



ARMAFLEX® ACCESSORIES

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- Specially designed to install Armaflex®
- Reliable installations
- Optimal performance
- Complete range of high-quality tools and accessories
- Innovative solutions to meet present and future market needs

Technical Data - Armaflex Ultima 700 [Adhesive]

Brief description	One-component adhesive specifically for processing Armaflex Ultima and insulating materials based on Armaprene® synthetic rubbers.
Material type	Contact adhesive on polychloroprene basis, free of aromatic components.
Colour	blue
Applications	Application on pipes and tanks with service temperatures up to +110 °C. Gluing of Armaflex Ultima and insulation materials based on Armaprene® synthetic rubbers.
Special Features	Specially formulated adhesive for uniform and safe seam bonding of Armaflex Ultima and insulating materials based on Armaprene® synthetic rubbers.
Assembly	<p>Please observe our installation instructions / product data. Application temperature: ideally between +15 °C and + 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.</p> <p>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.</p>
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 +110 °C min. service temperature -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 m² /l	These figures are a guide only.
Storage & Shelf life	18 month 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. 1,0 Vol. % Upper: approx. 12,8 Vol. %	
Hazard Statement	highly flammable liquid and vapour	For more information pls. see EC Safety Data Sheet.
Ageing stability	Very good	
Resistance to weathering	Very good	
Pre-treatment of surface to be bonded	Clean dirty surfaces and Armaflex Ultima surface with Armaflex Cleaner Compatibility with bases: very good adhesion to metallic base. The compatibility with colour coated surface with adhesive needs to be tested. Incompatible with Asphalt, bitumen or red lead (inseed oil-based).	For more information see Technical Bulletin no. 17
Transport Classes	Depending on the type of transport	
Disposal considerations	Allocation of a waste code number, according to the European Waste Catalogue, should be carried out in agreement with the regional waste disposal company. 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.	
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.

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. For some refrigerants the discharge temperature may exceed +110 °C, please consult our Customer Service Center for further information.

Technical Data - Armaflex Ultima SF990 [Adhesive]

Brief description	Water-based one component solvent-free adhesive. Specifically formulated for processing Armaflex Ultima and insulating materials based on Armaprene® synthetic rubbers.
Material type	Solvent-free dispersion adhesive based on synthetic latex.
Colour	blue
Material Special Information	liquid
Applications	Gluing of Armaflex Ultima and insulation materials based on Armaprene® synthetic rubbers.
Assembly	Please observe our installation / product data. The maximum relative humidity must not exceed 70%. Work should not be carried out on working plants, for areas exposed to strong sunlight. and high wind speed. Apply adhesive with a brush in a thin uniform layer to both surfaces to be joined. Adhesive bond reaches full strength after 72 hours. The system should not be operated during this period and any self-adhesive tapes or protective coatings should only be applied after this period has elapsed. A detailed application advice is available.
Remarks	The application of the Armaflex Ultima SF990 shall be performed only by certified users. Before starting application work, a practical instruction training performed by the Armacell Technical Customer Service is obligatory!

Property	Value/Assessment	Special Remark
Temperature Range		
Temperature Range	max. service temperature	+100 °C
	min. service temperature	-30 °C
Processing temperature	Ideally between +20 °C and +30 °C For temperatures at low temperature e.g. +5 °C please contact our application specialist.	
Other technical features		
Yield	Minimum consumption with the adhesive applied to both surfaces:: 3-4 m ² / l	These figures are a guide only.
Storage & Shelf life	6 month in sealed original container.	In a cool (preferably not under +15 °C and not below +30 °C) and dry place. Protect from temperatures below +5 °C!
Pre-treatment of surface to be bonded	Clean dirty surfaces and Armaflex surface with Armaflex Cleaner or Armaflex SF Cleaner. Compatibility with bases: very good adhesion to metallic base, except galvanized surfaces. The compatibility with colour coated surfaces with adhesive needs to be tested.	
Transport classes	No hazardous material as defined by the transport regulations.	
Disposal considerations	Allocation of a waste code number, according to the European Waste Catalogue, should be carried out in agreement with the regional waste disposal company. 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.	
Working time	at 20 °C; 55% : 1. Minimum drying time (airing time): approx. 12 - 60 minutes 2. Contact adhesion time (open time): approx. 5 to 10 minutes 3. Setting time: 72 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.

