



# step<sup>®</sup> safety vinyl

surestep<sup>®</sup> | safestep<sup>®</sup>



creating better environments



FLOORING SYSTEMS

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**step**<sup>®</sup>

Forbo's Step safety flooring collection provides a complete range of products designed to meet safety demands across a wide range of applications, from general areas to more extreme areas such as commercial kitchens, wetroom (barefoot) areas and industrial applications.

The Step range meets all HSE and European safety norms and delivers safety with minimal compromise in terms of cleaning and maintenance due to the PUR Pearl finish. All Step safety vinyl flooring has a guaranteed slip resistant performance throughout the life of the product. The ranges are designed to be easy to combine with other ranges, like Sphera and Eternal; but especially with our wall covering range Onyx+.

In creating a healthy indoor environment we focus on all aspects that contribute positively to the safety, hygiene and well-being of every individual. Our Step collection offers a wide variety of genuine safety flooring solutions that perform but are easy to maintain as well. Next to functionality, design for well-being is a key focus for Step in our choice of designs and colours. The product itself is 100% phthalate free, has Step Crystals of recycled material and up to 70% recycled content in the backing; and offers sufficient items with high LRV ratings.

The Forbo Step range is a step ahead of the competition by offering the best in Safety, Design and Confidence in a product offer that is giving you the best in sustainable slip resistance, the widest choice in popular and differentiated design and colour; and an ease of cleaning and maintenance for life.

### SAFETY

- A collection which covers all relevant slip resistance ratings which can be used across co-ordinating colour schemes.
- Safety vinyl flooring with guaranteed lifetime slip resistant performance, created with slip resistant particles throughout the matrix.
- This range offers the largest diversity in safety vinyl solutions, aesthetically pleasing but with no compromise on performance.

### DESIGN

- All ranges are designed with the application in mind, including fresh and comfortable solutions for continuously wet and barefoot/footwear combined areas.
- The largest choice in Wood and Materials, introducing the most authentic natural wood-visual in 4 items with PUR Wood Pearl, a new dimension in safety vinyl design.
- Introducing unique design in smooth trendy Surestep Steel; and inspiring new possibilities in digitally printed safety flooring.

### CONFIDENCE

- Forbo Step products are all finished with PUR Pearl or PUR Wood Pearl, a finish that is stain and chemical resistant, scratch resistant and offering superior appearance retention.
- All Step products offer unmatched cleaning and maintenance performance through the PUR Pearl finish.
- Innovative slip resistant particles Step Crystals on the majority of the range contribute to a clean fresh design and easier cleaning.
- Forbo has over 50 years of experience in producing safety vinyls.



Your steps; Sure and Safe

## surestep®

Sustainable slip resistance: Surestep is suitable for use in a wide variety of applications, such as general walking areas, where there is an increased slip risk.

Surestep is the optimum combination of slip resistance and ease of maintenance. Surestep is available in a wide variety of design options, including the new Surestep Steel collection in to this product group.

A selection of Original, Wood and Material is also available in Surestep Decibel. This product is ideal for areas where a combination of increased impact sound reduction (17dB) and slip resistance is required.

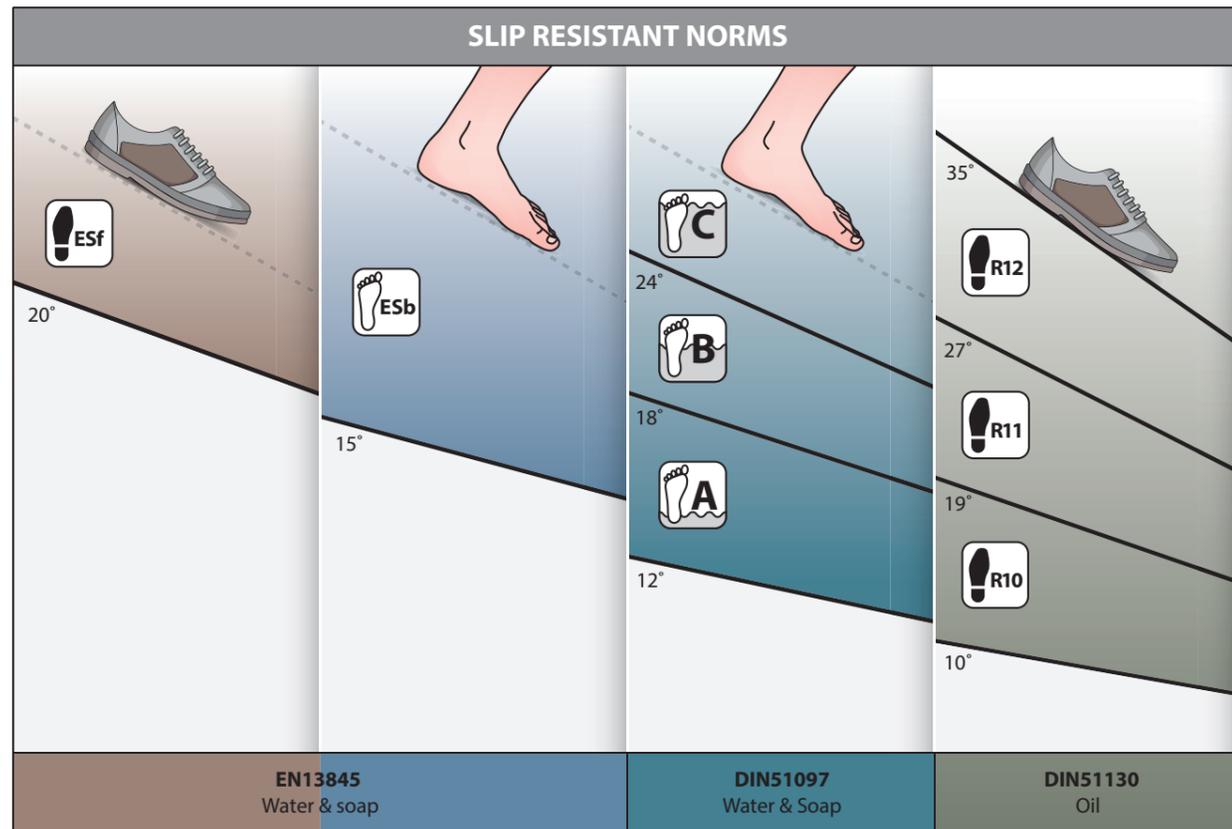
## safestep®

Products in this category are ideal for use in areas where a high slip risk has been identified from continuous contamination of the floor. In these areas it is simply not possible to prevent spillages, due to the type of work being conducted. The optimum product choice will be determined by the area of use and type of contamination.

## wetroom

Wetroom floor products are developed for use in continuously wet areas, where water flows frequently and barefoot traffic is the standard, or where a combination of barefoot and footwear traffic is expected.





<p>All</p>	<p>Surestep Laguna Safestep Aqua Surestep Star Barefoot</p>	<p>Surestep Laguna (B) Safestep Aqua (C) Surestep Star Barefoot (B)</p>	<p>All Suresteps R10 Safestep R11 Safestep R12 Safestep Aqua R10</p>
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**A sustainable, lifetime performance as a result of particles throughout the matrix of the product is the requirement to comply with EN 13845. This standard specifies the requirements that must be met to ensure durable slip resistance in varying degrees of usage intensity. All Step floors comply with EN13845.**

For products used in barefoot areas, DIN51097 applies. The testing method is similar to that of the DIN 51130, but this time the product is flooded with a 'soap and water' solution, a testing method that is more relevant to the barefoot application. The Step range also offers unique solutions up to the highest class in barefoot safety performance. By choosing the right Step floor for the right application one can prevent the potential for accidents caused by slipping significantly.

Floors are often evaluated on slip resistance performance by using the R-scale, which is linked to the Din 51130 standard. Measuring slip resistance on a ramp covered with oil at different angles and thereby resulting in different classes of slip. Step safety flooring is covering the most relevant classes of R10 to R12, in a comprehensive range of products that are used in conditions where footwear is the standard.

## Step: a versatile high performance product

Forbo's engineered layered construction of all Step products offers the best in heterogeneous product properties delivering optimal performance.

The performance of Step starts with its compact calendered backing that allows high static and dynamic loads and minimizes residual indentation. In addition the backing of our Step products is consisting for 70% out of controlled recycled material, delivering environmental performance as well. The flexible reinforced glass fleece offers optimal dimension stability. The important slip resistant performance is delivered at the top of the product.

