

ADHESIVE

ArmaFlex[®] 525

Special adhesive for the next generation of ArmaFlex synthetic rubber.

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Specially formulated adhesive for uniform and safe seam bonding of the next generation of flexible ArmaFlex insulation materials.


ArmaFlex[®]

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 ArmaFlex Adhesives".
Material type	Contact adhesive based on polychloroprene.
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	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	Special Remark
Temperature Range	max. service temperature +110 °C min. service temperature ¹ -50 °C	
Yield	Minimum consumption with the adhesive applied to both surfaces: ArmaFlex tubes (thickness > consumption unstotted > consumption stotted): 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 frostfree 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 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 please 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.

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