



AV 515

Single Pack Polyurethane Adhesive

Date: 18th May 2017

YOUR SMART ADVANTAGES

- Very High Bond Strength
- Single Pack
- Non Flammable
- Solvent Free
- Fast Set

DESCRIPTION

AV 515 is a single component, solvent-free, thixotropic, quick setting, moisture cured polyurethane adhesive. Fully cured **AV 515** has an extremely strong bond with excellent resistance to water.

AV 515 is suitable for bonding porous to porous and porous to non-porous substrates. **AV 515** may be used to bond timber, plasterboard, fibrous cement, some metals, EPS foam, concrete, brick, some plastics (testing is recommended) and many other common substrates, providing that one or two of the surfaces contain moisture.

AV 515 is ideal for bonding timber in applications such as furniture and can be used with softwoods and many hardwoods.

PRODUCT CHARACTERISTICS

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| Type | Polyurethane |
| Colour | Uncured - Translucent Cured - Cream to Yellow |
| Viscosity | High |
| Tack Free Time | Approx. 10 mins @ 23°C / 50% RH |
| Initial Set Time | Approx. 60 mins @ 23°C / 50% RH |
| Clamp Time | Approx. 60 mins @ 23°C / 50% RH |
| Full Strength | 24 Hours |
| Application Temp | 15°C - 35°C |

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| Application Rate | 120 - 250g/m ² depending on porosity and profile of the substrate |
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| Product code | |
| 300ml cartridge / 12 Carton | |
| AV 515 | 30804697 |

APPLICATION INSTRUCTIONS

Ensure adequate tests are conducted before using commercially.

It is important that at least one of the surfaces has a moisture content of at least 8%. The product will not cure if there is no moisture available from the substrate.

Application Instructions

Metal surfaces should be lightly sanded and wiped with Anchor Weld 901 solvent.

All joints must be close fitting. Maximum glue line thickness is 0.5mm (ideally 0.1 to 0.25 mm).

Apply sufficient adhesive for the application to one surface, using a cartridge gun. Keep the adhesive approximately 10mm in from the external edge to minimise 'squeeze-out'.

Bring both surfaces together immediately and clamp tightly and evenly to ensure proper spread of the adhesive and to produce a glue line 0.1mm to 0.25mm thick. Clamps need to remain in place for at least 60 minutes at 23°C and 50% relative humidity.

Allow any 'squeeze-out' to dry and then remove with a sharp blade. Do not try to remove the 'squeeze-out' before it dries as this will spread the adhesive over the surface and is very difficult to remove.

AV 515 expands slightly thus filling any irregularities in the substrate. Once opened **AV 515** will begin to cure. It is recommended that the tip of the cartridge be sealed to extend the life of the product.

Note:

A mist spray of water over the surface will assist cure during dry cool conditions.

AV 515 is an adhesive not a mastic and therefore should not be used as a gap filler. If used as a gap filler the strength of the bond will be reduced.

5CLM

Clamping Pressures

Softwood 50 PSI

Hardwoods 150 PSI

i.e. enough pressure to bring joints tightly together with some glue "squeeze out".

LIMITATIONS

Do not use for structural or load bearing applications. If used in exterior applications, all finished joints MUST be painted with a suitable weather resistant paint. Not recommended for edge gluing in fine furniture.

STORAGE & SHELF LIFE

Store in a cool, dry place, out of direct sunlight. Storage areas must be well ventilated and comply with Local, State and Federal regulations. For maximum shelf life, store between 5° and 35°C. Shelf life is up to 18 months when stored in original, unopened containers, under the above conditions.

CLEAN-UP

Clean tools and equipment with Xylene before the adhesive has cured. Dried adhesive may be removed from tools and equipment by mechanical abrasion or scraping. Do not try to remove adhesive from bonded assemblies before it dries as this will spread the adhesive over the surface and is very difficult to remove. Xylene may attack some surfaces.

For emergency information contact the Poisons Information Centre, phone 131 126 or the Emergency Response Service, phone 1800 033 111.



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