Recycled Step Crystals are present in the upper layers of the product and the PUR protection delivers a silk matt finish that optimizes appearance retention and is guaranteed for warranty lifetime and beyond. Even under high traffic conditions maintenance properties are world class and the beauty of the product is not endangered throughout its life time. PUR finishes are tough and resistant against scratches and offer optimal stain and chemical resistance as required in many applications. Most of the Step products come with a PUR Pearl embossing: a natural matt surface gloss

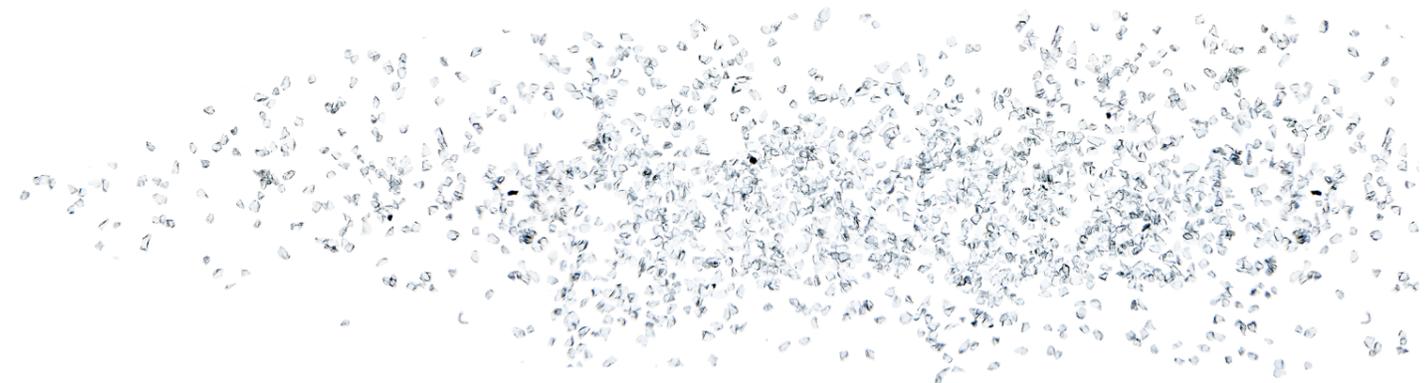
that has a structure which allows easy cleaning and maintenance, dirt and soil repellent on a very high hygienic level. Step Wetroom embossing structures are designed for purpose: organic and hygienic; yet comfortable and attractive. Forbo has designed all Step products to have the cleanest possible visual look, not jeopardizing the functionality of the product. For this purpose the Step Crystals were developed, which are used in many of our designs.

Step Crystals offer a clear design visual and will decrease soiling further due to its small particle size. Step Crystals also are a sustainable choice since they are made from recycled material. Additional design changes were made to clean up and brighten the particle look of our products (see picture).

Apart from the Surestep Design products, such as Wood, -Stone, -Mineral and -Texture, all coloured Step products are produced with a pure PVC pigmented top layer.

### Step is:

- A suitable, durable slip resistant floor covering...
- that is very easy to clean and maintain...
- with flexible glass fleece reinforcement for superior dimensional stability...
- a matt surface design for natural appearance...
- with a wide range of colours and natural designs for creative solutions...
- that can be combined with other Forbo flooring solutions.

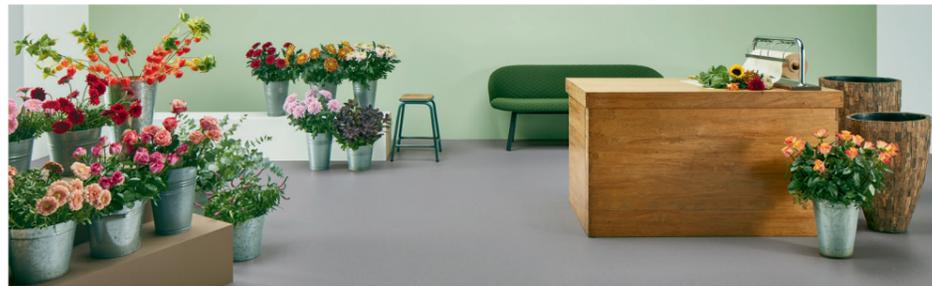


# What to use where

Forbo's new Step safety flooring collection provides a complete range of floor coverings that are designed to meet safety requirements in a wide range of applications. All products in the Step collection meet and exceed strict Health and Safety Executive (HSE) and European standard requirements.



**surestep® R10**



**safestep® R11**



**safestep® R12**



**surestep® laguna**



**safestep® aqua**

## General and spillage areas with increased (a higher) slip risk

- General workrooms areas
- Wet cellars in food and beverage production
- Kitchens: thawing, coffee related, hotels and station
- Acceptance for packaged (meat) goods
- Areas for packaged goods
- General storage areas
- Parking areas
- School areas: toilets, kitchens
- Healthcare: sterilization, sewage, section, wash/bath room
- Wet areas in food and beverage production
- Kitchens, dining rooms
- Outlets, commercial spaces
- Rooms in health / welfare care
- Storerooms
- School and kindergartens
- Operational infrastructure

## Areas with increased slip risk due to accidental or continuous contamination

- Gourmet kitchens up to 100 meals a day
- Community kitchens for meals in public areas
- Cold rooms for packaged goods
- Acceptance and operation of meatproducts products
- Washing machine areas with wet laundry removal
- Food production
- Ceramic industry: wet milling, mixers and presses
- Loading and processing of glass and stone
- Milk processing, cheese production
- Chocolate and Confectionery Manufacturing
- Manufacture of bakery products
- Wet areas in food and beverage production
- Kitchens, dining rooms
- Schools: crafts and woodworking machinery and other specialist rooms
- Cold rooms, freezer rooms, cold stores, freezer houses
- Outlets, commercial spaces
- Rooms in health / welfare care
- Laundry
- Leather and textiles production
- Ceramic industry
- Concrete buildings
- Chemical and thermal treatment of iron and metal
- Metalworking, metal processing, metal workshops
- Workshops for vehicle maintenance
- Workshops for the maintenance of aircraft
- Operational infrastructure

## Light industrial usage

- Production and processing of most dairy products
- Manufacturing of bakery and associated products
- Slaughter and meat processing
- Vegetable processing
- Gourmet kitchens over 100 meals a day
- Cold rooms for unpackaged goods
- Paint shops with wet grinding
- Ceramic industry: casting and glazing area
- Wastewater treatment plants
- Next to outdoor loading and oblique ramps, fuelling areas
- Manufacture of margarine, edible fats and oil
- Milk processing, cheese production
- Chocolate and confectionery manufacturing
- Slaughter and meat processing
- Kitchens, dining rooms
- Cold rooms, freezer rooms, cold stores, freezer houses
- Outlets, commercial spaces
- Leather and textiles production
- Paint shops
- Ceramic industry
- Storerooms
- Chemical treatment of iron and metal
- Metalworking, metal processing, metal workshops
- Workshops for vehicle maintenance
- Wastewater treatment plants
- Fire brigade
- Operational infrastructure

## Wetroom areas, predominantly barefoot use, but also accessed by footwear

- Continuously wet areas, mainly barefoot but also footwear
- Changing rooms in combination with footwear
- Bathrooms in combination with footwear
- Locker rooms