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. For some refrigerants the discharge temperature may exceed +110 °C, please consult our Customer Service Center for further information.

Technical Data - Armaflex 520 [Adhesive]

Brief description	Special adhesive for installing all flexible Armaflex insulation materials (with the exception of Armaflex EPDM-based products). See also "Overview Adhesive Application".
Material type	Contact adhesive on polychloroprene basis, free of aromatic solvent.
Colour	Beige
Material Special Information	Liquid
Applications	Gluing flexible Armaflex insulation materials (see above).
Special Features	Specially formulated adhesive for uniform and safe seam bonding of flexible Armaflex insulation materials.
Assembly	<p>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 these cases bonding is poor or impossible. This can be tested using absorbent paper (blotting or crepe paper). Work should not be carried out on working plants or areas exposed to strong sunlight.</p> <p>Shake and stir well before use. Apply thinly to the areas to be bonded with a brush or spatula. In case of contact adhesion press together with force during the contact adhesion time. Extensive guidance for application are available.</p>
Remarks	Setting time of the adhesive is 36 hours. Only then should plant be put into operation. Never insulate a plant which is in operation or work in strong sunlight. 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 + 105 °C min. service temperature ¹ - 50 °C	
Other technical features		
Yield	Yield of 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: 7-9 m ² /l	These figures are a guide only.
Storage & Shelf life	18 months in a closed (unopened) container in a dry, cool, well ventilated place. Do not store together with: explosive substances; spontaneously combusting substances.	In a cool, but frost-free place. Jellification due to frost is reversible.
Flash Point	approx. - 15 °C	
Hazard Statement	highly flammable liquid and vapour	For more information pls. see EC Safety Data Sheet.
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	
Disposal considerations	Allocation of a waste code number, according to the European Waste Catalogue, should be carried out in agreement with the regional waste disposal company. Packaging must be emptied of all residues. Packaging with traces of cured product can be re-cycled. Packaging with uncured product must be disposed of in the same manner as the medium.	
Working time ²	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 below -50 °C please contact our Customer Service Center to request for the corresponding technical information.

2. The full adhesion of the adhesive is achieved after 168 h.

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. For some refrigerants the discharge temperature may exceed +110 °C, please consult our Customer Service Center for further information. Armaflex 520 adhesive and Clipse must be used to guarantee proper installation.

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 Armaflex EPDM- based products like HT/Armaflex, but also suitable for all other Armaflex synthetic rubber based insulation materials.
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 Armaflex EPDM-based insulation material and other Armaflex synthetic rubber based insulation materials.
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 ¹ + 150 °C min. service temperature ² -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 ml / > 140 ml; 20 mm > 280 ml / > 70 ml; 30 mm > 175 ml / > 45 ml; 40 mm > 130 ml / > 35 ml; Sheets: 7-9 m ² / l	These figures are a guide only.
Storage & Shelf life	18 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. 1,0 Vol. % Upper: approx. 12,8 Vol. %	
Hazard Statement	highly flammable liquid and vapour	For more information pls. see EC Safety Data Sheet.
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.	
Disposal considerations	Allocation of a waste code number, according to the European Waste Catalogue, should be carried out in agreement with the regional waste disposal company. 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.	
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.

Technical Data - Armaflex RS850 [Adhesive]

Brief description	Non-dripping one-component adhesive in gel form. Specifically for processing all Armaflex insulating materials based on synthetic rubber with the exception of Armaflex EPDM-based products.
Material type	Thixotropic contact adhesive on polychloroprene basis
Colour	Yellowish
Material Special Information	Jellylike
Applications	Application on pipes, ducts and tanks with service temperature up to +70 °C. Gluing of all Armaflex insulation materials with the exception of HT/Armaflex.
Special Features	Specifically formulated adhesive for uniform and safe seam-bonding of flexible Armaflex insulation materials.
Assembly	Please observe our installation instructions / product data. Application temperature: ideally between +15 °C and 25 °C, not below +10 °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.
Remarks	Adhesive bond reaches full strength after 24 hours. The system should not be operated during this period and any self-adhesive tape or protective coatings, except Armafinish 99 paint, should only be applied after this period has elapsed.

