessories is for indoor use only with temperatures maintained from 65° F (19°C) and 85° F (30°C). Color selections must be made from actual samples as exact matching of color or shade may vary. Rubber accessories may be installed over radiant heated floors provided the surface temperature is maintained between 65° F (19°C) and 85° F (30°C). If radiant-heated floors have cooled after installation, a gradual increase in temperature is required to prevent adhesive bond from being adversely affected. Follow all local, state, and federal safety standards and practices.

6.2 Subfloor/Substrate Inspection and Preparation

6.2.1 All subfloors/substrates must be inspected prior to installation. All substrates must be clean, smooth, permanently dry, flat, and structurally sound. The substrate must be free of moisture, dust, sealers, paint, primers, curing compounds, parting agents, residual adhesives, adhesive removers, hardeners, resinous compounds, solvents, wax, oil, grease, asphalt, gypsum compounds, alkaline salts, excessive carbonation or laitance, mold, mildew, any other extraneous coatings, films, materials and all other foreign matter which might interfere/restrict proper adhesive bonding. DO NOT use sweeping compounds, solvents, adhesive removers, or acid etching to clean the substrate. DO NOT install flooring over gypsum-based or plaster based leveling or patching compounds. DO NOT install new floor covering over old floor covering, as the old floor covering may not be adequately bonded, hide possible structural defects, or cause plasticizer migration into the new flooring. In renovation or remodel work, remove all existing *adhesive residue so that 100% of the overall area of the original subfloor/substrate is exposed. Follow The Resilient Floor Covering Institute's (RFCI) "Recommended Work Practice for Removal of Existing Floor Covering and Adhesive, and all applicable industry, local, state, and federal standards. Care must be taken to analyze the conditions and correct any problems prior to installation. Follow the manufacturer's recommendations for any patching or underlayment materials, excluding gypsum based or plaster based levelers or patching compounds.* Some previous manufactured asphaltic "cutback" contained asbestos. For removal instructions, refer to the Resilient Floor Covering Institute's publication "Recommended Work Practices for Removal of Resilient Floor Covering".

6.2.2 Concrete substrates on all Grade Levels must be tested in accordance with ASTM F 1869 Standard Test Method for Measuring Moisture Vapor Emission Rate of Concrete Subfloor Using Anhydrous Calcium Chloride or ASTM F 2170 Standard Test Method for Determining Relative Humidity in Concrete Floor Slabs using *in situ* Probes to quantitatively determine the amount of moisture vapor emission at least one week prior to the installation. **Caution:** ASTM F 1869 or ASTM F 2170 tests cannot predict long-term moisture conditions of concrete slabs. Moisture testing only indicates moisture conditions at the time the tests are performed. Before conducting ASTM F 1869 or ASTM F 2170 test, the installation area must be maintained between for 65° F (19°C) and 85° F (30°C) or at least 48 hours prior to testing, during testing and thereafter. In addition, the concrete's temperature range must also be identical to that of the installation area. Conduct three test for the first 1,000 sq. ft. and one additional test for each 1,000 sq. ft. or fraction thereof per grade level. The Vapor Emission Rate shall not exceed 5.0 lbs and Relative Humidity Test shall not exceed 75% when using ROP535U Universal Urethane Enhanced