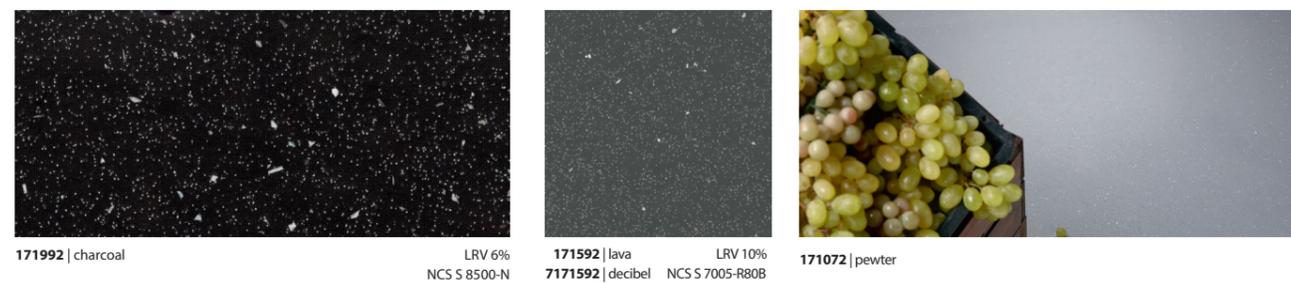
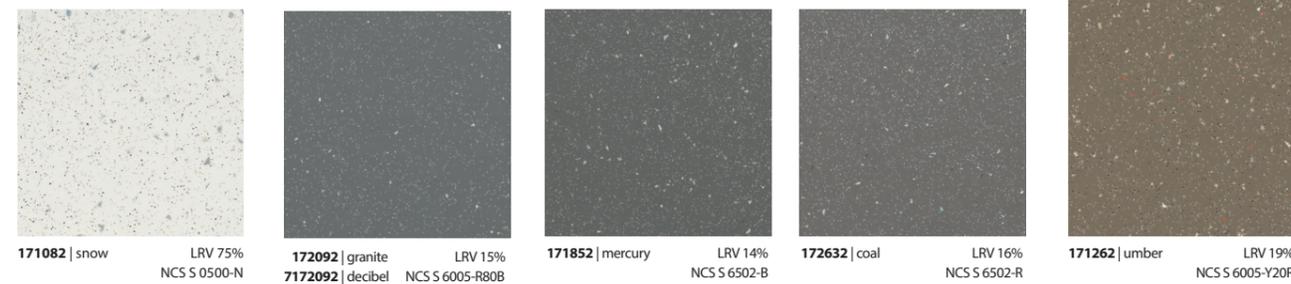
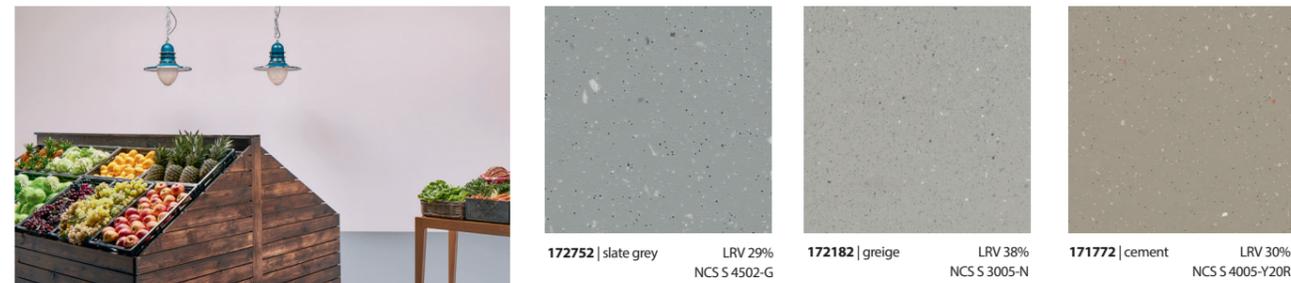
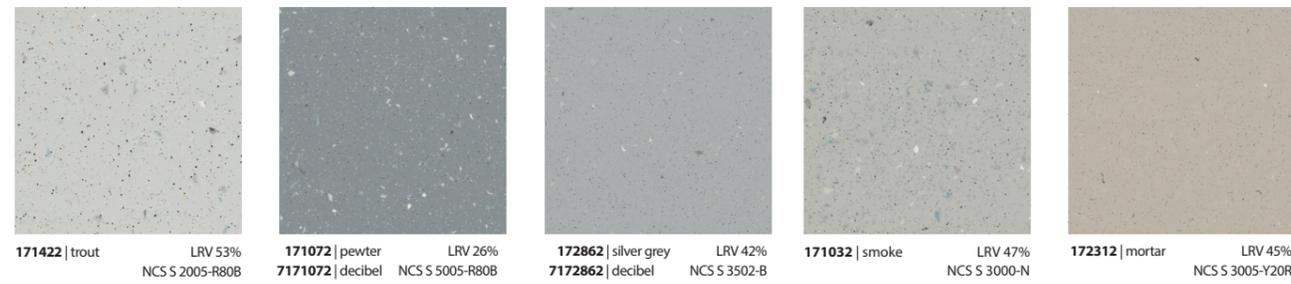
## Spa's, showers and swimming pool areas

- Continuously wet areas, barefoot and soft shoes
- Walk-in showers
- Hydrotherapy areas
- Indoor swimming pool areas

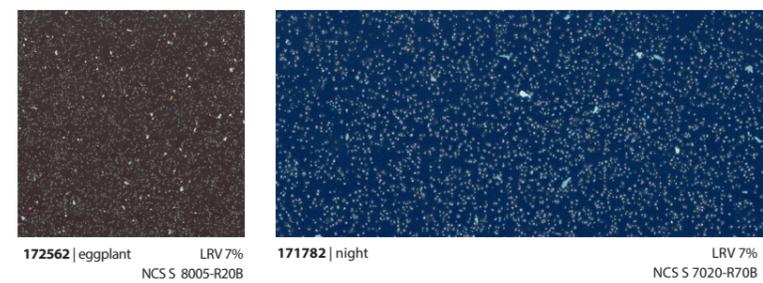
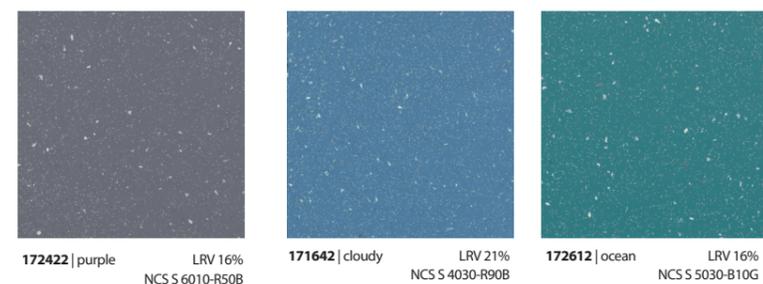
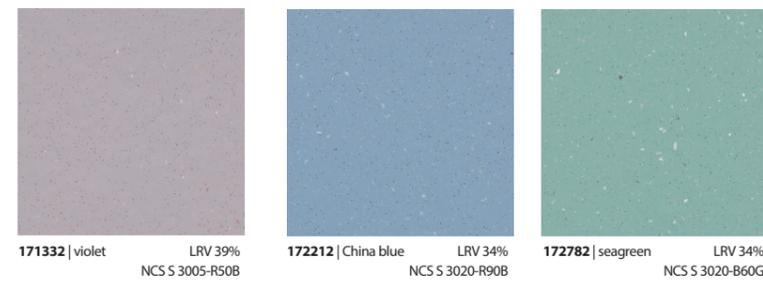
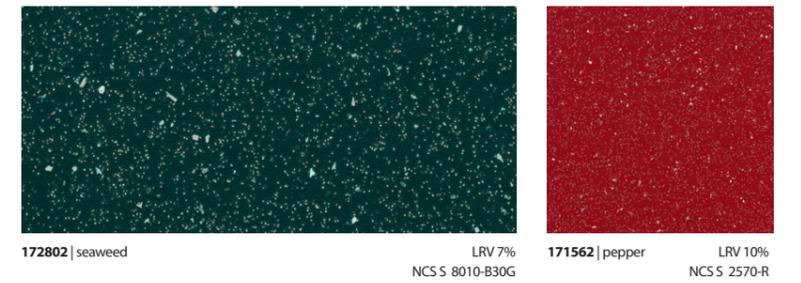
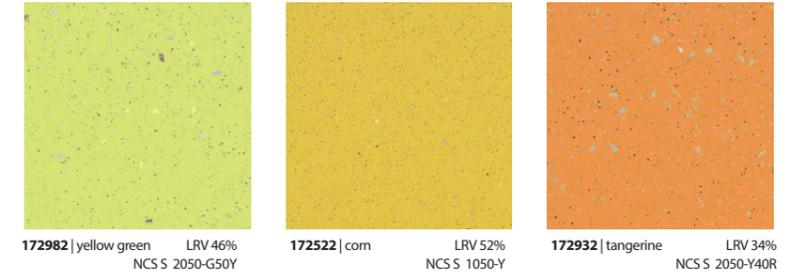
# surestep® original

The fresher looking alternative to the conventional safety flooring visual, hardwearing 100% PVC wearlayer Improved cleaner, brighter visual. A palette of 33 colours, build up in coordinated colour gradations of saturation/hue/lightness.

