



ROPECC Epoxy Caulking Compound

Description: 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 & Vinyl Stair Treads and Rubber & Vinyl Stair Nosings. ROPECC Epoxy Caulking Compound is applied directly inside the internal nose area of the stair treads/stair nosings, prior to installation, and when uniformly and properly applied fills slight voids or gaps between the internal nose angle of the stair tread/stair nosing and steps edge, developing a strong bonding support between the two surfaces. ROPECC is also required to bond the leading edge of the stair treads/stair nosings nose directly to the riser.

Sizes: ROPECC Epoxy Caulking Compound is available in 1-quart and 1-gallon pails and in 13.5 ounce dual cartridges.

Installation Temperature Ranges: The installation area, substrate, flooring, associated material and adhesive are to be maintained between 65°F (19°C) and 85°F (30°C) for at least 48 hours before installation, during installation, and thereafter. Room temperature must be maintained between 65°F (19°C) and 85°F (30°C) thereafter to prevent adhesive failure and to prevent distortion or destruction of flooring. In addition, the subfloors temperature range must also be between 65°F (19°C) and 85°F (30°C) prior to installation, during installation and maintained thereafter.

Color: Off-White

Shelf Life: Shelf life is one year stored at 70°F (21°C) in an unopened container stored at indoor room temperature.

Freeze Thaw Stability: The adhesive is freeze/thaw stable to 5 cycles at 0°F (-18°C); however, it is recommended to protect all adhesive products from freezing. If frozen, DO NOT stir until material has completely thawed.

Clean-Up: Any adhesive on the surface of the stair treads/nosings/risers 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 material

Use: Interior installations of Roppe Rubber & Vinyl Stair Treads (Nose Filler Only), Rubber Stair Nosings (Nose Filler & Full Adhesion of both Vertical and Horizontal of rubber stair nosings only) and Vinyl Stair Nosings (Nose Filler Only).

Calculated VOC's: 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

ROPECC Qualifications: Meets CHPS, LEED, SCAQMD & CRI Green Label Plus.

Recommended Substrates: Recommended for interior installations over on, below or above grade porous substrates (concrete), approved wood underlayments, metal, cementitious terrazzo and ceramic floors. See Individual Product 10-Part Specification Sheet for complete details, cautions and warnings.

Limitations: ROPECC is required as nose filler when installing all Roppe Rubber & Vinyl Stair Treads and Rubber & Vinyl Stair Nosings. For interior use only. Do not use over painted, primed surfaces or over old adhesive residue. There is to be no foot traffic on the flooring for at least 48 hours. There is to be no maintenance performed for at least 72 hours after installation. ROPECC must be used in combination with the recommended Roppe Adhesive depending on substrate and installation type. Only use the recommend ROPECC Epoxy Caulking Gun to apply ROPECC Epoxy Caulking Compound. Secure stair treads nosing with 3M Blue Tape until ROPECC Epoxy Caulking Compound has dried. Remove tape prior to allowing traffic or cleaning. Do not apply ROPECC directly over the adhesive/tape being utilized to install the stair treads/rubber stair nosing. DO NOT mix partial units of this adhesive. Do not use over existing floor-covering.

Caution: Before applying the recommended Roppe Adhesive and ROPECC Epoxy Caulking Compound, the stair tread, riser and stringer's entire backing (including stair treads nosing) must first be thoroughly cleaned with Denatured Alcohol (always follow manufacturer's recommendations, cautions and warnings etc.) and a clean white cloth to remove the factory mold release agent applied during the manufacturing process, along with any other contaminants which could interfere with the bonding process. When applying the leading edge of the stair treads nosing to riser, the risers face must also be cleaned with Denatured Alcohol in order to remove the mold release agent. Once cleaned with Denatured Alcohol, allow backing to dry completely before applying recommended Roppe Adhesive or ROPECC Epoxy Caulking Compound, and test to ensure a successful bond can be achieved. DO NOT kneel on or against the tread nosings. 100% coverage of ROPECC Epoxy Caulking Compound in the treads nosing. DO NOT roll the stair

tread or stair nosings nose. Rolling the nosing will squeeze out the epoxy nose filler. **Cautions:** When installing flooring, either use a kneeling board, or for best results, work off the flooring to avoid shifting, adhesive displacement & adhesive telegraphing. Remove wet adhesive immediately. Do not allow adhesive to dry on the flooring, tools or surrounding areas since it may be impossible to remove. Do not allow adhesive to dry or skin-over which will result in either none or inadequate adhesive transfer resulting in an installation failure. All flooring must be properly rolled and re-rolled to ensure proper adhesive transfer. Do Not apply ROPECC directly over stair tread adhesive/tape being utilized to install stair treads/stair nosings.

Subfloor/Substrate Inspection and Preparation: 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, primers, paint, oxidation, 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, citrus 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".

Concrete Substrates: 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 Calcium Chloride test & Relative Humidity 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 tests for the first 1,000 sq. ft. and one additional test for each 1,000 sq. ft. or fraction thereof per grade level (on, below or above grade). The moisture emission shall not exceed 5.0 lbs per 1000 square feet per 24 hours as per ASTM F1869 and 75% RH as per ASTM F2170. A pH level of 8 or less is acceptable.

Wood Subfloors: Wood subfloors to be used as subfloors/substrates are to follow the procedures recommended for Subfloor/Substrate Inspection and Preparation (see above). 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.

Metal Floors: Metal floors to be used as subfloors/substrates must be thoroughly cleaned of any residue, oil, paint, sealer, rust, and oxidation and properly sanded/grinded to provide a smooth, level, clean substrate to receive stair treads and flooring. Metal floors and other substrates can only be slightly flexing. Do not install over extremely flexing substrates. The stair treads and 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, Quik-Stik Adhesive Tape, ROPECC Epoxy Caulking Compound 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. Caution: The installation of Stair Treads, risers or other flooring material will not prevent deterioration of metal substrates from occurring.

Cementitious Terrazzo and Ceramic Floors: Cementitious Terrazzo and ceramic floors to be used as subfloors/substrates are to follow the procedures recommended for concrete (see above). 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.

Mixing:

- Quart and One-Gallon Pails: Mixing required. Remove the lids and add all of Part B into Part A. Mix the combined parts by hand using the furnished paddle using a rotary motion while at the same time lifting from the bottom. DO NOT mix partial units of this adhesive! ROPECC is packaged in two separate containers marked Part A (epoxy resin) and Part B (polyamide resin, hardener). A slow speed, less than 300 RPM maximum, drill with an attached mixing paddle may also be used. Mix approximately 4 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.
- 13.5 ounce Dual Cartridges: Material is self-mixed when pumped thru cartridge tip furnished. 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 down the face of the riser! Only use the recommend ROPECC Epoxy Caulking Gun to apply ROPECC Epoxy Caulking Compound.

Application: 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. When applying ROPECC to Round Nose Vinyl Stair Treads, apply nose caulk approximately 1/2" inch from the top curvature of the stair tread completely covering the entire backing of the nosing to achieve a successful bond directly to the steps nosing. ROPECC Epoxy Caulking Compound must also be applied in a tight serpentine bead pattern covering the entire width and length of the stair treads nosing in order to adhere directly to the steps riser. 100% transfer to the products backing is required.

Warning: Follow all local, state, and federal standards and practices for the proper removal and disposal of flooring, adhesives, or other materials. Follow all local, state, federal, and manufacturer's safety standards for the use of all products and equipment.

* **Notice:** This document is intended as a general guide only. Therefore, refer to Individual Product 10-Part Specification Sheet for complete details, cautions and warnings.

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