

# Armaflex®

HT625 Adhesive

THE ADHESIVE FOR SUPERIOR  
ARMAFLEX® SYSTEM RELIABILITY IN  
HIGH TEMPERATURE & SOLAR  
APPLICATIONS



- Specially formulated for wide range of temperatures and applications
- Easy application
- Superior, water-tight bonding of HT/Armaflex® and Armaflex® DuoSolar insulation systems
- For operating temperatures up to +150 °C

## Technical Data - Armaflex HT625 [Adhesive]

Brief description	One-component adhesive which has been developed to bond Armaflex insulation applied on high temperatures, especially well matched with HT/Armaflex, but also suitable for all other Armaflex synthetic rubber based insulation materials (except Armaflex Ultima).
Material type	Contact adhesive on polychloroprene basis, free of aromatic components.
Colour	Beige
Material Special Information	Liquid.
Applications	Application on pipes and tanks with service temperatures up to 150 °C. Gluing of HT/Armaflex insulation material and other Armaflex synthetic rubber based insulation materials (except Armaflex Ultima).
Special Features	Specially formulated adhesive for uniform and safe seam bonding of flexible Armaflex insulation materials applied on high temperature lines.
Assembly	Please observe our installation instructions / product data. Application temperature: ideally + 20 °C, not below 0 °C. At temperatures below + 5 °C or high humidity (above approx. 80%), increased condensation may form on the surfaces to be glued or adhesive films. In this cases bonding is bad or impossible. This can be tested by using absorbent paper (blotting or crepe paper). Work should not be carried out on working plants or areas exposed to strong sunlight.  Shake and stir well before use. Apply thinly to the places to be bonded with a brush or spatula. In case of contact adhesion press together with force during the contact adhesion time. Extensive notes for application are available.
Remarks	The adhesive achieves its final strength after 36 hours. Only then should the plant be taken into operation. Wait 36 hours before applying coatings (exception: Armafinish 99), adhesive tape, coverings etc.

Property	Value/Assessment	Special Remark
Temperature Range		
Temperature Range	max. service temperature <sup>1</sup> + 150 °C min. service temperature <sup>2</sup> -50 °C	
Other technical features		
Yield	Minimum consumption with the adhesive applied to both surfaces: Armaflex tubes (thickness > consumption unslotted > consumption slotted): 10 mm > 1120 m/l > 140 m/l; 20 mm > 280 m/l > 70 m/l; 30 mm > 175 m/l > 45 m/l; 40 mm > 130 m/l > 35 m/l;  Sheets: 3-4 m <sup>2</sup> /l	These figures are a guide only.
Storage & Shelf life	12 months in a closed (unopened) container . Do not store together with: explosive substances; spontaneously combusting substances.	As cool as possible, but protected from frost. In the event of frost any gelling is reversible on warming.
Flash Point	approx. -26 °C	
Explosion limits	Lower: approx. 1,1 Vol. % Upper: approx. 12,8 Vol. %	
Hazard Class	highly flammable	Regulation of inflammable liquids
Ageing stability	Very Good	
Resistance to weathering	Very good	
Pre-treatment of surface to be bonded:	Clean dirty surfaces and the Armaflex surface with Armaflex Cleaner.  Compatibility with bases: very good adhesion to metallic base. The compatibility with colour coated surfaces with adhesive needs to be tested.  Incompatible with: Asphalt, bitumen or red lead paint (inseed oil based).	For more information pls. see Technical Bulletin no. 17.
Transport classes	Depending on the type of transport.	
Recycling	Allocation of a waste code number, according to the European Waste Catalogue, should be carried out in agreement with the regional waste disposal company. More details see relevant Safety Data Sheet.	Residuals must be removed from packaging and when emptied completely disposed of in accordance with the regulations for waste removal. Incompletely emptied packaging must be disposed of in the form of disposal specified by the regional disposer.

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### Working time

at 20 °C:

1. Minimum drying time (airing time): 3-5 minutes
2. Contact adhesion time: 15-20 minutes
3. Setting time: 36 hours

The open time depends on the quantity as well as indoor climate conditions. Before operation time the setting time needs to be allowed to elapse.

1. For temperatures above +150 °C please contact our Customer Service Center to request for the corresponding technical information.
2. For temperatures below -50 °C please contact our Customer Service Center to request for the corresponding technical information.

All data and technical information are based on results achieved under typical application conditions. Recipients of this information should, in their own interest and responsibility, clarify with us in due time whether or not the data and information apply to the intended application area. Installation instructions are available in our Armaflex installation manual. Armaflex HT625 adhesive must be used to guarantee proper installation.

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