



# 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

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

#### Application Instructions

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

#### Application Instructions

Surface must be clean, dry, free from oil, grease, or other contamination. Metal surfaces should be solvent cleaned and lightly sanded. Apply **AV510** to the less porous surface using specified application equipment, airless spray, brush or notched trowel. Press both surface together and clamp.

#### Notes:

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
3. Ensure that container lids are thoroughly cleaned of any adhesive before closing. If not cleaned, AV510 WILL bond the lid closed. A smear of Vaseline on screw threads will ensure easy opening of part used containers.

#### Properties

Type	Polyurethane
Color	Clear, unpigmented
Viscosity	Medium
Tack Free Time	Approx 3½ Hrs @ 23°C / 50% RH

Initial Set Time	Approx 3¼ 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

#### 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 20°C.

Shelf life is up to 12 months when stored in original, unopened containers, under the above conditions.

#### Clean-Up

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

#### Health & Safety

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

AV510 reacts with water, generating carbon dioxide gas in the process. Take care not to contaminate equipment or containers with water. DO NOT reseal containers that MAY have been contaminated with water. Severe pressure build up may occur, leading to violent rupture of the container.





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#### Product Details

Item Number	Size	Colour	Pack Quantity
910147	5 Litre		4
910148	20 Litre		

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