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Epoxy Adhesive or ROPECC Epoxy Caulking Compound. If the substrate does not meet the above noted requirements, the flooring shall not be installed until the problem has been corrected. DO NOT install flooring if there is hydrostatic pressure. Every concrete floor slab on-grade or below grade to receive resilient flooring shall have a permanent, effective moisture vapor retarder installed below the slab. A pH test must be performed to test for excessive alkalinity using a pH pencil or litmus paper and deionized water. A scaly, sandy, or powdery surface is an indication of some form of contaminant, usually excessive alkalis or an alkali-silica residue. A pH reading higher than 8 is an indication of a potential problem and the concrete must be neutralized by rinsing with clear water. Apply clear water with a mop and allow to dry. Re-rinse with clear water, allow to dry and retest to ensure pH level is within acceptable range of 5 to 8 on the pH scale. Continue to neutralize until the pH level is acceptable. The testing of concrete for alkalinity indicates the degree of alkalinity only at the time the test is conducted, and cannot be used to predict long-term conditions. Moisture and alkali salts in the concrete can cause the following problems after installation: adhesive deterioration, bumps, ridges, bubbles, discoloration, mold, mildew, bacteria growth, efflorescence, tile shifting, tile releasing, tile peaking, or sheet seam curling. DO NOT install over burnished (slick troweled) concrete to avoid adhesive and underlayment patch or self-leveling bonding problems due to the non-porosity of the concrete finish. Corrective measures such as bead blasting (shot blasting) or scarifying must be performed prior to installation. The concrete slab must be of good quality, standard density concrete with low water/cement ratios consistent with placing and finishing requirements, having a maximum slump of 4", a minimum compressive strength of 3500 psi, and following the recommendations of ACI Standard 302.1R-96 for class 2 or call 4 floors and the Portland Cement Association's recommendations for slabs on ground. Joints such as expansion joints, contraction joints, isolation joints, saw cuts, control joints, grooves or other moving joints shall not be filled with patching compound or covered with resilient flooring. Expansion joint covers designed for use with resilient flooring should be used. Any non-moving surface cracks, depressions, and other irregularities shall be filled and smoothed with a high quality grade Portland cement-based, water resistant, non-shrinking, non-staining, mildew resistant, alkali resistant underlayment having a minimum compressive strength of 3500 psi after 28 days. Some underlayments may fail under excessive weight; an epoxy caulking compound may be required for certain repairs. Mechanically cleaning the substrate by shot-blasting, scarifying, or sanding shall be performed to achieve a flat, smooth, clean surface to prevent irregularities, roughness, or other defects from telegraphing through the new resilient flooring. The surface of the concrete shall be flat to within the equivalent of 3/16" in 10 feet, as described in ACI 117R. The surface shall be cleaned of all loose material by scraping, brushing, vacuuming, or other methods, or a combination thereof, immediately before commencing installation of resilient flooring. Follow the proper safety practices during the preparation and installation. Follow the recommendations of the American Concrete Institute (ACI 302.1R, *Guide for Concrete Floor and Slab Construction*; ACI 360.R, *Design of Slabs on Grade*; ACI 223, *Standard Practice for the Use of Shrinkage-Compensating Concrete*); The American Society for Testing and Materials (ASTM F 710, *Standard Practice for Preparing Concrete Floors and Other Monolithic Floors to Receive Resilient Flooring*), and the American National Standards Institute (ANSI A157.1, *Recommended Practice for Concrete Floor and Slab Construction*) for the preparation of concrete to receive resilient flooring. Refer to 6.2.1.



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6.2.3 Wood subfloors to be used as subfloors/substrates are to follow the procedures recommended in 6.2.1 and 6.2.2. Wood subfloors should be of double layer construction with a minimum thickness of 1". Crawl spaces underneath wood subfloors shall be in compliance with local building code ventilation practices and have clearance of at least 18" of cross-ventilated space between the ground level and joists. Wood joists should be spaced on no more than 16" centers. Place a moisture retarder; having a maximum rating of 1.0 perm, on the top of the ground under the wood subfloor overlapped at least 8". APA, The Engineered Wood Association, Underlayment Grade plywood, minimum 3/8" thick, with a fully sanded face is to be used. Use APA approved exterior grade plywood if finished floors are subjected to moisture. OSB, lauan, maranti, solid-core mahogany, waferboard, particleboard, chipboard, flakeboard, tempered hardboard, glass mesh mortar units or cementitious tile backer boards, sheathing-grade plywood, preservative-treated plywood, or fire-retardant treated plywood are not recommended as some manufacturers may use resins or other adhesives in the manufacturing of the product that may cause discoloration or staining of the flooring. Wood subfloor movement, flexing or instability will cause the flooring installed to release, buckle or become distorted. Do not proceed with the installation until corrective measures have been made. The warranties, performance, installation, and use are the responsibility of the manufacturer and/or contractor. DO NOT use plastic or resin filler to patch cracks. DO NOT use cement or rosin coated nails or staples or solvent-based construction adhesive to adhere the plywood. Installation on a sleeper, a wood subfloor system constructed over the top of concrete, is not recommended. Installation directly over Sturd-I-Floor panels is not recommended. All wood subfloors, single construction plywood floors, single and/or double tongue-and-groove strip floors, and wood plank floors must be prepared to receive resilient flooring in accordance with federal and industry standards. Follow the recommendations of the APA, The Engineered Wood Association, *Design/Construction Guide, Residential and Commercial*, and ASTM F 1482, *Standard Guide to Wood Underlayment Products Available for Use Under Resilient Flooring*, for the installation and proper construction of the panels to receive resilient flooring. It is the contractor's responsibility to determine if the subfloor is acceptable to receive the flooring.

