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# ARDEX AF 620

## Solvent Free Contact Adhesive

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Solvent free formulation

Very low emission

Easy to apply with a short-piled roller, paint brush or notched trowel

Long working time

Strong bond and high initial tack

Floors can receive foot traffic immediately after application



**ARDEX GmbH**  
Postfach 6120 58430 Witten  
DEUTSCHLAND  
Tel.: +49 (0) 23 02/664-0  
Fax: +49 (0) 23 02/664-240  
kundendienst@ardex.de  
www.ardex.de

# ARDEX AF 620

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### DESCRIPTION

ARDEX AF 620 is a heavy duty, solvent-free dispersion based contact adhesive. Ideal for securing floor coverings accessories and profiles to internal vertical and horizontal surfaces such as, walls, ceilings and stairs. For internal use only.

ARDEX AF 620 has a high initial tack, and excellent bond strength with good resistance to plasticiser migration.

### USE

ARDEX AF 620 can be used to fix vinyl, linoleum, textiles, (including needle punch) rubber floor coverings, flexible stair nosings, vinyl and rubber skirtings, accessories, and flexible stair stringers. ARDEX AF 620 can be used on porous and non-porous substrates, including alloys and steel, and it is suitable for use on subfloors incorporating hot water underfloor heating systems.

### SUBSTRATE PREPARATION

The subfloor must be hard, clean, free from barrier materials, sound and smooth in accordance with the relevant clauses of British Standards

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 ENDURA Cementitious Levelling and Smoothing Compound e.g. CL 11 or K 301

### 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 substrates should be kept at the appropriate temperature as specified by the floor covering manufacturer and the relevant clauses of the British Standards. These temperatures need to be maintained 48 hours prior to installation, during installation, and 48 hours after installation.

Apply ARDEX AF 620 with a short-piled roller or a paint brush onto the covering/profile first and then the substrate second. This can reduce waiting time for the adhesive to sufficiently air.

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 in to position.

If preferred, the floor covering or profile can be pre-coated the day before installation. On the day of installation apply the adhesive only on to the substrate and following a sufficient airing time, bond the pre-coated floor covering in to the dried adhesive film. The open time for flooring/profiles already pre-coated on the previous day into the newly applied film is approximately 90 minutes, however the adhesive films of ARDEX AF 620 can be re-activated by means of a hot air gun after the airing time has been exceeded.

Please note that the surfaces coated with ARDEX AF 620 adhesive must be placed together within the open time of 24 hours.

Removal at this critical time will require the adhesive to be reapplied and allowed to dry to an almost non-tacky feel. Once adhered consolidate under maximum, even pressure. Once the surfaces are pressed together, apply pressure using a cork board, hand roller, or a soft rubber mallet to ensure full contact is achieved between both surfaces.

If required, a hot air gun can be used to shorten the drying time. This can also soften cove or skirting on floor and wall coverings, making the materials more flexible when fitting to coves and corners. Avoid excessive heat on resilient products, as deformation can occur. Hot welding of vinyl flooring should not be carried out for at least 24 hours after installation.

ARDEX AF 620 can also be applied with a A1 notched trowel. If applied with a trowel the airing time will be prolonged due to the thicker application.

In small areas and corners we recommend applying the adhesive with a brush.

Airing time: approx. 30 - 60 minutes depending on the absorbability of the subfloor and approx. 180 minutes for heavily textured textile flooring, preferably overnight.

Floors can receive foot traffic immediately after application.

**NOTE:** The two surfaces, subfloor or background and profiles or floor coverings, must be in the correct position, as the adhesive will form an immediate bond, and repositioning will not be possible.

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### PACKAGING

ARDEX AF 620 is packed in plastic tubs 2.5 kg net weights. After use ensure the lid is placed back on the bucket and stored correctly.

### COVERAGE

Approximately 100 - 200 g/m<sup>2</sup> using a short pile velour roller.

