

AC-220



Solvent-Free, Acrylic-Based PVC Flooring Adhesive

Description

Hammerfast AC-220 is a solvent-free, acrylic dispersion-based adhesive used for bonding PVC-based homogeneous and heterogeneous floor tiles and coverings, as well as rubber roll coverings in interior applications.

Advantages

- Solvent-free, harmless, and environmentally friendly
- High bonding strength
- Resistant to temperature changes
- Easy to apply
- Long open working time

Areas of Use

It is used for bonding PVC-based homogeneous and heterogeneous floor tiles and coverings, as well as rubber sheets.

- Schools, universities
- Hospitals, clinics, laboratories
- Offices, meeting rooms, warehouses
- Store flooring in shopping malls
- Laboratories and technical rooms
- Industrial facilities
- Banks, shops, showrooms
- Airports, municipal buildings
- Sports halls and cultural centers
- Residential areas such as bedrooms, living rooms, corridors, and kitchens

Substrates

- Cement-based screeds
- Levelled concrete surfaces
- Self-levelling screeds
- Calcium sulphate (anhydrite) screeds (with suitable primer)
- Existing, sound and well-bonded PVC floor coverings (after proper preparation)
- High-strength floor levelling compounds.

Unsuitable Substrates:

- Surfaces with high moisture content
- Dusty, loose, or weak substrates
- Oil-, grease-, or contaminated surfaces
- Wood and wood-based materials (require special systems)
- Metal surfaces without a suitable primer

Surface Preparation

- The substrate must be clean, free from oil and dirt, levelled, and absorbent.
- The substrate must be load-bearing, with a minimum tensile strength of $\geq 1.5 \text{ N/mm}^2$.
- Loose or weak areas must be removed and repaired using Hammerfast RM-150 repair mortar at least 24 hours before applying Hammerfast AC-220.
- Uneven surfaces should be levelled using Hammerfast SL series self-levelling compounds.
- For fast-track applications, Hammerfast RM-150 R and SL-272 Rapid products should be used.
- On cement-based substrates, moisture content must be $\leq 2-3\% \text{ CM}$.

Application

- Before use, Hammerfast AC-220 must be thoroughly mixed using an electric mixer.
- Apply to the surface using an appropriate notched trowel (A2 or B1).
- After approximately 15–20 minutes, the flooring material should be installed. The PVC covering should be placed onto the adhesive within the specified open time.
- Immediately after installation, a 50–70 kg roller should be applied over the flooring to eliminate air pockets and ensure full contact with the adhesive.
- Joints and seams must be properly aligned and joined.

Consumption

Depending on the trowel size, flooring type, and surface smoothness, consumption is 250–300 g/m².

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Technical Properties

Color/Appearance	Grey / semi-fluid liquid
Content	Solvent-free acrylic copolymer-based
Setting Time	20-25 min.
Working Time	40-60 min.
Time to Open to Traffic	24-48 hours
Final Drying	3-4 days
Application Temperature	+15 °C / +30 °C
Density	1,35±0,05 kg/lit
Heat Resistance	+70°C (In underfloor heating systems)
Shear Strength	≥ 0,3 N/mm ² (EN 1373)
Peel Resistance	≥ 1,0 N/mm (EN 1372)
Dimensional Deformation	≤ %0,2 (EN 1903)
HS Code	3506.10.00.90.19

Note: Measured at 23 ± 2 °C and 50 ± 5% RH.

*Performance tests were conducted according to DIN EN 14259.

Important Notes

- Hammerfast AC-220 is ready to use; no foreign substances should be added.
- Floor coverings must be bonded after the adhesive reaches the tacky stage (20–25 minutes).
- In underfloor heating systems, the heating should be operated for 10 days before installation and turned off during application. It can be restarted 72 hours after application.
- Optimum working conditions are 18–25°C, with a floor temperature of 15°C / 59°F. Relative humidity should be below 75%.
- Low temperatures and high humidity extend drying time, while high temperatures and low humidity shorten it.
- Welding of covering joints should be carried out at least 24 hours after bonding.
- Open time and drying time vary depending on substrate temperature and absorbency.
- Hammerfast AC-220 must not be exposed to sunlight or high temperatures during transport or storage. High temperatures may increase viscosity and damage the chemical structure of the product.

Cleaning of Tools

All tools used should be cleaned with warm water immediately after application.

Storage and Shelf Life

When stored in its original, unopened packaging in dry and moisture-free environments, protected from direct sunlight, and kept between +10°C and +35°C, the product has a shelf life of 12 months from the production date. When not in use, the lid must be tightly closed. Pallets must not be stacked on top of each other. High temperatures may increase viscosity and cause chemical degradation.

Packaging

20 kg plastic buckets
1 pallet = 33 buckets = 660 kg
Pallet dimensions: 80 × 120 × 100 cm

Safety Precautions

- Keep out of reach of children.
- Do not eat or swallow.
- Keep away from food products.
- Do not inhale directly or allow contact with skin.
- May cause allergic reactions.
- In case of eye contact, rinse thoroughly with plenty of water and consult a doctor.
- Use gloves, goggles, and protective clothing during application.
- Wash hands thoroughly with water after application.
- For detailed safety information, read the Material Safety Data Sheet (MSDS).

Quality Certificates

- ISO 9001
- ISO 14001



Explanation Regarding CE Marking and Declaration of Performance

When used as recommended, Hammerfast AC-220 does not fall under a harmonized technical specification or National Technical Assessment / European Technical Assessment; therefore, CE marking cannot be applied and a Declaration of Performance cannot be issued.