



ARDEX AF 415

Polyurethane Parquet Adhesive

- Extended working time
- Superior adhesion strength
- For absorbent and non-absorbent surfaces
- No priming required
- Easy to apply
- Polyurethane resin based
- Can receive parquets after only 1 hours on surfaces with ARDEX K55 rapid drying levelling compound.
- Conforms to EN 14293



DESCRIPTION

ARDEX AF 415 is a two component PU flooring adhesive according to EN 14293 for the shear-resistant laying of solid wood lam parquet flooring, mosaic parquet, on-edge lamella parquet, strip parquet, multi layer parquet, and solid wood planks on absorbent and non-absorbent subfloors indoors.

SUBSTRATE PREPARATION:

The subfloor and the climatic conditions of the room must meet the requirements of DIN 18356.

Subfloor must be permanently dry, solid, with enough compressive & tensile strength, free from cracks, dirt and adhesion inhibiting substances. Can be applied on dust free concrete and calcium sulphate screeds, chipboards and oriented strand boards. Mechanically pre-treat and vacuum-clean calcium sulphate concrete according to manufacturer's specifications or according to the applicable standards and codes.

If required, ARDEX PU 30 Polyurethane Primer should be applied as a thin coat. ARDEX AF 415 should not be applied earlier than 6 hours and later than 24 hours on this primed surface.

The cracks and holes on the substrate must be repaired and levelled especially for large format parquets. Use ARDEX K80 self levelling compound is suitable for every kind of parquets. ARDEX K11 T is only an alternative for multilayer parquets. ARDEX AF 415 can be applied as early as 60 minutes if the cracks & holes up to 10 mm are repaired by ARDEX K 55.

Bituminous substrates or substrates consisting of softer materials should be pretreated with ARDEX PU 30 and covered with a suitable ARDEX self levelling product with a minimum layer.

APPLICATION

To balance the temperature between the product and application environment let the ARDEX AF 415 wait in the application environment a while before opening the packaging.

Pour contents of the hardener container completely into the resin container and intensively mix together both components with a suitable stirring device for at least 3 minutes, until a uniform colour tone occurs and no streaking is apparent.

Using a notched trowel, apply adhesive uniformly, avoid paddles. Immediately lay parquet and press well. Ensure that the entire underside of each wooden element is sufficient coated with adhesive. This should be carefully controlled, especially for large format parquets.

The laid areas should not be trodden within the first 4 - 6 hours. The parquet may be sanded and sealed after complete hardening, under standardised conditions, after 24 hours.

NOTES

- Processing not below floor temperature of +15°C and room temperature of +18°C, as well as room humidity preferably between 40% and 65% but not exceeding 75%.
- In cold weather warm up the product in due time in heated room.
- Solid wood lam parquet flooring must not exceed a thickness/width ratio of 1:5.
- Completely remove spots on sealed surfaces before the adhesive sets. Dried adhesive residue can be removed only by mechanical means.
- Clean hand tools after use
- Clear adhesive residues on joints if the covering will be subject to polish.
- Set up the required joints and dilatations by considering the geometry and conditions of the room and the substrate before installation

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SUGGESTED TROWEL SIZES AND RELATED CONSUMPTION:

TKB B3 850 - 1050 g/m²	3,25 mm	3,70 mm	3,30 mm	55°

Mosaic and small-sized ready-to-lay parquet

TKB B5 750 - 950 g/m²	5,15 mm	5,70 mm	14,30 mm	55°

Large-sized ready-to-lay parquet and laminate

TKB B11 1050 - 1250 g/m²	5,0 mm	6,10 mm	7,90 mm	60°

Lam, on-edge-lamella, strip flooring, small-sized ready to lay parquet and wood-block pavings

TKB B13 1150 - 1350 g/m²	6,50 mm	7,10 mm	11,40 mm	55°

Large-sized strip flooring and ready-to-lay parquet, as well as solid wood planks.

TKB B15 1400 - 1500 g/m²	6,30 mm	5,60 mm	6,90 mm	45°

Large-sized multilayer parquet as well as solid wood planks.

TECHNICAL DATA ACCORDING TO ARDEX QUALITY STANDARDS

Raw material basis:	Polyurethane resin based
Mixing ratio:	By weight; 10,7 parts of A component, 1 part of B component
Consumption:	Between 850 - 1500 g/m ² depending on the trowel size, surface properties & absorbability
Application temperature:	Above +18°C
Relative humidity:	Below 75%
Airing time:	None
Pot life*:	approx. 80 minutes
Open time*:	approx. 90 minutes
Drying time*:	approx. after 24 hours
Surface treatment*:	approx. after 24 hours

*All data is approximately based on laboratory test made at a temperature of +20°C and relative humidity of %65. Environmental conditions may change these values. Higher temperatures and lower relative humidity decrease these duration whereas lower temperature and higher relative humidity increases them.

Cleaning:	Remove spills or seepage through joints with a cloth moistened with water before the adhesive dries.
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Suitable for underfloor heating: Yes

Ambalaj:	12 kg'lık A Bileşeni ve 1,12 kg'lık B bileşeninden oluşur.
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Storage and Shelf Life:	ARDEX PU 415 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.
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