Rubber Stair Tread, Risers & Stringers

Installation

Roppe Rubber Stair Treads, Risers and Stringers are designed to complete any commercial project. We manufacture from the highest quality raw materials and inspect all materials prior to shipment. The responsibility for a quality installation lies on the installation contractor. Therefore, these products are designed to be installed by a Commercial Flooring Contractor which has previously demonstrated the capabilities to install Rubber Stair Treads, Risers and Stringers.

Read all literature concerning the product description, product limitations, substrate preparation, adhesive information, adhesive application, product installation procedures and warranty before installation. Deliver all materials to the installation location in its original packaging with labels intact. Inspect all material for proper type and color prior to installation. It is the responsibility of the installation contractor to verify the adequacy of the substrate including porosity and adhesive prior to installation.

Roppe Stair Treads, Risers and Stringers are not for outdoor use even under covered walkways. Uncontrolled environments may also cause undesirable affects if not properly maintained; please refer to the adhesive recommendations for the adhesive to use in these applications. Oil & Grease formulation must be used for areas that will be subjected to petroleum based materials (oil change centers, garage offices, manufacturing areas, etc.). Neither standard formulation nor Oil & Grease Resistant formulation should be used near vegetable oils or animal fats (commercial kitchens, food prep areas, etc.).

Handling, Storage and Acclimation

Stair Treads, Risers, Stringers, Adhesives and Substrate shall be maintained between 65º F (19º C) and 85º F (30º C) for 48 hours before, during, and after installation with permanent HVAC system to ensure proper product and adhesive functionality. Temporary HVAC systems can contribute to undesirable installation issues.

If installing over Radiant Heated Substrates, lower the temperature of the heating system to 65°F (19°C). 24 hours after installation, slowly raise the temperature to the desired setting or a maximum of 85°F (30°C). Increasing the temperature too quickly will cause undesirable results.

Proceed with the installation only when the conditions are proper and correct and all other trades have completed their work. It may be necessary to block or cover the light source in stairwells that are subject to intense or direct sunlight during installation.

Substrate Preparation

Stairwell surfaces shall be clean, smooth and dry. All dust, loose particles and debris shall be removed prior to installation. Surface shall be free of chemical & citrus based adhesive removers, solvents, latex paints, grease, oils, waxes, alkali, sealing compounds, curing compounds and/or any material that could affect adhesive bonding.

Due to uncertainty of bond of existing material to substrate, Roppe does not recommend bonding or provide warranty for bond of any Stair Treads, Risers and/or Stringers installed over existing materials. However, if you choose to proceed in this direction we have provided a few suggestions below to help with the chances of success.

Concrete Stairs

- All concrete stairwells shall be checked for moisture content. Test according to the latest revision of ASTM F 1869, Standard Test Method for Measuring Moisture Vapor Emission Rate of Concrete Subfloor Using Anhydrous Calcium Chloride. Acceptable MVER levels are listed in the approved adhesive section below.
- All concrete stairwells shall be checked for pH of the concrete surface prior to installation. Acceptable pH levels are listed in the approved adhesive section below.
- Porosity of the concrete shall be determined prior to installation, in this case we are only looking to determine if the substrate is porous or non-porous. We are not trying to determine the level of porosity. To determine porosity, place a dime sized drop of water on the concrete. Wait 60 seconds and review the drop. If the drop has absorbed into the concrete, the area should be considered porous. If the drop has not absorbed into the concrete, the area should be considered non-porous. The purpose for this test is to determine how the adhesive will work with the substrate and product being installed.
- Perform bond test of the actual materials being installed with a minimum of 12” x 12” piece of the product. Evaluate after 72 hours for bond strength prior to installation.
- Remove excessive alkali or efflorescence by mechanical means such as sanding, grinding and/or bead blasting.
- Fill all cracks, depressions and/or surface irregularities with a quality cementitious underlayment, filler or 5100 Tread Nose Compound. If 5100 Tread Nose Compound is used, it shall be sanded prior to installation to ensure proper bonding.

