



## AAT-280 The Ultimate Adhesive Specification Sheet

AAT-280 The Ultimate Adhesive is a *Go2 Adhesive* is specially formulated to handle your toughest installation challenges. AAT's *Go2 Adhesive* formulas have been formulated to ensure adhesive performance under the very demanding conditions commonly found in today's fast paced construction. This firm setting, fast tacking adhesive is excellent for "double glue down" installations, woven carpets, and carpets with stiff unitary backing or attached cushions. AAT-280 is a safe, light colored, low odor, latex based adhesive designed with the installer's needs in mind. AAT-280 is moisture resistant and non-flammable, and is the most versatile, strongest, and most trouble-free floor covering adhesive. This adhesive is backed by a 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 wet and dry state.

AAT-280 Ultimate Adhesive can be used for the following carpet backings and floor coverings:

- Direct-Glue: woven polypropylene (ActionBac®, hot melt, etc.) latex unitary, polyurethane foam-backed (Enhancer® I,II,III,IV, BioCel™ and Durafoam), rubber backs, woven, axminster, needlepunch, and jute
- Double-Glue: 280 is recommended for double-glue "carpet to pad" applications with specific carpet backings approved by AAT for this application. This adhesive can also be used to adhere approved double-glue carpet cushions.



**Note:** This adhesive is not recommended for vinyl backed (PVC) sheet goods or carpets.

AAT-280 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-280 cannot be used if adhesive removers, solvent or chemical cleaners have been used.

The maximum moisture emission rate of the sub-floor cannot exceed 8lbs/1000 sq.ft./24 hours [ASTM F-1869], with a pH of 7.0- 9.0 [ASTM F-710], and a maximum *in situ* RH of 85% [ASTM F-2170]. Prior to the application of AAT-280, 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.

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-280 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-280.*

#### **Installation Recommendations:**

Typical trowels and approximate coverage: (depth x width x spacing)

**Woven polypropylene, woven, axminster:** 1/8" x 1/8" x 1/8" U notch, 100 sq. ft. /gal.

**Attached cushions:** 3/32" x 3/32" x 3/32" V notch, 125 sq. ft. /gal.

**Unitary and Double-Glue (carpet to cushion):** 1/8" x 1/8" x 1/16" U notch, 50 sq. ft./gal.

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 and seam sealing.
3. Refer to the information above for specific information regarding sub-floor preparation and site conditions.
4. Spread the adhesive with the appropriate trowel as defined above. Allow the appropriate dwell or open time. Lay the carpet into the adhesive as to minimize bubbles and wrinkles.
5. Roll the carpet with a three-section roller [75lb. for direct glue and 35lb. double-glue] to ensure adequate transfer. Wet adhesive transfer to the carpet must be 100%.
6. Roll the carpet "north to south" and "east to west" from center to edge forcing out air pockets and eliminating wrinkles.

**Specific Technical Data:**

- Base: SBR-resin emulsion
- Color: yellow-tan
- Flammability: Non-flammable
- Shelf Life: One year from date of manufacture in an unopened container
- Freeze-Thaw Stable: If frozen, allow to thaw at room temperature. Do NOT stir or agitate while frozen. Stability and spread-ability can be reduced if frozen. For best results do not allow to freeze.
- Clean-up: Remove wet adhesive with damp cloth (plain water). Use AAT-197 Adhesive Remover for dried adhesive.
- VOCs: 0 g/l (Calculated per Ca. Rule 1168); Solvent free
- Not recommended for exterior installations.

**NOTE:** We recommend installers follow the guidelines set forth in the latest version of the CRI's *Carpet Installation Standard - 104*. Before placing the carpet, the adhesive must be allowed an open or dwell time appropriate for the carpet backing, jobsite and sub-floor conditions. It is extremely important to maintain recommended notch depth, width and spacing. The proper notch depth is that which will produce adhesive ridges that affect a 100% transfer to both the substrate and the carpet backing to include the inner recesses of the texture of the back.



May 6, 2016 (Replaces November 16, 2015)