

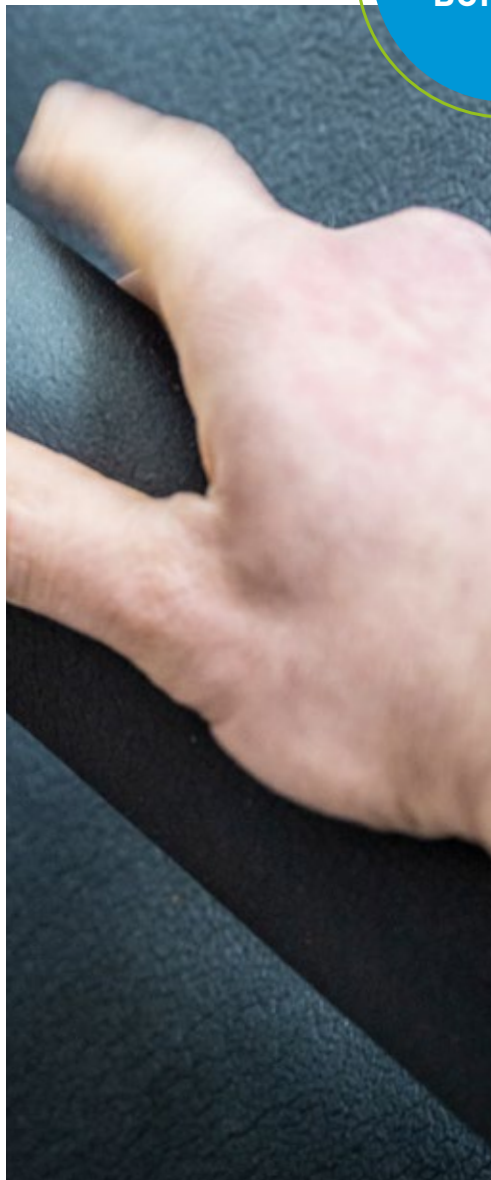
ArmaFlex[®] EC0550 Adhesives

More than just an adhesive. The ArmaFlex EC0550 range is a revolutionary solution combining sustainability, safety, and ease of application with improved efficiency. Experience the future of adhesive technology, ensuring high performance without compromising the environment, health, or productivity.

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REINVENTING
BONDING



 **armacell**[®]
ArmaFlex[®]

WORKING WITH ARMAFLEX EC0550

ArmaFlex EC0550 and ArmaFlex Ultima EC0550 adhesives are easy to work with and requires minimal tools and equipment.

TOOLS FOR INSTALLING



Brush



Lacquer foam roller



Water



Metal brush

PROCESSING CONDITIONS

- // The suitable application temperature for ArmaFlex EC0550 is from +5°C up to +35°C.
- // Enclosures or tenting may be required if rain or adverse weather is anticipated during installation.
- // Do not install ArmaFlex EC0550 Adhesive under unsuitable weather conditions, such as rain, condensing fog, or snowfall.

COMPATIBILITY

- // **ArmaFlex EC0550** is designed for all NBR/PVC and Armacell's black ArmaPrene™ based products.
- // **ArmaFlex Ultima EC0550** Adhesive is specifically formulated for all ArmaPrene based products.
- // **ArmaFlex EC0550 Activator** is an optional second component to be used in combination with both adhesives to speed up the application process.

APPLICATION

- // Stirring ArmaFlex EC0550 Adhesive before use is not necessary.
- // Apply a thin layer of ArmaFlex EC0550 adhesive on both surfaces – please note: three times less product is required than using for example ArmaFlex 520 – **less is more.**
- // The fingernail test is unnecessary to assess the airing time of ArmaFlex EC0550 Adhesive. Follow the times provided in the application timetable on page 5.
- // Use a lacquer foam roller when all-over adhesion is needed.
- // For wet glueing applications, airing time is not required. Ensure all wet glueing applications are done under pressure.
- // Keep the ArmaFlex EC0550 Adhesive tin close unless it is in use.
- // The brush or lacquer foam roller can be cleaned with water immediately after use. Dried adhesive particles can be easily removed from the brush using a metal brush.





1 Consider the ambient temperature and the relative humidity during the work. (Use the application timetable on page 5).



2 Do not immerse the brush fully into ArmaFlex ECO550 Adhesive. Just the point of the brush should contain the necessary amount of the adhesive. **Less is more.**



3 Do not apply ArmaFlex ECO550 Adhesive onto the surface of the FEF directly. Allocate the adhesive in droplets onto the surface of the FEF product.