Wood Stairs

- All wood stairwells shall be firmly constructed in accordance with local building codes and sanded flat.
- Fill all cracks, depressions and/or surface irregularities with a quality latex patching compound or 5100 Tread Nose Compound. If 5100 Tread Nose Compound is used, it shall be sanded prior to installation to ensure proper bonding.

Terrazzo, Quarry Tile and Ceramic Stairs

- All glaze, waxes, and contaminates shall be removed by thoroughly sanding the surface.
- All loose tiles shall be removed and filled with a cementitious leveling compound.
- All grout lines shall be filled and smoothed with a cementitious leveling compound.

- Use an adhesive designed for non-porous surfaces. Roppe strongly recommends the 4100 Quik Stik Stair Tread Tape Adhesive for this installation.

Steel Stairs
- All steel stairs shall have the surface thoroughly cleaned by sandblasting, wire brush and/or other mechanical means to remove all rust, paints and/or other contaminants.
- Prepare surface with an anti-corrosive coating to prevent deterioration of the steel stairs.
- Roppe does not recommend installing over expanded metal or diamond plate steel stairs. These surfaces need to be changed or covered prior to installing Rubber Stair Treads.
- Use an adhesive designed for non-porous surfaces. Roppe recommends the 4100 Quik Stik Stair Tread Tape Adhesive for this installation.

Epoxy Painted Stairs
- All latex painted stairs shall have the paint completely removed prior to installation.
- All epoxy painted stairs shall have the surface thoroughly cleaned of contaminants.
- All loose areas of the epoxy painted areas shall be removed prior to installation.
- Fill all cracks, depressions and/or surface irregularities with the 5100 Tread Nose Compound.
- Sand the surface area to ensure proper bonding.
- Use an adhesive designed for non-porous surfaces. Roppe recommends the 4100 Quik Stik Stair Tread Tape Adhesive for this installation.

VCT & Other Resilient Flooring
- All finishes, waxes, and contaminates shall be removed by thoroughly sanding the surface.
- All loose tiles shall be removed and filled with a cementitious leveling compound.
- Use an adhesive designed for non-porous surfaces. Roppe strongly recommends the 4100 Quik Stik Stair Tread Tape Adhesive for this installation.

Carpeted Stairs
- All carpet, padding, etc. shall be removed prior to the installation of Rubber Stair Treads.

Approved Adhesives for Installation
Select the appropriate adhesive for your installation, substrate and use. Failure to use Roppe recommended adhesives with the installation of Rubber Stair Treads, Risers and Stringers will void the adhesion and bond warranty of the products installed. Failure to use 5100 Tread Nose Compound when installing Rubber Stair Treads will void the product warranty and claims will not be accepted for any reason if not used.

5100 Tread Nose Compound
- Two-Part Epoxy Compound
- Shall be used on all substrates
- ASTM F 1869; Calcium Chloride – Maximum 5 lbs / 24 hours MVER
- pH – Reading shall be between 7 and 10

3100 Rubber Tile & Tread Adhesive
- Transitional Acrylic Wet Set Adhesive
- Suitable for use on Concrete and Wood Stairs
- ASTM F 1869; Calcium Chloride – Maximum 5 lbs / 24 hours MVER
- pH – Reading shall be between 7 and 10

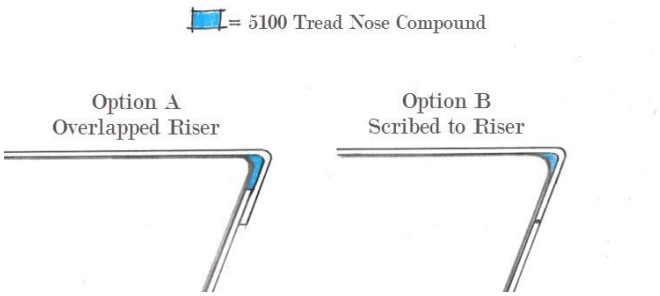
4100 Quik Stik Stair Tread Tape Adhesive
- Pressure Sensitive Scrim Reinforced Tape
- Suitable for use on all substrates, recommended on Terrazzo, Quarry Tile, Ceramic, Steel, Epoxy Painted stairs and/or Existing Resilient Flooring
- Recommended adhesive for use on all **one-piece stair tread/riser** products
- Recommended adhesive for the installation of #167 Fillet Strip with one-piece stair tread/riser products
- ASTM F 1869; Calcium Chloride – Maximum 5 lbs / 24 hours MVER
- pH – Reading shall be between 7 and 10

