

**Description**

**AV 515** is a single component, solvent-free, thixotropic, quick setting, moisture cured polyurethane adhesive. Fully cured **AV 515** has an extremely strong bond with excellent resistance to water.

**AV 515** is suitable for bonding porous to porous and porous to non porous substrates. **AV 515** may be used to bond timber, plasterboard, fibrous cement, some metals, EPS foam, concrete, brick, some plastics (testing is recommended) and many other common substrates, providing that one or two of the surfaces contain moisture.

**AV 515** is ideal for bonding timber in applications such as furniture and can be used with softwoods and many hardwoods.

**Features**

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

**Application Instructions**

**Ensure adequate tests are conducted before using commercially.**

It is important that at least one of the surfaces has a moisture content of at least 8%. The product will not cure if there is no moisture available from the substrate.

**Application Instructions**

Metal surfaces should be lightly sanded and wiped with Anchor Weld 901 solvent. All joints must be close fitting. Maximum glue line thickness is 0.5mm (ideally 0.1 to 0.25 mm). Apply sufficient adhesive for the application to one surface, using a cartridge gun. Keep the adhesive approximately 10mm in from the external edge to minimise 'squeeze-out'. Bring both surfaces together immediately and clamp tightly and evenly to ensure proper spread of the adhesive and to produce a glue line 0.1mm to 0.25mm thick. Clamps need to remain in place for at least 60 minutes at 23°C and 50% relative humidity. Allow any 'squeeze-out' to dry and then remove with a sharp blade. Do not try to remove the 'squeeze-out' before it dries as this will spread the adhesive over the surface and is very difficult to remove.

**AV 515** expands slightly thus filling any irregularities in the substrate. Once opened **AV 515** will begin to cure. It is recommended that the tip of the cartridge be sealed to extend the life of the product.

**Note:**

A mist spray of water over the surface will assist cure during dry cool conditions.



**AV 515 is an adhesive not a mastic** and therefore should not be used as a gap filler. If used as a gap filler the strength of the bond will be reduced.

### Clamping Pressures

**Softwood 50 PSI**

**Hardwoods 150 PSI**

i.e. enough pressure to bring joints tightly together with some glue "squeeze out".

### Properties

<b>Type</b>	Polyurethane	<b>Clamp Time</b>	Approx 60 mins @ 23°C / 50% RH
<b>Colour</b>	Uncured - Translucent Cured - Cream to Yellow	<b>Full Strength</b>	24 Hrs
<b>Viscosity</b>	High	<b>Application Temp</b>	15°C-35°C
<b>Tack Free Time</b>	Approx 10 mins @ 23°C / 50% RH	<b>Application Rate</b>	120 - 250g/m <sup>2</sup> depending on porosity and profile of the substrate.
<b>Initial Set Time</b>	Approx 60 mins @ 23°C / 50% RH		

### Limitations

Do not use for structural or load bearing applications.

If used in exterior applications, all finished joints **MUST** be painted with a suitable weather resistant paint.

Not recommended for edge gluing in fine furniture.

### Storage & Shelf Life

Store in a cool, dry place, out of direct sunlight. Storage areas must be well ventilated and comply with Local, State and Federal regulations. For maximum shelf life, store between 5° and 35°C.

Shelf life is up to 18 months when stored in original, unopened containers, under the above conditions.

### Clean-Up

Clean tools and equipment with Xylene before the adhesive has cured.

Dried adhesive may be removed from tools and equipment by mechanical abrasion or scraping.

Do not try to remove adhesive from bonded assemblies before it dries as this will spread the adhesive over the surface and is very difficult to remove.

Xylene may attack some surfaces.

### Health & Safety

Please refer to the Material Safety Data Sheet which is available on request or can be downloaded from [www.bostik.com.au](http://www.bostik.com.au)

### Product Details

Item Number	Size	Pack Quantity
912846	300ml	12

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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Quality  
ISO 9001  
SAI GLOBAL  
Quality endorsed ISO9001 (Thomastown site)  
TS16949 (Automotive).

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