



## AAT-675 Universal Multi-purpose Adhesive Specification Sheet

A truly “multi-purpose” adhesive, AAT-675 can be used to successfully install virtually any floor covering product. So versatile, this advanced acrylic formula redefined the installation process. It can be used in the same fashion as a conventional adhesive or as a pressure sensitive adhesive. This is a real advantage, providing the installer with a higher degree of flexibility in regard to his work practices. AAT-675 is chemically compatible with virtually every known floor covering backing system presently in use in the industry. This revolutionary adhesive virtually eliminates the possibility of an installer selecting “the wrong glue” and the need for him to be an “expert” on flooring manufacturing, construction, backing systems, and chemistry. Like all of our adhesives, this adhesive is protected by the CleanGuard® two-stage antimicrobial. CleanGuard® is a specifically formulated broad-spectrum, anti-microbial agent that protects our adhesives and sealers from microorganisms, such as mold or mildew, in both the wet and dry state. The CRI Green-label Plus Adhesive Certification Program has certified AAT-675 as a “low VOC” adhesive.

This versatile adhesive can be used over concrete sub-floors with MVER up to 5lbs (ASTM F-1869) and relative humidity up to 85% (ASTM F-2170). Its also performs in highly alkaline environments. The pH range, generally considered acceptable by the industry is 7 to 9. AAT-675 will tolerate a pH up to 11; one hundred times the traditional maximum.

AAT-675 Universal Multi-purpose Adhesive is recommended for the following backings and floor coverings:

- Broadloom carpet with polyurethane attached cushion, carpet tile and 6 ft PVC broadloom.
- Homogeneous sheet vinyl designed for “full-spread” installations, felt and fiberglass backed sheet vinyl, linoleum, sheet rubber flooring, , vinyl composition tile, rubber tile, solid vinyl tile, LVT, vinyl plank, rubber or vinyl stair treads.

AAT-675 may contribute to the LEED certification of projects in the following categories:

- IEQ Credit 4.1—Low Emitting Materials – Adhesives & Sealants
- IEQ Credit 4.3—Low Emitting Materials – Flooring Systems
- IEQ Credit 5—Regional Materials



### Sub-floor and Site Conditions:

Recommended Sub-floors ■ Concrete above, on or below grade ■ APA rated plywood underlayment ■ Properly prepared gypsum cement

Sub-floors on and below grade must be protected from ground moisture with a functioning and intact Class A vapor retarder that conforms to the requirements of the most current version of ASTM E-1745. This vapor retarder must be directly beneath, and in contact with, the slab. Concrete sub-floors must be properly prepared according to the practices detailed in the latest standard, ASTM F-710. Gypsum sub-floors must meet the requirements of the most current version of ASTM F-2419. All curing agents [topical and admix], adhesives, paints, varnishes, oils, waxes, dust, dirt and any other bond inhibiting substances must be removed. The removal of bond inhibiting substances must be by mechanical means: sanding, shot or bead blasting. AAT-675 cannot be used if adhesive removers, solvent or chemical cleaners have been used.

The maximum moisture emission rate of the sub-floor cannot exceed 5lbs/1000 sq.ft./24 hours [ASTM F-1869], with a pH of 7.0- 11.0 [ASTM F-710], and a maximum *in situ* RH of 85% [ASTM F-2170]. Prior to the application of AAT-675, sub-floors must be tested in strict accordance to the most recent versions of ASTM F-1869 and F-2170. Both testing protocols must be performed in order to provide the most accurate view of the sub-floor's condition. Sub-floors of lightweight concrete must be tested in strict accordance to the most recent version of ASTM F-2170. The placement of calcium chloride kits and humidity probes must follow the ASTM standards for proper locations and the correct quantity of test sites. These and other tests may be performed by AAT in the event of a warranty claim. *When installing PVC backed carpet tile or broadloom the pH level cannot exceed 10.*

All sub-floors must be flat and structurally sound. Smooth or glazed surfaces must be abraded. Repair all joints and cracks with latex-based portland cement underlayments. Never sand existing resilient flooring that could contain asbestos. Follow all Federal, State and Local regulations relating to the removal of in-place, asbestos containing material. Very porous sub-floors must be primed with AAT-570 Primer.

