

Hammerfast AC-420

Technical data sheet

Date of issue : 10.05.2023

Revision no : 02

Description

Solvent-free, acrylic based dispersion adhesive developed for interior PVC and linoleum floor coverings.

Advantages

- Solvent-free,
- High adhesion,
- Resistant to changes in temperature,
- Easy to apply,
- Long working time.

Application areas

Used for bonding PVC based homogenous and heterogenous tiles and floor coverings, linoleum floor coverings and rubber tiles and floor coverings.

Application substrates

Interiors; levelled concrete floors, prefabricated concrete, cement based screed, gypsum based screed, please consult us for other applications.

Application limits

Curing time	20-25 minutes*
Working time	40-60 minutes*
Set to traffic	24-48 hours*
Final strenght	3-4 days*
Working temperature	+18 °C / +25 °C

* At 20 °C and 65 % relative humidity, depending on the type of floor covering and the absorbency of the substrate.

Substrate preparation

The substrate should be cleaned from oil and dust, levelled and absorbent. The substrate should be durable, loose parts should be removed; defects on the substrate should be repaired using Hammerfast RM-150 at least 24 hours before the application of Hammerfast AC-420; for rapid application, Hammerfast RM-150 R & Hammerfast SL-272 Rapid should be used instead. Uneven floors should be smoothed using Hammerfast SL series self-levelling screeds.

Application

Hammerfast AC-420 should be mixed before use. Pour Hammerfast AC-420 onto the substrate and apply the adhesive evenly using a suitable v-notch trowel. Flooring material should be laid down on the floor after 20-25 minutes of waiting time. Pressurise the flooring material right after laying down to make sure the whole surface contacts with the adhesive and air gaps removed.

Consumption

250-300 g/m².

Technical specifications

Z	Grey liquid
Content	Acrylic based
Density	1,35±0,05 kg/lit
Performance	Tested according to DIN EN 14259
Shear strength	≥ 0,3 N/mm ² (EN 1373)
Peel strength	≥ 1,0 N/mm (EN 1372)
Dimensional change	≤ %0,2 (EN 1903)
Temperature resistance	+70°C (floor heating systems)

Points of attention

- Hammerfast AC-420 is ready to use, do not add any foreign materials.
- Flooring material should be bonded on the floor after 20-25 minutes of curing time.
- For floor heating, the heating system should be turned off 10 days before flooring and remain off during the application. The heating system can be turned on again 72 hours after the application.
- Optimum working conditions 18-25°C/64-77 °F, floor temperature above 15°C/59°F, Relative Humidity below 75%. Low temperatures and high humidity lengthen, and high temperatures and low humidity shorten the working-, setting- and drying-times.
- Welding process of flooring joints should be started at least 24 hours after the bonding application.
- Working time and dry time of the adhesive depend on the substrate temperature and absorbance.

Safety Precautions

- Use appropriate safety equipment (mask, gloves, glasses).
- Protect your eyes/face.
- Avoid direct contact with eyes and skin.
- In case of contact with eyes, rinse immediately with plenty of clean water and seek medical attention.
- Please read Material Safety Data Sheet (MSDS) for further safety information.

Storage and shelf life

12 months from date of manufacture when stored unopened and undamaged in a dry, moisture-free environment, away from direct sunlight and temperature between +10 °C and +35 °C. Packages should be kept tightly closed when not in use. Packages should be protected against frost.

Packing

20 kg plastic bucket
1 pallet = 33 bags = 660 kg
Pallet measures 80 x 120 x 100 cm

Cleaning of tools

After the application, wash all equipment used before drying with warm water.

Quality certificates

ISO 9001:2015