R10, ESf, TRRL≥36, Rz≥20



**172522** | corn **172802** | seaweed **172982** | yellow green



**171332** | violet **172212** | China blue

# surestep® star

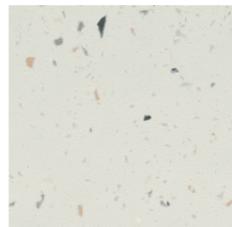
Innovative, muted and sophisticated. The holographic chips adds colour to the natural and neutral colour series. Colour tones of today, all with hints of grey, provide a uniquely refined identity. 100% PVC wear layer, with added holographic large chip. Improved cleaner visual. Particles colour match the terrazzo/ natural base color of each item. Neutral and natural tones of today, available in 9 colours.

\* 3 colours of the Surestep star range are also available in an Esb (barefoot) option.

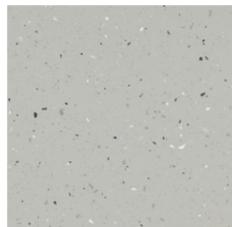
R10, ESf, TRRL≥36, Rz≥20



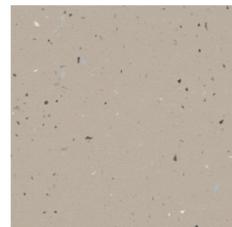
176312 | mortar 176772 | cement



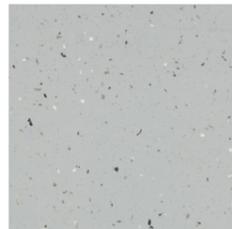
176082 | snow LRV 75%  
178082 | snow \*Esb NCS S 1002-G



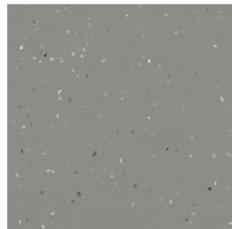
176032 | smoke LRV 47%  
178032 | smoke \*Esb NCS S 8500-N



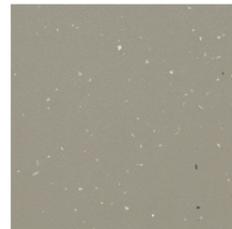
176312 | mortar LRV 45%  
NCS S 3005-Y20R



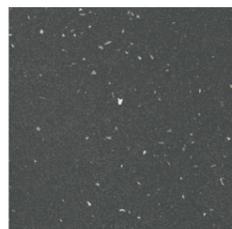
176422 | trout LRV 54%  
NCS S 2005-R80B



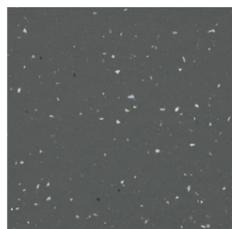
176922 | concrete LRV 28%  
178922 | concrete NCS S 4500-N



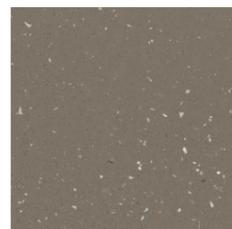
176772 | cement LRV 30%  
NCS S 4005-Y50R



176592 | lava LRV 10%  
NCS S 7005-R80B



176952 | mercury LRV 14%  
NCS S 6502-B

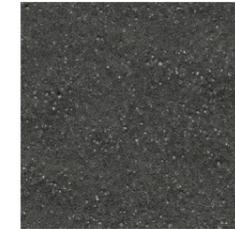


176262 | umber LRV 19%  
NCS S 6005-Y20R

# surestep® steel

Surestep Steel is a new visual in 4 colours with a smooth concrete look and a metallic sparkle effect in the background. It is really on trend and new in in safety vinyl. The effect is the most appealing in neutral and natural colours related to concrete. The specifications are similar to Surestep Original and Surestep Star.

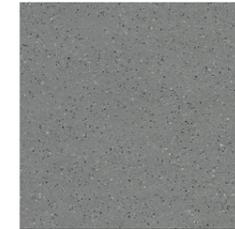
R10, ESf, TRRL≥36, Rz≥20



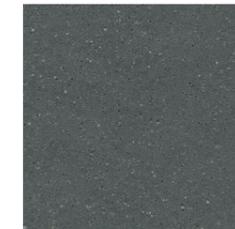
177992 | metallic charcoal LRV 10%  
NCS S 8000-N



177982 | metallic carbon LRV 17%  
NCS S 6005-B20G



177852 | metallic mercury LRV 19%  
NCS S 6000-N



177592 | metallic lava LRV 13%  
NCS S 6502-B

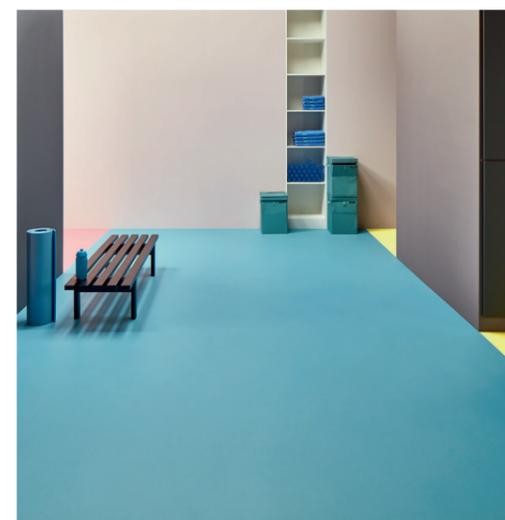
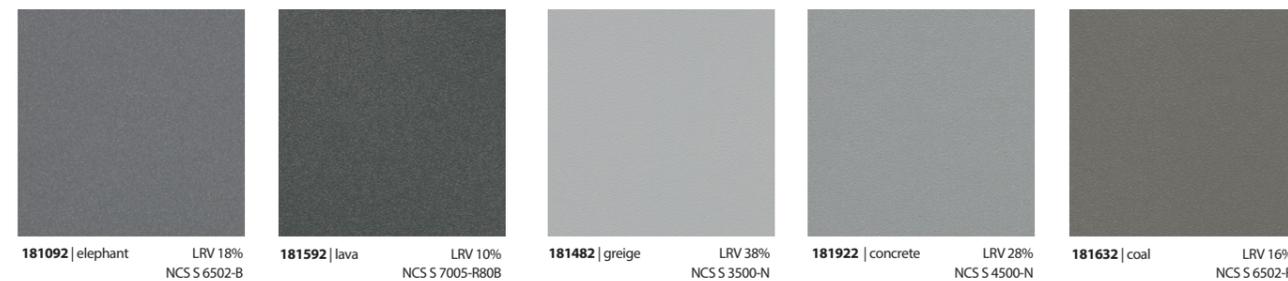


177992 | metallic charcoal

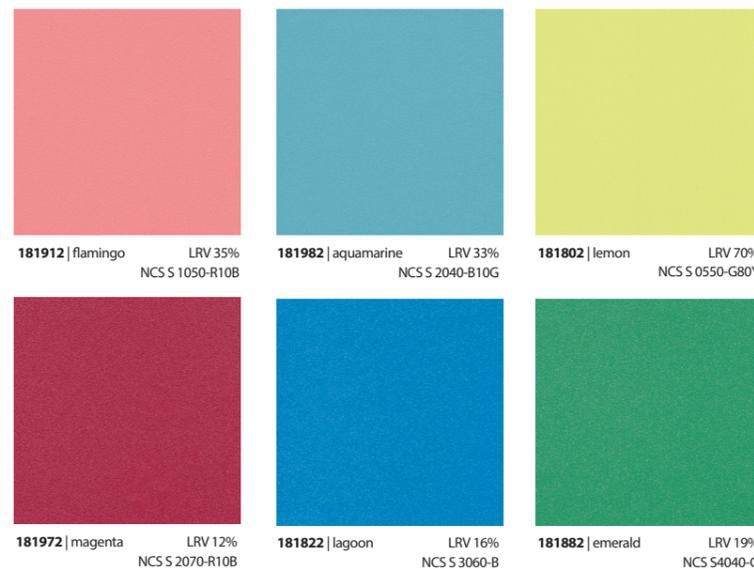
# surestep® laguna

This product combines barefoot and footwear slip resistance, for areas where both are likely and frequently will take place. Complying to the relevant norms for both products it can cover all transition areas, like changing rooms and circulation areas. The subtle, soil hiding particle is integrated in the visual, offering a clean and fresh look.

