AURO Natural resin universal adhesive No. 380

Technical Data Sheet

Type of material: Solvent free, very low-emissions dispersion adhesive based on natural rubber and natural resin.

Intended purpose
- For bonding of floorings and tiles in interior applications, e.g. unsealed cork materials (not coated on the rear side), linoleum on jute, linoleum-cork composite materials, cork composite and cork felt board, textile floor coverings (tiles and roll bulk), natural fibre carpets with jute and naturel latex backing, ceramic tiles laid by the thin bed method, tiles, boards, natural stone tiles and Solnhofer boards.
- In the wall area the profile on the rear side shall not exceed 1 mm.
- Not for directly wet areas (e.g. shower) or on old coatings (e.g. tile on tile).
- When applied on warm water floor heating, observe the guidelines of the producer. Switch off the heating 24 hours prior to application of adhesive. Switch on gradually 72 hours after application, adjusting the water passage to rise 5 °C per day, max. temperature 30 °C.

Technical properties
Gives strong, durable adhesion and complies with the requirements regarding emissions according to the German Committee for Health Evaluation of Construction Products (AgBB), the requirements of the class A+ of the French VOC regulations, and the product code GISCode D1, solvent-free dispersion based adhesives.

Composition
Water, mineral fillers, natural latex, colophony glycerol ester, linseed oil, milk casein, cellulose, swelling clays, potash, benzisothiazolinone, sodium pyrithione. See the current full declaration on www.auro.de.

Colour shade: White when liquid, light grey after drying.

Drying time in standard climate (20 °C, 50 % relative humidity)
Airing time: materials with good vapour diffusion properties (e.g. carpets) can be laid immediately. Thicker materials such as cork, linoleum or glazed tiles can be laid after several minutes. **Laying time**: max. 20 min. **Load bearing**: after 48 hours. **Final adhesive power**: after 72 hours. The time can vary depending on substrates and sorts of material.

Viscosity: Pasty.

Thinner Do not dilute if used as adhesive. As carpet fixing thinnable to max. 1:1, as primer up to max. 1:2 with water.

Cleaning of tools: Immediately after use clean the work utensils with water, if necessary adding some AURO Plant soap No. 411*.

Storage Store cool, frost-free, dry, out of reach of children in original closed container. After opening, clean the lid and the edge of container, cover with a bit of AURO Thinner No. 191* before closing. Storage stability 12 months.

Packaging material: Polypropylene.

Disposal
Dried product residues or residues hardened with cement can be disposed of as construction or household waste. Empty, clean containers can be recycled. Liquid residues: EWC code 080416, dispose of according to the valid regulations.

Attention
For information on the safe handling of the product, for product labelling and for hazardous goods regulations, please refer to the current Safety Data Sheet and the product label.

REMARKS
- Stir well before and during application.
- The room must be dry and tempered. The covering materials and the utensils should have a minimum temperature of 18 °C.
- Best application temperature: 18-22 °C, 45-55% rel. air humidity. These values should be kept until the final hardness of the adhesive has been reached. Air humidity should not exceed 65%.
- Please observe the instructions of the manufacturers of the covering materials.
- Avoid solar radiation, moisture and draught during application.
- Possible skin layer on the product should be removed, not stirred into the adhesive.
- Fluctuations of texture and product-specific smell are caused by natural ingredients, but have no influence on the suitability of product. Trial applications are recommended.

Technical recommendations for application
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1. SUBSTRATE

1.1 Suitable substrates

Substrates acc. to the German Regulation for Assignments and Contracts in Construction Services (VOB): DIN 18365 floor laying services, 18352 Tiles and boards based on cement, anhydrite, mastic asphalt and magnesia, fibre boards, wood based materials. Observe the recommendations of the material producers.

1.2 General substrate requirements

The surface must be dry, even, clean, pressure- and pull-resistant, vibration-free, grease-free, chemically neutral, moderately absorbent and contain no joints or cracks. The substrate moisture should not exceed certain levels. Measurements of temperature and humidity must be carried out and recorded for evidence.

2. APPLICATION

2.1 Substrate preparation

- Depending on the type and condition of the substrate, preparations must be done, e.g. uneven surfaces must be levelled off. It must be ensured that there is no possibility of rising moisture.
- On mastic asphalt and construction boards, a levelling compound is recommended, see recommendations of the producer.
- Old coverings, loose residues of adhesives and fillers must be removed completely.
- On substrates containing plaster the sintered skin must be removed by grinding; remove dust thoroughly.

