



## *technical data sheet*

# AV 510

## Single Pack Polyurethane Adhesive

### DESCRIPTION

**AV510** is a brush grade, solvent free, slow setting, single component moisture curing polyurethane adhesive. Fully cured **AV510** has an extremely strong bond with exceptional resistance to water, weathering, ageing and marine conditions.

**AV 510** is suitable for bonding porous to porous or porous to non porous substrates. It is especially suited to a variety of laminating applications and panel manufacture where extended set-up times are required. It is important that at least one of the surfaces contains moisture. The product will not cure if there is no moisture available from the substrate eg. glass to glass or metal to metal is not possible. Its high bond strength is ideal for bonding hardwood species such as Spotted Gum, Brush Box and Black Butt.

### FEATURES & BENEFITS

- Very High Bond Strength
- Single Pack
- Non Flammable
- Solvent Free

### TYPICAL PROPERTIES

Type	Polyurethane
Color	Clear, unpigmented
Viscosity	Medium
Tack Free Time	Approx 3½ Hrs @ 23°C / 50% RH
Initial Set Time	Approx 3¾ Hrs @ 23°C / 50% RH
Full Strength	24 Hrs
Application Temp	15°C-35°C
Application Rate	150 to 250gm/m <sup>2</sup> depending upon the porosity and profile of the surface

### APPLICATION

Ensure adequate tests are conducted before using commercially. Mix thoroughly before use.

*The representations and recommendations regarding the products are based on tests which we believe to be reliable. However, no guarantee of their accuracy can be made because of the great range of field conditions and variations encountered in raw materials, manufacturing equipment and methods. Thus, the products are sold with a limited warranty only, and on the condition that purchasers will make their own tests to determine the suitability of the product for their particular purposes. Under no circumstances will Bostik Australia Pty Ltd be liable to anyone except for replacement of the products or refund of the purchase price.*

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Product:	AV510
Issue Date:	March 2006
Division:	Industrial Distribution
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**(ABN 79 003 893 838)**





## *technical data sheet*

# AV 530

## Single Pack Polyurethane Adhesive

### DESCRIPTION

AV 530 is a spray grade, high solids, single component, moisture cured polyurethane adhesives. Fully cured, both AV 530 and AV 530R have extremely strong bond with excellent resistance to water, weathering, ageing and marine conditions.

AV 530 is suitable for bonding porous to porous and porous to non-porous substrates. Both products have been used in the panel manufacturing industry for over 20 years and are ideally suited for bonding fibrous cement sheeting and EPS Foam to various types of metal sheets for use in both internal and external exposure applications. When tested under temperature cycling from -25°C to +85°C in no instance did the EPS Foam / adhesive / steel interface break. The adhesive was not effected by the thermal cycling.

### FEATURES & BENEFITS

- Very High Bond Strength
- Single Pack
- Non Flammable
- Solvent Free

### TYPICAL PROPERTIES

<b>Type</b>	Polyurethane
<b>Colour</b>	AV 530 – Clear AV 530R – Rose
<b>Viscosity</b>	Low
<b>Tack Free Time</b>	Approx 2½ Hrs @ 23°C / 50% RH
<b>Initial Set Time</b>	Approx 3-4 Hrs @ 23°C / 50% RH (depending on moisture content of substrate)
<b>Clamp Time</b>	Approx 3-4 Hrs @ 23°C / 50% RH (depending on moisture content of substrate)
<b>Full Strength</b>	24 Hrs
<b>Application Temp</b>	15°C-35°C
<b>Application Rate</b>	3-4.5m <sup>2</sup> /kg where applied to one surface and 6 - 9m <sup>2</sup> /kg where applied to each surface in a two way contact bonding situation. Rates will vary depending upon the porosity and profile of the surface

### APPLICATION

**Ensure adequate tests are conducted before using commercially. Mix thoroughly before use.**

It is important that at least one of the surfaces contains moisture. The product will not cure if there is no moisture available from the substrate, eg. gloss to gloss or metal to metal.

### Application Instructions

Surface must be clean, dry, free from oil, grease and any other contamination. Metal surfaces should be solvent cleaned and light sanded. AV 530 are supplied ready for use. Apply by spray, roller, brush to the least absorbent surface or both surfaces depending upon the substrates and allow the solvent to flash off. Bring both surfaces together while still wet and press firmly.

### Note:

1. Slight foaming of the adhesive during the curing process is normal due to the reaction between the adhesive and moisture in the substrate and atmosphere.
2. A mist spray of water over the surface will assist cure during dry cool conditions

### Product Performance Testing

AV530 was fully tested in a laboratory by an independent party as part of the Building Solutions System. A separate report, Report "Thermal Cycling Tests on Polyurethane Adhesive AV 500 Series" dated 13 March 1993, is available outlining the results of these tests. For a copy of this report contact AV Syntec Pty Ltd.

### STORAGE:

Maximum of 12 months unopened in original containers at +5°C to +25°C in dry conditions. The storage temperature should not exceed 25°C for extended periods of time. Once opened the storage life will be substantially reduced. The removal of moist air by purging with nitrogen prior to sealing will extend the life.

Storage areas to be well ventilated and comply with Local, State and Federal regulations.

### CLEAN-UP

Clean tools and equipment with Xylene. Excess adhesive should be removed before cure. Xylene may attack some surfaces.

## SAFETY DIRECTIONS:

Please refer to the Material Safety Data Sheet which is available on request.

## AVS AV530 Polyurethane Adhesive

Item No	Stock Size
910149	AV530 20 Litre
913316	AV530R 200 Litre

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