**NOTE:** Strip or plank wood flooring, particleboard and OSB sub-floors should be covered with an approved underlayment (minimum thickness of ¼"). AAT-675 cannot be used if adhesive removers, solvent or chemical cleaners have been used. Before beginning installations with backing systems or over sub-floors not listed contact AAT's Technical Services for recommendations. AAT Technical Services can be reached at 1(800)228-4583 or by email at [techservice@aatglue.com](mailto:techservice@aatglue.com). It is the sole responsibility of the applicator of this product to determine the suitability and compatibility of this product for their intended use. *If the provided preparation and application instructions are not followed, DO NOT USE AAT-675.*

#### **Installation Recommendations:**

The building should be completely enclosed. All outside doors and windows should be properly installed with latching mechanisms in place. Adequate ventilation should be available. The HVAC system for the building should be operational and provide a consistent temperature of 65-85°F (air and sub-floor) and humidity levels should be between 40-65% for a minimum of 72 hours prior to the installation. These conditions must be maintained to ensure the long term success and performance of the installation.

1. Flooring and adhesive should be acclimated to the job site conditions for a minimum of 24 hours prior to the installation.
2. Be familiar with the recommendations and any special instructions from the flooring manufacturer before beginning the installation. Follow the flooring manufacturer's specific recommendations regarding sub-floors.
3. Refer to the information above for specific information regarding sub-floor preparation and site conditions. Spread the adhesive with the appropriate trowel as defined below. Allow the appropriate dwell or open time.
4. Since this product can be used with so many floor covering products, proper trowel selection is critical to the success of the installation. The adhesive application rate can be affected by several variables including porosity and texture of the sub-floor, backing texture of the floor covering and other factors. It is the mechanic's responsibility to determine the proper trowel notch before beginning the installation. A basic guideline is as follows: solid vinyl tile, VCT, LVT, vinyl plank over non-porous<sup>1</sup> sub-floors<sup>2</sup> – 1/16" x 1/32" x 1/32" U, 200-250 sq ft/gal; solid vinyl tile, VCT, LVT, vinyl plank, rubber flooring and carpet tile over porous sub-floors – 1/16" x 1/16" x 1/16" U, 125-150 sq ft/gal<sup>2</sup>; vinyl sheet over non-porous<sup>1</sup> sub-floors<sup>2</sup> - 1/16" x 1/32" x 5/64" U – 250-300 sq ft/gal; vinyl sheet over porous sub-floor - 1/16" x 1/32" x 1/32" U, 200-250 sq ft/gal; broadloom carpet with polyurethane attached cushion – 3/32" x 3/32" x 3/32" U, 110 sq ft/gal.<sup>2</sup> (width x depth x space)
5. When installing products over porous substrates allow the appropriate "flash time". However, some flooring materials, such as VCT, carpet tiles, and LVT are more efficiently installed after the adhesive has dried to the touch. (does not transfer to the finger) When installing flooring materials over nonporous substrates<sup>1</sup>, additional "flash time" is required.
6. Place broadloom and sheet goods into adhesive so as to minimize air bubbles and wrinkles.
7. Roll flooring with an appropriate size roller (resilient: 75 – 100 lbs.; carpet, direct glue: 50 – 75 lbs.) to ensure adequate adhesive transfer. Should bubbles develop, or edges curl (a common problem with some of today's floor coverings), allow adhesive to dry further and re-roll.

May 5, 2016 [replaces October 28, 2015]

8. Direct glue down carpet placed into “wet-tacky” adhesive should be protected from foot traffic for at least 12 hours and heavy and/or roller traffic (including the placement of heavy furniture) for 24 hours. Traffic restrictions for resilient installations should be extended to 24 to 48 hours. Installations over “dry” adhesive can be exposed to light traffic immediately.

