



ARDEX AF 620

Universal Water-based Contact Adhesive

Suitable for installing all main floorcovering types

- Heterogeneous and homogenous vinyl
- Cushioned vinyl
- Carpet and textile (including needle punch)
- Linoleum
- Rubber
- ARDEX WeldTec Undertile Waterproofing Membranes

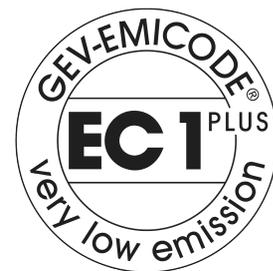
Excellent early and long term adhesive strength

Can receive floorcoverings as early as 30 minutes and be applied to floorcovering 24 hours in advance

Suitable for use over underfloor heating systems

Trafficable directly after laying

Excellent resistance to plasticiser migration



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ARDEX AF 620

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DESCRIPTION

ARDEX AF 620 is a water-based, solvent-free, low-odour, dispersion contact floorcovering adhesive. ARDEX AF 620 has a reduced airing, and long open time, and also a high bond strength with permanent high tack. It is protected from biodegradation and has excellent resistance to plasticiser migration.

ARDEX AF 620 meets the requirement guidelines for the EMICODE licence 'EC1 PLUS', achieving the lowest possible emission limits.

USE

ARDEX AF 620 is ideal for installing all types of vinyl, carpet and textiles, linoleum and rubber floorcoverings and vinyl and rubber skirting.

ARDEX AF 620 can be used on porous and non-porous substrates including correctly prepared alloys and steel. ARDEX AF 620 is suitable to be used with all ARDEX levelling and smoothing compounds in both commercial and domestic locations.

PRIMING

Priming is not required, however, on highly absorbent surfaces it can be advantageous to prime with ARDEX P 51 diluted 1:3 with cold, clean water. This will maintain the working time and ensure maximum coverage of the adhesive.

SUBSTRATE PREPARATION

The subfloor must contain an effective damp proof membrane and be dry, with an equilibrium relative humidity of 75% or below. Where an effective damp proof membrane is absent, or the relative humidity of the subfloor is above 75% RH, contact ARDEX Technical Services for the correct product selection.

The surface being adhered to must be clean, firm and free dust, dirt, oil, grease, curing compounds, release agents and other barrier materials. The surface being adhered to must also be sound and smooth in accordance with the relevant clauses of NZS/AS 1884:2013. Any dust should be removed using suitable vacuum equipment, prior to applying ARDEX AF 620, as it can affect both the coverage and performance of the adhesive.

Uneven subfloors should be levelled with the appropriate ARDEX levelling and smoothing compounds e.g. ARDITEX NA or ARDEX K 15 Micro.

ARDEX A 45 can be used for repairs to the subfloor/stairs etc., in accordance with the product data sheet.

Joints, nail holes and imperfections in plywood, or minor surface damage to existing levelling and smoothing compounds i.e. footprints or trowel marks, may be pre-smoothed and levelled prior to the application of ARDEX AF 620, using ARDEX Feather Finish in accordance with the product data sheet.

Fabricated underlays such as flooring grade plywood, (SP101) should be installed where required over existing timber bases. Wood-based fabricated underlays should be suitable for the floorcovering and be at the equilibrium moisture content they will have in service at the time they are covered. Light organic solvent preservative (LOSP) treated plywood is not a suitable substrate.

MIXING

ARDEX AF 620 is ready for use, but for optimum performance the adhesive should be thoroughly mixed to ensure the even dispersion of polymers before application.

APPLICATION

The installation area and subfloor should be kept at the recommended temperature as specified by the floorcovering manufacturer and the relevant clauses of NZS/AS 1884:2013. These temperatures need to be maintained 48 hours prior to installation, during installation, and 48 hours after installation.

ARDEX AF 620 should be applied evenly to the back of floorcovering/profile first and the suitably prepared substrate second using an appropriate applicator such as a short-haired roller, brush, or fine v-notched trowel held at a 60 degree angle to the subfloor, to maximise coverage and avoid forming pools of adhesive.

To achieve an even covering of adhesive, ensure the roller is thoroughly wetted with adhesive and rolled out on waste material before the application. The application of the adhesive to the substrate should be in a thin, uniform, opaque layer, this should be allowed to dry to an almost non-tacky feel. When both surfaces have reached this state then the coverings or profiles can be placed into position.

Floorcoverings should be applied directly into the wet adhesive on absorbent backgrounds after the airing time, between 30-60 minutes depending on ambient conditions, the porosity of the subfloor and floorcovering type (see table overleaf).

Allowing the adhesive to air will improve early stage grab. Drying process may be accelerated by means of a hot air blower.

Only once both sides of adhesive applications are sufficiently dried can the flooring be fitted.

Periodically check that the adhesive has transferred to the rear of the floorcovering.