6.2.4 Cementitious Terrazzo and ceramic floors to be used as subfloors/substrates are to follow the procedures recommended for concrete in 6.2.1 & 6.2.2. Ceramic tile must be solidly adhered and all loose tiles must be removed and repaired or replaced. Ensure all glazed, sealed, smooth, and/or shiny surfaces are properly sanded and cleaned. Fill all grout lines and other irregularities with a manufacturer's recommended Portland cement-based underlayment with a minimum compressive strength of 3500 psi. The subfloor must be structurally sound. Inspect and ensure there is an adequate bond of the old flooring to the original substrate. Do not install over epoxy based terrazzo. Cementitious terrazzo must first be sanded to remove all finishes, and then cleaned. Conduct a bond test with adhesive to ensure a successful bond can be achieved before installing. Roppe **will not** warranty the product if there is a bond failure caused by problems relating to the old flooring.

6.2.5 Metal floors to be used as subfloors/substrates must be thoroughly cleaned of any residue, oil, paint, primer, sealer, rust, and oxidation and properly sanded/grinded to provide a



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smooth, level, clean substrate to receive flooring. The flooring must be installed within 12 hours after sanding/grinding to prevent the metal from re-oxidizing. The metal subfloor shall be structurally sound. Deflection of the metal can cause a bond failure between the adhesive and the metal substrate. It is the contractor's responsibility to decide the feasibility of the application, and Roppe Corporation will not be held liable for failures caused by flexing or deterioration of metal substrates. On an extremely smooth, non-porous, metal substrate, a longer "tack up" may be required in order to prevent the adhesive from oozing between the seams. Refer to 6.2.1. Caution: The installation of flooring material will not prevent deterioration of metal substrates from occurring.

6.2.6 Wall Surface Applications (Cove Caps and Corner Guards):

All surfaces should be inspected prior to installation. Use only on structurally sound interior wall surfaces such as dry plaster, cured drywall, exterior grade plywood (Group 1, CC type), concrete, and masonry that are clean, smooth, dry, and structurally sound. Roppe Wall Surface Products (i.e.: Cove Caps & Corner Guards) are not to be installed over non-porous surfaces such as vinyl or rubber wall coverings, laminated masonite, plastic laminates, FRP Panels, ceramic tile, marble or non-porous paints, or freshly painted surfaces, or over existing alcohol resin adhesives. If needed to install on a wall with vinyl wall covering, the wall covering must be first be cut and remove the wall covering exposing the drywall completely. Cut the wall covering leaving ¼" (6.35mm) margin below where the top of the material to be installed. All surfaces must be completely free from moisture, alkali, old adhesive, dust dirt, wax, oil, grease, loose paint, or plaster, non-porous wall coverings or paints, and other extraneous coatings or materials that could prevent a successful bond. Plaster and cement must be thoroughly dry and cured. Any rough or uneven surfaces may telegraph through the wall base. Follow the manufacturer's recommendations for any patching materials. Warning: When removing old wall base, accessories or adhesives, unless they can be positively identified not to contain hazardous materials, you must presume the materials may contain hazardous materials. Follow the recommended practices for the proper removal and disposal of the materials.

6.3 Adhesive Application

6.3.1 Roppe 535U "Universal" Urethane Enhanced Epoxy Two-Part Adhesive

Roppe 535U "Universal" Urethane Enhanced Epoxy is a solvent-free two-component adhesive for high performance installations. ROP535U "Universal" is recommended for indoor installations over properly prepared and recommended concrete, plywood, metal and other non-porous substrates, on grade, below grade, or above grade. Spread coverage using the 1/32" deep x 1/16" wide x 1/32" "U" notch trowel is approximately 125-185 square feet (Part A & B Mixed) per US gallon when applied over smooth substrates (i.e.: metal). Coverage will vary according to the type of surface, surface texture, spreading angle, and adhesive temperature. Note: Over extremely porous or rough concrete, a 1/16"x 1/16" x 1/16" Square notch trowel may be required (100-125 sq/ft/gal). Adhesive is available in 1-gallon units. Shelf life is one year @ 70°F (21°C) in an unopened container. Approximate Working Time: After properly mixed and immediately emptied onto substrate or applied to accessory backing: 30 - 40 minutes (depending on substrate temperature & trowel size). Although the epoxy components are non-freezing, the



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adhesive must be allowed to stabilize to ambient temperature before mixing. Before applying the recommended ROP535U, all backing must first be thoroughly cleaned with Denatured Alcohol (always follow manufacturer's recommendations, cautions and warnings etc.) and a clean white cloth to remove any other contaminants which could interfere with the bonding process. Once cleaned with Denatured Alcohol, allow backing to dry completely before applying recommended Roppe Adhesive and test to ensure a successful bond can be achieved. Any adhesive on the surface of the accessory or surrounding area must be removed immediately with a clean cloth dampened with warm soapy water or denatured alcohol. DO NOT allow the adhesive to cure on the surface of the rubber accessories or surrounding areas. A bond failure will occur if the epoxy is not properly mixed. Read all of the product and safety information concerning the adhesive and any other chemicals or cleaning agents prior to installation.

