

Altro wall adhesive information

Data sheet

AltroFix™ W639

January 2025

For use with all types of Altro PVCu cladding systems. Can be used in hygienic environments and areas subject to wet usage. It has excellent adhesion properties to all sound substrates used for internal wall construction. Suitable for new and refurbishment building projects.

Properties

AltroFix W639 is a non hazardous two-part MS polymer adhesive supplied in the correct quantities for mixing. Both parts are held separately within the container. The setting and curing time is dependent upon site working temperatures:-

Working time:	30 mins*
Loadable after:	48 hours*
Joint welding after:	24 hours*
Final strength after:	3 - 5 days*

*At 20 °C and 65% relative humidity

Pack sizes

AltroFix W639 is supplied in one pack size:-
5 kg unit (Ref: A639/5KG) - suitable for use with all sheet sizes.

Substrate moisture content

All substrates to be dried to 16% WME (Wood Moisture Equivalent) on Protimeter 'Surveymaster' equipment.

Installation temperatures

Recommended application temperature 10° - 30°C
Altro recommends the PVCu wall sheet is installed at the approximate ambient service temperature at which the area will be when commissioned. This is to ensure that expansion parameters are not exceeded. The adhesive must not be used if the temperature is below +5°C. Lower temperatures can cause permanent damage to the product.

Substrates

Substrates should be sound and free from all surface contaminants. Any contamination should be cleaned from the surface using appropriate methods and allowed to dry. Dusty or friable surfaces to be stabilised using a stabilising solution of Unibond PVA diluted 1:10 with water or Altro Primer Seal (Ref: AGCPNF/01). Both stabilisers to be applied with brush or roller and allowed to dry.

Suitable substrates include good quality fairfaced brick or blockwork: well aligned joints bagged up flush: straight to within 3mm over a 2m straight edge: brick and blocks to be flush with ones adjacent: sand and cement rendering. AltroFix W639 is suitable for plasterboard, plywood, MDF, plaster, ceramic tiles which are securely bonded to substrate and thoroughly degreased or certain sound painted surfaces (subject to an adhesive test).

Mixing of parts A and B

Part A is a viscous cream coloured paste supplied in metal tubs. Part B is a catalyst supplied in foil bags, and is coloured blue. Pour the contents of Part B into the metal container holding Part A and mix thoroughly, for a minimum of 3 minutes, until a uniform consistency and colour is obtained throughout. A slow speed drill with a paddle attachment should be used to ensure complete mixing. Scrape the sides thoroughly during this process. Care should be taken to avoid spillage when mixing, as staining of floor coverings may occur.

Application

The back of the PVCu sheet must be clean and free of surface contaminants such as grease and dust.

Apply adhesive to the back of the sheet as soon as possible before the adhesive thickens. Apply adhesive approximately 15mm from edges using a 4 mm x 4 mm square notched trowel, producing a coverage of approximately 1.4 kg/m².

On application, immediately apply the sheet to the wall.

Apply pressure to the whole surface area of the sheet to ensure transfer and a good overall bond. Altro double sided tapes (Ref: A815) should be used to assist with initial contact to substrate, and Altro recommend that sheets are supported during the initial cure phase.

On completion, the installation should not be subject to a temperature variation of + or - 5°C until the adhesive cures.

Coverage

AltroFix W639 adhesive is supplied in a 5 kg pack size.

A 5 kg tub of adhesive is sufficient to cover a 3.0 m x 1.22 m PVCu sheet, (approximately 1.4 kg/m²).

Coverages are based on applications with a 4 mm x 4 mm notched trowel. Please note, there will be adhesive left over when using with a 2.5 m x 1.22 m sheet.

Storage and conditioning (on site)

It is essential that AltroFix W639 is stored at ambient temperatures of between 10°C to 25°C.

Lower temperatures can cause permanent damage to product. Storage temperatures determine the viscosity of the product and if stored in cold conditions, the adhesive will not spread easily and coverage will be reduced. If stored at extreme heat conditions, deterioration of Part B can occur.

AltroFix W639 has a shelf life of 9 months from date of manufacture.

Health & safety

Before using this adhesive, users should refer to the SDS (Safety Data Sheet) for correct safety advice and to determine the level of PPE (Personal Protective Equipment) and RPE (Respiratory Protective Equipment) that is required. A COSHH (Control of Substances Hazardous to Health) assessment and risk assessment should be carried out before using this adhesive.

Part A - Base

- Generally no significant hazard
- May cause mild irritation on contact with skin
- After contact with skin, wash affected area thoroughly with soap and water
- In case of eye contact, rinse eyes with water as a precaution
- Wear suitable protective clothing and gloves

Part B - Hardener

- May cause slight irritation to eyes
- May cause mild irritation on contact with skin
- After contact with skin, wash affected area thoroughly with soap and water
- In case of eye contact, rinse eyes with water as a precaution
- Wear suitable protective clothing and gloves

Care must be taken when mixing Part B with Part A component to avoid contact with eyes and skin.

Wear suitable protective clothing, gloves, eye protection and keep away from ignition sources.

Ensure the area is adequately ventilated.

In the case of contact with eyes or skin, rinse immediately with plenty of water.

For further information or technical advice

tel: 01462 707600

email: enquiries@altro.com or www.altro.com