

**Advanced Adhesive Technologies, Inc.**  
**AAT-677 Universal Multi-Purpose Spray Adhesive**  
**Specification Sheet**

**I. Description:**

A truly “multipurpose” adhesive, AAT-677, can be used to install virtually any floor covering product. So versatile, the *patented* formula has redefined the installation process. It can be used as a “wet set” adhesive to install carpet or resilient products over any structurally sound, porous subfloor.

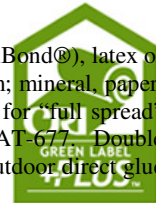
AAT-677 can be used in the same fashion as a conventional carpet or resilient adhesive. When installing VCT, pure vinyl tile, or carpet tiles it can be allowed to dry completely, even overnight if need be. This is because of its residual, pressure sensitive nature, a real advantage, providing the installer with a new degree of flexibility in regard to his work practices. If, for some reason, a bubble should develop, simply pressing the material firmly into the adhesive can easily eliminate it.

AAT-677 is chemically compatible with every known floor covering backing system presently in use in the industry. Not only that, it sets new standards for tolerance of moisture emission and alkali. While the rest of the industry recommends the moisture emission rate not to exceed 3 lbs./1,000 sq. ft./24 hrs., AAT-677 will not break down, decompose or re-emulsify when used over floors emitting as much as 5 lbs./1,000 sq. ft./24 hrs. It will also perform in highly alkaline environments. The pH range, generally considered acceptable by the industry is 5 to 9. AAT-677 will tolerate a pH range, generally considered acceptable with every known floor covering backing system presently in use in the industry. Not only that, it sets new standards for tolerance of moisture emission and alkali. While the rest of the industry recommends the moisture emission rate not to exceed 3 lbs./1,000 sq. ft./24 hrs., AAT-677 will not break down, decompose or re-emulsify when used over floors emitting as much as 5 lbs./1,000 sq. ft./24 hrs. It will also perform in highly alkaline environments. The pH range, generally considered acceptable by the industry is 5 to 9. AAT-677 will tolerate a pH up to 11; **one thousand times the present maximum.** This revolutionary adhesive virtually eliminates the possibility of an installer selecting the wrong glue and the need for him to be an expert on floor covering manufacturing, construction, backing systems, and chemistry.

Due to its broad “window of opportunity” in regard to its usage, and its greater tolerance of moisture emissions and alkali, it moves the installer farther from the “edge of the envelope,” greatly increasing the “probability of success” in the installation of virtually everything.

**II. Recommended for use with:**

Woven, needle punched or tufted carpets with just, woven polypropylene (ActionBac®), hot melt (UniBond®), latex or urethane unitary backings. Rubber or urethane attached cushions: PVC carpet tile and 6 ft. broadloom; mineral paper, or felt backed vinyl sheet goods, linoleum, sheet rubber flooring, homogenous sheet vinyl designed for “full spread” installations, and vinyl compositions, rubber, cork and pure vinyl tiles can also be installed with AAT-677. Double glue down installations with approved cushions can be done with AAT-677. It can also be used for outdoor direct glue down installations of products designed for outdoor use.



**Subfloor surfaces:** APA rated underlayment grade plywood, hardboard, Assn. Grade particle board (when approved by flooring manufacturer), existing well bonded resilient flooring (cushioned or heavily embossed vinyl should be properly prepared with an approved embossing leveler), terrazzo, and structurally sound, clean, level concrete (on, above or below grade) with a moisture emission rate not to exceed 5 lbs./1,000 sq.ft./24 hrs. and a pH below 11.

**Specifications:**

• Patented polymer blend • Solvent Free • 0 VOC (calculated) • Non-Flammable • Open time: can be used as a “wet set” with no open time, allowed to dry completely, or anywhere in between (see installation instructions) • Freeze-thaw stable to 10°F • Shelf life: 1 year in unopened container • Clean up: Wet-warm water and detergent; Dry-AAT-197 Adhesive Remover or AAT-1905 Universal Cleaner

**III. Installation Recommendations:**

1. Flooring materials must be stored in a pre-heated building where room and sub-floor temperature should be no less than 65°F, 24 hours before, during and after installation. US-1 Sprayer unit must also be acclimated to room temperature before any adhesive can be placed into canister.
2. Subfloors must be clean, free of dust, dirt, grease, wax, paint, or any other substance that may affect the bond. Sub-floors must be structurally sound, level, free of curing or parting agents with a moisture emission rate not to exceed 5lbs./1,000

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- sq. ft./24 hrs. and a pH below 11.
3. Since this product can be used to install so many floor covering products, correct spray equipment and tip selection is required. A smooth uniform application should be achieved to ensure proper to ensure proper surface area contact between the floor covering and subfloor. AAT-677 should be sprayed exclusively through the US-1 spray unit using tip number 80-06.

**TYPICAL COVERAGE RATES AND APPLICATION PATTERNS:**

• **10-12 sq/yds per gallon or 2.2-2.6 m<sup>2</sup>/L (40% over lap of spray)**  
Woven polypropylenes (ActionBac®), Enhancer® Backs, Foam Backs, Life Span® Premier Plus®

• **8-10 sq/yds per gallon or 1.7-2.2 m<sup>2</sup>/L (60% over lap of spray)**  
Latex Unitary (20lbs. tuft bind), UniBond, Double Lock ActionBac, Double Glue (carpet to pad)

• **18-20 sq/yds per gallon or 4.2-4.5 m<sup>2</sup>/L (no over lap of spray)**  
Sheet vinyl, VCT, carpet tile, Double Glue (pad to floor)

**Coverage rates may vary with condition of sub-floor, pad and flooring texture. Do Not exceed the flooring manufacturer's specification for adhesive coverage rates.**

4. When installing many products over porous substrates there is no need to allow "open time," however, some flooring materials, such as VCT, carpet tiles, and rubber tiles are more efficiently installed after the adhesive has dried completely. When installing nonporous backed materials over nonporous substrates, appropriate "open time" is recommended.
5. Place broadloom and sheet goods into adhesive to minimize air bubbles and wrinkles.
6. Roll flooring with an appropriate sized roller (resilient: 75-100 lbs., carpet: direct glue, 50-75 lbs., double glue, 35-50 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 and re-roll.
7. Direct glue down carpet placed into "wet" 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 and "double glue" carpet installations should be extended to at least 24 and 48 hours, respectively. Installations over "dry" adhesive can be exposed to foot traffic immediately.
8. Clean-up: Remove wet adhesive with cloth dampened in tap water. Use AAT-1905 Universal Cleaner or AAT-197 Adhesive Remover to clean dried adhesive. Check colorfastness before using either cleaner on flooring or any other surface. *Clean the US-1 Sprayer according to the instructions provided with the sprayer before changing adhesives and after completing each installation.*

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