**Specific Technical Data:**

- A. Base: Acrylic-Ester Emulsion
- B. Color: White
- C. Clean-up: Remove wet adhesive with water and mild soap solution. Use AAT-197 Adhesive Remover to remove dried adhesive. Dried adhesive may be more difficult to remove; therefore, take care to remove adhesive from the surface of the flooring before it dries. DO NOT apply the solvent directly to the flooring material.
- D. Packaging: 4 gallon pails and one gallon pails (4 per case)
- E. Shelf-Life: One year from date of manufacture in un-opened container when stored at 70°F.
- F. Freeze-Thaw Stable to 15°F. Stability and spread-ability can be affected if allowed to freeze. Frozen material should be allowed to thaw at room temperature. DO NOT agitate or stir while frozen.
- G. VOCs: 0 g/l (Calculated per Ca. Rule 1168)
- H. Not recommended for exterior installations.

**NOTE:** We recommend installers follow the guidelines set forth in the CRI’s *Carpet Installation Standard* and the specific installation and site recommendations provided by the flooring manufacturer. Before placing the floor covering, the adhesive must be allowed an open or dwell time appropriate for the carpet backing or flooring, jobsite and sub-floor conditions. AAT-675 has an extended working time up to 6 hours after the initial drying for carpet tile and up to 4 hours for LVT if the area is kept dust free. It is extremely important to maintain recommended notch depth, width and spacing.

<sup>1</sup> Determining whether the sub-floor is porous or non-porous is the responsibility of the user. You can check the sub-floor by placing several drops of water in several areas across the sub-floor. The sub-floor is porous if the water is absorbed within a few seconds. If the water beads and is not absorbed within a few seconds the sub-floor is non-porous.

<sup>2</sup> Armstrong recommends the use of the following trowel: 1/32” x 1/16” x 5/64” U notch.





## Safety Data Sheet

Print Date: April 7, 2016 (Replaces May 13, 2015)

## 1. Identification

- **Product Name:** AAT-675
- **Product Use:** Universal Multipurpose Adhesive
- **Manufacturer:** Advanced Adhesive Technologies, Inc.  
424 South Spencer Street  
Dalton, GA 30721  
800-228-4583
- **Emergency telephone number:** Chemtrec 1-800-424-9300

## 2. Hazard(s) identification

- **Classification of the substance or mixture**

*This product does not meet the criteria for classification as hazardous under the GHS and 29 CFR 1910.1200*

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- **Label elements**

- **GHS label elements** Void
- **Hazard pictograms** Void
- **Signal word** Void
- **Hazard statements** Void

- **Classification system:**

- **NFPA rating (scale 0 – 4)**

Health = 1  
Fire = 0  
Reactivity = 0



- **HMIS-rating (scale 0 – 4)**

Health = 1

Fire = 0

Physical Hazard = 0

### 3. Composition/information on ingredients

- **Chemical characterization:** Mixtures

- **Description:** Adhesive

- **Dangerous components:**

No hazardous/reportable components

Cas # 7732-18-5	Water	45-48%
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- **Trade name:** AAT-675

### 4. First-aid measures

- **Description of first aid measures**

- **After inhalation:** Overexposure, remove to fresh air and seek medical attention.

- **After skin contact:** Immediately wash with water and soap and rinse thoroughly.

- **After eye contact:** Rinse opened eye for several minutes under running water.

- **After swallowing:** Do not induce vomiting; immediately call for medical help.

- **Most important symptoms and effects, both acute and delayed:** No further relevant information available.

- **Indication of any immediate medical attention and special treatment needed:**

No further relevant information available

### 5. Fire-fighting measures

- **Extinguishing media**

- **Suitable extinguishing agents:**

CO<sub>2</sub>, extinguishing powder or water spray. Fight larger fires with water spray.

Use fire fighting measures that suit the environment.

- **Special hazards arising from the substances or mixture:** Dried solids can burn and release toxic fumes and vapors.
- **Advice for firefighters**
- **Protective equipment:** Protective clothing and respiratory protective device.

