

This document is intended to cover substrate preparation requirements and installation instructions for all Stair Tread concepts for Roppe including Rubber Stair Treads, Vinyl Stair Treads, and Riser formats. If there are any questions or concerns, please reach out to solutions@rhctechical.com.

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Recommended Adhesive Coverage Rates, Moisture and Traffic Limits after Installation*							
Adhesive	Porous	Non-Porous	RH% Limit	MVER Limit	Light	Heavy	Maintenance
AW-510	160 sq. ft.	225 sq. ft.	90%	6 lbs.	24 Hours	48 Hours	72 Hours
EN-610	25 – 50 lin. ft. / cartridge		90%	6 lbs.	8 Hours**	24 Hours	48 Hours
TP-620	164 lin. ft. / roll		90%	6 lbs.	Immediate	Immediate	Immediate
C-630	20 – 40 lin. ft. / pail		85%	6 lbs.	Immediate	Immediate	72 Hours
U-705	160 sq. ft.	235 sq. ft.	100%	12 lbs.	8 Hours	24 Hours	48 Hours
*coverages are per gallon unless noted otherwise							
*rates are approximate and subject to level of porosity as well as ambient conditions, actual values may vary							
**when used with TP-620, can be walked on immediately							
R = Roller Application, T= Trowel Application							

1. BUTTING TREADS & PATTERN ALIGNMENT

Wider stairwells and stairwells that require pattern alignment will require additional planning and dry fitting prior to installation. We recommend ordering treads the next size up to achieve these layouts and installations. Our treads are manufactured to be trimmed on each end of the length and the depth of the tread.

2. ACCESSORY ITEMS FOR INSTALLTION

2.1 DENATURED ALCOHOL

Denatured alcohol or similar product should be used to remove the ‘mold-release’ from the back side of the treads prior to installation to ensure a proper bond.

2.2 EN-610 EPOXY NOSE FILLER

The predominant step being used in construction today is the metal formed frame with a pan filled with concrete, having a nose radius of 1/2” maximum as spelled out in the ADA guidelines. When installing Rubber Stair Treads on these substrates, either new construction or remodel, they do not require the use of the EN-610 Epoxy Nose Filler. Fitting the tread properly to the step and creating a tight fit to the substrate will ensure proper installation and performance of the Stair Tread.

For installations that occur on other substrates (worn metal, wood, existing approved flooring types), the EN-610 Nose Filler may be required to ensure proper fit to the substrate. These substrates need to be verified for uneven wear and corrected appropriately using the best means available. One of these means is the EN-610 Epoxy Nose Filler. It is our recommendation to check for gaps between the radius in the nose of the tread and the substrate. If a gap greater than 1/4” is present, it is required to use the EN-610 Epoxy Nose Filler. If a gap of 1/2” or greater is present, the substrate should be prepared using other methods.

Of course, with any Stair Tread installation it is acceptable to utilize the EN-610 Epoxy Nose Filler.

When installing Vinyl Stair Treads, the EN-610 Epoxy Nose Filler is required for all installations.

3. PRE-INSTALLATION

Prior to acceptance of this document refer to website www.roppe.com to confirm that you have the most current revision. Consult all associated product literature concerning adhesive installation, maintenance and warranty prior to installation of flooring. Allow all trades to complete work prior to installation when possible. Deliver all materials to the installation location in its original packaging with labels intact. Do not stack pallets to avoid damage. Remove any plastic and strapping from packaging after delivery. Inspect all material for proper type, color and matching lot numbers if appropriate. Ensure that all adhesives intended for installation are approved for use with accessory

material. Turn off radiant-heated flooring systems 48 hours prior to installation. 48 hours after installation, gradually increase the temperature over the course of 24 hours to a maximum temperature of 85°F (29.5° C). Do not proceed with installation until all conditions have been met.

3.1 STORAGE, ACCLIMATION & SERVICE ENVIRONMENT

Ensure material is adequately stored at temperatures between 65° F (19° C) and 85° F (30° C) prior to installation. This product is designed, manufactured and tested to perform at constant temperatures, not fluctuating more than 4° from normal selected service temperatures from the allowable 65° F (19° C) - 85° F (30° C) range.

During acclimation, the site must be fully enclosed, weather tight, and material must be in the installation area with the HVAC system functional and operating at desired service temperatures for a period of 48 hours prior to installation, during the installation and for the service life of the installation afterwards.