Remove any air pockets with a cork board or rubbing tool whilst within the working time of the adhesive and roll the flooring with a roller and/or a smoothing tool. Roll from side to side first and then end to end.

Rolling will ensure good overall contact and minimise the potential for adhesive show through.

Some floorcoverings may benefit from further rolling/smoothing. Heat welding should only commence 24 hours from laying and once the adhesive has dried sufficiently.

Do not allow the floor to be wet cleaned immediately after the floorcovering has been installed. Allow significant time for the adhesive bond to develop before wet cleaning commences, typically 48 hours at 20°C.

When applying adhesive onto the substrate, ensure that any adhesive which is surplus to requirements, and has been moved across the subfloor, is not placed back into the container. It should be placed into an alternative container for safe, easy disposal. This will avoid possible contamination issues.

UNDERFLOOR HEATING

Underfloor heating systems should be commissioned in accordance with the heating manufacturer's instructions; if comment cannot be found then the guidance given in NZS/AS 1884:2013 should be followed.

Thermal cycling of the subfloor will require raising the temperature of the substrate slowly to full operating temperature, held for a defined period, and slowly brought back down so that any shrinkage that is likely to take place occurs before the floorcovering is installed.

Moisture tests are required to verify the relative humidity of the substrate, the underfloor heating system should be switched off for 48 hours prior to testing.

After the tests are completed, the heating system should be stabilised to room temperature, but not below 15°C, before installing the floorcovering.

The floorcovering should be allowed to acclimatise to the substrate temperature before installation with ARDEX AF 620.

After installation allow at least 48 hours of constant temperature for the adhesive to properly cure, before slowly increasing the temperature up to the normal operating temperature of the area at a rate of approximately 2°C per day.

Do not subject the floor to static or dynamic loads, loaded trolleys, etc., or move fixtures, furniture, etc., onto the flooring until the adhesive has fully set, typically 48 hours at 20°C.

HIGH TEMPERATURE

ARDEX AF 620 is suitable for use over underfloor heating systems and is classified as high temperature resistant. The surface floor temperature must not exceed 30°C. Consult the floorcovering manufacturer for detailed guidance. For areas subjected to prolonged or extreme solar gain, such as northerly facing aspects, consider the use of ARDEX AF 180 MS or ARDEX AF 2525 Heavy Duty Adhesives.

CLEANING

Remove spills or seepage through joints with a cloth moistened with water before the adhesive dries. Aggressive cleaning agents should only be used with the permission of the floorcovering manufacturer.

PACKAGING

ARDEX AF 620 is packed in plastic tubs 2.5kg net weight.

COVERAGE

See table below.

The actual coverage achieved in practice is affected by application technique, as well as the texture and absorbency of the subfloor.

STORAGE

ARDEX AF 620 has a shelf life of 12 months if stored in good conditions, between 5°C and 30°C, in the original unopened container. Do not allow to freeze.

PRECAUTIONS

ARDEX AF 620 is non-hazardous in normal usage, however, good hygiene practices should be followed. Avoid contact with skin; wash off with soap and water before drying takes place. In case of contact with eyes, rinse carefully and thoroughly with water and seek medical advice. In case of ingestion seek medical assistance. Consult the relevant Safety Data Sheets for further information.

For the latest technical or health and safety information on this product, consult the current product or safety data sheet online at: www.ardex.co.nz

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WORDING AND TERMINOLOGY

Airing Time

The time the adhesive must be left open before applying the floorcovering. Between 30 and 60 minutes for most floorcoverings*. Between 180 minutes and 24 hours for heavily textured textile floorings - preferably overnight.

Working Time

The time in which the adhesive can receive the floorcovering. Up to 120 minutes. Between 90 minutes and 24 hours with pre-coated flooring.

Open Time

The combination of airing and working time. Up to 24 hours.

*depending on the absorbency of the subfloor and ambient conditions.

The guidance from the floorcovering manufacturer should always be followed if different from the information contained in this Technical Data Sheet.

Toll Free Technical Services:

1800 224 070 (Australia)

0800 227 339 (New Zealand)

The technical details, recommendations and other information contained in this data sheet are given in good faith and represent the best of our knowledge and experience at the time of printing. It is your responsibility to ensure that our products are used and handled correctly and in accordance with any applicable New Zealand & Australian Standards, our instructions and recommendations and only for the uses they are intended. We also reserve the right to update information without prior notice to you to reflect our ongoing research and development program. Country specific recommendations, depending on local standards, codes of practice, building regulations or industry guidelines, may effect specific installation recommendations. The supply of our products and services is also subject to certain terms, warranties and exclusions, which may have already been disclosed to you in prior dealings or are otherwise available to you on request. You should make yourself familiar with them.

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Flooring Type	Applicator Type	Coverage
PVC and CV flooring, PVC soft skirting boards, rubber floorcoverings	Short-haired velour roller, brush	Up to 7m ²
Textile flooring, linoleum, impact walls	Short-haired velour roller, brush, A1 notch trowel	Up to 5m ²