## 6. Accidental release measures

- **Personal precautions, protective equipment and emergency procedures**

Wear protective equipment. Keep unprotected persons away.

Ensure adequate ventilation

- **Environmental precautions:** Dilute with water.

- **Methods and material for containment and cleaning up:**

Absorb with liquid-binding material (sand, diatomite, acid binders, universal binders, sawdust)

Wash area thoroughly with water.

Dispose of contaminated material as waste in accordance with federal state and local regulations.

Ensure adequate ventilation.

- **Reference to other sections**

See section 7 for information on safe handling

See section 8 for information on personal protection equipment

See section 13 for disposal information

## 7. Handling and storage

- **Precautions for safe handling**

Avoid prolonged or repeated contact with skin.

Avoid contact with eyes.

Wash thoroughly after handling.

- **Information about protection against explosions and fires:** No special measures required.

- **Conditions for safe storage, including any incompatibilities**

- **Storage**
- **Requirements to be met by store rooms and receptacles:**  
Store above 40 °F. Freeze-thaw stable up to five cycles at 20 °F.
- **Information about storage in one common storage facility:** Not required
- **Further information about storage conditions:** Protect product from freezing.
- **Specific end use(s)** No further relevant information available.

## 8. Exposure controls/personal protection

- **Additional information about design of technical systems:** No further data; see item 7
- **Control parameters**
- **Components with limit values that require monitoring at the workplace:**  
This product does not contain any relevant quantities of materials with critical values that have to monitor at the workplace.
- **Additional information:** The lists that were valid during the creation were used as basis.
- **Exposure controls**
- **Personal protective equipment (see listings below)**
- **General protective and hygienic measures:**  
The usual precautionary measures for handling chemicals should be followed.
- **Breathing equipment:** Not necessary if room is well-ventilated
- **Protection of hands:** Protective gloves  
The glove material has to be impermeable and resistant to the product/the substance/ the preparation.
- **Material of gloves:** natural rubber
- **Eye protection:** Safety glasses with side shields
- **Body protection:** Protective work clothing

## 9. Physical and chemical properties

- **Information on basic physical and chemical properties**
- **General Information**
- **Appearance:**

Form:	Heavy liquid
Color:	white to light beige
- **Odor:** Acrylic
- **Odour threshold:** Not determined
- **pH-value at 20°C (68°F):** 7.5-9.5
- **Change in condition**

Melting point:	Undetermined
Boling point:	212°F (100°C)
- **Flash point:** Not applicable
- **Flammability (solid, gaseous):** Not applicable
- **Ignition temperature:**

<b>Decomposition temperature:</b>	Not determined
• <b>Auto igniting:</b>	Product is not self igniting
• <b>Danger of explosion:</b>	Product does not present an explosion hazard.
• <b>Flammable limits:</b>	
<b>Lower:</b>	Not determined
<b>Upper:</b>	Not determined
• <b>Specific gravity at 20°C (68°F):</b>	1.06 – 1.09
• <b>Relative density:</b>	Not determined
• <b>Vapour density:</b>	Not determined
• <b>Evaporation rate:</b>	Slower than ether
• <b>Solubility in/Miscibility with Water:</b>	<b>Miscible in water, difficult to mix</b>
• <b>Solvent content:</b>	
<b>Organic solvents:</b>	0.0%
<b>Water:</b>	45-48%
• <b>Other information:</b>	California VOC Compliance: Solvent Free Product SCAQMD Rule 1168: VOC compliant

## 10. Stability and reactivity

- **Reactivity**
- **Chemical stability**
- **Thermal decomposition/conditions to be avoided:** No decomposition if used according to specifications
- **Possibility of hazardous reactions:** No dangerous reactions known.
- **Conditions to avoid:** No further relevant information available.
- **Incompatible materials:** No further relevant information available.
- **Hazardous decomposition products:** Carbon monoxide and carbon dioxide

## 11. Toxicological information

- **Information on toxicological effects**
- **Acute toxicity:**
- **Primary irritant effect:**
- **on the skin:** May irritate the skin
- **on the eye:** May irritate the eye
- **Sensitization:** No sensitizing effects known.
- **Additional toxicological information:**

The product is not subject to classification according to internally approved calculation methods for preparations: When used and handled according to specifications, the product does not have any harmful effects according to our experience and the information provided to us.