Roppe 535U "Universal" Solvent Free Urethane Enhanced Epoxy Flooring Adhesive Calculated VOC's according to California Rule #1168: Roppe 535U Part A: 1.3 grams per liter of coating. Roppe 535U Part B: 2.4 grams per liter of coating. ROP535U Part A & Part B Mixed Calculated VOC's: 1.21 grams per liter of coating.

6.3.2 Roppe ECC Epoxy Caulking Compound:

6.3.3 ROPECC Epoxy Caulking Compound

ROPECC Epoxy Caulking Compound (nose filler) is a Solvent-free epoxy caulking compound designed specifically to prevent the flexing and premature cracking of Roppe Rubber Stair Nosing/Landing Trim, and recommended to install additional specifically specified Roppe products. When installing Rubber Stair Nosing/Landing Trim, ROPECC Epoxy Caulking Compound is applied directly inside the internal nose area of nosing, prior to installation, and when uniformly and properly applied fills slight voids or gaps between the internal nose angle of the rubber stair nosing/landing trim and steps nose, developing a strong bonding support between the two surfaces. **Caution:** Do Not apply ROPECC directly over adhesives being used in conjunction with ROPECC. Before applying the recommended Roppe Adhesive or ROPECC Epoxy Caulking Compound, all backing must first be thoroughly cleaned with Denatured Alcohol (always follow manufacturer's recommendations, cautions and warnings etc.) and a clean white cloth to remove any other contaminants which could interfere with the bonding process. Once cleaned with Denatured Alcohol, allow backing to dry completely before applying recommended Roppe Adhesive and test to ensure a successful bond can be achieved. **Caution:** When applying ROPECC Epoxy Caulking Compound (nose filler) in cartridges, the first six inches (6") of unmixed material from each cartridge must be discarded to prevent bond failure and oozing of unmixed material! Only use the recommend ROPECC Epoxy Caulking Gun to apply ROPECC Epoxy Caulking Compound. ROPECC Epoxy Caulking Compound is available in 1-quart and 1-gallon pails and in 13.5 ounce dual cartridges. Shelf life is one year @ 70° F (21° C) in an unopened container. Spread coverage is approximately 200 linear feet per US gallon on a smooth substrate. Spread rate using the 13.5 oz. dual cartridge applicator with the required 1/2" bead in the stair treads nosing is approximately 25 linear feet. Coverage will vary according to the type of surface, surface texture, and adhesive temperature. Although the epoxy components are non-freezing, the adhesive must be allowed to stabilize to ambient temperature before



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mixing. Any adhesive on the surface of flooring material or surrounding area must be removed immediately with a clean cloth dampened with denatured alcohol. DO NOT allow the adhesive to cure on the surface of the accessory. A bond failure will occur if the epoxy is not properly mixed to one consistent color. Read all of the product and MSDS literature.

Roppe ROPECC Epoxy Caulking Compound (Stair Tread Nose Filler) Calculated VOC's according to California Rule #1168: Roppe ROPECC Part A: 2 grams per liter of coating. Roppe ROPECC Part B: 21 grams per liter of coating.

