
step

safety vinyl

creating better environments
• Safety vinyl flooring with sustainable slip resistance for the guaranteed life of the product.

• The widest offering and contemporary visuals of PUR finished R10, R11 and R12 safety flooring.

• Fit for purpose in both visual, low lifecycle costs and non-slip performance, the total collection offers solutions for all major specified slip resistant areas.

• Unique and attractive solutions for wet room applications, offering the best in barefoot, but also combined barefoot and footwear slip resistance in a comfortable way.

• NEW unique, innovative slip resistant “Step Crystals” that provide security, a clean, modern and fresh design, easier cleaning and an improved Life Cycle Assessment.

• A revolutionary new flooring concept optimized for its environmental performance by using recycled content and recycled components.
Surestep®
Sustainable R10 slip resistance: all Surestep products are non-slip particle enhanced and can be applied in all types of general walking areas, where an increased slip risk may occur. Surestep offers lasting performance and keeps looking good with easy regular cleaning.

Typical areas:
High traffic areas, corridors, ramps, special areas such as coffee corners, washrooms, toilets, crafts class rooms, public rooms etc.

Collections:

Most relevant Slip resistant norms:
EN13845 / DIN 51130 (R10).

Safestep®
Safestep products are applicable in areas where a higher slip risk is identified because of incidental, accidental or continuous active contamination or the floor. In these areas it is simply not possible to prevent spillage, due to the type of work environment. The intensity of the activity identifies the type of product to use.

Typical areas:
Professional kitchens, light industrial food production, florist shops, garden centres.

Collections:
Safestep R1 1, Safestep R12.

Most relevant Slip resistant norms:
EN13845 and DIN51130 (R11, R12).

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

Typical areas:
Shower tray, spa/pool surrounding, changing rooms, locker rooms.

Collections:
Surestep Laguna, Safestep Aqua

Most relevant Slip resistant norms:
EN13845 and DIN51097 for wet-loaded barefoot use.
**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.

- 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 meat 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
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 24 colours, build up in coordinated colour gradations of saturation/hue/lightness.

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 13 colours.

R10, ESf, TRRL≥36, Rz≥20
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 stone designs in sheet or plank/tile formats.

Surestep Wood Decibel
All colourways are also available as Surestep Wood Decibel on request, which offers 17db impact sound reduction. A combination of classical woods which also have a non-slip equivalent for adjacent areas.

Surestep Stone
True to life stone floor designs with a modern look, for contemporary areas. Both in a series of concrete design and in a black and white granite all-over stone variety. A range with a hard and solid appearance, in straightforward colours, dark & light, warm & cool. Enriched by both carborundum or Step Crystals particles for realistic visuals.

Surestep Mineral
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.

Surestep Texture
A trendy focused design with a subtle textile impression, for a soft and elegant look & feel. A textured embossing enhances the tactility and the gentle look of the visual. Both. Mineral and Texture, are in a natural colour range. With Step Crystals, to have a not so obtrusive, non compromised safety floor.

R10, ESf, TRRL≥36, Rz≥20.
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Safestep R11
A range of 8 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

Safestep R12
A range of 4 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
This is innovation in wetroom flooring and Forbo at its best when combining functionality with design. Two completely new products brought in a fresh, contemporary and suitable for application, colour scheme.

**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.

**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.
Forbo Step brochure 2014 - Engels algemeen

**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

**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 final trimming of the welded seam may be skipped. Always follow the instructions, provided with the weld rod.

**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

**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 Eurosafé 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
With the focus on LCA improvement, the key developments for the new Step collection can be summerised 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 a 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/m3  
• 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

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<tr>
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<th>Surestep Original</th>
<th>Surestep Star</th>
<th>Surestep Stone</th>
<th>Surestep Mineral</th>
<th>Surestep Texture</th>
<th>Safestep R11</th>
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<td>&lt; 26V</td>
</tr>
<tr>
<td>Thermal Conductivity</td>
<td>EN 12524</td>
<td>0.25 W/m.K</td>
<td>0.25 W/m.K</td>
<td>0.25 W/m.K</td>
<td>0.25 W/m.K</td>
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<td>0.25 W/m.K</td>
<td>0.25 W/m.K</td>
</tr>
<tr>
<td>Slip resistance</td>
<td>EN 13893</td>
<td>DS ≥10</td>
<td>DS ≥10</td>
<td>DS ≥10</td>
<td>DS ≥10</td>
<td>DS ≥10</td>
<td>DS ≥10</td>
<td>DS ≥10</td>
<td>DS ≥10</td>
</tr>
</tbody>
</table>

Step meets the requirements of EN 14041
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

Benefits
More Forbo flooring

**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 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**
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 wide range of commercial and residential environments.
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.

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.

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, bonding 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.