- **Carcinogenic categories:**

• <b>IARC (International Agency for Research on Cancer)</b>
None of the ingredients is listed
• <b>NTP (National Toxicology Program)</b>
None of the ingredients is listed
• <b>OSHA-Ca (Occupational Safety &amp; Health Administrations)</b>
None of the ingredients is listed



## 12. Ecological Information

- **Toxicity**
- **Aquatic toxicity:** No further relevant information available.
- **Persistence and degradability:** No further relevant information available.
- **Bioaccumulative potential:** No further relevant information available.
- **Mobility in soil:** No further relevant information available.
- **Other adverse effects:** No further relevant information available.

## 13. Disposal Considerations

- **Waste treatment methods**
- **Recommendation:** Comply with current regulations
- **Uncleaned packaging:**
- **Recommendation:** Comply with current regulations.

## 14. Transport information

• <b>Un-Number</b>	
• <b>DOT, ADR, AND, IMDG, IATA</b>	Not regulated
• <b>UN proper shipping name</b>	
• <b>DOT, ADR, AND, IMDG, IATA</b>	Not regulated
• <b>Transport Hazard class (es)</b>	
• <b>DOT, ADR, AND, IMDG, IATA</b>	
• <b>Class</b>	Not regulated
• <b>Packing group</b>	
• <b>DOT, ADR, IMDG, IATA</b>	Not regulated
• <b>Environmental hazards:</b>	Not applicable
• <b>Special precautions for user</b>	Not applicable
• <b>Transport in bulk according to Annex II of MARPOL73/45 and the IBC Code</b>	Not applicable
• <b>Transport/Additional information:</b>	DOT, ADR, IMDG, IATA – Not regulated in transport. Not dangerous according to the above specifications.
• <b>UN “Model Regulation”:</b>	

## 15. Regulatory information

- **Safety, health and environmental regulation/legislation specific for the substance or mixture**
- **Sara**

• <b>Section 355 (extremely hazardous substances):</b>
None of the ingredients is listed
• <b>Section 313 (Specific toxic chemical listings):</b>
None of the ingredients is listed
• <b>TSCA (Toxic Substances Control Act):</b>
All components of this product are on the TSCA Inventory or are exempt from TSCA Inventory

requirements,
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- **Proposition 65**

<ul style="list-style-type: none"> <li>• <b>Chemicals known to cause cancer:</b></li> </ul>
None of the ingredients is listed
<ul style="list-style-type: none"> <li>• <b>Chemicals know to cause reproductive toxicity:</b></li> </ul>
None of the ingredients is listed

- **(DSL) Canada Domestic Substance List**

All components of this product are on the DSL (Canada Domestic Substance list) or are exempt from SDL requirements

- **Carcinogen categories**

<ul style="list-style-type: none"> <li>• <b>EPA (Environmental Protection Agency)</b></li> </ul>
None of the ingredients is listed
<ul style="list-style-type: none"> <li>• <b>TLV (Threshold Limit Value established by ACHIH)</b></li> </ul>
None of the ingredients is listed
<ul style="list-style-type: none"> <li>• <b>NIOSH-Ca (National Institute for Occupational Safety and Health)</b></li> </ul>
None of the ingredients is listed

## 16. Other information

Although the information and recommendations set forth in the SDS are presents in good faith and are believed to be correct as of the date of this SDS, AAT makes not representations as to the completeness or accuracy thereof. Information is supplied on the condition that the persons receiving and using it will make their own determination as to the suitability for their purpose prior to use. In no event will AAT or any affiliate thereof be responsible for damages of any nature whatsoever resulting from the use or reliance on the information set forth in the SDS.

**Department issuing SDS:** Environment protection department

**Creation date:** May 1, 2015