Property	Value/Assessment	Special Remark
Temperature Range		
Temperature Range	max. service temperature +70 °C	
	min. service temperature -40 °C	
Other technical features		
Yield	Yield of 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: 7-9 m ² /l	These figures are a guide only.
Storage & Shelf life	36 months in a closed (unopened) container; Store between 0 °C and 35 °C in a dry place. Do not store together with: explosive substances; spontaneously combusting substances.	As cool as possible, but protected from frost. Cold or frozen adhesive (under +5 °C) will become fully usable again if slowly acclimatized up to working temperature (approx. +20 °C).
Flash Point	-17 °C	
Explosion limits	Lower: 1,1 Vol.% Upper: 11,5 Vol.%	
Hazard Statement	highly flammable liquid and vapour	For more information pls. see EC Safety Data Sheet.
Ageing stability	Very good	
Resistance to weathering	Very good	
Pre-treatment of surface to be bonded	Clean dirty surfaces and Armaflex surface with Armaflex Cleaner. Compatibility with bases: The compatibility with color coated surface with adhesive needs to be tested. Incompatible with: Asphalt, bitumen, red lead (in seed oil-based), polystyrene and plasticized PVC	For more information see Technical Bulletin No. 17
Transport classes	Depending on type of transport	
Disposal consideration	Allocation of a waste code number, according to the European Waste Catalogue, should be carried out in agreement with the regional waste disposal company. 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.	
Working time	at 20 °C 1. Minimum drying time (airing time): > 2 minutes 2. Contact adhesion time: 10 to 15 minutes 3. Setting time: 24 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.

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. For some refrigerants the discharge temperature may exceed +110 °C, please consult our Customer Service Center for further information.

Technical Data - Armaflex SF990 [Adhesive]

Brief description	Water-based one component adhesive. Specifically for processing of all Armacell insulating materials based on synthetic rubber with the exception of Armaflex EPDM-based and Armaprene based products in buildings.
Material type	Solvent-free dispersion adhesive based on synthetic latex.
Colour	dark grey
Material Special Information	liquid
Applications	Gluing of Armaflex insulation materials based on synthetic rubber (see above).
Assembly	Please observe our installation / product data. The maximum relative humidity must not exceed 70%. Work should not be carried out on working plants, for areas exposed to strong sunlight and high wind speed. Apply adhesive with a brush in a thin uniform layer to both surfaces to be joined. Adhesive bond reaches full strength after 72 hours. The system should not be operated during this period and any self-adhesive tapes or protective coatings should only be applied after this period has elapsed. A detailed application advice is available.
Remarks	The application of the Armaflex SF990 shall be performed only by certified users. Before starting application work, a practical instruction training performed by the Armacell Technical Customer Service is obligatory!

Property	Value/Assessment	Special Remark
Temperature Range		
Temperature Range	max. service temperature	+100 °C
	min. service temperature	-30 °C
Processing temperature	ideally between +20 °C and +30 °C For temperatures at low temperature e.g. +5 °C please contact our application specialist.	
Other technical features		
Yield	Minimum consumption with the adhesive applied to both surfaces:: 3-4 m ² / l	These figures are a guide only.
Storage & Shelf life	6 month in sealed original container.	In a cool (preferably not under +15 °C and above +30 °C) and dry place. Protect from temperatures below +5 °C!
Pre-treatment of surface to be bonded	Clean dirty surfaces and Armaflex surface with Armaflex Cleaner or Armaflex SF Cleaner. Compatibility with bases: very good adhesion to metallic base, except galvanized surfaces. The compatibility with colour coated surfaces with adhesive needs to be tested.	
Transport classes	No hazardous material as defined by the transport regulations.	
Disposal considerations	Allocation of a waste code number, according to the European Waste Catalogue, should be carried out in agreement with the regional waste disposal company.	
	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.	
Working time	at 20 °C; 55% : 1. Minimum drying time (airing time): approx. 12 - 60 minutes 2. Contact adhesion time (open time): approx. 5 to 10 minutes 3. Setting time: 72 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.

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. For some refrigerants the discharge temperature may exceed +110 °C, please consult our Customer Service Center for further information.

