

THICK BED PORCELAIN & STONE FLOOR ADHESIVE

Highly Polymer Modified Fast Setting Cementitious Adhesive



- ◇ Flexible
- ◇ Fully Vitrified/Porcelain & Natural Stone Tiles
- ◇ 3 Hour Set
- ◇ Interior & Exterior
- ◇ Underfloor Heating
- ◇ Plywood Overlay
- ◇ 5—25mm
- ◇ Large Size Tiles
- ◇ White & Grey
- ◇ BS EN 12004 C2F

A highly polymer modified fast setting cement-based powder adhesive available in white and grey, specially designed for fixing large format and natural stone tiles to a variety of floor surfaces in internal, external and total immersion locations. The high polymer level of the adhesive means that it only needs to be mixed with water to achieve the flexibility, water resistance and increased strength usually only obtained by the addition of separate polymer admixtures. The adhesive has excellent thermal ageing properties and is particularly suitable for heated floors and strengthened timber floors.

Not suitable for fixing to walls or other vertical surfaces.

When fixing light coloured or translucent stone Norcross Thick Bed Porcelain & Stone White
 Conforms to BS EN 12004 C2F.

Pot Life @ 20°C	Set Time @ 20°C	Bed Thickness	Coverage	Trowels
Up to 30 minutes	3 hours	3-25mm	Floors : Approx. 5kg/m ² at a bed depth of 5mm	Floors: 20mm round notches

Cement: Sand Screed	Anhydrite Screeds	Existing Vinyl/ Flooring Grade Asphalt	Existing Glazed Tiles	Heated Floors	Timber Floors	Total Immersion
Y	Y Seal & Prime As Overleaf	Y	Y Slurry Bond Coat	Y	Y Permalayer or Plywood/ Pro Board Overlay	Y



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General Surface Preparation

All surfaces should be dry, clean and strong enough to support the tiles to be fixed. All traces of dirt, dust laitance and other contaminants must be mechanically removed. Substrates should be true and flat to allow tiles to be fixed without visible lipping of tile edges. On floors, variations in surface level of the substrate which exceed 3mm under a 2 metre straight edge, should be levelled using either **Norcross Universal Floor Leveller** or **Norcross Pro 50 Levelling Compound**. This will be particularly appropriate where larger tiles, tiles with rectified

SUBSTRATE	PREPARATION
CONCRETE/ POWER FLOATED CONCRETE	Must be a minimum of 6 weeks old. This may be reduced to 48 hours if Norcross Permalayer anti-fracture membrane is used. Power Floated concrete—brush apply a slurry bond coat consisting of 2 parts adhesive: 1 part Prime Bond & allow to dry
CEMENT: SAND SCREED	Must be a minimum 21 days old. This may be reduced to 48 hours if Norcross Permalayer anti-fracture membrane is used.
ANHYDRITE/HEMIHYDRITE SCREED(GYPSUM) SCREEDS)	Dry in accordance with manufacturers recommendations. Mechanically remove all traces of laitance. Prime using progressively stronger coats of Norcross Prime Bond— 1: 4 with water: 1:3 with water & if still absorbent 1: 2 with water. Allow to dry between coats.
HEATED FLOORS	After tiling the heating should not be switched on for 14 days after which the temperature should be raised at a rate of 5°C per day to operating temperature. Undertile heating cables and mats should be encapsulated in a bed of either Norcross Pro 50 or Norcross Universal Floor Leveller
VINYL TILES/ASPHALT	Must be sound & in good condition. Prime with undiluted Prime Bond & allow to dry
EXISTING GLAZED TILES	Must be well fixed and able to support the additional weight of tiling, Thoroughly clean and degrease & allow to dry before brush applying a slurry bonding coat consisting of 2 parts adhesive: 1 part Prime Bond. Allow to dry.
PLYWOOD OVERLAY ON EXISTING TIMBER FLOORS (WBP/MARINE GRADE)**	Plywood must be minimum 15-18mm thick and be screwed to existing boards and joists with staggered joints at 300mm centres and 150mm centres along board edges. Seal back, face & edges with undiluted Prime Bond & allow to dry. All timber construction must be adequately ventilated behind to prevent warpage of boards.

In wet areas or those with intermittent wetting such as showers, moisture sensitive backgrounds should be tanked using **Norcross Wet Seal

Tanking Membrane

Mixing

The adhesive is designed to be mixed wetter than conventional cement-based adhesives and may be poured onto the substrate instead of being applied by trowel. Add approximately 3.5-4 parts adhesive powder to 1 part of cold water stirring to blend the mixed mortar to a smooth lump-free consistency. **It should be noted that using less water to achieve a stiffer mix will considerably reduce the pot life and working time of the adhesive.**

Application

Using a suitably notched trowel spread the adhesive onto the fixing surface to form parallel ribs into which the tiles should be laid with a firm twisting action. Spread only enough material that remains workable and as such fully wets out the back of the tiles. The adhesive contains special additives which cause the wet mix to gel, allowing it to be combed with a notched trowel and support the weight of large tiles. Solid void-free fixing is essential.

Tiles, especially those with deep keyed back profiles may need additional back-buttering to ensure solid bed fixing is achieved. Tiles may be grouted as soon as the adhesive bed is set. Do not use below 5°C.

Storage

Store in dry internal conditions away from direct sunlight between 5-25°C. The product has a 12 month shelf life from date of manufacture.

Technical Advice

For advice on tile installation products call **Norcross Technical Helpline** on **01782 524 140**

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Norcross Adhesives, Harewood Street, Tunstall, Stoke-on-Trent Staffordshire, ST6 5JZ	
EN 12004: 2007 + A1 : 2010	
Improved fast setting cementitious adhesive with additional characteristics for internal and external tiling	
Reaction to fire	Class E
Release of dangerous substances	See SDS
Bond strength as:	
- Early tensile adhesion strength	≥ 0.5N/mm ²
- High initial tensile strength	≥ 1 N/mm ²
Durability for:	
- High tensile adhesion strength after heat ageing	≥ 1 N/mm ²
- Tensile strength after water immersion	≥ 1 N/mm ²
- Tensile adhesion strength after freeze/thaw cycles	≥ 1 N/mm ²

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