Class B, R10, Esf + ESb, TRRL≥36, Rz≥20.



**181912** | flamingo **181982** | aquamarine **181802** | lemon



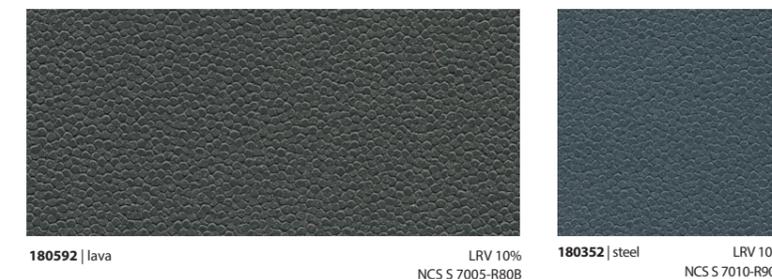
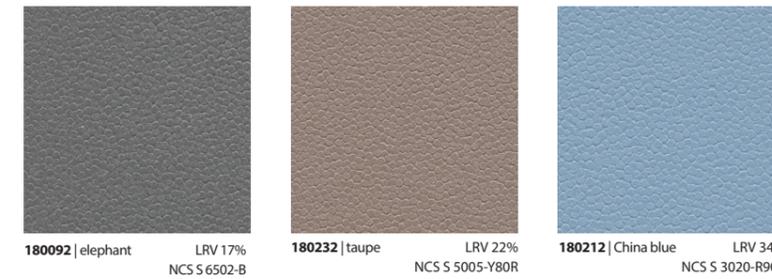
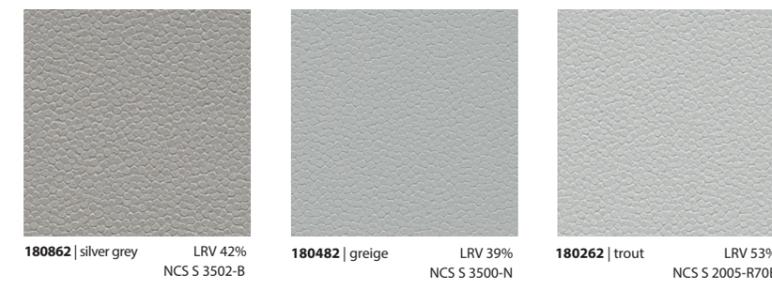
# safestep® aqua

This modern, organic design with a new and unique embossing shape is designed for barefoot (and soft soled shoes) areas. A flexible product, that can easily be installed to the specific requirements of these areas; but most importantly will perform on the highest barefoot class. The clean and modern collection content fits the hygienic and sensitive requirements of the application areas, like bathrooms and swimming pool areas.

Class C, R10, ESb, TRRL≥36, Rz≥20.



**180232** | taupe **180482** | greige



# surestep® wood

Natural designs, realistic and close to nature, for areas with a warm ambience. The popular Wood designs are included and all have a clear and sharp wood visual with the practically invisible 'Step Crystals' for slip resistance. New are the abstract woods, allover designs for both very small (pantry) and larger applications. Matching with other Forbo wood or material designs in sheet or plank/tile formats. 4 colours of the Surestep wood range are also available with 17 dB impact sound reduction as Surestep wood decibel.

R10, ESf, TRRL≥36, Rz≥20.



17122 | cool concrete 18962 | whitewash oak



18372 | white chestnut LRV 34%  
NCS S 4005-Y20R



18962 | whitewash oak LRV 25%  
718962 | decibel NCS S 5010-Y10R



18802 | elegant oak LRV 32%  
718802 | decibel NCS S 4010-Y30R



18972 | rustic oak LRV 18%  
718972 | decibel NCS S 6010-Y10R



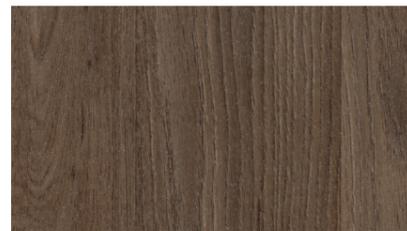
18882 | classic oak LRV 24%  
718882 | decibel NCS S 5010-Y10R



18942 | natural oak LRV 39%  
NCS S 3500-N



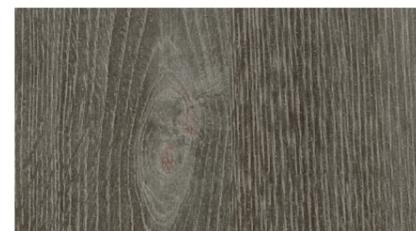
18382 | chestnut LRV 21%  
NCS S 5010-Y30R



18792 | dark oak LRV 12%  
NCS S 7010-Y30R



18832 | grey oak LRV 23%  
NCS S 5502-Y



18952 | dark grey oak LRV 12%  
NCS S 7000-N



18982 | shadow oak LRV 20%  
NCS S 5502-Y

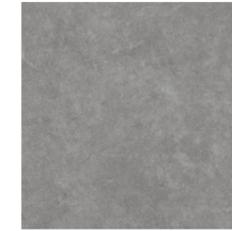
# surestep® material

A unique mineral design; a small speckle with a monumental gesture for large areas. A unique new trend of focused design with a unique look. The chips in the transparent wear layer create depth and add refinement to the floor. 4 colours of the Surestep material range are also available with 17 dB impact sound reduction as Surestep material decibel.

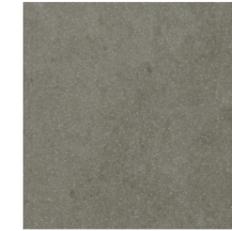
R10, ESf, TRRL≥36, Rz≥20.



17122 | cool concrete LRV 37%  
717122 | decibel NCS S 4000-N



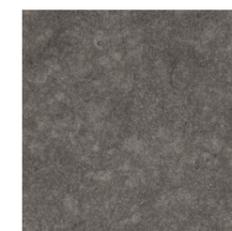
17132 | blue concrete LRV 25%  
NCS S 4502-B



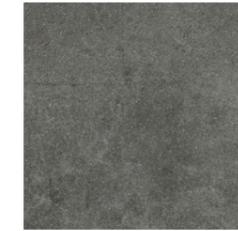
17412 | taupe concrete LRV 22%  
NCS S 5502-Y



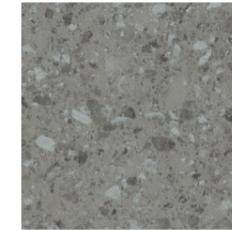
17422 | beton concrete LRV 28%  
717422 | decibel NCS S 5000-N



17162 | grey concrete LRV 17%  
NCS S 6502-Y



17482 | gravel concrete LRV 15%  
717482 | decibel NCS S 7010-R90B



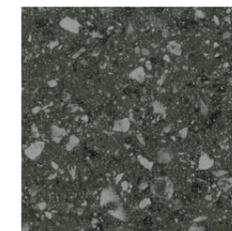
17512 | quartz stone LRV 21%  
NCS S 5500-N



18562 | grey seagrass LRV 18%  
NCS S 6005-Y20R



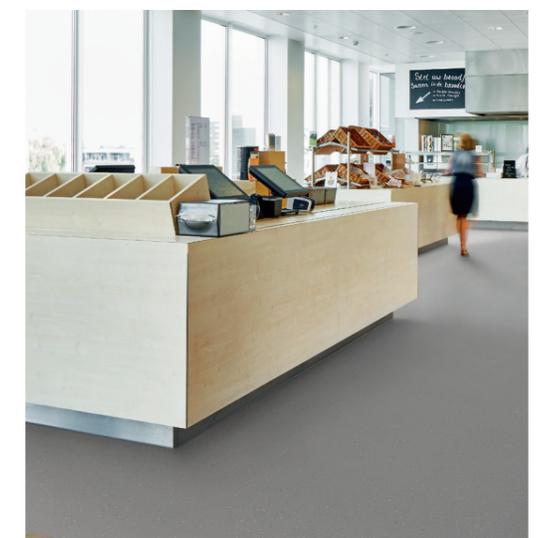
17172 | black concrete LRV 8%  
717172 | decibel NCS S 8000-N