6.4 Adhesive Application and Product Installation

6.4.1 Square Nose & Round Nose Rubber Stair Nosing & Landing Trim - Adhesive Application and Product Installation

Always conduct a test to ensure the correct installation radius can be achieved. If the installation radius of the Rubber Stair Nosing/Landing Trim does not fit the radius of the step, do not proceed. Do not proceed with installation unless a tight secure fit to the steps nosing/surface can be achieved. Stair Nosing/Landing Trims must be installed prior to installing adjoining floor covering. Measure the length of the step and transfer measurements to the stair nosing/landing trim. Utilize a razor knife and straight edge to cut the stair nosing/landing trim to the desired length. A radial arm saw equipped with an 80 tooth or greater Carbide Tip Blade can also be utilized to cut stair nosing/landing trim. After stair nosing/landing trim has been cut, clean the entire backing, including the stair tread/landing trim's internal nosing with Denatured Alcohol (follow all warning and cautions) and a clean white cloth to remove containments which may interfere with the adhesive bonding process. When installing Square Nose Rubber Stair Nosings/Landing Trim, first apply at least a full 1/2" bead of ROPECC Epoxy Caulking Compound into the internal nose of the stair nosing/landing trim to fill all voids between the internal angle of the stair nosing/landing trim and the steps nosing. **Caution:** When applying ROPECC Epoxy Caulking Compound (nose filler) in cartridges, the first six inches (6") of unmixed material from each cartridge must be discarded to prevent bond failure and oozing of unmixed material! Only use the recommend ROPECC Epoxy Caulking Gun to apply ROPECC Epoxy Caulking Compound. To adhere the rubber stair nosing/landing trim directly to the steps surface and riser surface, ROP535U Universal Urethane Enhanced Epoxy Adhesive is required. Remove the lids of ROP535U both Part A and Part B and add all of Part B into Part A. DO NOT mix partial units of this adhesive! ROP535U Adhesive is packaged in two separate containers marked Part A (polyurethane epoxy resin) and Part B (polyamide resin, hardener). Mix the combined parts (A&B) adhesive by hand or use a slow speed less than 300 RPM maximum drill with an attached mixing paddle. While mixing, lift from the bottom of the pail to ensure material is mixed consistently. Mix 3-5 minutes. After mixing, the adhesive must be one consistent solid color. **Caution:** Higher mixing speeds and/or longer mixing time will reduce the open time/working time and can cause premature curing of the adhesive. Adhesive will not cure if not properly mixed. DO NOT allow the mixed epoxy adhesive to remain in the container. After mixing, immediately spread the adhesive evenly and completely to the entire backing of the stair nosing/landing trim, including the vertical



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section of the stair nosing/landing trim, using the recommended trowel depending on substrate type. **Caution:** Do Not spread ROP535U directly over the previously applied ROPECC. Doing so will result in an adhesive and bond failure. Spread coverage using the 1/32" deep x 1/16" wide x 1/32" "U" notch trowel is approximately 175 square feet (Part A & B Mixed) per US gallon when applied over smooth substrates (i.e.: metal). Coverage will vary according to the type of surface, surface texture, spreading angle, and adhesive temperature. Note: Over extremely porous or rough concrete, a 1/16"x 1/16" x 1/16" Square notch trowel may be required (125 sq/ft/gal). Install Stair Nosing/Landing Trim while both adhesives are still wet. Do not let ROP535U or ROPECC to dry. At least a 90% transfer of ROPECC and ROP535U must be achieved. After applying adhesives, position stairs nosing/landing trim on step and then roll all vertical and horizontal areas of stair nosing with hand-roller. Do not roll the nosing area of the stair nosing/landing trim. Doing so will displace ROPECC resulting in either/or a bonding failure or stair nose cracking. DO NOT wait until the entire installation is completed before rolling as the adhesive may have surpassed the open time and be cured. **Caution:** DO NOT STRETCH the rubber accessories. The rubber accessories can be stretched while rolling and will later return to its original length resulting in gaps. Note: It is important to always hand-roll the rubber accessories in one direction, or when installing multiply pieces, roll in the direction toward the last piece installed. Do Not roll material in two directions. This practice will ensure a tight fit. Re-roll stair nosing/landing trim 30 minutes after initial rolling. Work off the stair nosing/landing trim to avoid shifting and prevent permanent adhesive displacement, and to also not track the adhesive onto nosing. Periodically, lift the nosing/landing trim to check for proper adhesive transfer. Secure stair nosing/landing trim to the surface of the step and riser until adhesives have completely cured using 3M Blue Tape. Apply tape to stair nosing/landing trim both vertically and horizontally. Once adhesives have fully cured, remove 3M Blue Tape before exposing to traffic or installing adjoining flooring material. Do Not Clean Stair Nosing/landing Trim or allow traffic of any kind for at least 72 hours. Read product limitation/precautions and installation literature before proceeding. Follow safety precautions on the adhesive label and Material Safety Data Sheet. Must have adequate ventilation.