2.2 Basic treatment

Prime strongly or unevenly absorbing substrates as well as anhydrite with thinned adhesive. Leave for drying for at least 24 hours.

2.3 Gluing – general application

- Apply adhesive evenly with required spatula toothing on the entire surface. Avoid adhesive puddles or clusters. Apply only the amount of adhesive that can be well connected with the rear side of the coating within the laying time.
- The adhesive layer must still be wet when gluing, (do a finger check to assure this) and must not have built a solid skin yet.
- Do not let stains on the coverings dry out but remove immediately with a moist sponge and clean water.
- If the covering is exposed to strong tension, bend the edges for decurling.
- Press or roll on the covering strongly; if needed, repeat after 20-30 min.

2.3.1 Gluing of cork and cork materials

Lay the cork material onto the adhesive bed and, applying slight pressure, push into place to achieve an exact fit. Apply pressure over the entire surface using a seam roller or a rubber mallet, removing all bubbles. Leave the adhesive layer to air for a short time then roll or hammer again with more pressure. It may be necessary to weigh down any "bowing" floor tiles.

2.3.2 Gluing of linoleum

Flex the linoleum into the adhesive bed, carefully press down over the entire surface and roller off. The rear side of the roll must be wetted by the adhesive over its entire surface. Do not include any air. Carefully roller down the edges and seams once again about 20 minutes after laying. If required the linoleum can be weighted down (e.g. with small sand sacks) until the adhesive has set.

2.3.3 Gluing of textile coverings

Lay the covering onto the adhesive bed without allowing for airing time and fit it into place under light pressure. Roll the covering using, for example, a rubber roller to squeeze out all trapped air. In the case of carpet rolls, cut roughly to size and lay out completely in the room. Apply the adhesive evenly and over the entire surface. Lay the covering onto the adhesive bed without allowing for airing time and, starting in the middle, roller down avoiding folds. In the case of fibres which swell with water, first glue down the covering and only cut to size when the adhesive has completely dried.

2.3.4 Fixing of textile coverings

Alternatively, the adhesive can be used for fixation. After advance trials, thin the adhesive with water in 1:1 ratio. Apply the thinned adhesive by a roller. Otherwise proceed as 2.3.3.

2.3.5 Gluing of tiles

Lay tiles into the adhesive bed without allowing for airing time, press well, e.g. with a rubber mallet, and reposition if necessary. Use tile spacers near walls to maintain sufficient clearance. Grouting should not be carried out until the adhesive has achieved its final adhesion strength.

	Length of edge	Sharp tooth spatula	Tooth offset	Approx. consumption	Material	Square spatula
Cork, cork materials		Fine A3	1,5 mm	0,3 kg/ m²	Cork materials up to 6mm	
		Fine A2	1,8 mm	0,4 kg/ m²	Cork parquet from 6 mm	
Carpet floor		Fine A3	1,5 mm	0,3 kg/ m²		
		Fine A2	1,8 mm	0,4 kg/ m²	Coconut, sisal with honey-comb back wool with jute or foam back	
		Coarse B1	2,7 mm	0,6 kg/ m²	Coconut, sisal with or without natural latex back; natural latex back	
Linoleum		Fine A3	1,5 mm	0,3 kg/ m²	For thinner qualities	
		Coarse B1	2,7 mm	0,6 kg/ m²	For all thicknesses	
Tiles	Up tp 50 mm		3 mm	0,8 kg/ m²		C3
	50 – 108 mm		4 mm	0,9 kg/ m²		C1
	109 – 200 mm		6 mm	1,0 kg/ m²		C2
	Over 200 mm		8 mm	1,1 kg/ m²		C4

* See respective Technical Data Sheets.

The Technical Data Sheet gives recommendations and examples of possible use. No liability or other legal responsibility can be derived. Use of the advice does not create any legal relationship. The information provided is based on our present knowledge and does not exempt the user from his personal responsibility. The respective state-of-the-art practices must be observed when implementing coating work and the required preparations. The conditions on site and the product's suitability must be checked appropriately and professionally. With publication of a new edition this technical data sheet is no longer valid. Status: April 2020

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