It is recommended to maintain an ambient relative humidity between 40% and 60% for a period of 48 hours prior to installation, during the installation and for the service life of the installation afterwards.

If the material will be installed outside of the above acclimation and service temperature ranges contact Technical Services for more detailed installation recommendations. Do not proceed with installation until all conditions have been met.

3.2 PRODUCT LIMITATIONS

Stair Treads are not intended or designed for use **outdoors**, including covered walkways or areas not completely enclosed. Do not install stair tread material over LVT, cushioned vinyl, hardwood flooring, cork, rubber, or asphaltic materials. Do not install stair tread material in outdoor areas and in or around commercial kitchens or areas that may be exposed to animal or vegetable fats and oils, grease and petroleum-based hydrocarbons. Do not install in areas that may be subjected to sharp, pointed objects. Do not allow product to be directly exposed to direct sunlight or extreme heat sources, such as radiators, ovens or other high-heat equipment. Long term, extended or excessive exposure to Sunlight & UV Heat can cause discoloration or other undesirable effects, so use caution and/or window treatments in these areas. Dragging or sliding objects across the flooring may cause damage to the flooring. May be susceptible to staining from rubber tires, casters or rubber-backed walk-off mats, as well as harsh disinfectants, cleaning agents, dyes or other harsh chemicals – ensure all chemicals and materials that may come in contact with flooring surface will not stain, mar or otherwise damage the flooring material prior to use.

4. SUBSTRATE PREPARATION

In regards to substrate preparation when mechanical sanding, grinding, shot blasting and vacuuming always follow the Resilient Floor Covering Institute's (RFCI) "Recommended Work Practice for Removal of Existing Floor Covering and Adhesives", and all applicable local, state, federal and OSHA requirements in regards to Asbestos and Silica containment regulations.

All substrates must be prepared according to the following information or ASTM F710 or ASTM F1482 at a minimum, as well as applicable ACI and RFCI guidelines. Substrates must be clean, smooth, permanently dry, flat, and structurally sound. Substrates must be free of visible water or moisture, dust, sealers, paint, sweeping compounds, curing compounds, residual adhesives and adhesive removers, concrete hardeners or densifiers, solvents, wax, oil, grease, asphalt, visible alkaline salts or excessive efflorescence, mold, mildew and any other extraneous coating, film, material or foreign matter.

It is recommended that all substrates have a floor flatness of FF32 and/or a flatness tolerance of 1/8" in 6' or 3/16" in 10'. Substrates that do not meet this requirement should have a compatible cementitious patch (such as the Excelsior CP-300) or self-leveling underlayment (such as the Excelsior SU-310) installed to flatten the installation area.

All substrates must have any and all existing adhesives, materials, contaminants or bond-breakers mechanically removed via scraping, sanding, grinding or buffing with a 25 grit DiamaBrush Prep Plus tool prior to adhesive installation. In extreme situations, shot-blasting may be required. Mechanical preparation must expose at least 90%

of the original substrate. Following cleaning and removal, all substrates must be vacuumed with a HEPA approved vacuum and flat vacuum attachment to remove all surface dust. Sweeping without vacuuming will not be acceptable. **Do not use solvent/citrus based adhesive removers prior to installation.**

4.1 CONCRETE SUBSTRATES

All concrete must have a minimum compressive strength of 3500 PSI and be prepared in accordance with information below. When flooring is being installed directly over concrete, concrete surfaces that have an ICRI Concrete Surface Profile (CSP) over 4 should be smoothed with a self-leveling underlayment or a patch to prevent imperfections from telegraphing through flooring materials.

All substrates must be tested per ASTM F3191 to confirm porosity. Use a pipette or equivalent to conduct three tests by placing a .05 mL (1/4" wide) droplet of clean, potable water onto the surface. If the substrate absorbs water within 60 seconds, the substrate is considered porous. Conduct 3 tests for the first 2000 sq. ft. and one for each additional 3000 sq. ft., at least one per room. All other substrates that do not meet this requirement are considered non-porous. Ensure that all non-porous substrates are not contaminated with any aforementioned contaminants.

4.2 CONCRETE FILLED METAL PAN STEPS

When treads are installed over these steps, the concrete must be well bonded and secure without movement. The concrete also must be flush and level with rolled metal leading edge of the step. When laying a square or straight edge from back to the front of the step, if the concrete is higher than the leading edge the concrete will need to be ground level and flush. If the concrete is lower, then a compatible cementitious patch must be used to level out and make flush. Make sure that spot welds do not get in the way of the treads along the sides. Be sure that concrete is smooth and flat along the sides of the steps where it meets the stringer.

