THE RIGHT TOOLS & ACCESSORIES TO ENSURE THE BEST ARMAFLEX® INSTALLATIONS

- Complete set of professional tools and accessories
- Specially designed and optimized for use with Armaflex®
- Complete range with cleaner, knifes, adhesives, tapes, paints and others
## Technical Data - Armaflex® 520 Adhesive

**Brief description**  
Special adhesive for installing all flexible Armaflex® insulation materials (with the exception of HT/Armaflex® and Armaflex Ultima®).

**Material type**  
Contact adhesive on polychloroprene basis, free of aromatic solvent.

**Colour**  
Beige

**Material Special Information**  
Liquid

**Applications**  
Gluing of all flexible Armaflex® insulation materials, with the exception of HT/Armaflex® and Armaflex Ultima®.

**Special Features**  
Specially formulated adhesive for uniform and safe seam bonding of flexible Armaflex® insulation materials.

### Assembly

Please review the product data and our installation instructions before use. The ideal temperature for application is +20 °C. At temperatures below +5°C or at high humidity (above approx. 80%), condensation may form on the adhesive films or on the surfaces to be adhered. Hence, bonding performance would be poor. This can be tested with a piece of absorbent paper (such as 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 a thin layer on the surfaces to be adhered with a brush or spatula. In case of contact adhesion, press together firmly throughout the contact adhesion time. Extensive notes regarding application is available upon request.

### Remarks

The maximum bond strength of the adhesive is achieved after 36 hours. Before this is achieved, the plant should not be in operation. Do not insulate a plant that is in operation, or work in strong sunlight conditions. Wait for 36 hours before applying any coatings (exception: Armafinish 99), adhesive tapes, coverings or the like.

<table>
<thead>
<tr>
<th>Property</th>
<th>Value/Assessment</th>
<th>Special Remark</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Temperature Range</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Temperature Range</strong></td>
<td>max. service temperature &amp; 105 °C</td>
<td></td>
</tr>
<tr>
<td></td>
<td>min. service temperature &amp; 50 °C</td>
<td></td>
</tr>
<tr>
<td><strong>Other technical features</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Yield</strong></td>
<td>Minimum consumption with the adhesive applied to both surfaces: Armaflex tubes (thickness &gt; consumption unslotted &gt; consumption slotted): 10 mm &gt; 1120 ml &gt; 140 ml; 20 mm &gt; 280 ml &gt; 70 ml; 30 mm &gt; 175 ml &gt; 45 ml; 40 mm &gt; 130 ml &gt; 35 ml;</td>
<td>These figures are a guide only.</td>
</tr>
<tr>
<td></td>
<td>Sheets: 3-4 m²/³</td>
<td></td>
</tr>
<tr>
<td><strong>Storage &amp; Shelf life</strong></td>
<td>12 months in a closed (unopened) container in a dry, cool, well ventilated place.</td>
<td>In a cool, but frost-free place. Jellification due to frost is reversible.</td>
</tr>
<tr>
<td><strong>Flash Point</strong></td>
<td>approx. -20 °C</td>
<td></td>
</tr>
<tr>
<td><strong>Explosion limits</strong></td>
<td>Lower: approx. 1.0 Vol.%</td>
<td>Regulation of inflammable liquids</td>
</tr>
<tr>
<td></td>
<td>Upper: approx. 13.0 Vol.%</td>
<td></td>
</tr>
<tr>
<td><strong>Hazard Class</strong></td>
<td>VbF AI, highly flammable</td>
<td></td>
</tr>
<tr>
<td><strong>Aging stability</strong></td>
<td>Very good</td>
<td></td>
</tr>
<tr>
<td><strong>Resistance to weathering</strong></td>
<td>Very good</td>
<td></td>
</tr>
<tr>
<td><strong>Pre-treatment of surface to be bonded</strong></td>
<td>Clean all surfaces to be bonded with Armaflex® Cleaner. Compatibility with bases: very good adherence to metallic base. The compatibility of the adhesive with color-coated surfaces needs to be tested. Incompatible with: Asphalt, bitumen or red lead paint (inseed oil based).</td>
<td>For more information pls. see Technical Bulletin no. 17.</td>
</tr>
<tr>
<td><strong>Transport Classes</strong></td>
<td>Depends on the type of transport</td>
<td>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.</td>
</tr>
<tr>
<td><strong>Recycling</strong></td>
<td>Dispose waste according to applicable local, state and federal regulations. European Waste Catalogue: Recycling Nr: EAK 080409 Adhesives and sealants containing organic solvents or other dangerous substances. Note: The waste classification may change depending on the application area. Please review EC-directive 2001/118/EC.</td>
<td></td>
</tr>
<tr>
<td><strong>Working time</strong></td>
<td>at 20 °C: 1. Minimum drying time (airing time): 3-5 minutes 2. Contact adhesion time: 15-20 minutes 3. Setting time: 36 hours</td>
<td>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.</td>
</tr>
</tbody>
</table>

1. For temperatures below -50 °C please contact our Customer Service Center to request for the corresponding technical information.