Technical Data - Armaflex Cleaner

Brief description	Special cleaner for use with all Armaflex adhesives
Colour	Clear
Material Special Information	Liquid
Applications	Cleaning of surfaces where Armaflex Adhesive are to be used.
Assembly	To ensure perfect adhesion all contaminated surfaces - including contaminated Armaflex - must be cleaned. In addition, the cleaner can also be used to clean surfaces when Armafinish 99, for example, is to be applied.
Remarks	Please also use the Armaflex Cleaner to clean tools (except Armaflex Ultima SF990 and Armaflex SF990 adhesive).

Property	Value/Assessment	Special Remark
Other technical features		
Storage & Shelf life	24 months	Keep container tightly closed in a cool, well ventilated place. Protect from heat and direct sunlight. Do not store together with: explosive substances; spontaneously combusting substances.
Flash Point	approx. - 20 °C	
Explosion limits	Lower: approx. 1 Vol-% Upper: approx. 13 Vol-%	
Hazard Statement	highly flammable liquid and vapour	For more information pls. see EC Safety Data Sheet.
Transport classes	depending on the type of transport	
Disposal consideration	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.	

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. During storage of the product blooming on the surfaces may occur, especially at wall thickness below 19mm. This blooming does not affect the technical properties of the material, but can affect the adhesion properties. Therefore, the surface needs to be cleaned (wiped off) before adhesives can be applied.

Technical Data - Armaflex SF Cleaner

Brief description	Water-soluble Cleaner
Colour	yellowish
Material Special Information	Liquid
Applications	Cleaning of surfaces where Armaflex Adhesive are to be used.
Assembly	To ensure perfect adhesion all contaminated surfaces - including contaminated Armaflex - must be cleaned.
Remarks	Armaflex SF Cleaner is sprayed onto areas to be cleaned, allowed to have an effect depending on pollution degree, then wash off.

Property	Value/Assessment	Special Remark
Other technical features		
Storage & Shelf life	1 year in sealed original container	Keep container tightly closed in a cool, well-ventilated place. Protect from frost, do not store it below of +5 °C.
Flash Point	> 100 °C	
Hazard Statement	This product does not meet the classification and labelling criteria given in the Regulation (EC) No 1272/2008 (CLP).	
Transport classes	No hazardous material as defined by the transport regulations.	
Disposal consideration	Dispose of waste according to applicable legislation. More details see relevant Safety Data Sheet.	

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.

Technical Data - ArmaFinish 99

Brief description	Armafinish 99 is a paint, which remains permanently elastic, is resistant to weathering and has good ageing resistance.
Material type	Non-drip
Colour	white (RAL 9001) or grey (RAL 7037)
Material Special Information	Normal consumption: 0,55 l/m ² when two coats are applied (corresponds to a dry film thickness of 0,26mm).
Applications	Protection of Armaflex insulation materials when installed outdoors and for marking purposes for interior use.
Assembly	All Armaflex insulation (except HT/Armaflex and Armaflex products based on Armaprene), see relevant product data sheet) which is installed outdoors must be covered with two complete coats of Armafinish 99. Application temperature: + 10 °C to + 30 °C, maximum relative humidity 80%. Drying time at + 20 °C: approx. 2 hours. It is also necessary to allow this time between coats; the second coat must be applied within 7 days. Paint may be applied using a brush or roller. Clean tools with water.
Remarks	Unprotected Armaflex must not be exposed to weathering for more than 3 days, so the paint should be applied as soon as possible. The protective coating should be inspected at regular intervals. After 2 years at the latest, two further coats should be applied. Refer to special instruction / safety data sheet.

Property	Value/Assessment	Special Remark
Other technical features		
Storage & Shelf life	Shelf-life in unopened container: 12 months.	Keep container tightly closed and store in a cool, well ventilated and frost-free place.
Explosion limits	Lower: none Upper: none	
Hazard Class	Environmentally hazardous substance as defined by the transport regulations (ADR/RID, IMDG-Code, ICAO-TI/IATA-DGR).	
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.	Packaging must be emptied of all residues. Packaging with traces of cured product can be recycled. Packaging with uncured product must be disposed of in the same manner as the medium.

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.