17532 | coal stone LRV 12%  
NCS S 7500-N



18572 | black seagrass LRV 13%  
NCS S 7000-N



17122 | cool concrete

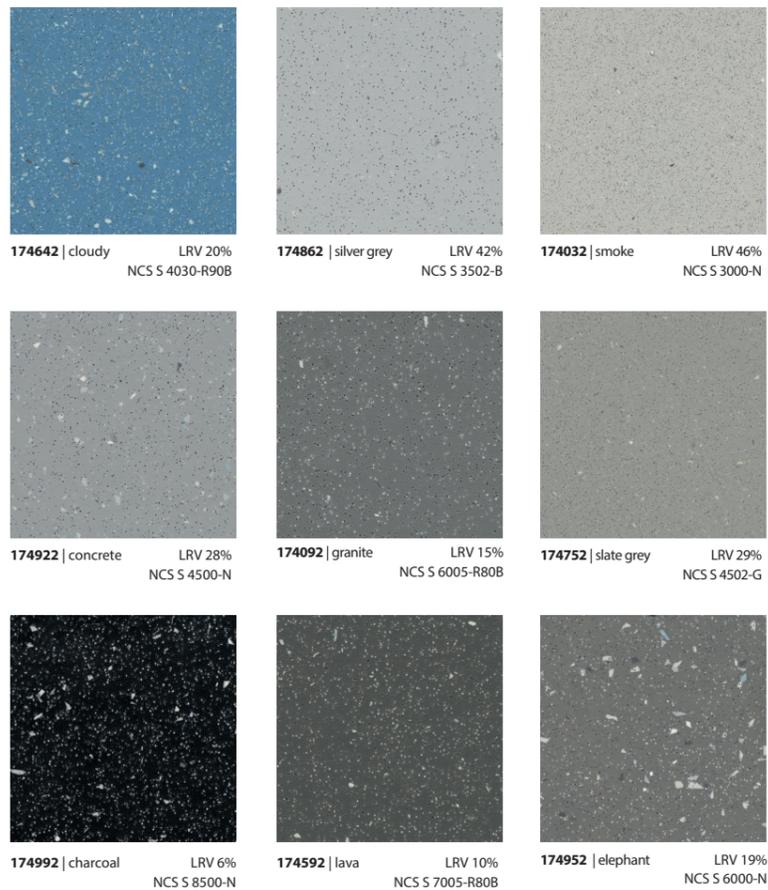
# safestep® R11

A range of 9 colours, matching the target applications - including professional kitchens - for hygienic and clean appearance. All available R11 colours match with a Surestep collection item. Like with Original, and compared to other safety flooring on the market, the amount of black particles is reduced to realize a friendlier floor visual. A combination of high slip resistance and high hygienic standards, ideal for areas with a higher general need for enhanced slip resistance. Safe and long lasting and with PUR Pearl coating for easy cleaning and maintenance.

R11, ESf, TRRL≥40, Rz≥45



174922 | concrete



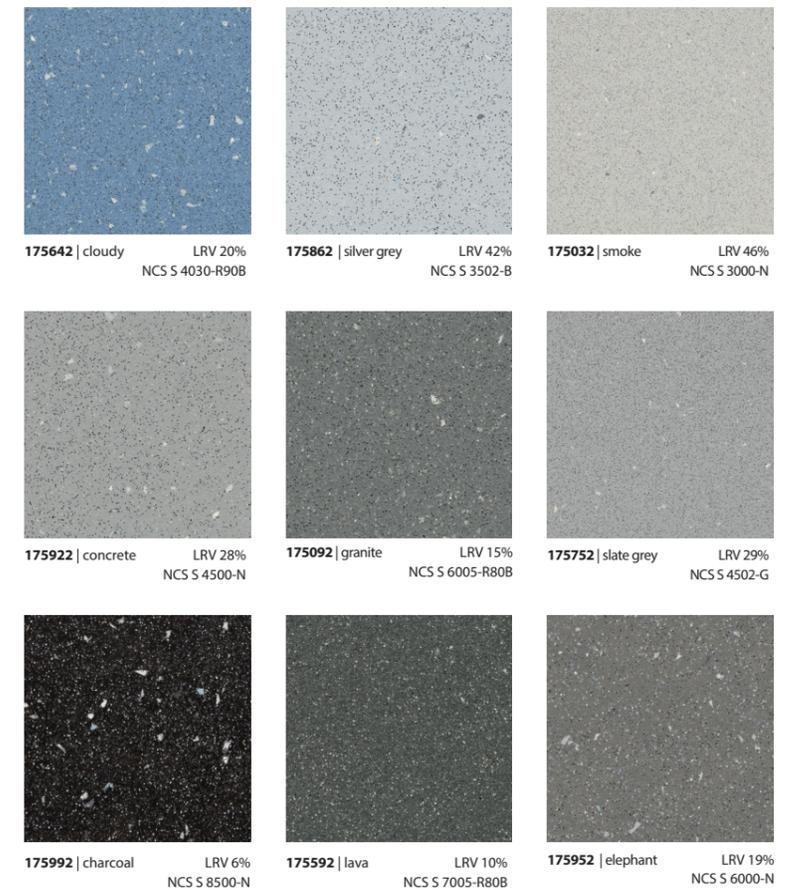
# safestep® R12

A range of 9 soil hiding colours, matching the application in light industrial areas. All colours match with a Surestep item and with Safestep R11. Long lasting, high slip resistant R12 rated floors ensure slip resistance under even the most extreme conditions.

R12, ESf, TRRL≥50, Rz≥60



175952 | elephant



# surestep® digital print

Forbo is proud to introduce the first safety vinyl which offers you complete design freedom through its state of the art digital printing technique. Whether you are looking to recreate a complex logo or design feature, match perfectly with your interior colour scheme or visualise an entirely new flooring design, we have the knowledge and technology to help and guide you every step of the way.

"Moon" and "Ice cream" are ready to use examples of the endless possibilities of this innovation production technology. Contact us to find out what we can do for your customized design requirement.



17992 | ice cream



17982 | moon

# onyx+



onyx+ 26511 | grey  
surestep 17122 | cool concrete

Onyx+ is a durable vinyl wall covering, especially developed for commercial wetroom applications such as wetrooms for health facilities, nursing homes and senior residences.

Onyx+ is developed to coordinate with Step to offer a complete and visually attractive wetroom solution from floor to wall.

This 0.92 mm thick product with 0.1 mm wear layer can be hot welded.

For the full technical specification, Installation and Floorcare information, please visit [www.forbo-flooring.com/wetroom](http://www.forbo-flooring.com/wetroom)



## FORBO'S WETROOM SOLUTIONS

The popularity of the 'wetroom concept', a watertight walk-in shower room, is growing and not just in nursing homes, hospitals and care homes, but also in student accommodation, sports centres and hotels. The continuously sealed floor and wall system stops moisture ingress and therefore prevents bacterial growth.

Easy to access, even for wheel chair users, hygienic and easy and quick to clean (with no sharp corners or crevices for dirt and bacteria to collect).

### Co-ordinated wall and safety floor surfaces

Safestep Aqua, Surestep Laguna and Surestep Star barefoot ranges are perfect for wetroom applications. They were specifically developed for use in continuously wet areas, where water flows frequently and barefoot traffic is the standard; or where there is a combination of barefoot and footwear traffic.

To complement these well established safety flooring options, we have introduced Onyx+, a range of stylishly co-ordinated vinyl wall coverings.

## YOUR WETROOM SHOPPING LIST

In order for a wetroom to function correctly, it's important that all surfaces are watertight. We've produced a video and detailed installation instructions showing how to install a wetroom system ([www.forbo-flooring.co.com/wetroom](http://www.forbo-flooring.co.com/wetroom)) and below is a shopping list of the key items that you will need for a successful installation. Details of where to source these items can also be found online at the link above.

All of the profiles are used to allow for the floor and covering to be continued up the wall for a neat and clean finish in wet and sanitised areas. The cove former is installed at the junction between the wall and the floor. This creates a hidden curved support for the floor covering as it is formed over the junction and up the wall. The cove former is also installed on the internal corners on the walls to ensure that there are no crevices which can harbour bacteria.

### Diminishing Strip – 2mm

Installed behind the wall covering to ensure a smooth transition at the overlap of the wall and floor covering.



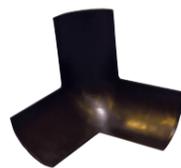
### Cove Former 35mm

For a smooth transition at floor to wall junctions and at internal corners.



### Internal corner pieces

To provide support and make a smooth transition for the Step floor covering at internal corners.