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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. For some refrigerants the discharge temperature may exceed +110 °C, please consult our Customer Service Center for further information. Armaflex® 520 adhesive must be used to ensure rree proper installation.
**Technical Data - Armaflex® HT625 Adhesive**

**Brief description**
One-component adhesive developed to bond Armaflex® insulation for high temperatures applications. This is especially well-matched with HT/Armaflex®, and is 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 the uniform and safe seam bonding of flexible Armaflex® insulation materials for high temperature applications.

**Assembly**
Please review the product data and our installation instructions before use. The ideal temperature for application is +20 °C. At temperatures below +5 °C or at high humidity (above approx. 80%), condensation may form on the adhesive films or on the surfaces to be adhered. Hence, bonding performance would be poor. This can be tested with a piece of absorbent paper (such as 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 a thin layer on the surfaces to be adhered with a brush or spatula. In case of contact adhesion, press together firmly throughout the contact adhesion time. Extensive notes regarding application is available upon request.

**Remarks**
The maximum bond strength of the adhesive is achieved after 36 hours. Before this is achieved, the plant should not be in operation. Do not insulate a plant that is in operation, or work in strong sunlight conditions. Wait for 36 hours before applying any coatings (exception: Armafinish 99), adhesive tapes, coverings or the like.

**Property**

<table>
<thead>
<tr>
<th>Value/Assessment</th>
</tr>
</thead>
<tbody>
<tr>
<td>max. service temperature</td>
</tr>
<tr>
<td>min. service temperature</td>
</tr>
</tbody>
</table>

**Special Remark**
These figures are a guide only.

**Other technical features**
Minimum consumption with the adhesive applied to both surfaces:
- Armaflex tubes (thickness > consumption unsloped > consumption sloped):
  - 10 mm > 1170 ml > 140 ml/ft;
  - 20 mm > 280 ml > 70 ml/ft;
  - 30 mm > 175 ml > 45 ml/ft;
  - 40 mm > 130 ml > 35 ml/ft;
- Sheets:
  - 3-4 m²/ft

**Storage & Shelf life**
12 months in a closed (unopened) container

As cool as possible, but protected from frost. In the event of frost any getting is reversible on warming.

**Flash Point**
approx. -20 °C

**Explosion limits**
Lower: approx. 1.0 Vol.%;
Upper: approx. 13.0 Vol.%

**Hazard Class**
Vb/F A, highly flammable

**Aging stability**
Very good

**Resistance to weathering**
Very good

**Pre-treatment of surface to be bonded:**
Clean all surfaces to be bonded with Armaflex® Cleaner.
Compatibility with bases: very good adhesion to metallic base. The compatibility of the adhesive with color-coated surfaces 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**
Depends on the type of transport.

**Recycling**
Dispose waste according to applicable local, state and federal regulations.
European Waste Catalogue:
08 04 09 (waste adhesives and sealants containing organic solvents or other dangerous substances).
Please note: The classification of waste for this product may change according to the field of application. Please observe Decision 2001/118/EC.

**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 ensure proper installation.
### Technical Data - Armaflex® 820

**Brief description**  
Armaflex® 820 is a low viscosity adhesive used within the service temperature range of - 50 °C to + 60 °C. It is specially formulated to create uniform and safe bonding of seams and butt joints and for adhering Armaflex® to cleaned metal surfaces.

<table>
<thead>
<tr>
<th>Material type</th>
<th>Armaflex® 820 Adhesive is a black-coloured, low viscosity adhesive for use with Armaflex® insulation.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Colour</td>
<td>Black</td>
</tr>
<tr>
<td>Product Range</td>
<td>Armaflex® 820 Adhesive is ideal for most chilled water and duct applications.</td>
</tr>
</tbody>
</table>

**Special Features**  
Specially formulated adhesive for uniform and safe seam bonding of flexible Armaflex® insulation materials.

