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# ARDEX AF 325

## Carpet Adhesive

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Excellent early grab means that carpet can be installed immediately

20 minute extended working time

Rapid strength development

High temperature resistance, suitable for use over underfloor heating systems

Solvent free

Low odour

Covers up to 35m<sup>2</sup>



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# ARDEX AF 325

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### DESCRIPTION

ARDEX AF 325 is a water-based, low odour, solvent free, acrylic, emulsion based floorcovering adhesive. With an extended working time, ARDEX AF 325 offers excellent application properties with high early grab and a high final bond strength. It is protected from biodegradation and has excellent resistance to plasticiser migration.

ARDEX AF 325 meets the requirement guidelines for the EMICODE license "EC1" achieving very low emission properties.

### USE

ARDEX AF 325 is ideal for installing all textile floor coverings including fibre bonded, needle punch, latex and rubber foam backed, hessian, polypropylene, nylon, "action-bac", felt and resin backed, and can be used with all ARDEX ENDURA cementitious Levelling and Smoothing Compounds in both commercial and domestic locations.

ARDEX AF 325 is suitable for use with chairs fitted with castor wheels.

### PRIMING

Priming is not required, however, on highly absorbent surfaces it can be advantageous to prime with P 51 Priming and Bonding Agent 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 be hard, clean, free from barrier materials, sound and smooth in accordance with the relevant clauses of BS 5325 and BS 8204.

Any dust should be removed using suitable vacuum equipment, prior to applying ARDEX AF 325, 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 325 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 appropriate temperature as specified by the floor covering manufacturer and the relevant clauses of BS 5325.

These temperatures need to be maintained 48 hours prior to installation, during installation, and 48 hours after installation.

ARDEX AF 325 should be applied evenly to the suitably prepared substrate using the appropriate serrated trowel. Hold the trowel at approximately a 60 degree angle to the subfloor to maximise coverage and avoid forming pools of adhesive.

Floor coverings can be applied directly into the wet adhesive on absorbent backgrounds, immediately, or after an airing time, usually 5 minutes depending on ambient conditions. Allowing the adhesive to air will improve its initial grab.

When using ARDEX AF 325 only apply sufficient adhesive that can be covered within the working time of 20 minutes on an absorbent subfloor.

Periodically check that the adhesive has transferred to the rear of the floor covering.

Remove any air pockets with a cork board or rubbing tool whilst the adhesive is still wet, and roll the floor covering with a 68kg roller and/or a smoothing tool if required. Roll from side to side first and then end to end. Rolling will ensure good overall contact and minimize the potential for adhesive serration grin through.

Some textile floor coverings may benefit from further rolling/smoothing after approximately 1 hour.

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 BS 5325 and BS 8204 should be followed.

Thermal cycling of the subfloor will require raising the temperature of the substrate slowly, usually 10°C a day, to full operating temperature, held for a defined period, and slowly brought back down, usually 10°C a day, so that any shrinkage that is likely to take place occurs before the floor covering is installed.

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If 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.

If moisture testing is not required, or after the tests are completed, the heating system should be stabilised to room temperature, but not below 15°C, before installing the floor covering.

The floor covering should be allowed to acclimatise to the substrate temperature before installation with ARDEX AF 325.

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. 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 325 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 floor covering manufacturer for detailed guidance. For areas subjected to prolonged or extreme solar gain, such as southerly facing aspects, consider the use of ARDEX AF 2575 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 floor covering manufacturer.

### PACKAGING

ARDEX AF 325 is packed in plastic tubs 14kg net weight.

### STORAGE


ARDEX AF 325 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 container.

### PRECAUTIONS

ARDEX AF 325 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 Health & Safety Data Sheets for further information.

### COVERAGE

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

Flooring Type	Trowel Size	Coverage
Textile Flooring	B1 	Up to 35m <sup>2</sup>

### WORDING AND TERMINOLOGY

#### *Airing Time*

The time the adhesive must be left open before applying the floor covering. Between 5-10 minutes\*

#### *Working Time*

The time in which the adhesive can receive the floor covering, after the initial airing time. Up to 20 minutes\*.

#### *Open Time*

The combination of airing and working time. Up to 25 minutes\*

\*depending on the absorbency of the subfloor and ambient conditions. (20 C and 65% RH).

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

**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 325

## Carpet Adhesive

### Distributed by Indian offices

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an ISO 9001:2015 & ISO 14001:2015 certified company

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