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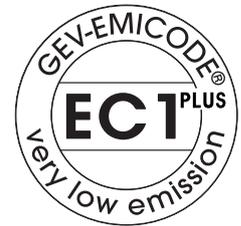
MAY 2025  
(SUPERSEDES MARCH 2021)  
PRODUCT DATA SHEET

# ARDEX AF 2525

## Two Component Heavy Duty Adhesive

### Features

- Moisture, weather and water resistant
- Suitable for internal and external use
- High temperature resistance, for use in areas of direct sunlight e.g. conservatories
- Very high bond strength, for use in high load areas
- Easy to mix and apply
- Very low emissions
- Solvent free
- Covers up to 20m<sup>2</sup>



Reg No. FM 01207

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OHS 628374

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# ARDEX AF 2525

## Two Component Heavy Duty Adhesive

### DESCRIPTION

ARDEX AF 2525 is a low odour, low emission, solvent free two component polyurethane floorcovering adhesive.

ARDEX AF 2525 offers, very high bond strength, excellent application properties and an extended open time. It is protected from biodegradation and has good resistance to plasticiser migration.

### USE

ARDEX AF 2525 is ideal for installing all types of vinyl, rubber, exterior floorcoverings such as artificial grass, dense non-absorbent backed floorcoverings and some timber floorcoverings. ARDEX AF 2525 can be used with all ARDEX Latex and Water-Based Levelling and Smoothing Compounds in both commercial and domestic internal and external locations, and is suitable for use with chairs fitted with castor wheels.

ARDEX AF 2525 meets the requirement guidelines for the EMI CODE licence 'EC1 PLUS R', achieving very low emission limits.

### 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.

Do not use ARDEX P 51 Priming and Bonding Agent in external areas. Contact ARDEX Technical Services for further advice.

### 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 8203, BS 8201 and BS 8204.

Any dust should be removed using suitable vacuum equipment, prior to applying ARDEX AF 2525, 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 2525, 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

Acclimatise the adhesive to the ambient temperature of the installation area, as defined in the relevant code of practice (normally 18°C). Add the entire contents of the hardener, Component B, (the bottle in the upper part of the unit), to the resin component, and mix using a suitable whisk and slow speed drill, for approximately 3 minutes until both components are thoroughly mixed together. Once mixed use immediately.

### 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 8203 and BS 8201. These temperatures need to be maintained 48 hours prior to installation, during installation, and 48 hours after installation.

ARDEX AF 2525 should be applied evenly to the suitably prepared substrate using the appropriate serrated trowel, held approximately at 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, ensuring full transfer to the rear of the floorcovering, however allowing the adhesive to air will improve early stage grab.

Only apply sufficient adhesive that can be covered within the working time, usually 70 minutes.

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.

Allow the adhesive sufficient time to generate some tack before rolling with a 68kg roller, however roll the floorcovering before the adhesive hardens so that the adhesive serrations will flatten. Roll from side to side first and then end to end. Repeat as necessary to ensure the floorcovering is in contact with the adhesive at the curing and hardening phase. Floorcoverings that are not in contact with the adhesive at the curing and hardening phase will not be bonded.

Avoid spinning the roller on the floorcovering and do not leave the roller on the floorcovering during the curing phase, this can cause visible indentations in the adhesive bed.

Rolling will ensure good overall contact and minimise the potential for adhesive serration grin through.

Heat welding should only commence once the adhesive has fully cured. Do not allow the floor to be wet cleaned immediately after the floorcovering has been installed.

Allow significant time for the adhesive bond to develop before wet cleaning commences, typically 48 hours at 20°C.

### 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 8203 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.

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.

# ARDEX AF 2525

## Two Component Heavy Duty Adhesive

### HIGH TEMPERATURE

ARDEX AF 2525 is suitable for use over underfloor heating systems and is classified as high temperature resistant. ARDEX AF 2525 is suitable for use in areas of high solar gain such as conservatories and southerly facing aspects. The surface floor temperature must not exceed 50°C for prolonged periods.

Consult the floorcovering manufacturer for detailed guidance.

### CLEANING

Remove spills or seepage through joints with a suitable cleaning solution such as solvent. Check that any cleaning chemicals do not damage the floorcovering. Do not use thinners/solvent on rubber flooring. Adhesive wipes may be preferable

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

### PACKAGING

ARDEX AF 2525 is packed in plastic tubs. Net volume 6kg net weight.

### COVERAGE

See table below.

### STORAGE

ARDEX AF 2525 must be stored in unopened packaging, clear of the ground in cool dry conditions and be protected from excessive draught. If stored correctly, as detailed above, the shelf life of this product is 12 months from the date shown on the packaging.

### PRECAUTIONS

ARDEX AF 2525 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 must be left open before applying the floorcovering. Between 0-5 minutes\*

#### Working Time

The time in which the adhesive can receive the floorcovering, after the initial airing time. Up to 70 minutes\*

#### Open Time

The combination of airing and working time. Up to 75 minutes\*

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

\*\*Consult the wood manufacturer for the correct trowel notch size.

The guidance from the flooring 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
Homogenous an Heterogeneous PVC Sheet Floorcoverings Rubber VCT	A2 	Up to 20m <sup>2</sup>
Linoleum and other backings with little structure on the backing	B1 	Up to 13m <sup>2</sup>
Heavily structured backing	B2 	Up to 12m <sup>2</sup>
Wood**	B3 	Upto 7m <sup>2</sup>
Wood**	B10 	Up to 6m <sup>2</sup>

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