4 To achieve a thin layer of adhesive, apply the droplets by spreading over the entire surface using a brush.



5 Correct amount of the adhesive is essential. Do not apply too much adhesive. **Less is more.**



6 As soon as the ArmaFlex ECO550 Adhesive is distributed/coated onto the surfaces, count the time for the necessary airing time as per the instructions on the application timetable.



7 Consider having an airing time of 1 to 3 minutes (depending on the ambient conditions and ArmaFlex ECO550 Activator usage) to connect the FEF products.



8 To achieve a sufficient contact of adhesive, connect both products together under high pressure at each seam point.



While applying ArmaFlex ECO550 Adhesive on flat surfaces, it is recommended to use a lacquer foam roller to spread the adhesive thin and evenly.



Do not immerse the roller fully into ArmaFlex ECO550 Adhesive. Just the point of the roller should contain the necessary amount of the adhesive. **Less is more.**



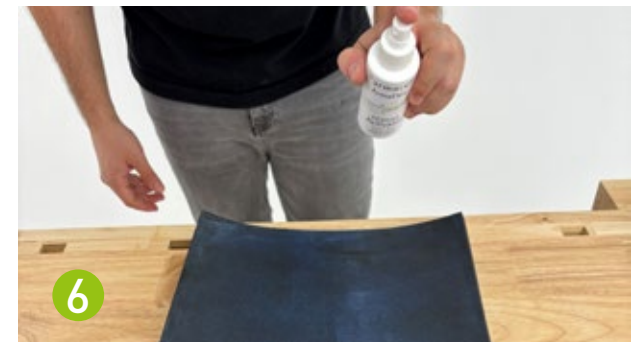
Do not apply the ArmaFlex ECO550 Adhesive onto the surface of the FEF product. Allocate the adhesive in droplets onto the surface of the FEF product.



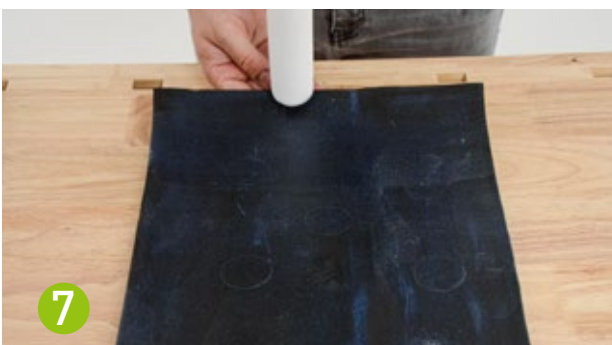
To achieve a thin layer of adhesive, apply the droplets by spreading over the entire surface using a lacquer foam roller.



Correct amount of the adhesive is essential. Do not apply too much adhesive. **Less is more.**



For boosted efficiency, as soon as ArmaFlex ECO550 Adhesive is distributed/coated onto the surfaces, we recommend applying ArmaFlex ECO550 Activator onto the glued surfaces from a distance of 30 - 50 cm.



Consider having an airing time of 1 to 3 minutes (depending on the ambient conditions and ArmaFlex ECO550 Activator usage) to connect the FEF products.



To achieve a sufficient contact of adhesive, connect both products together under high pressure at each seam point.

WHEN SHOULD I CONNECT THE FEF PRODUCTS?



| Product | Ambient Temperature (°C) | Relative Humidity (%) | Airing Time (min) * | Open Time (min) ** |
|---|--------------------------|-----------------------|---------------------|--------------------|
| ArmaFlex EC0550 | +5°C / +35°C | < 70% | 2-3 min. | 15 min. |
| ArmaFlex EC0550 + ArmaFlex EC0550 Activator | +5°C / +35°C | < 70% | 1-2 min. | n.a. |



*** Airing Time:**

In contact adhesion, the period of time during which the necessary ingredients must evaporate from the adhesive film applied to both surfaces in order to enable an instantaneous bond between the adherents.

**** Open Time:**

Period of time during which apparently dry adhesive layers can still be bonded to each other (contact adhesion time).

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ABOUT ARMACELL

As the inventor of flexible foam for equipment insulation and a leading provider of engineered foams, Armacell develops innovative and safe thermal and mechanical solutions that create sustainable value for its customers. Armacell's products significantly contribute to global energy efficiency making a difference around the world every day. With more than 3,300 employees and 27 production plants in 19 countries, the company operates two main businesses, Advanced Insulation and Engineered Foams. Armacell focuses on insulation materials for technical equipment, high-performance foams for acoustic and lightweight applications, recycled PET products, next-generation aerogel technology and passive fire protection systems.

For product information, please visit:
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