7100 Epoxy Adhesive
- Two-Part Epoxy Adhesive
- Suitable for use on all substrates, recommended on Terrazzo, Quarry Tile, Ceramic, Steel Stairs and/or Existing Resilient Flooring.
- Recommended for use in areas subjected to temperature variation and/or topical moisture
- ASTM F 1869; Calcium Chloride – Maximum 5 lbs / 24 hours MVER
- pH – Reading shall be between 7 and 10

7200 Urethane Epoxy Adhesive
- Two-Part Urethane Enhanced Epoxy Adhesive
- Suitable for use on all substrates, recommended on Terrazzo Quarry Tile, Ceramic, Steel Stairs and/or Existing Resilient Flooring.
- **Required** for use on **Oil & Grease Resistant** Formulation Rubber Stair Treads, Risers and Stringers.
- Recommended for use in areas subjected to temperature variation and/or topical moisture.
- Recommended for use in seams of **Butting Stair Treads**.
- ASTM F 1869; Calcium Chloride – Maximum 5 lbs / 24 hours MVER
- pH – Reading shall be between 7 and 10

Product Installation
Roppe Rubber Stair Treads, Risers and Stringers are manufactured with the intent that one or both ends will need to be trimmed to properly fit the step, we trim treads ½" to ¾" over the nominal length ordered. It is extremely important to field measure the steps prior to ordering to ensure the proper length tread is ordered. Do not install the Rubber Stair Treads on steps in which the nosing of the tread does not properly fit

the step. The nosing of the tread cannot be modified onsite to fit a step it was not intended or designed for (i.e. square nose design modified to fit an angled riser). The use of extra 5100 Tread Nose Compound to fill the void is not recommended. It is the responsibility of the installation contractor to determine if the Stair Tread received is the appropriate Stair Tread for the installation. Failure to do so and/or proceeding with the installation of the incorrect Stair Tread for the stair system in place cannot be warranted by Roppe.



There are two options recommended when installing treads regarding the area in which the risers meet the leading edge of the nose. Overlapped Riser and Scribed to Riser. Roppe recommends overlapping the riser with the leading edge of the tread nose above or Option A. In both installations, it is very important to ensure the tread is fit properly to the step to avoid any nose movement or breakage. If Option B to scribe to the riser is chosen, variation and manufacturing tolerances could result in the two areas not being the same thickness, we do not consider this a defect.

Butting Stair Treads for Extended Lengths
Wide stairs that require the butting of two or more Stair Treads shall be ordered as “butting treads”. Roppe will manufacture the treads within specified tolerances to minimize the amount of work required on the job site to butt the Stair Treads. The installation of butting Stair Treads will require additional effort of the installation contractor at the time of installation. Proper planning and layout of the Stair Treads prior to spreading the adhesive will help to achieve a quality butting installation.

Pattern Alignment
Installations that require pattern alignment in the stairwells may require additional trimming on both ends of the Stair Treads to ensure alignment. It is possible that longer Stair Treads should be ordered to ensure proper alignment in stairwells with width variation.

Stringer Installation
Stringers shall be installed prior to the installation of the Stair Treads and Risers. This product is designed to cover the vertical areas next to the stairs to provide a finished appearance. The installation of Stringers is not required by Roppe.

- Use cardboard, builders felt and/or some other type of material to make a template for the stringers by measuring each step and transferring those dimensions to the template material. Final trimming after rough cutting will ensure a proper fit to the stairwell.
- Use prepared template to transfer layout to the stringer material and use the appropriate tool to mark and cut the stringer. Trim for final adjustments prior to the application of any adhesive.
- Determine the appropriate adhesive for the application of the stringers depending upon the substrate type.
- Apply adhesive according to label directions for the appropriate substrate.
- Position Stringer and hand roll to ensure proper adhesive transfer.

Stair Tread and Riser Installation
Roppe Stair Treads shall be trimmed to fit each step and should be dry laid prior to spreading any adhesive or permanently installing the Stair Tread. Proper handling of Stair Treads on the job site will prevent many issues that related to the installation of Stair Treads.

