

# PRO 50 LEVELLING COMPOUND

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

- ▣ Flexible
- ▣ 3-50mm
- ▣ Traffic after 4 hours
- ▣ Suitable for heated floors
- ▣ Excellent wear resistance
- ▣ Ideal for vinyl floor coverings
- ▣ CT-C35-F9



Norcross Pro 50 Levelling Compound is a single part; fibre reinforced self smoothing floor underlayment. It is suitable for use from 3mm to 50mm in one application without the need for additional granite chippings. The product is suitable for levelling a variety of substrates including concrete, screed, flooring grade asphalt, terrazzo and existing quarry and vinyl tiles. It is ideal for use with undertile heating mats where it may be used to cover the wired elements, providing a level substrate to tile to and also protecting the heating elements during the fixing process. The product is also suitable for use on timber floors which must be overlaid with a minimum 15 to 18mm thick WBP or Marine grade plywood screw fixed at maximum 300mm centres to both joists and existing boards. The plywood should be primed with neat Norcross Prime Bond which should be allowed to dry prior to application of the levelling compound. It is essential to ensure that the floor is sufficiently rigid and deflection free to support the additional weight of tiling before commencing.

The excellent levelling and flow properties of the product make it ideal for preparing sub floors prior to fixing ceramic or natural stone tiles or soft floor coverings such as carpet, vinyl and timber. It has a setting time of 4 hours at 20°C permitting early foot traffic and fast track tile fixing. Norcross Pro 50 Levelling Compound can be used as a wearing finish.

#### PREPARATION

All surfaces should be dry, clean and free from any release agents, which should be mechanically removed. All ground floors should incorporate a damp proof membrane. Dusty or porous surfaces should be primed with Norcross Prime Bond diluted 1:4 with water. For impervious backgrounds a slurry bonding coat made of 1 part Norcross Prime Bond to 2 parts Norcross Pro 50 Levelling Compound should be applied to the substrate using a soft brush. Once dry the slurry will provide a key coat onto which the Levelling Compound will form a strong bond.

N.B. It is not recommended that more than 2 layers of levelling compound are used. Always prime the first layer of levelling compound with Norcross Prime Bond diluted 1:4 with water and allow to dry before applying a second layer.

<b>EN 13813 Classification</b>	CT-C35-F9	
<b>Working Time @ 20°C</b>	15 to 20 minutes	
<b>Walk on Hardness Time @ 20°C</b>	4 hours	
<b>Ready to Receive Floor Coverings (at 3mm Thickness)</b>	4 hours	Ceramic & Porcelain
	24 hours	Natural Stone
	12 hours	Soft Floor Coverings
<b>Compressive Strength (EN13813: 2002)</b>	7 day	25 N/mm <sup>2</sup>
	28 day	35 N/mm <sup>2</sup>
<b>Flexural Strength (EN13813: 2002)</b>	7 day	7.5 N/mm <sup>2</sup>
	28 day	9 N/mm <sup>2</sup>
<b>Consumption Per mm Thickness</b>	Approx. 1.4kg	
<b>Coverage (Per 20kg Bag)</b>	3mm	5.0m <sup>2</sup>
	5mm	3.0m <sup>2</sup>
	10mm	1.5m <sup>2</sup>
<b>Application Thickness: Unfilled</b>	3mm to 50mm	



## PREPARATION

<b>Concrete/ Power Floated Concrete</b>	Must be a minimum of 6 weeks old. This may be reduced to 48 hours if Norcross Permlayer 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 a minimum of 3 weeks old. This may be reduced to 48 hours if Norcross Permlayer is used. Prime with Norcross Prime Bond diluted 1:4 with water and allow to dry.
<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 (Refer to Norcross How to sheet 'Commissioning of Underfloor/Undertile Heating Systems). 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 a slurry bonding coat consisting of 2 parts Pro 50 to 1 part Norcross Prime Bond. Allow to dry.
<b>Plywood Overlay</b>	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.

## SETTING OUT

To gauge the floor to be levelled use a 2m straightedge and rotate through 360° noting where any gaps are present between the base and straightedge. Any gaps above 3mm should be chalk marked. In the case of more serious deviations in levels, countersunk screws may be drilled and plugged into the floor at 500mm centres. The screws can be lined up and adjusted to the correct height by placing the straight edge and spirit level across them to achieve plumb markers up to which the compound can be screeded.

## MIXING

In to a clean pail add 4 to 4.4 litres of water and slowly add the 20kg of Norcross Pro 50 Levelling Compound. Mix with a rotary drill paddle to form a creamy lump free consistency.

N.B. Using excess water may weaken the leveller causing it to separate, crack and debond

## APPLICATION

Pour the compound onto the floor and trowel out to the desired depth. The product is self smoothing. The compound has a pot life of approximately 20 minutes which will be reduced at high temperatures and extended in cool conditions. Do not use below 5°C.

Ceramic & Porcelain tiles can be laid as soon as the product supports weight, i.e. after approximately 4 hours. Natural stone may be laid after 24 hours and soft floor coverings after 48 hours.

Undertile heating systems should not be switched on for at least 14 days and then brought up to operating temperature at a rate of 5°C per 24 hours.

## COVERAGE

Norcross Pro 50 Levelling Compound mixed with 4.4 litres of water will cover approximately 1.4kg/m<sup>2</sup> per 1mm thickness, i.e. 4mm thick = 1.4 x 4 = 5.6kg/m<sup>2</sup>, therefore a 20kg will cover approximately 3.5m<sup>2</sup> (20/5.6).

## 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.

Further information may also be obtained from the Norcross 'How to' sheets available on the website.

## 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-F9 EN 13892-4 AR1  
Screed materials and floor screeds