6.4.3 Round Nose Rubber Stair Nosing Installation:

Always conduct a test to ensure the correct installation radius can be achieved. If the installation radius of the Rubber Stair Nosing does not fit the radius of the step, do not proceed. Do not proceed with installation unless a tight secure fit to the steps nosing/surface can be achieved. Stair Nosing must be installed prior to installing adjoining floor covering. Measure the length of the step and transfer measurements to the stair nosing. Utilize a razor knife and straight edge to cut the stair nosing to the desired length. A radial arm saw equipped with an 80 tooth or greater Carbide Tip Blade can also be utilized to cut stair nosing. After stair nosing has been cut, clean the entire backing, including the stair tread's internal nosing with Denatured Alcohol (follow all warning and cautions) and a clean white cloth to remove containments which may interfere with the adhesive bonding process. Then apply ROPECC Epoxy Caulking Compound to approximately 1/2" inch from the top curvature of the round nose stair tread completely covering the entire backing of the nosing to achieve a successful bond directly to the steps nosing. When applying ROPECC Epoxy Caulking Compound (nose filler) in cartridges, the first six inches (6")



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of unmixed material from each cartridge must be discarded to prevent bond failure and oozing of unmixed material! Only use the recommend ROPECC Epoxy Caulking Gun to apply ROPECC Epoxy Caulking Compound. To adhere the rubber stair nosing directly to the steps surface, ROP535U Universal Urethane Enhanced Epoxy Adhesive is required. Remove the lids of ROP535U Part A and Part B then add all of Part B into Part A. DO NOT mix partial units of this adhesive! ROP535U Adhesive is packaged in two separate containers marked Part A (polyurethane epoxy resin) and Part B (polyamide resin, hardener). Mix the combined parts (A&B) adhesive by hand or use a slow speed less than 300 RPM maximum drill with an attached mixing paddle. While mixing, lift from the bottom of the pail to ensure material is mixed consistently. Mix 3-5 minutes. After mixing, the adhesive must be one consistent solid color. **Caution:** Higher mixing speeds and/or longer mixing time will reduce the open time/working time and can cause premature curing of the adhesive. Adhesive will not cure if not properly mixed. DO NOT allow the mixed epoxy adhesive to remain in the container. After mixing, immediately spread the adhesive evenly and completely to the entire backing of the stair nosing using the recommended trowel depending on substrate type. However, Do Not spread ROP535U directly over the previously applied ROPECC. Doing so will result in an adhesive and bond failure. Spread coverage using the 1/32" deep x 1/16" wide x 1/32" "U" notch trowel is approximately 175 square feet (Part A & B Mixed) per US gallon when applied over smooth substrates (i.e.: metal). Coverage will vary according to the type of surface, surface texture, spreading angle, and adhesive temperature. Note: Over extremely porous or rough concrete, a 1/16"x 1/16" x 1/16" Square notch trowel may be required (125 sq/ft/gal). Install Stair Nosing while both adhesives are still wet. Do not allow ROP535U or ROPECC to dry. At least a 90% transfer of ROPECC and ROP535U must be achieved to both the stair nosing and steps nosing. After applying adhesives, position stairs nosing on step and then roll stair nosing with hand-roller. Do not roll the nosing area of the stair nosing. Doing so will displace ROPECC resulting in either/or a bonding failure or stair nose cracking. DO NOT wait until the entire installation is completed before rolling as the adhesive may have surpassed the open time and be cured. **Caution:** DO NOT STRETCH the rubber accessories. The rubber accessories can be stretched while rolling and will later return to its original length resulting in gaps. Note: It is important to always hand-roll the rubber accessories in one direction, or when installing multiply pieces, roll in the direction toward the last piece installed. Do Not roll material in two directions. This practice will ensure a tight fit. Re-roll stair nosing within 30 minutes after initial rolling. Work off the stair nosing to avoid shifting and prevent permanent adhesive displacement, and to also not track the adhesive onto nosing. Periodically, lift the nosing to check for proper adhesive transfer. Secure stair nosing to the surface of the step until adhesives have completely cured using 3M Blue Tape. Apply tape to stair nosing both vertically and horizontally. Once adhesives have fully cured, remove 3M Blue Tape before exposing to traffic or installing adjoining flooring material. Do Not Clean Stair Nosing or allow traffic of any kind for at least 72 hours. Read product limitation/precautions and installation literature before proceeding. Follow safety precautions on the adhesive label and Material Safety Data Sheet. Must have adequate ventilation.