Stair Treads containing abrasive, ribbed or smooth inserts require additional care on the job site. These treads should not be bent, flexed and/or carried over the shoulder to prevent damage to the inserts. After installation the inserts shall be rolled to ensure adhesion to the Stair Tread and ends shall be trimmed 1/16” from the Stringer on both ends to allow for expansion of the insert.

The most important part of the proper installation of a Stair Tread is the fit to the step. Not all steps are created equally and therefore we recommend scribing each Stair Tread to fit the step in which it is being installed. It may be necessary to scribe both ends of the Stair Tread; following is a step by step method for doing this.

- Determine and mark the center of step on the Riser portion.
- Determine and mark the center of Stair Tread at the back where it will butt to the Riser.
- Place the Stair Tread on the step with the Right Hand side of the Stair Tread firmly against the Stringer.
- Lock down a pair of dividers approximately 1/16” wider than the space between the mark on the Riser and the mark on the Stair Tread, this will leave room for any expansion of the Stair Tread.
- While keeping firm pressure on the Stringer, mark the surface of the Stair Tread by dragging the dividers across the tread. If installing the one piece Tread/Riser combo, mark the Riser portion at the same time as the Tread portion.
- Use the appropriate blade or cutting tool to trim the Stair Tread at the scribed mark.
- Place the Stair Tread on the step with the Left Hand side of the Stair Tread firmly against the Stringer and repeat the process above for the other end.
- To determine the depth of the tread or how much material to remove from the back of the tread, use a sturdy straight object such as a carpenter’s level placed behind the nose of

the treads a pressed firmly against the riser. You may need to remove some material from the back of the tread or use the wide side of the level to ensure the back of the tread is away from the riser and lying flat on the step.
- Lock down a pair of dividers approximately 1/16” wider than the edge of the carpenter’s level you are using. Scribe the back edge of the tread and trim appropriately.
- Position the tread on the step and you should have an appropriate fit to the step with minimal clearance around the edges to allow for expansion.

Risers can be scribed using the same methods as listed above and should be fit prior to the next tread so there will be proper clearance. If using Option B, Scribed to Riser installation method you will need to place the tread nose over the riser. Then using one point of the dividers, simply follow the nose of the tread to scribe the trim point on the riser and carefully trim using the appropriate cutting method. At this point, the top of the riser should fit under the bottom of the nose or leading edge of the tread.

If riser will butt to the underside of the nosing, it will need to be scribed prior to application of the adhesive. To do this, hold the riser and tread into place and scribe the underside of the nosing onto the face of the riser. Remove the riser and carefully cut the scribed line to remove excess material.

Standard Tread and Riser Adhesive Application
- Clean the entire back of the Stair Tread with denatured alcohol to remove mold release prior to installation to promote proper adhesion of the tread to the substrate
- Determine appropriate adhesive for the application in which you are installing
- Apply adhesive according to the label directions and allow proper open time while taking caution to avoid the standard adhesive from coming into contact with the 5100 Tread Nose Compound
  - 3100 Rubber Tile & Tread Adhesive may be used on porous and non-porous tread applications
    - Porous applications use a 1/16” Square Notch Trowel and allow 5-10 minutes drying time and place the tread into the wet adhesive
    - Non-Porous applications use a 1/16” V Notch Trowel and allow adhesive to dry to the touch with little or no transfer to the finger, cover within 45 minutes of adhesive reaching this dryness
    - Leave 1/2"-3/4” space on each side of the 5100 Tread Nose Compound to prevent contamination and ensure the 5100 properly bonds
    - Use a hand roller immediately after placing treads and risers into the adhesive and then again 45-60 minutes after installation
  - 4100 Quik Stik Stair Tread Adhesive Tape may be used on porous and non-porous tread applications
    - Leave 1/2"-3/4” space on each side of the 5100 Tread Nose Compound to prevent contamination and ensure the 5100 properly bonds
    - Use a hand roller immediately after placing treads and risers into the adhesive and then again 45-60 minutes after installation
  - 5100 Tread Nose Compound is required on all tread applications
    - Leave 1/2"-3/4” space on each side of the 5100 Tread Nose Compound to prevent contamination and ensure the 5100 properly bonds
- Once adhesive is ready for application, place the Tread into the adhesive and ensure proper placement as trimmed
- Roll tread with a hand roller to ensure Tread is seated into the adhesive properly for transfer of the adhesive and bonding
- Immediately remove excessive wet adhesive with a soft, clean cloth dampened with warm soapy water or mineral spirits. **5100 Tread Nose Compound, 7100 Epoxy Adhesive and/or 7200 Urethane Epoxy Adhesive cannot be removed from tread surface once cured without damage.**
- Periodically, lift a Tread to check for proper adhesive transfer and ensure the proper amount of 5100 Tread Nose Compound is being used (this is extremely important on warn or older stairs)
- After completion of a section or run of stairs, ensure all Tread noses are seated properly on the stairs to prevent nose movement

