



CI/SfB

(43)

Yq

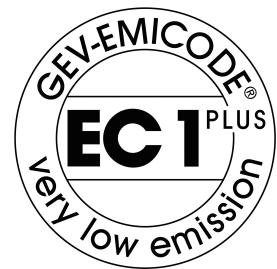
MARCH 2021  
(SUPERSEDES AUGUST 2018)  
PRODUCT DATA SHEET

# ARDEX AF 325

## Low Emission Carpet Adhesive

### Features

- Excellent early grab means that carpets can be installed in as little as 5 minutes
- Up to 30 minute extended working time
- Rapid strength development
- High temperature resistance, suitable for use over underfloor heating systems
- Ideal for use with the double stick method, in conjunction with ARDEX AF 825 Tackifier
- Solvent free
- Low odour
- Covers up to 35m<sup>2</sup>



Reg No. FM 01207

EMS 565427

OHS 628374

ARDEX UK LIMITED  
Homefield Road, Haverhill, Suffolk CB9 8QP UK.  
Telephone: +44 (0)1440 714939  
Fax: +44 (0)1440 716640  
Email: [technical\\_admin@ardex.co.uk](mailto:technical_admin@ardex.co.uk)  
ARDEX online: [www.ardex.co.uk](http://www.ardex.co.uk)

# ARDEX AF 325

## Low Emission Carpet Adhesive

### DESCRIPTION

ARDEX AF 325 is a water-based, low odour, solvent free, acrylic, emulsion based floorcovering adhesive. With an extended working time, ARDEX AF 325 offers excellent application properties with high early grab and a high final bond strength. It is protected from biodegradation and has excellent resistance to plasticiser migration.

ARDEX AF 325 meets the requirement guidelines for the EMICODE license "EC1Plus" achieving the lowest possible emission.

### USE

ARDEX AF 325 is ideal for installing all textile floorcoverings including fibre bonded, needle punch, latex and rubber foam backed, hessian, polypropylene, nylon, "action-bac", felt and resin backed carpets, and natural carpets, such as sea grass/hessian/jute. They can all be used with ARDEX Latex and Water-Based Levelling and Smoothing Compounds in both commercial and domestic locations.

ARDEX AF 325 is suitable for use with chairs fitted with castor wheels.

### PRIMING

Priming is not required, however, on highly absorbent surfaces it can be advantageous to prime with ARDEX P 51 Priming and Bonding Agent diluted 1:3 with cold, clean water. This will maintain the working time and ensure maximum coverage of the adhesive.

### SUBSTRATE PREPARATION

The subfloor must contain an effective damp proof membrane and be dry, with an equilibrium relative humidity of 75% or below. Where an effective damp proof membrane is absent, or the relative humidity of the subfloor is above 75% RH, consult the ARDEX Moisture Control brochure or contact ARDEX Technical Services for the correct product selection.

The subfloor must be hard, clean, free from barrier materials, sound and smooth in accordance with the relevant clauses of BS 5325 and BS 8204.

Any dust should be removed using suitable vacuum equipment, prior to applying ARDEX AF 325, as it can affect both the coverage and performance of the adhesive.

Uneven subfloors should be levelled with the appropriate ARDEX Latex or Water-Based Levelling and Smoothing Compound e.g. ARDITEX NA or ARDEX K 39.

ARDEX ARDURAPID A 45 Rapid Drying and Hardening Internal Repair Mortar can be used for repairs to the subfloor/stairs etc. up to 50mm thick, in accordance with the product data sheet.

Joints, nail holes and imperfections in plywood, or minor surface damage to existing levelling and smoothing compounds i.e. footprints or trowel marks, may be pre-smoothed and levelled prior to the application of ARDEX AF 325, using ARDEX FEATHER FINISH in accordance with the product data sheet.

Fabricated underlays such as flooring grade plywood, (SP101) should be installed where required over existing timber bases. Wood-based fabricated underlays should be suitable for the floorcovering and be at the equilibrium moisture content they will have in service at the time they are covered.

### MIXING

ARDEX AF 325 is ready for use, but for optimum performance the adhesive should be thoroughly mixed to ensure the even dispersion of polymers before application.

### APPLICATION

The installation area and subfloor should be kept at the appropriate temperature as specified by the floorcovering manufacturer and the relevant clauses of BS 5325.

These temperatures need to be maintained 48 hours prior to installation, during installation, and 48 hours after installation.

ARDEX AF 325 should be applied evenly to the suitably prepared substrate using the appropriate serrated trowel. Hold the trowel at approximately a 60 degree angle to the subfloor to maximise coverage and avoid forming pools of adhesive.

Floorcoverings can be applied directly into the wet adhesive on absorbent backgrounds, immediately, or after an airing time, usually 5-10 minutes depending on ambient conditions. Allowing the adhesive to air will improve its initial grab.

When using ARDEX AF 325 only apply sufficient adhesive that can be covered within the working time of 30 minutes on an absorbent subfloor.

Periodically check that the adhesive has transferred to the rear of the floorcovering. Remove any air pockets with a cork board or rubbing tool whilst the adhesive is still wet, and roll the floorcovering with a 68kg roller.