Technical Data - ArmaFlex 525 [Adhesive]

Brief description	Special premium adhesive for installing the next generation of flexible Armaflex insulation materials (e.g. AF/ArmaFlex Evo). See also "Overview Adhesive Application".
Material type	Contact adhesive on polychloroprene basis, free of aromatic solvent.
Colour	Beige
Material Special Information	Liquid
Applications	Gluing flexible Armaflex insulation materials (see above).
Special Features	Specially formulated premium adhesive for uniform and safe seam bonding of the next generation of flexible Armaflex insulation materials.
Assembly	<p>Please observe our installation instructions / product data. Application temperature: ideally + 20 °C, not below 0 °C.</p> <p>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 these cases bonding is poor or impossible. This can be tested using absorbent paper (blotting or crepe paper). Work should not be carried out on working plants or areas exposed to strong sunlight.</p> <p>Shake and stir well before use. Apply thinly to the areas to be bonded with a brush or spatula. In case of contact adhesion press together with force during the contact adhesion time. Extensive guidance for application are available.</p>
Remarks	The adhesive achieves its final strength after 36 hours. Only then should plant be put into operation. Never insulate a plant which is in operation or work in strong sunlight. 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 + 110 °C min. service temperature ¹ - 50 °C	
Other technical features		
Yield	Yield of 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: 7-9 m ² /l	These figures are a guide only.
Storage & Shelf life	18 months in a closed (unopened) container in a dry, cool, well ventilated place. Do not store together with: explosive substances; spontaneously combusting substances.	In a cool, but frost-free place. Jellification due to frost is reversible.
Flash Point	approx. -26 °C	
Explosion limits	Lower: approx. 1,0 Vol. % Upper: approx. 12,8 Vol. %	
Hazard Statement	highly flammable liquid and vapour	For more information pls. see EC Safety Data Sheet.
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.	
Disposal considerations	Allocation of a waste code number, according to the European Waste Catalogue, should be carried out in agreement with the regional waste disposal company.	
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 below -50 °C please contact our Customer Service Center to request for the corresponding technical information.

Technical Data - ArmaFlex 750 [Adhesive]

Brief description	Special adhesive for installing the next generation of NH/ArmaFlex Smart. See also "Overview Adhesive Application".
Material type	Contact adhesive on polychloroprene basis, free of aromatic solvent.
Colour	Beige
Material Special Information	Liquid
Applications	Gluing flexible NH/ArmaFlex Smart materials (see above).
Special Features	Specially formulated adhesive for uniform and safe seam bonding of flexible NH/ArmaFlex Smart insulation materials.
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 these cases bonding is poor or impossible. This can be tested using absorbent paper (blotting or crepe paper). Work should not be carried out on working plants or areas exposed to strong sunlight. Stir well before use. Apply thinly to the areas to be bonded with a brush or spatula. In case of contact adhesion press together with force during the contact adhesion time. Extensive guidance for application are available.
Remarks	The adhesive achieves its final strength after 36 hours. Only then should plant be put into operation. Never insulate a plant which is in operation or work in strong sunlight. Wait 36 hours before applying coatings (exception: Armafinish 99), adhesive tape, coverings etc.

Property	Value/Assessment	Test ¹	Special Remark
Temperature Range			
Temperature Range	max. service temperature	+90 °C	
	min. service temperature ¹	-50 °C	
Other technical features			
Yield	Yield of 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: 7-9 m ² /l		These figures are a guide only.
Storage & Shelf life	18 months stored in original unopened containers at 5 °C - 35 °C. 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. - 12 °C		
Hazard Statement	highly flammable liquid and vapour		For more information please see EC Safety Data Sheet.
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		
Disposal considerations	Allocation of a waste code number, according to the European Waste Catalogue, should be carried out in agreement with the regional waste disposal company. Packaging must be emptied of all residues. Packaging with traces of cured product can be re-cycled. Packaging with uncured product must be disposed of in the same manner as the medium.		
Working time ²		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 below -50 °C please contact our Customer Service Center to request for the corresponding technical information.

2. The full adhesion of the adhesive is achieved after 168 h.

*1 Further documents such as test certificates, approvals and the like can be requested using the registration number given.

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. For some refrigerants the discharge temperature may exceed +110 °C, please consult our Customer Service Center for further information.

notes

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