One-Piece Tread/Riser Adhesive Application
- Clean the entire back of the Stair Tread with denatured alcohol to remove mold release prior to installation to promote proper adhesion of the tread to the substrate
- Determine appropriate adhesive for the application in which you are installing we strongly recommend the **4100 Quik Stik Stair Tread Adhesive Tape** for installing the one-piece tread and riser combinations
- When installing One-Piece Stair Tread/Riser products, we require the use of our **#167 Fillet Strip** in the angle where the step and riser meet. This piece should be installed prior to properly fitting the one piece stair tread/riser. We recommend using the 1” 4100 Quik Stik Tread Tape to install the #167.
- Apply adhesive according to the label directions and allow proper open time while taking caution to avoid the standard adhesive from coming into contact with the 5100 Tread Nose Compound
  - 4100 Quik Stik Stair Tread Adhesive Tape may be used on porous and non-porous tread applications
    - Use 9.5” width of 4100 on the tread portion
    - Use 4” width of 4100 on the riser portion
    - Use 1” width of 4100 on the nose portion
    - Leave 1/2"-3/4” space on each side of the 5100 Tread Nose Compound to prevent contamination and ensure the 5100 properly bonds
    - Use a hand roller immediately after placing treads and risers into the adhesive and then again 45-60 minutes after installation

- 3100 Rubber Tile & Tread Adhesive may be used on porous and non-porous tread applications
  - Porous applications use a 1/16” Square Notch Trowel and allow 5-10 minutes drying time and place the tread into the wet adhesive
  - Non-Porous applications use a 1/16” V Notch Trowel and allow adhesive to dry to the touch with little or no transfer to the finger, cover within 45 minutes of adhesive reaching this dryness
  - Leave 1/2"-3/4” space on each side of the 5100 Tread Nose Compound to prevent contamination and ensure the 5100 properly bonds
  - Use a hand roller immediately after placing treads and risers into the adhesive and then again 45-60 minutes after installation
- 5100 Tread Nose Compound is required on all tread applications
  - Leave 1/2"-3/4” space on each side of the 5100 Tread Nose Compound to prevent contamination and ensure the 5100 properly bonds

- Once adhesive is ready place the Tread into the adhesive and ensure proper placement as trimmed
- Fold the Riser portion to meet the Tread portion to make placement easier. If using the 4100 only remove the release paper from the tape on the Tread portion at this time
- One the Tread is seated properly, remove the release paper from the Riser portion and slowly place the Riser portion into place
- Remove the release paper on the inside of the Tread nose and press the nose into place
- Roll Tread with a hand roller to ensure Tread/Riser is seated into the adhesive properly for transfer of the adhesive and bonding
- Immediately remove excessive wet adhesive with a soft, clean cloth dampened with warm soapy water or mineral spirits. **5100 Tread Nose Compound, 7100 Epoxy Adhesive and/or 7200 Urethane Epoxy Adhesive cannot be removed from tread surface once cured without damage.**
- Periodically, lift a Tread nose to check for proper adhesive transfer and ensure the proper amount of 5100 Tread Nose Compound is being used (this is extremely important on warn or older stairs)
- After completion of a section or run of stairs, ensure all Tread noses are seated properly on the stairs to prevent nose movement