### External corner pieces

To support the Step floor covering and make a smooth transition at external corners.



## BEAUTIFULLY COLOUR CO-ORDINATED WALL AND FLOOR SURFACES



Surestep laguna 181482 | greige + 181982 | aquamarine + Surestep wood 18562 | grey seagrass

### The floor covering – safestep® aqua surestep® laguna surestep® star barefoot

- Guaranteed lifetime slip resistance
- Innovative slip resistant Step Crystals for a clean and fresh design and easier cleaning
- Up to 70% recycled content in the backing
- Glass fleece carrier for superior dimensional stability
- PUR Pearl floor surface finish for protection and optimal hygiene
- Suitable for wheelchair use



Safestep Aqua 180092 | elephant + Onyx+ 26521 | grey accent

### The wall covering – onyx+

- Available in 2m wide rolls
- Designed to complement the wetroom ranges in the Step Safety flooring collection
- Suited to commercial applications in health centres, hospitals and care homes
- Can be installed horizontally where required
- The backing layer is colour co-ordinated with the top layer making the product easier to weld

# Step FloorCare

The Forbo Surestep slip resistant vinyl collections are easy to clean and maintain, thanks to their highly durable PUR pearl and PUR coated surfaces.

## surestep®

### Cleaning after installation

Remove all debris, dirt and dust off the floor and clean the floor with a neutral floor cleaner. For larger areas a scrubber dryer or a rotary machine with a suitable cleaning pad may be used. Pick up dirty water with a wiper and mop or wet vacuum, rinse with clean water and allow floor to dry.

### Regular cleaning

Wipe with a dust mop and dust cloth, or vacuum the floor.  
Remove spots with a damp mop.  
Spray clean with a rotary machine and a buffing pad, use spray where necessary.

### Occasional maintenance

Scrub with cleaner, a rotary machine and a scrub pad.  
Pick up dirty water with a wiper and mop or a water vacuum.  
Rinse with clean water and a mop.  
Allow the floor to dry.

## safestep® R11, safestep® R12, safestep® aqua, surestep® laguna

### Cleaning after installation

Remove all debris, dirt and dust off the floor. Vacuum clean and/or sweep the floor thoroughly then scrub with a neutral detergent. For larger areas a scrubber drier or rotary machine with a suitable brush or a cylindrical brush machine e.g. Rotowash/Multiwash, will be most effective. Pick up dirty water with wiper and mop or wet vacuum, rinse and allow floor to dry.

### Regular cleaning

Vacuum or sweep the floor to remove loose dirt and dust.  
Manual Cleaning – Scrub with a neutral detergent (ph7-8) and a scrubbing brush. Remove dirty water with a wiper and mop.  
Machine Cleaning - A combined scrubber drier or rotary machine with a suitable brush or a cylindrical brush machine e.g. Rotowash/Multiwash, will produce best results on larger areas. If the floor is heavily soiled, a stronger detergent with a ph of around 10 can be used. Rinse well afterwards with clean water.

### Periodic cleaning

Clean the floor periodically using the manual or machine methods above. Clean heavily soiled areas with a concentrated cleaning solution, which should be allowed to soak on the floor for a few minutes before scrubbing. Rinse well with clean water afterwards. High pressure cleaning is an alternative method to scrubbing provided the excess water can be dealt with.

**N.B.** Do not use seals or polishes on Step Ranges as the slip resistant properties could be reduced.

For more information: [www.forbo-flooring.com](http://www.forbo-flooring.com).



# Step Installation



### Coving

Covings are used to cover the transition between horizontal and vertical parts, by installing a strip of flooring material over a cove former profile. When applying covings always use pressure sensitive (contact) adhesive for installation of both the cove former and the strip and ensure that the material is firmly pressed into position. Check the adhesive instructions for detailed information. The horizontal and vertical seams can be sealed by hot welding.

### Drains

- Use floor drains with clamping covers
- Minimum fall to drains in wetrooms 1%
- Drains > 30cm from the wall.  
Some regulations allow 15 cm but more makes installation easier



### New speckled welding rods

Matching welding rods are developed for each collection item. Some welding rods might be applicable for multiple floor items. New to the market are 10 new colours in a speckled design which matches the floor and visually hides the welding rod.

Seams in safety vinyl can be made impervious by using the hot welding technique. The seams in the flooring material are routed out, usually 2/3 of the total thickness. After thorough cleaning, the weld is made using the hot air gun and special nozzle available to perform the task properly. Finally the weld is trimmed in two stages. First, trim off the excess material using a quarter moon knife and seam sledge. After the weld has completely cooled down, the final trimming should be performed with the quarter moon knife only.  
For straight angles in vinyl, a special triangular welding rod is available. This type also requires routing before welding, but nail trimming of the welded seam may be skipped. Always follow the instructions, provided with the weld rod.



### Installation advise

On the backing of Step there is an imprint, showing the direction of production and advice on the installation direction. Installation direction is also found on the roll label.

### • All over designs: reverse installation

Surestep – Original, Star, Stone, Mineral, Laguna  
Safestep – R11, R12, Aqua

### • Directional designs: install in one direction

Surestep – Wood, Texture

### Adhesives

Adhesive advice for compact (and acoustic) sheet vinyl installation is:

- 540 Eurosafe Special
- Solvent free; project vinyl specific
- 640 Eurostar Special
- Solvent free; Low Emission EC1
- Locally, the adhesive advice can differ

For more information about Service Products and System Solutions contact your sales office or visit the website

[www.forbo-flooring.com](http://www.forbo-flooring.com)

*With the focus on LCA improvement, the key developments for the new Step collection can be summarised as follows:*

- Internal recycling of all production waste from safety products
- Increased recycled content in the backing layer; from 39% to 70%
- Overall improvements by using Step Crystals: a recycled by-product, requires lower energy to produce, resulting in clearer visual and less soiling; therefore less water usage for cleaning in use phase

- All other Forbo's sustainable usp's remain;
- Better for the Indoor air quality; AgBB compliant and TVOC<250 µg/m<sup>3</sup>
  - Compliant\* to the REACH substances list
  - Produced with 100% green electricity
  - Water based inks used in printed designs
  - Low requirements for cleaning and maintenance, reduced water and detergent use
  - Forbo Spray method suitable for all R10 products, 100% biodegradable, no chlorine, pH neutral
  - A 100% recyclable product





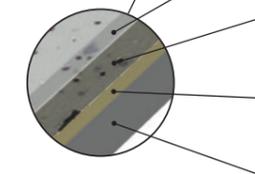
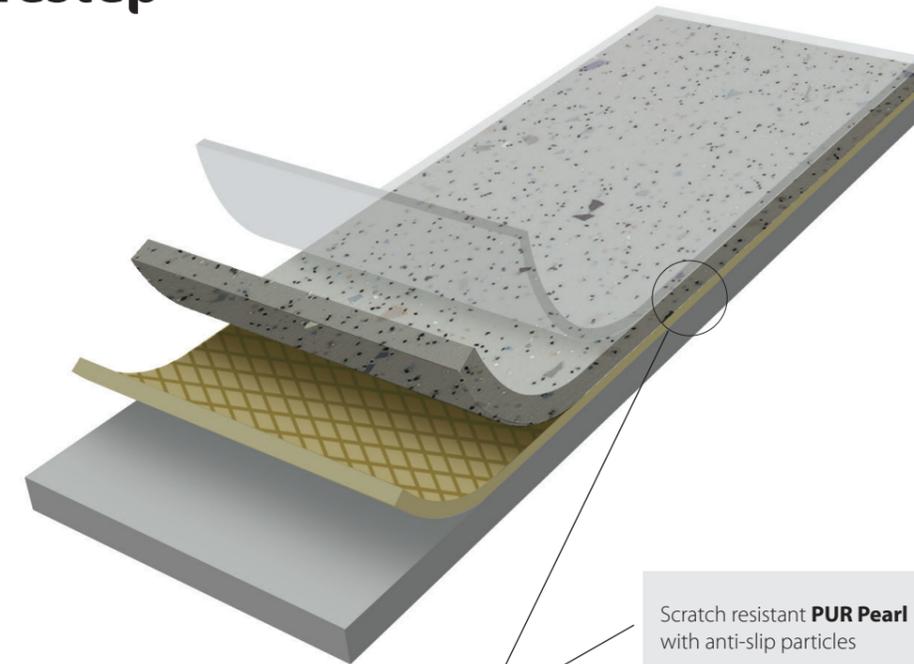
## Technical specifications