4.3 CHEMICALLY ABATED SUBSTRATES

In situations where existing flooring adhesive was removed chemically, the follow conditions now exist. Since there are known concerns with the chemical abatement process, including the following; (1) once the chemical is present in the substrate it cannot recognize the difference between the old adhesive and the new adhesive, (2) it is considered a penetrant and there is no way to know how deep into the substrate it could have penetrated into the substrate due to porosity, (3) there is no way to tell (in a short term test) if the substrate has been neutralized or rinsed (abatement chemical removed) well enough to accept new adhesive. The two most common mechanical abatement methods are shot blasting or hydro blasting. We also recommend all abatement be performed by a licensed and trained professional, familiar with local, state and federal laws.

However, if a chemical abatement has already been performed, we recommend the Mapei process to prepare the substrate to receive a finish flooring product. The Mapei process is to scour the substrate using the Planiprep SA according to Mapei instructions, the top with the Planiprep ET according to Mapei instructions. Then treat the substrate as non-porous for the selection of installation methods.

4.4 RESINOUS SUBSTRATES

When installing directly over a resinous products, such as the Excelsior MM-100 or an epoxy coating, ensure that coating is dry to the touch and has cured for the prescribed length of time. Substrate must be clean, dry, sound and free of contaminants. Resinous substrates are considered **non-porous** so ensure selected adhesives can be used over non-porous substrates and follow all installation instructions and flash times for non-porous substrates.

4.5 GYPSUM BASED SUBSTRATES

Gypsum-based substrates must have a minimum compressive strength of 3500 PSI. Gypsum substrates that do not meet this requirement may have one coat of the Excelsior MM-100 installed to improve the top layer bonding strength of the substrate. Substrate must be structurally sound and firmly bonded to the subfloor below. Any cracked or fractured areas must be removed and repaired with a compatible patch or repair product. Follow instructions for installation over a gypsum substrate. New or existing gypsum substrates may require the substrate has a primer or sealer applied just prior to finished floor being installed. Follow all manufacturers' recommendations regarding preparation for resilient flooring installation.

4.6 WOOD SUBSTRATES

Wood substrates must be prepared in accordance with ASTM F1482. Prior to installation, moisture retardant sheathing with a maximum rating of 1.0 perm must be installed beneath the wood subfloor, overlapped at least 8". Other wood subfloor materials, such as OSB, lauan, particleboard, chipboard or cementitious tile backer boards, are not acceptable subfloors. Avoid preservative treated and fire-retardant plywood, as some may be manufactured with resins or adhesives that may cause discoloration or staining of the flooring.

This also includes plywood sheathing designed for long lasting exposure to exterior climates. These also could contain resins/waxes that could stain or be considered bond breakers. Always refer to those manufactures recommendations. If the subfloor materials mentioned above are already installed or the wood substrate is old and not repairable, the use of multi-ply Underlayment Grade plywood at a minimum of ¼" thick with a fully sanded face will be required. Wood subfloor deflection, movement, or instability will cause the flooring installations to release, buckle or become distorted. As such, do not use plastic or resin filler to patch cracks. Do not use cement or rosin coated nails and staples or solvent-based construction adhesives to adhere the plywood. Only install over a properly constructed sleeper system (wood subfloor system over concrete, consult the technical department for further details) and do not install directly over Sturd-I-Floor panels.

4.7 METAL SUBSTRATES

Metal substrates must be thoroughly sanded/ground and cleaned of any residue, oil, rust and/or oxidation. Substrate must be smooth, flat and sound prior to installation. When installing in areas that may be subject to topical water or moisture and/or high humidity, an anti-corrosive coating must be applied to protect metal substrate. Contact a local paint or coating supplier for coating recommendations. Install flooring within 12 hours after sanding/grinding to prevent re-oxidation. Any deflection in the metal floor can cause a bond failure between the adhesive and the metal substrate. Be sure to follow installation procedures and trowel sizes for non-porous substrates.

Installing over Checker plate or Diamond plate is not recommended.

4.8 EXISTING STAIR TREAD SUBSTRATES

Existing rubber stair tread, vinyl stair tread and resilient flooring and LVT, as well as the adhesives used to install them, must be completely removed from the substrate prior to installation. Existing VCT, VAT, quartz tile, solid vinyl tile, sheet goods, hardwood flooring, asphaltic materials and existing adhesives or adhesive residue must have a compatible cementitious patch or underlayment installed over the substrate prior to installation. Existing hardwood flooring requires suitable underlayment grade plywood be installed over the substrate.

