

AC-420



Solvent-Free, Acrylic-Based PVC Flooring Adhesive

Description

Solvent-free, acrylic-based dispersion adhesive used for bonding PVC and linoleum floor 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

Used for bonding PVC-based homogeneous and heterogeneous floor tiles and coverings, natural linoleum floor coverings, rubber rolls, tiles, and coverings.

Substrates

Applicable on leveled concrete floors, precast concrete, cement-based screeds, gypsum-based screeds, and similar surfaces in interior areas. Please consult us for all other application surfaces.

Surface Preparation

The surface must be clean, free of oil and dirt, leveled, and absorbent. The substrate must be resistant to pressure; loose areas should be scraped off and repaired with Hammerfast RM-150 repair mortar at least 24 hours before applying Hammerfast AC-420.

Uneven surfaces should be corrected using Hammerfast SL series self-leveling screeds.

For areas requiring rapid application, Hammerfast RM-150 R & SL-272 Rapid products should be used.

Application

Hammerfast AC-420 should be thoroughly mixed before use. After completing surface preparations, pour the adhesive onto the floor and spread it evenly using an appropriate notched trowel depending on the substrate condition. After waiting approximately 20–25 minutes, bond the floor covering to the surface. Immediately after bonding, roll the covering with a roller to eliminate air gaps and ensure full contact with the adhesive.

Consumption

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

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)

Note: Note: Values are based on conditions of 23 ± 2°C and 50 ± 5% relative humidity.

*Performance tests were conducted according to DIN EN 14259.

Important Notes

- Hammerfast AC-420 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-420 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.

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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

Cleaning of Tools

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

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-420 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.