SEAMLESS JOINT FOR LIFETIME

ArmaFlex® DuctSeal

// Seamless strong joints
// Good coverage
// Quick drying
// Easy to apply
// Very good adhesion strength
// Optimal viscosity

www.armacell.in
Air drying contact adhesive for joining ArmaFlex and ArmaSound sheet insulations to metal ducting.

Benefits

// Adhesion strength
Air drying contact adhesive for joining ArmaFlex and ArmaSound sheet insulations to metal ducting with seamless strong joints hold technology.

// Quick drying
With Armacell’s quick drying technology stop worrying about long wait application time.

// Easy to apply
Quick and easy installation with good coverage helping you save resources and time.
**TECHNICAL DATA - ArmaFlex DuctSeal**

<table>
<thead>
<tr>
<th>Brief description</th>
<th>Air drying contact adhesive for joining ArmaFlex and ArmaSound sheet insulations to metal ducting.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Material type</td>
<td>Rubber based contact adhesive in blend of solvents.</td>
</tr>
<tr>
<td>Colour</td>
<td>Pale yellow</td>
</tr>
<tr>
<td>Product range</td>
<td>5 and 30 litres</td>
</tr>
<tr>
<td>Applications</td>
<td>Recommended for duct insulation. Not recommended for piping.</td>
</tr>
</tbody>
</table>

**Environmental safety aspects**
- Highly flammable. Keep away from open flame.

<table>
<thead>
<tr>
<th>Property</th>
<th>Value/Assessment</th>
<th>Special Remark</th>
</tr>
</thead>
<tbody>
<tr>
<td>Temperature range</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Maximum service temperature</td>
<td>+ 85 °C</td>
<td></td>
</tr>
<tr>
<td>Minimum service temperature</td>
<td>+5 °C</td>
<td></td>
</tr>
<tr>
<td>Viscosity @ 30 °C</td>
<td>700 - 1200 CPS</td>
<td></td>
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<tr>
<td>Specific gravity</td>
<td>0.80 - 0.85 g/cc</td>
<td></td>
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<tr>
<td>Flash point</td>
<td>&gt; 10°C</td>
<td></td>
</tr>
</tbody>
</table>

**Practical fire behaviour**
- Doesn’t affect the fire resistance properties of the insulation negatively, once it dries or cures.

**Drying time**
- 4 - 5 minutes for tack drying, depending on the ambient conditions. Allow 36 hours for complete curing before lines are charged. High humidity (greater than 90 %) may prolong the drying time.

**Health aspects**
- Don’t work in closed environments, work in well ventilated areas.

**Storage & shelf life**
- Up to 12 months in original unopened containers when stored indoors, away from direct Sunlight.

**Coverage**
- 6-8 m² of bonded area*

**Application instructions**
1. Before using, stir adhesive thoroughly to ensure mixing of solids which may have settled.
2. Use brush with short stiff bristles. Apply a thin uniform film of adhesive, to both surfaces to be joined.
3. Do fingernail test to check for tack dry. If fingernail doesn’t stick to the surface, the joint may be closed.
4. Wet seal where it is not possible to allow the adhesive to tack dry before joining, like in butt joints.
5. A wet seal may be made by separating the surfaces, applying a thin film of adhesive and closing joint.
6. Allow minimum 36 hours of curing before charging the line or applying any coating.
7. Minimum application temperature +20°C to +30°C.
8. Do not mix any other solvent such as thinner or water with the adhesive.
9. Adhesive to be applied in shadow area only.

**Compatibility with bases:**
- Very good adhesion to metallic base. The compatibility with coloured coated surfaces with adhesive needs to be tested.
- Incompatible with: Asphalt, bitumen or red lead paint (In seed oil based).

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*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.

*Area of ArmaFlex material and duct together per litre.
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 3,135 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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