Approximately 250 - 350 g/m<sup>2</sup> for PVC and CV flooring, PVC soft skirting boards, rubber floor coverings using a brush.

Approximately 400 - 500 g/m<sup>2</sup> for Textile flooring, linoleum and impact walls using a short pile velour roller, brush, or A1 notched trowel.

Consumption is dependent on surface structure and absorbability of subfloor.

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 not less than 12 months if stored in good conditions, between 5°C and 30°C, in the original, unopened containers.

### PRECAUTIONS

Consult the relevant Health & Safety Data Sheets for further information.

### WORDING AND TERMINOLOGY

#### *Airing Time*

The time the adhesive must be left to air before applying the floor covering. 30-60 minutes\*

#### *Working Time*

The time in which the adhesive can receive the floor covering, after the initial airing time. Up to 120 minutes\*

#### *Open Time*

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

\*depending on the absorbency of the subfloor and ambient conditions, (20°C & 65% RH). The guidance from the floor

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

### TECHNICAL DATA

#### According to ARDEX Quality Standards:

Raw Material Base	:	Special dispersions
Material Requirement	:	100 - 200 g/m <sup>2</sup> Refer to coverage section of this datasheet.
Application Temperature	:	Not below 15°C
Relative Atmosphere inc Humidity (RH)	:	Not above 75%
Floor coverings	:	Lower temperatures and higher RH will prolong the airing time, and reduce bond strength. The times indicated are based on 18°C and 65% RH.
Cleaning Agent	:	Clean/remove excess adhesive from tools and the final floor with water before the adhesive dries.
Resistant to Chair Castors	:	Yes (castors in accordance with DIN -EN 12 529)
Suitable for Underfloor Heating	:	Yes

**NOTE:** The information supplied in our literature or given by our employees is based upon extensive experience and, together with that supplied by our agents or distributors, is given in good faith in order to help you. Our Company policy is one of continuous Research and Development; we therefore reserve the right to update this information at any time without prior notice. We also guarantee the consistent high quality of our products; however, as we have no control over site conditions or the execution of the work, we accept no liability for any loss or damage which may arise as a result thereof.

Country specific recommendations, depending on local standards, codes of practice, building regulations or industry guidelines, may affect specific installation recommendations.

# ARDEX AF 620

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### Distributed by Indian offices

#### ARDEX ENDURA (INDIA) PRIVATE LIMITED

an ISO 9001:2015 & ISO 14001:2015 certified company  
Corporate Office & Regd. Office: Unit No. 406 & 407,  
"Brigade Rubix" No. 20, HMT Campus,  
Yeshwanthpur Hobli, Bengaluru - 560013.  
CIN No: U24233KA1997PTC022383 Tet: +91 80 66746500  
Email: [customercare@ardexendura.com](mailto:customercare@ardexendura.com)  
Website: [www.ardexendura.com](http://www.ardexendura.com)



#### Branches

• AHMEDABAD	079 26425310	• HUBBALLI	0836 2970505	• NAGPUR	+919822223743
• AURANGABAD	+918605445577	• HYDERABAD	040 48559455	• PATNA	+919934687909
• BENGALURU:	080 40912934	• INDORE	0731 4021148	• PUNE	+919028811555
• BHUBANESHWAR	0674 2578101	• JAIPUR	0141 2441893	• RAIPUR	0771 4038300
• CALICUT	0495 2740334	• KOLKATA	+919831071084	• SALEM	0427 2271454
• CHENNAI	044 42805544	• LUCKNOW	0522 4043251	• SHIVAMOGGA	+919880605770
• DELHI	011 26384711	• LUDHIANA	0161 2532170	• TRICHY	+919894766109
• ERNAKULAM	0484 2341044	• MANGALURU	0824 2442176	• TRIVANDRUM	0471 2598648
• GOA	0832 2750992	• MUMBAI	022 65133299	• VIJAYAWADA	+918688354587
• GUWAHATI	+917896002188	• MYSURU	0821 2570171	• VISAKAPATNAM	0891 6469499