



Technical Data Sheet

AVS AV 515

Single Pack Polyurethane Adhesive

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, weathering, ageing and marine conditions. Certified to EN204 D4.

AV515 is suitable for bonding porous to porous and porous to non porous substrates such as wood, plasterboard, fibrous cement, metal, EPS foam, concrete, brick, melamine, various plastics (testing is recommended) and many other common substrates providing one or two of the surfaces contain moisture. The product will not cure if there is no moisture available from the substrate. E.g. glass to glass or metal to metal is not possible. Its high strength bond is ideal for bonding hardwood species such as Spotted Gum, Black Butt and Brush Box.

Features

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



Application Instructions

Ensure adequate tests are conducted before using commercially. Mix thoroughly before use.

It is important that at least one of the surfaces contains moisture. The product will not cure if there is no moisture available from the substrate, eg. gloss to gloss or metal to metal.

Application Instructions

Always use in well ventilated areas. Surface must be clean, dry, free from oil, grease, dust, loose particles or any other contamination. Metal surfaces should be solvent cleaned and lightly sanded. Apply a bead with a cartridge gun approximately 10mm in from the external edge to minimise 'squeeze-out'. Bring both surfaces together immediately and clamp for about 60 minutes (It is not necessary to have a high but a constant pressure over the entire surface). Allow the '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.

AV515 expands slightly thus filling any irregularities in the substrate. Once opened **AV515** 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.

AV515 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.

Properties

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 Hrs
Application Temp	15°C-35°C
Application Rate	120 – 250g/m ² depending on porosity and profile of the substrate.



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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 20°C.

Shelf life is up to 12 months when stored in original, unopened containers, under the above conditions.

Clean-Up

Clean tools and equipment with Xylene. Excess adhesive should be removed before cure. Xylene may attack some surfaces.

Health & Safety

Please refer to the Material Safety Data Sheet which is available on request..

Product Details

Item Number	Size	Colour	Pack Quantity
912846	300ml		12

The representations and recommendations regarding the products are based on tests which we believe to be reliable. However, no guarantee of their accuracy can be made because of the great range of field conditions and variations encountered in raw materials, manufacturing equipment and methods. Thus, the products are sold with a limited warranty only, and on the condition that purchasers will make their own tests to determine the suitability of the product for their particular purposes. Under no circumstances will Bostik Australia Pty Ltd be liable to anyone except for replacement of the products or refund of the purchase price.

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