

Armaflex[®] Ductseal Adhesive

SEAMLESS JOINT FOR LIFETIME



- Seamless strong joints
- Good coverage
- Quick drying
- Easy to apply

- Very good adhesion strength
- Optimal viscosity

Technical Data - Armaflex Ductseal [Adhesive]

Brief description	Air drying contact adhesive for joining Armaflex and ArmaSound sheet insulations to metal ducting	
Material type	Rubber based contact adhesive in blend of solvents	
Colour	Pale Yellow	
Product Range	5 & 30 litres	
Applications	Recommended for Duct insulation, under-deck and wall insulation. Not recommended for piping	
Safety and Environment	Highly flammable. Keep away from open flame.	
Property	Value/Assessment	
Temperature Range		
Temperature Range	max. service temperature	+ 85 °C
	min. service temperature	+ 5 °C
Viscosity @ 30°C	700 - 1200 CPS	
Specific Gravity	0.80 - 0.85 g/cc	
Flash Point	> 10°C	
Fire performance		
Practical Fire Behavior	Doesn't affect the fire resistance properties of the insulation negatively, once it dries/cures.	
Drying time	4 - 5 mins 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 m ² of bonded area*	
Application instructions	Before using, stir adhesive thoroughly to ensure mixing of solids which may have settled.	
	Use brush with short stiff bristles. Apply a thin uniform film of adhesive, to both surfaces to be joined.	
	Do fingernail test to check for tack dry. If fingernail doesn't stick to the surface, the joint may be closed.	
	Wet seal where it is not possible to allow the adhesive to tack dry before joining, like in butt joints. A wet seal may be made by separating the surfaces, applying a thin film of adhesive and closing joint.	
	Allow minimum 36 hours of curing before charging the line or applying any coating.	
Pre-treatment of surface to be bonded	Minimum application temperature +20°C to +30°C	
	Do not mix any other solvent such as thinner or water with the adhesive.	
	Adhesive to be applied in shadow area only.	
	Clean dirty surfaces and the Armaflex surface with clean cloth/cotton.	
	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 (Inseed oil based).	

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.

Armacell India Pvt. Ltd.

GAT No. 744-745, Village Lonikand, Pune Nagar Road • 412216 Pune •

Maharashtra • India

Phone +91 20 66782000

www.armacell.com • info.isa@armacell.com

CIN: U24293PN2005FTC131939