

# PRO 50 LEVELLING COMPOUND

**Polymer Modified, Fibre Reinforced,  
Self Smoothing Cementitious Floor Leveller**

- 3mm to 50mm in one application
- Fibre reinforced
- Single part
- Traffic after 4 hours
- Eco friendly
- Underfloor heating
- Flexible
- Excellent wear resistance



A single part, polymer modified, fibre reinforced, self-smoothing cementitious floor leveller designed for use from 3mm to 50mm in one application without the need for additional granite chippings. Suitable for levelling a variety of substrates including heated floors and timber floors strengthened with a plywood overlay. The excellent levelling and flow properties of the product make it ideal for preparing sub-floors prior to installing soft floor coverings. Norcross Pro 50 Levelling Compound can be used as a wearing finish.

## SURFACE PREPARATION

Floor surfaces must be suitably prepared: sound, dry (<75%RH) and free from contaminants that may prevent adhesion. Concrete and sand/cement screeds must be fully cured and any laitance or surface treatments must be removed. The temperature of the floor must be maintained above 5°C throughout the application and drying of the underlayment. Under floor heating must be turned off, or maintained at not greater than 15°C\*\* for at least 48 hours before, during and after application. The heating must not be switched up to operating temperature until at least 14 days after the leveller has been applied, when it should be raised at a rate of 5°C per day.

For thickness above 10mm, it is recommended that 3mm granite chippings are added for economy.

\*\*This may be different for the adhesive. Check adhesive manufacturers recommendations for guidance.

## PRIMING

If surfaces are porous or dusty, it is recommended that they are primed with Norcross Prime Bond diluted 1:4 with water to prevent rapid drying of the underlayment and allow to dry. Impervious surfaces should be primed with Norcross Key Bond. Allow to dry.

## MIXING

Pour 4 to 4.4 litres of clean water into a mixing bucket and gradually add all of the Powder whilst stirring with a power whisk fitted in an electric drill, until a smooth creamy, lump-free consistency is achieved. The material should be mixed for a minimum of 3 minutes.

10kgs of 3mm granite chippings can be added at this stage and mixed using a paddle mixer until fully dispersed in the mix.

EN 13813 Classification	CT-C30-F7	
Working Time @ 20°C	15 to 20 minutes	
Walk on Hardness Time @ 20°C	4 hours	
Ready to Receive Floor Coverings (at 3mm Thickness)	12 hours	
Compressive Strength (EN13813: 2002)	28 day	36 N/mm <sup>2</sup>
Flexural Strength (EN13813: 2002)	28 day	7.5 N/mm <sup>2</sup>
Consumption Per mm Thickness	Approx. 1.7kg	
Coverage** (Per 20kg Bag)	3mm	4.0m <sup>2</sup>
	5mm	2.5m <sup>2</sup>
	10mm	1.25m <sup>2</sup>
Application Thickness: Unfilled	3mm to 50mm	

\*\* Coverage rates are for guidance only & will vary according to the condition of the subfloor.

## PREPARATION

<b>Concrete/ Power Floated Concrete</b>	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 either Norcross Key Bond or a slurry bond coat consisting of 2 parts cement-based levelling compound powder: 1 part Prime Bond & allow to dry.
<b>Cement:Sand Screed</b>	Must be below 75%RH. Prime with Prime bond diluted 1:4 with water.
<b>Anhydrite/ Hemihydrate (Gypsum) Screed</b>	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.
<b>Heated Floors</b>	After levelling 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 Norcross Pro 50 Levelling Compound.
<b>Asphalt</b>	Must be sound & in good condition. Prime with undiluted Prime Bond & allow to dry.
<b>Existing Glazed Tiles</b>	Must be well fixed and able to support the additional weight of tiling, thoroughly clean and degrease & allow to dry before applying Norcross Key Bond. Allow to dry.
<b>Plywood Overlay on Existing Timber Floors (BS EN 636-3 WBP/Marine Grade Plywood)</b>	<p>Plywood must be minimum 6mm to 18mm thick, screw-fixed to joists and existing boards at maximum 300mm centres. Seal the back, face and edges of the board with undiluted Norcross Prime Bond &amp; allow to dry. All timber construction must be adequately ventilated from behind to prevent warpage of the boards.</p> <p>Beware of some grades of Eastern European and Far Eastern Plywood which may be susceptible to disintegration when wet. Plywood which has been treated/coated may not be suitable to receive a tiled finish as the coating may inhibit adhesion to the board.</p>

## PUMP APPLICATION

Suitable for pump application. For specific advice please contact the Technical Service Department.

## APPLICATION

Pour the mixed material onto the prepared subfloor and allow to flow to give a smooth finish. Minimal work with a smoothing trowel is required. The use of a spiked roller will help eliminate trapped air and smooth out trowel/ flow lines to give a more uniform surface appearance. The mixed material should be applied at a thickness between 3mm to 50mm, but may be taken down to a feathered edge where required. For best results, an overall thickness of at

least 3mm should be maintained. Norcross Pro 50 Levelling Compound is self-smoothing, but should any imperfections remain they can be removed by rubbing with a carborundum stone when dry. The underlayment will accept light foot traffic typically 4 hours after application. A 20 kg unit will cover approximately 4m<sup>2</sup> at 3mm of thickness.

## COVERAGE

APPLICATION THICKNESS	APPROX. COVERAGE PER 20kg BAG**	APPROX. COVERAGE PER 20kg BAG MIXED WITH 10kg CHIPPINGS**
3mm	4.0m <sup>2</sup>	N/A
5mm	2.5m <sup>2</sup>	N/A
10mm	1.25m <sup>2</sup>	2.0m <sup>2</sup>

\*\* Coverage rates are for guidance only & will vary according to the condition of the subfloor.

## STORAGE

Store in dry internal conditions away from direct sunlight between 5°C to 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 524140.

## HEALTH & SAFETY



CONTAINS  
CHROMIUM VI  
DANGER

Causes skin irritation. Harmful if swallowed. Causes serious eye damage. May cause respiratory irritation. Keep out of reach of children. Avoid breathing dust. Wear protective gloves and eye protection. Wash hands thoroughly after handling. IF SKIN IRRITATION OCCURS: Get medical advice/attention. IF SWALLOWED: Call a poison centre or doctor/physician if you feel unwell. IF IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing. Immediately call a poison centre or doctor/physician. Dispose of contents/container in accordance with local/regional regulations.



EN 13813 : 2002 CT C35-F7 EN 13892-4 AR1  
Screed materials and floor screeds