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6.4.4 Thresholds, Adapter & Transitions Installation:

Always conduct a test to ensure the correct installation radius can be achieved. If the installation radius can not be achieved, do not proceed. Roppe Rubber Thresholds, Adapters and Transitions are to be adhered with ROP535U Universal Urethane Enhanced Epoxy Adhesive or ROPECC Epoxy Caulking Compound directly over recommended substrates listed within this document. Thresholds, Adapters and Transitions must be installed prior to installing adjoining floor covering. Measure the length of the opening and transfer measurements to the rubber accessory being installed. Utilize a razor knife and straight edge to cut the rubber accessory to the desired length. Backing must first be thoroughly cleaned with Denatured Alcohol (always follow manufacturer's recommendations, cautions and warnings etc.) and a clean white cloth to remove any other contaminants which could interfere with the bonding process. Once cleaned with Denatured Alcohol, allow backing to dry completely before applying recommended Roppe Adhesive and test to ensure a successful bond can be achieved. Apply ROP535U onto the substrate using the recommend notch trowel (Section: 6.3.1) depending on substrate type. If using ROPECC to adhere, ROPECC must be applied in a 1/2" tight serpentine bead. Install material within 15 minutes of applying ROP535U or ROPECC and roll with a hand roller. Re-roll within 30 minutes after initial rolling. **Caution:** DO NOT STRETCH the rubber accessories. The rubber accessories can be stretched while rolling and will later return to its original length resulting in gaps. Note: It is important to always hand-roll the rubber accessories in one direction, or when installing multiply pieces, roll in the direction toward the last piece installed. Do Not roll material in two directions. This practice will ensure a tight fit. Work off rubber accessories to avoid shifting and prevent permanent adhesive displacement. Periodically, lift the rubber accessories to check for proper adhesive transfer. Secure rubber accessories until adhesive has completely cured using 3M Blue Tape. Once adhesives have fully cured, remove 3M Blue Tape before exposing to traffic or installing adjoining flooring material. Do Not Clean Rubber Accessories or allow traffic of any kind for at least 72 hours. Must have adequate ventilation.

6.4.4 Cove Caps Installation:

Always conduct a test to ensure the correct installation radius can be achieved. If the installation radius can not be achieved, do not proceed. Cove Caps are to be adhered with ROP535U Universal Urethane Enhanced Epoxy Adhesive or ROPECC Epoxy Caulking Compound directly over recommended substrates listed within this document. Cove Caps must be installed prior to installing adjoining floor covering. Measure the length of the opening and transfer measurements to the rubber accessory being installed. Utilize a razor knife and straight edge to cut the rubber accessory to the desired length. Backing must first be thoroughly cleaned with Denatured Alcohol (always follow manufacturer's recommendations, cautions and warnings etc.) and a clean white cloth to remove any other contaminants which could interfere with the bonding process. Once cleaned with Denatured Alcohol, allow backing to dry completely before applying recommended Roppe Adhesive and test to ensure a successful bond can be achieved. Apply ROP535U onto the substrate using the recommend notch trowel (Section 6.3.1) depending on substrate type. If using ROPECC to adhere, ROPECC must be applied in a 1/2"



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tight serpentine bead. Install material within 15 minutes of applying ROP535U or ROPECC and roll with a hand roller. Re-roll within 30 minutes after initial rolling. **Caution:** DO NOT STRETCH the rubber accessories. The rubber accessories can be stretched while rolling and will later return to its original length resulting in gaps. Note: It is important to always hand-roll the rubber accessories in one direction, or when installing multiply pieces, roll in the direction toward the last piece installed. Do Not roll material in two directions. This practice will ensure a tight fit. Periodically, lift the rubber accessories to check for proper adhesive transfer. Secure rubber accessories until adhesive has completely cured using 3M Blue Tape. Once adhesives have fully cured, remove 3M Blue Tape before exposing to traffic or installing adjoining flooring material. Do Not Clean rubber accessories for at least 72 hours. Must have adequate ventilation.

6.4.5 Corner Guard Installation:

Corner Guard must be adhered with ROPECC Epoxy Caulking Compound over recommended substrates within this document. Measure the length of the opening and transfer measurements to Corner Guard. Utilize a razor knife and straight edge to cut the corner guard to the desired length. Backing must first be thoroughly cleaned with Denatured Alcohol (always follow manufacturer's recommendations, cautions and warnings etc.) and a clean white cloth to remove any other contaminants which could interfere with the bonding process. Once cleaned with Denatured Alcohol, allow backing to dry completely before applying recommended Roppe Adhesive and test to ensure a successful bond can be achieved. Once dry, apply ROPECC in a tight serpentine bead pattern and adhere to wall. Roll Corner Guard with a hand roller in one direction only. Re-roll within 30 minutes after initial rolling. **Caution:** DO not stretch the rubber accessories. The rubber accessories can be stretched while rolling and will later return to its original length resulting in gaps. Note: It is important to always hand-roll the rubber accessories in one direction, or when installing multiply pieces, roll in the direction toward the last piece installed. Do Not roll material in two directions. This practice will ensure a tight fit.