After Installation Restrictions
3100 Rubber Tile & Tread Adhesive
Light Foot Traffic after 24 hours
Commercial Foot Traffic after 48 hours
Initial Maintenance after 72 hours

4100 Quik Stik Stair Tread Installation Tape
All Foot Traffic Immediately
Initial Maintenance Immediately

7100 Low Viscosity Epoxy Adhesive
Light Foot Traffic after 12 hours
Commercial Foot Traffic after 24 hours
Initial Maintenance after 48 hours

7200 Urethane Two-Part Epoxy Adhesive
Light Foot Traffic after 12 hours
Commercial Foot Traffic after 24 hours
Initial Maintenance after 48 hours

After Installation Protection of Flooring
- Protect Stair Treads from other trades during the construction process by appropriate means such as Masonite, Ram Board or heavy construction paper
- When moving in appliances or heavy furniture, it is always wise to protect the Stair Treads from scuffing and tears if utilizing the steps for movement of furniture
- Dragging or improperly moving furniture or equipment across the surface of the Stair Treads can cause permanent damage.
- Place walk-off mats at outside entrances manufactured with non-staining backs to prevent discoloration and tracking of debris onto the new tread install

After Installation Initial Maintenance
Roppe Rubber Stair Treads are a low maintenance product that does not require waxes or finishes. The application of a wax or finish will not cause damage to the product. Roppe considers this a low maintenance product when there are no waxes or finishes applied. With any Rubber Stair Tread product, the more maintenance performed after installation will increase the life of the product as well as make the subsequent maintenance easier. Always use thoroughly cleaned untreated mops for maintenance of Roppe Rubber Stair Treads. Do not use Kerosene, Gasoline, Naphtha and/or other solvents to clean Roppe Rubber Stair Treads.

- Allow 72 hours after installation for proper curing of the adhesives
- Remove any coverings used to for tread protection after installation prior to cleaning
- Sweep, dust mop and/or vacuum floor to remove any dirt or particulates accumulated on the treads
- Prepare chosen neutral pH cleaner according to directions on bottle for a medium duty cleaning
- Using a **Soft Bristle Deck Brush**, apply the cleaning solution to the area and allow the cleaning solution to stand for approximately 5-10 minutes, while not allowing the solution to dry. Scrub the area while wet, excessive or ground in dirt may require additional scrubbings
- Wet vacuum or mop up residue
- Rinse with clean, cool water and allow flooring to dry thoroughly before exposing to traffic
- Apply desired finish if necessary, we do not recommend a finish but it can be used to improve appearance and maintainability of the Treads

Approved Cleaners
XL North All Purpose Cleaner, XL North Rubber Cleaner, Hillway Direct Neutral Cleaner, Spartan Chemicals Green Solutions All Purpose Cleaner, Spartan Chemicals Clean by Peroxy, Johnson Stride and/or Taski Profi

Approved Finishes
XL North Matte Finish, XL North 18 Gloss Finish, XL North 25 Gloss Finish, Hillway Direct Matte, Hillway Direct Satin, Hillway Direct Gloss, Spartan Chemicals Green Solutions Floor Seal & Finish, Diversy Over & Under Plus and/or Johnson Carefree Matte

The use of highly alkaline, highly acidic or solvent-based cleaning products will remove color from the treads or degrade the treads prematurely. **DO NOT** use sweeping or cleaning agents containing oil or solvents. **DO NOT** allow the solution to work its way beneath the treads which could result in an adhesive failure. **Caution:** When wet, treads will become slippery; therefore, use the appropriate warning signs on the treads to eliminate foot or other traffic.

Maintenance Products Availability
These products are available from various sources and information can be found via search on the internet or by contacting the following.

- XL North products by phone at 1-888-530-2259 and on the internet at www.xlnorth.com
- Spartan Chemicals Distributors by phone at 1-800-537-8990 and on the internet at www.spartanchemical.com
- Hillway Direct products by phone at 1-877-356-6748 and on the internet at www.1877floorguy.com
- Diversy Distributors by phone at 1-262-631-4001

If you have any doubt prior to the installation or maintenance of this product, please do not hesitate to contact our Customer Service or Technical Department.