Step meets the requirements of EN ISO 10582 & EN 13845

		Surestep Original Surestep Star Surestep Steel	Surestep Material Surestep Wood Surestep DP	Safestep R11	Safestep R12	Safestep Aqua	Surestep Star Barefoot Surestep Laguna
Total thickness	EN ISO 24346	2.0 mm	2.0 mm	2.0 mm	2.0 mm	2.0 mm	2.0 mm
Thickness wear layer	EN ISO 24340	0.7 mm	0.7 mm	0.7 mm	0.7 mm	0.7 mm	0.7 mm
Surface finish		PUR Pearl	PUR Pearl PUR Wood Pearl	PUR Pearl	PUR Pearl	PUR	PUR
Commercial very heavy	EN ISO 10874	Class 34	Class 34	Class 34	Class 34	Class 34	Class 34
Light industrial	EN ISO 10874	Class 43	Class 43	Class 43	Class 43	Class 43	Class 43
Collection size		33 - 9 - 4	11 - 11 - 2	9	9	8	3 - 15
Roll width	EN ISO 24341	2.00 m	2.00 m	2.00 m	2.00 m	2.00 m	2.00 m
Roll length	EN ISO 24341	20 - 27 m	20 - 27 m	20 - 27 m	20 - 27 m	20 - 27 m	20 - 27 m
Total weight	EN ISO 23997	2.75 kg/m <sup>2</sup>	2.75 kg/m <sup>2</sup>	2.75 kg/m <sup>2</sup>	2.75 kg/m <sup>2</sup>	2.75 kg/m <sup>2</sup>	2.75 kg/m <sup>2</sup>
Dimension stability	EN ISO 23999	< 0.1%	< 0.1%	< 0.1%	< 0.1%	< 0.1%	< 0.1%
Residual indentation	EN ISO 24343-1	≤ 0.05 mm	≤ 0.05 mm	≤ 0.05 mm	≤ 0.05 mm	≤ 0.05 mm	≤ 0.05 mm
Castor chair continuous use	ISO 4918	No effect	No effect	No effect	No effect	No effect	No effect
Use in wet areas	EN 13553	Yes	No	Yes	Yes	Yes	Yes
Light fastness	EN ISO 105 B-02	≥6	≥6	≥6	≥6	≥6	≥6
Flexibility	EN ISO 24344	ø 10mm	ø 10mm	ø 10mm	ø 10mm	ø 10mm	ø 10mm
Slip resistance	EN 13845 Annex C	ESf	ESf	ESf	ESf	ESb	ESb / ESf
	EN 13845 Annex D 50,000 revolutions <10% loss	Pass	Pass	Pass	Pass	Pass	Pass
	DIN 51130	R10	R10	R11	R12	R10	R10
	Din 51097					Class C	Class B
Chemical resistance	EN ISO 26987	Very good	Very good	Very good	Very good	Very good	Very good
Indoor Air Emissions: TVOC after 28 days	ISO 16516	≤ 0.01 mg/m <sup>3</sup>	≤ 0.01 mg/m <sup>3</sup>	≤ 0.01 mg/m <sup>3</sup>	≤ 0.01 mg/m <sup>3</sup>	≤ 0.01 mg/m <sup>3</sup>	≤ 0.01 mg/m <sup>3</sup>
Life Cycle Assessment		LCA is the foundation for securing the lowest environmental impact					
<b>Creating better environments</b>							
Renewable electricity		Step is manufactured using 100% electricity from renewable sources					
Recycled content		Step contains up to 70% recycled content in the backing					
Step meets the requirements of EN 14041							
Reaction to fire	EN 13501-1	B <sub>f1</sub> -s1, G, NCS	B <sub>f1</sub> -s1, G, NCS	B <sub>f1</sub> -s1, G, NCS	B <sub>f1</sub> -s1, G, NCS	B <sub>f1</sub> -s1, G, NCS	B <sub>f1</sub> -s1, G, NCS
Slip resistance	EN 13893	μ ≥ 0.30	μ ≥ 0.30	μ ≥ 0.30	μ ≥ 0.30	μ ≥ 0.30	μ ≥ 0.30
Body voltage	EN 1815	< 2kV	< 2kV	< 2kV	< 2kV	< 2kV	< 2kV
Thermal conductivity	EN 12524	0.25 W/m.K	0.25 W/m.K	0.25 W/m.K	0.25 W/m.K	0.25 W/m.K	0.25 W/m.K

surestep®  
safestep®

## Construction



Scratch resistant **PUR Pearl** with anti-slip particles

**Clear and coloured wearlayer** with anti-slip particles

**Glass fleece** for dimensional stability

**Compact backing** with 70% recycled content

## Benefits

**A durable floor covering combining outstanding slip resistance, up to R12, with a wide range of design possibilities. The PUR Pearl surface provides superior, long-lasting appearance and performance.**

- R10, R11 and R12 in anti slip enhanced performance
- PUR Pearl lacquered surface providing easy cleaning and maintenance
- Low gloss surface for scuff and a natural look

- Transparent or coloured durable wear layer for a long-lasting appearance
- High recycled PVC content
- Widest design variety in safety flooring

All Forbo Flooring Systems' sales organisations worldwide have a certified Quality Management System in accordance with ISO 9001.  
All Forbo Flooring Systems' manufacturing operations have a certified Environmental Management System in accordance with ISO 14001.  
The Life Cycle Assessment (LCA) of Forbo Flooring Systems' products is documented in individual Environmental Product Declarations (EPDs) which can be found on all of our websites.

# More Forbo flooring



**allura**



**Allura Luxury Vinyl Tile**  
The all new Forbo Allura collection presents the ultimate finesse in realistic natural and abstract designs that have been created with state of the art production techniques and processes to create the most realistic and natural material expression in luxury vinyl tiles. Available in 5 individual collections, from glue down to loose lay and click systems.



**eternal**



**Eternal**  
Eternal is Forbo's general purpose Project vinyl offer. Within our Eternal general purpose project vinyl collection you'll discover a combination of state of the art designs in a strong durable, fit for purpose range – whatever your application. The collection presents a balanced range of wood-, stone-, and abstract designs, alongside with a comprehensive modern colour palette that complements your interior design.



**marmoleum**



**Marmoleum**  
As the world market leader in Linoleum flooring solutions, Forbo offers a huge range in natural linoleum floor coverings as well as surface linoleum for furniture and wall covering. Over a 100 years of experience and modern manufacturing techniques today create the most durable and sustainable resilient floor covering available. Made from linseed oil, rosin, wood flour and limestone, linoleum is a truly natural product that can be applied in a wide range of commercial and residential environments.



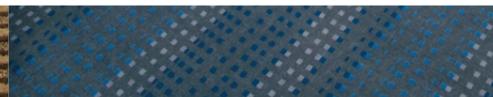
**entrance flooring**



**Entrance flooring**  
Creating better environments starts at the entrance of any building. To avoid water, sand, mud and gravel being carried into the building a proper entrance floor is a good line of defense. Coral entrance floors are created to absorb moisture and scrape dirt of shoes and wheel that find their way into a building. Entrance floors can reduce cleaning and maintenance costs and give the floors inside the building their optimum appearance retention.



**flotex**



**Flotex Flocked flooring**  
Flotex floor coverings are high tech textiles which are characterized by the fact that they combine comfort and warmth underfoot with excellent properties for cleaning and hygiene. The dense nylon 6.6. fibre surface (over 70 million per square metre) creates a hard wearing and extremely durable floor that withstands high traffic and heavy loads. The Flotex designs come in a great variety of colourways. Digital printing assures both bright and natural colour tones with which an infinite number of designs and collections can be created.



**tessera**



**Tessera**  
Forbo offers a wide range of contemporary high quality tufted loop-, cut&loop- and cutpile carpet tiles for office and leisure environments. With over 20 ranges the offer covers a wide spectrum of design, price and quality that can match any competitive offer.

Forbo Flooring Systems is part of the Forbo Group, a global leader in flooring and movement systems, and offers a full range of flooring products for both commercial and residential markets. High quality linoleum, vinyl, textile, flocked and entrance flooring products combine functionality, colour and design, offering you total flooring solutions for any environment.

**Find us on**



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**creating better environments**



FLOORING SYSTEMS