New stair treads may be installed over existing stone flooring substrates, such as terrazzo, porcelain or ceramic tile. Ensure existing flooring is a single layer of material and that all materials are clean, dry, sound, solid, well adhered and free of site-applied finishes, waxes and/or contaminants. Any and all loose tiles must be removed and repaired or replaced. All grout lines and irregularities must be filled and troweled flush with a suitable primer and patch such as the Excelsior NP-230 and CP-300 to prevent telegraphing of the existing floor. All existing flooring substrates that are outside of flatness tolerances that cannot be repaired with the Excelsior CP-300 patch should be leveled with the SU-310 self-leveling underlayment to achieve a smooth, flat substrate.

All existing flooring substrates must have any and all site-applied finishes and/or waxes completely removed prior to flooring installation in order to ensure a proper adhesive bond. For mechanical removal, use a low-speed buffer and 40-60 grit sandpaper. Properly prepared substrates should not have any remaining gloss or sheen. For chemical removal, ensure chemical treatments will not disrupt adhesion of the existing flooring to the substrate. Be sure to rinse the existing flooring adequately with clean, potable water to remove any and all chemicals from the surface of material.

Do not install stair treads until any moisture on, between or below existing flooring has completely dried. Ensure all dust, dirt and debris are removed prior to flooring installation.

4.9 ADHESIVE BOND TEST

Perform an adhesive bond test using an actual stair tread and adhesives being used prior to installation to determine adequacy.

5. INSTALLATION

The predominant step being used in construction today is the metal formed frame with a pan filled with concrete, having a nose radius of 1/2" maximum as spelled out in the ADA guidelines. When installing Rubber Stair Treads on these substrates, either new construction or remodel, they do not require the use of the EN-610 Epoxy Nose Filler. Fitting the tread properly to the step and creating a tight fit to the substrate will ensure proper installation and performance of the Stair Tread.

For installations that occur on other substrates (worn metal, wood, existing approved flooring types), the EN-610 Nose Filler may be required to ensure proper fit to the substrate. These substrates need to be verified for uneven wear and corrected appropriately using the best means available. One of these means is the EN-610 Epoxy Nose Filler. It is our recommendation to check for gaps between the radius in the nose of the tread and the substrate. If a gap greater than 1/4" is present, it is required to use the EN-610 Epoxy Nose Filler. If a gap of 1/2" or greater is present, the substrate should be prepared using other methods.

Of course, with any Stair Tread installation it is acceptable to utilize the EN-610 Epoxy Nose Filler.

When installing Vinyl Stair Treads, the EN-610 Epoxy Nose Filler is required for all installations.

5.1 GENERAL INSTALLATION

Ensure substrate is suitably prepared prior to installation, as manufacturer is not responsible for substrates that have not been properly prepared and tested for moisture. Ensure adhesive is approved for use with flooring material and the proper trowel type and size is used, as manufacturer is not responsible for any and all adhesion issues related to improper adhesive selection or usage. Select appropriate adhesives, such as wet-set acrylics or urethanes, for areas that will have excessive window/sunlight exposure from walls or ceilings such as sunrooms, window walls, skylights, etc. In these type areas a wet-set adhesive that sets hard should be used such as AW-510, MS-700 or U-705.

Prior to installation, inspect all treads before installing or during installation to verify that there are no visible defects, damages or excessive shading variations. If there are concerns regarding shade or color variation, do not install material and consult a sales representative and manufacturer's technical staff.

Apply adhesive according to instructions for specific product in use and observe adhesive flash times, if applicable. Ensure all adhesive working times are observed and followed. Be sure to follow instructions based on substrate porosity (porous or non-porous). Use below chart for reference.

When installing into adhesive using a wet-set method, avoid walking or working on material until adhesive has cured for light foot traffic. Working on material that is installed into wet adhesive could cause adhesive to displace. When working off of material is not possible, use a kneeling board or equivalent to disperse weight evenly and prevent adhesive displacement. Pay close attention to working time to avoid adhesion issues. This may require installing material in smaller sections. Replace trowels at recommended intervals to maintain proper trowel ridge and spread rate.