Some textile floorcoverings may benefit from further rolling/smoothing after approximately 1 hour.

When applying adhesive onto the substrate, ensure that any adhesive which is surplus to requirements, and has been moved across the subfloor, is not placed back into the container. It should be placed into an alternative container for safe, easy disposal. This will avoid possible contamination issues.

### UNDERFLOOR HEATING

Underfloor heating systems should be commissioned in accordance with the heating manufacturer's instructions; if comment cannot be found then the guidance given in BS 5325 and BS 8204 should be followed.

Thermal cycling of the subfloor will require raising the temperature of the substrate slowly, usually 5°C a day, to full operating temperature, held for a defined period, and slowly brought back down, usually 5°C a day, so that any shrinkage that is likely to take place occurs before the floorcovering is installed.

If moisture tests are required to verify the relative humidity of the substrate the underfloor heating system should be switched off for 48 hours prior to testing. If moisture testing is not required, or after the tests are completed, the heating system should be stabilised to room temperature, but not below 15°C, before installing the floorcovering.

The surface of the substrate can then be repaired/smoothed with the appropriate ARDEX product and allowed to dry. The floorcovering should be allowed to acclimatise to the substrate temperature before installation with ARDEX AF 325.

After installation allow at least 48 hours of constant temperature for the adhesive to properly cure, before slowly increasing the temperature up to the normal operating temperature of the area. Do not subject the floor to static or dynamic loads, loaded trolleys, etc., or move fixtures, furniture, etc., onto the flooring until the adhesive has fully set, typically 48 hours at 20°C.

**APPLICATION - DOUBLE STICK METHOD** To fix the underlay apply ARDEX AF 825 to a clean prepared substrate using a medium pile roller. Highly absorbent subfloors may require priming with ARDEX P 51 diluted 1 part primer to 3 parts water and applied to the sub floor and allowed to dry. Always follow the underlay manufacturers installation instructions. Once secured adhere the carpet using ARDEX AF 325 in accordance with the carpet manufacturers installation instructions, using the appropriate trowel serration, normally a B2.

# ARDEX AF 325

## Low Emission Carpet Adhesive

### HIGH TEMPERATURE

ARDEX AF 325 is suitable for use over underfloor heating systems and is classified as high temperature resistant. The surface floor temperature must not exceed 30°C. Consult the floorcovering manufacturer for detailed guidance. For areas subjected to prolonged or extreme solar gain, such as southerly facing aspects, consider the use of ARDEX AF 2575 or ARDEX AF 2525 Heavy Duty Adhesives.

### CLEANING

Remove spills or seepage through joints with a cloth moistened with water or an ARDEX Adhesive Wipe before the adhesive dries. Ensure the ARDEX Adhesive Wipes are compatible with the textile covering before use.

Aggressive cleaning agents should only be used with the permission of the floorcovering manufacturer.

### PACKAGING

ARDEX AF 325 is packed in plastic tubs 14kg net weight.

### COVERAGE

See table below.

The actual coverage achieved in practice is affected by application technique, as well as the texture and absorbency of the subfloor.

### STORAGE

ARDEX AF 325 has a shelf life of not less than 12 months if stored in good conditions, between 5°C and 30°C, in the original unopened container.

### PRECAUTIONS

ARDEX AF 325 is non-hazardous in normal usage, however, good hygiene practices should be followed. Avoid contact with skin; wash off with soap and water before drying takes place. In case of contact with eyes, rinse carefully and thoroughly with water and seek medical advice. In case of ingestion seek medical assistance. Consult the relevant Health & Safety Data Sheets for further information.

For the latest technical or health and safety information on this product, consult the current product or health and safety data sheet online at: [www.ardex.co.uk](http://www.ardex.co.uk)

### WORDING AND TERMINOLOGY

#### Airing Time

The time the adhesive should be left to air before applying the floorcovering.  
Approx. 5-10 minutes\*

#### Working Time

The time in which the adhesive can receive the floorcovering, after the initial airing time.  
Approx. 30 minutes\*

#### Open Time

The combination of airing and working time.  
Approx 35 minutes\*



\*depending on the absorbency of the subfloor and ambient conditions. (20°C and 65% RH).

The guidance from the floorcovering manufacturer should always be followed if different from the information contained in this Technical Data Sheet.

**NOTE:** The information supplied in our literature or given by our employees is based upon extensive experience and, together with that supplied by our agents or distributors, is given in good faith in order to help you. Our Company policy is one of continuous Research and Development; we therefore reserve the right to update this information at any time without prior notice. We also guarantee the consistent high quality of our products; however, as we have no control over site conditions or the execution of the work, we accept no liability for any loss or damage which may arise as a result thereof.

Country specific recommendations, depending on local standards, codes of practice, building regulations or industry guidelines, may affect specific installation recommendations.

**TECHNICAL ADVICE HELPLINE**  
**01440 714939**  
**ARDEX online: [www.ardex.co.uk](http://www.ardex.co.uk)**

Flooring Type	Trowel Size	Coverage
Textile Flooring	B1 	Up to 35m <sup>2</sup>
Needle Punch	B2 	Up to 28m <sup>2</sup>