

INSULATION FOR THE OIL AND GAS INDUSTRY

ArmaFlex[®] HT625 Adhesive

The adhesive for superior ArmaFlex[®] system reliability in oil and gas applications

- // Superior, water-tight bonding of HT/ArmaFlex[®] Industrial and ArmaSound[®] Industrial Systems
- // Superior, vapour-tight bonding with other ArmaFlex[®] insulation materials
- // Specially formulated for a wide range of temperatures and applications
- // For operating temperatures up to +150 °C
- // High performance, one component industrial grade adhesive
- // Low-viscosity air-drying contact adhesive

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 **armacell**[®]
ArmaFlex[®]

TECHNICAL DATA – ARMAFLEX HT625

Brief description	Adhesive which has been developed to bond ArmaFlex insulation applied on high temperatures, especially well matched with HT/ ArmaFlex (Industrial), 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 HT/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 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. Waiting times between layers should be observed. Please refer to Armacell Key Installation Instructions for further details or contact Technical Services.

Property	Value/Assessment	Special Remark
Temperature range		
Service temperature	Max. service temperature ^{*2} +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): 13 mm > 840 m/litre > 115 m/litre; 19 mm > 280 m/litre > 70 m/litre; 25 mm > 230 m/litre > 58 m/litre; Sheets: 3-4 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. -20 °C	
Explosion limits	Lower: approx. 1.0 Vol.%; Upper: approx. 13.0 Vol.%	
Hazard class	Please refer to Safety Data Sheet.	
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 (linseed oil based).	For more information please see Technical Bulletin no. 17.
Transport classes	Please refer to Safety Data Sheet.	
Recycling	Dispose waste according to applicable local, state and federal regulations. Please refer to Safety Data Sheet.	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	At 20 °C and 50 % RH: 1. Minimum drying time (airing time): <2 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 Technical Services to request for the corresponding technical information.

2. For temperatures below -50 °C please contact Technical Services to request for the corresponding technical information.

All data and technical information are based on results achieved under the specific conditions defined according to the testing standards referenced. It is the customer's responsibility to verify if the product is suitable for the intended application. The responsibility for professional and correct installation and compliance with relevant regulations and project specification lies with the customer. Armacell takes every precaution to ensure the accuracy of the data provided in this document and all statements, technical information and recommendations contained within are believed to be correct at the time of publication. By ordering/receiving product you accept the **Armacell General Terms and Conditions of Sale** applicable in the region. Please request a copy if you have not received these.

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ABOUT ARMACELL

As the inventors of flexible foam for equipment insulation and a leading provider of engineered foams, Armacell develops innovative and safe thermal, acoustic 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 3,100 employees and 24 production plants in 16 countries, the company operates two main businesses, Advanced Insulation and Engineered Foams. Armacell focuses on insulation materials for technical equipment, high-performance foams for high-tech and lightweight applications and next generation aerogel blanket technology.

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