Periodically lift material to ensure proper adhesive transfer and ensure adhesive has not surpassed the open time – adhesive should cover 90% of tread. Roll treads with a suitable hand roller within 30 minutes of installation, crossing in a perpendicular direction after initial roll.

Visually inspect installation to ensure that material has not shifted and that adhesive has not been squeezed out of joints or compressed onto surface. Clean excessive adhesive or adhesive residue from the surface of the material per adhesive recommendations. ***Do not apply abrasive or solvent based cleaners directly to stair tread materials.***

5.2 HANDLING EXTENDED WIDTH STAIRWELLS

Wider stairwells that require butting two treads together will require additional planning and dry fitting prior to installation. We recommend ordering treads the next size up to achieve these layouts and installations. Treads with VI or Abrasive strips may require mixing and matching to achieve the desired installation result.

Stair treads have an acceptable level of thickness variation from tread to tread. For this reason, stair treads that are intended to be butted together may need to be sanded, undercut, or shimmed in order match the thickness of adjacent treads. Treads should be trimmed so that the center of the pattern or profile is at the seam.

Once butting seams are cut and patterns are aligned the use of the Excelsior U-705 Urethane adhesive should be used at the seams to help adjust for slight height variations and to hold the seam tight.

5.3 HANDLING TOP STEPS & MID-LANDINGS

When installing a full size tread on the top step or landing and it will be butted up to flooring materials on the upper floor or landing, always check the thickness of the two materials. Due to the way treads are manufactured the gauge of the material can vary depending on where they are cut to butt up to the tiles.

Patching, shimming or sanding of the treads may be required to match the two materials in thickness for a flush installation. This is especially true on open landings where the tile will have to wrap around the side of the tread.

5.4 HANDLING ABRASIVE, SMOOTH & RIBBED INSERTS

Stair Treads including abrasive, smooth or ribbed inserts should be treated with extra caution. Folding or carrying longer treads with inserts over the shoulder will cause the inserts to stretch and possibly buckle after installation.

Also, when cutting treads tight to the stringer they will expand slightly due to thermodynamics and the laws of physics. When this occurs with the treads, the strip will buckle in the channel. Therefore after installing treads with abrasive, smooth or ribbed rubber inserts, the inserts must be trimmed 1/16" from the ends on both sides of the tread.

5.5 THREE SIDE SCRIBE METHOD FOR STAIR TREADS

Determine the center of the stairwell and mark a center line on the riser portion of each step. Determine the center of each stair tread and mark a center line on the back edge of the tread for alignment during trimming and installation.

Align the stair tread to the right side of the step and set divider to the distance between the center mark on the step riser and the center mark on the stair tread. While applying firm pressure to the stringer material with divider, mark the stair tread with the divider to determine scribe line. If using a One-Piece Tread & Riser, scribe the riser portion of the tread as well. Use a suitable knife to trim stair tread along scribe mark and create a slight undercut to ease final installation.

Once the right side of the tread is scribed and trimmed, reposition the stair tread to align to the left side of the step. Reset the divider to the distance between the center mark on the step riser and the center mark on the stair tread. Use divider to scribe stair treads as before and trim stair tread along scribe mark, creating a slight undercut. Ensure that stair tread fits step snugly against stringers without over-compressing tread material.

To aid in scribing and trimming the back edge of stair treads, a spacer (such as a carpenters level, 1" x 2" wood or equivalent) is required to set the depth of the tread. Prior to cutting the back edge of the stair tread, measure the depth of the step and the thickness of the spacer. Rough cut stair treads to be at least 1/4" deeper than the step but no deeper than the width of the spacer.

Once the back edge has been rough cut, align stair tread to the back of the step riser above. Insert the spacer between the leading edge of the stair tread and the step nose, ensuring that the spacer and stair tread fit snugly against the step. Set the divider to the exact width of the spacer and scribe the back edge of the stair tread to the

step riser. Trim the back edge stair tread along scribe mark, creating a slight undercut to ease installation. Ensure that all sides of the stair tread fit snugly to step while avoiding over-compressing material.

Once the initial step has been scribed and trimmed, the riser should be scribed and trimmed to accommodate imperfections in the step stringers using the Two Side Scribe Method.

5.6 SCRIBING RISERS

Prior to trimming risers, ensure that the stair tread below has been trimmed and fits snugly on the step beneath the riser. Use the previous center mark used when trimming the adjoining stair treads as the center of the stairwell, ensuring that center mark is visible while trimming risers. Repeat the process above to scribe both ends of the riser to the stairwell.