Secure Corner Guard in place with 3M Blue Tape until adhesive has cured, then remove. Corner Guards can be stretched while rolling and will later return to its original length resulting in gaps. Note: It is important to always hand-roll the rubber accessories in one direction, or when installing multiply pieces, roll in the direction toward the last piece installed. Do Not roll material in two directions. Do Not Clean Corner Guard for at least 72 hours. Must have adequate ventilation.

7. Product Maintenance/Precautions

7.1 DO NOT clean, rub or apply lateral or vertical pressure to the rubber accessories for at least 72 hours after the installation is complete to allow the adhesive to properly cure. Some disinfectants, cleaning agents, floor maintenance products, and pesticides may stain or damage the surface of rubber accessories. Roppe Rubber Accessories can be routinely cleaned by wiping with a soft cloth slightly dampened with warm water or by using a properly diluted neutral pH cleaner. **CAUTION:** Coarse cleaning materials and/or harsh cleaning agents may damage the surface of rubber accessories. Do not allow water, solutions or cleaners of any kind to work its way between the joints of rubber accessories, which can have an adverse effect on the



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adhesive. Always check for compatibility and performance prior to cleaning by utilizing uninstalled material or test in an inconspicuous area before proceeding to determine if the desired results can be achieved without distorting the rubber accessories.

8. Availability and Cost

8.1 Products are available through Roppe distributors. Contact Roppe Customer Service at 1.800.537.9527 or visit www.roppe.com for a distributor near you.

8.2 Samples may be obtained by may be obtained by calling Roppe Customer Service at 1.800.537.9527, or by visiting www.roppe.com

9. Technical Assistance

Technical service information and assistance may be obtained by calling Roppe Customer Service at 1.800.537.9527, or by visiting www.roppe.com.

10. Limited Warranty

Roppe Corporation manufactures and markets its floor products under the trade name Roppe. Roppe Rubber Accessories is warranted for a period of one (1) year from date of installation to be free of defects in material and workmanship. Rubber Accessories are for non-transit use, based by product design and installation purpose, if installed, maintained, and used strictly in accordance with Roppe's written instructions and installed with the recommended Roppe adhesive. Refer to Roppe Product Specification Sheet before proceeding with installation. For any applications not listed, do not proceed with installation regardless of the circumstance. Instructions may be obtained from a Roppe distributor or by writing Roppe Corporation, Attention: Sales Service Manager, P.O. Box 1158, Fostoria, OH, 44830. Notice of any defect must be made in writing to Roppe within thirty (30) days after buyer learns of the defect. No merchandise is to be returned prior to Roppe's inspection and written approval. Buyer's sole and exclusive remedy against Roppe and Dealer for claims arising hereunder for any and all losses and damages resulting from any cause shall be a pro rata credit based on the period remaining in this Limited Warranty toward the purchase of new Roppe Rubber Accessories. Replacement credit shall be equal to the proportion of Limited Warranty time remaining multiplied by the current price of Roppe Rubber Accessories. In no event shall Roppe be liable for incidental or consequential damages, even if some other provision of this Limited Warranty is unenforceable. Buyer waives all other claims and remedies of any nature. Roppe Rubber Accessories is not designed for use in or near commercial kitchens or for outdoors use. Roppe shall have no liability whatsoever to Buyer in the event the goods become defective if such defect is caused in whole or part by cuts, tears, vandalism, fire, willful destruction, damage from high heels, spiked footwear, improper installation, improper maintenance, subfloor and/or substrate irregularities, accidents, natural causes, or acts of God. Roppe will not be liable for labor costs or lost profits resulting from the use of or inability to use the product. Roppe will not be liable for labor costs for material that is installed with obvious defects. Products designated as "seconds", "mill run", "non-conforming", not being of first quality, are sold as-is and Roppe makes no warranties whatsoever, expressed or implied, with respect



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thereto, including warranties of merchantability or fitness for a particular use. These warranties are expressly in lieu of any other warranties expressed or implied. By retaining Roppe's merchandise for more than five (5) days after receipt of such merchandise, Buyer agrees that it accepts the terms of this Limited Warranty and that there are no warranties or rights beyond those contained herein. All claims must be made in writing and sent to Roppe Corporation, Attn: Claims Manager, P.O. Box 1158, Fostoria, Ohio, 44830. All claims for surface defects or variations in color or pattern must be delivered to Roppe in writing before the product is installed. Roppe will not accept the return of any product without prior written approval of the Roppe Claims Department.

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