5.7 HANDLING THE STAIR TREAD NOSE & RISER INTERSECTION

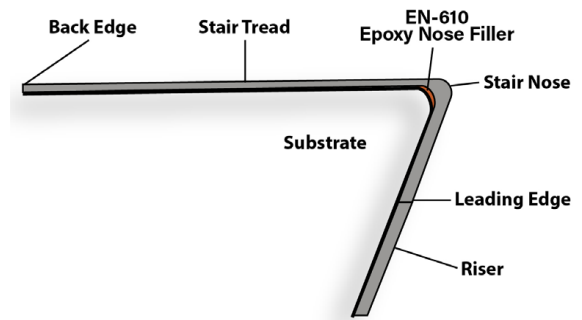
The seam between the leading edge (nose) of the stair tread and the riser should be treated using one of the following methods.

5.7.1 BUTTING or SCRIBED SEAM METHOD

When butting stair tread and riser seams using the Scribed Seam Method, ensure that the stair tread above and below the riser, as well as the riser itself, have been trimmed and fit the step snugly.

Ensure the stair tread below the riser is in place prior to scribing the riser to ensure a tight fit to the leading edge of the stair tread above.

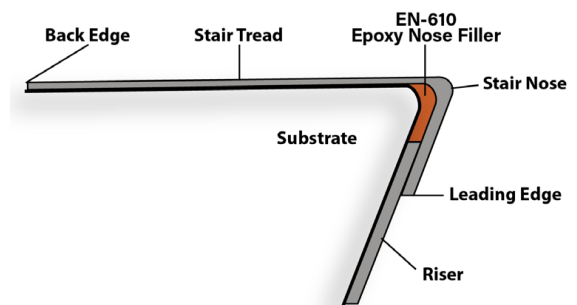
Overlap the stair tread above the riser with the riser while ensuring that riser toe is not over-compressed. Using the leading edge of the stair tread as a guide, a divider or a marking tool is needed to scribe the riser. Use a suitable knife to trim riser along the scribe mark.



5.7.2 OVERLAPPING SEAM METHOD

When overlapping stair tread and riser seams, ensure that the stair tread and riser have been trimmed and fit the step snugly.

Risers do not normally require trimming on the top edge prior to installation when overlapping seams. However, if the top edge of the riser extends up to or over the height of the step, trim riser to 1/4" - 1/2" from the top of the step to allow space for the EN-610 Epoxy Nose Filler Adhesive if needed.



5.8 CONTINUING THE INSTALLATION

When using the Excelsior TP-620 Pressure Sensitive Tape Adhesive or the C-630 Contact Adhesive, be sure to clean dusty and/or cementitious substrates with a damp mop or sponge prior to installation to remove dust, dirt and debris.

Clean the underside of the stair tread with a clean rag or towel and denatured alcohol or equivalent solvent. Failure to do so may result in bond issues due to mold-release chemical contamination.

Apply adhesive according to instructions for specific product in use. Be sure to follow instructions based on substrate porosity (porous or non-porous).

When installing adhesive on steps, be sure to leave a 1/2" - 3/4" space on either side of step nose to accommodate the Excelsior EN-610 Epoxy Nose Filler Adhesive, if needed, to avoid adhesive cross-contamination.

All leading edges (noses) must be adhered to the either the riser or riser substrate when installing stair treads.

Roll material with a hand roller or equivalent within 30 minutes of installation to ensure that material has not shifted and that adhesive has not been squeezed out of joints or compressed onto surface.

...after installing treads with abrasive, smooth or ribbed rubber inserts, the inserts must be trimmed 1/16" from the ends on both sides of the tread.

6. STAIR TREAD PROTECTION AFTER INSTALLATION

Protect newly installed stair treads and risers with construction grade paper or protective boards, such as Ram Board, ThermoPLY, Masonite or other materials to prevent damage by other trades. Do not slide or drag pallets or heavy equipment. Limit usage and foot traffic according to the adhesive's requirements. When moving appliances or heavy furniture, it is a good idea to protect stair treads and risers from scuffing or tearing using temporary floor protection.

Ensure all castors that may come in contact with stair treads are clean and free of any and all dirt and debris. Routinely clean castors to ensure that dirt or debris has not built up or become embedded in castors. Replace castors at regular intervals, especially if they become damaged or heavily soiled. Place walk-off mats at outside entrances. Ensure mats are manufactured with non-staining backs to prevent discoloration.