**Assembly**  
Please review the product data and our installation instructions before use. The ideal temperature for application is +20 °C. At temperatures below +5 °C or at high humidity (above approx. 80%), condensation may form on the adhesive films or on the surfaces to be adhered. Hence, bonding performance would be poor. This can be tested with a piece of absorbent paper (such as 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 a thin layer on the surfaces to be adhered with a brush or spatula. In case of contact adhesion, press together firmly throughout the contact adhesion time. Extensive notes regarding application are available upon request.

**Remarks**  
The maximum bond strength of the adhesive is achieved after 36 hours. Before this is achieved, the plant should not be in operation. Do not insulate a plant that is in operation, or work in strong sunlight conditions. Wait for 36 hours before applying any coatings (exception: Armafinish® 99), adhesive tapes, coverings or the like.

### Property | Value/Assessment | Special Remark
--- | --- | ---
**Temperature Range** |  
Maximum service temperature: + 60 °C  
Minimum service temperature: - 50 °C |  
**Yield**  
Minimum consumption with the adhesive applied to both surfaces:  
Armaflex® tubes (thickness > consumption unslit > consumption slit):  
10 mm > 1120 m² > 140 m²;  
For the Sheet, consumption is 3 square meters of the adhesive per litre |  
Flash Point | < 5 °C |  
Hazard Identification | Highly flammable, Heating may cause explosion, Vapor may cause respiratory irritation, Splash may cause eye and skin irritation |  
Resistance to Weathering | Very good |  
Pre-treatment of Surface to be Bonded | Clean all surfaces to be bonded with Armafinish® Cleaner. Compatibility with bases: very good adhesion to metallic base. The compatibility of the adhesive with color-coated surfaces needs to be tested. Incompatible with: Asphalt, bitumen or red lead paint (inseed oil based). |  
Transport Class | 3.2 – LIMITED QUANTITIES |  
Recycling | Dispose waste according to applicable local, state and federal regulations. European Waste Catalogue; Recycling Nr: EAK 089499 Adhesives and sealants containing organic solvents or other dangerous substances. Note: The waste classification may change depending on the application area. Please review EC-directive 2001/118/EC. |  
Working Time | at 20 °C:  
1. Wet adhesion time: up to 2 minutes  
2. Minimum drying time (airing time): 3-5 minutes |  
Before operations, the setting time should be allowed to elapse. |
## Armaflex® self-adhesive tapes

<table>
<thead>
<tr>
<th>Code</th>
<th>Colour</th>
<th>Width [mm]</th>
<th>Length [m]</th>
<th>Thickness [mm]</th>
<th>Rolls/carton</th>
</tr>
</thead>
<tbody>
<tr>
<td>AS-ATAPEC1T-9M</td>
<td>black</td>
<td>50.0</td>
<td>9.14</td>
<td>3</td>
<td>24</td>
</tr>
<tr>
<td>AS-ATAPECOB9M</td>
<td>black</td>
<td>50.0</td>
<td>9.14</td>
<td>3</td>
<td>24</td>
</tr>
<tr>
<td>HT-TAPE</td>
<td>black</td>
<td>50.0</td>
<td>15</td>
<td>3</td>
<td>12</td>
</tr>
<tr>
<td>MC-03005CS-9.14-T</td>
<td>black</td>
<td>50.0</td>
<td>9.14</td>
<td>3</td>
<td>12</td>
</tr>
<tr>
<td>NH-TAPE</td>
<td>black</td>
<td>50.0</td>
<td>15</td>
<td>3</td>
<td>12</td>
</tr>
</tbody>
</table>

## Armaflex® adhesives

<table>
<thead>
<tr>
<th>Code</th>
<th>Article description</th>
<th>cans/carton</th>
</tr>
</thead>
<tbody>
<tr>
<td>ADH-HT625/1,0</td>
<td>Armaflex® HT625 one-component adhesive, 1.0 litre cans</td>
<td>12</td>
</tr>
<tr>
<td>ADH820-700 ML-SE</td>
<td>Armaflex® 820 adhesive, 0.7 litre cans</td>
<td>12</td>
</tr>
<tr>
<td>AS-AD-5201G</td>
<td>Armaflex® 520 adhesive, 3.78 litre cans</td>
<td>4</td>
</tr>
</tbody>
</table>

## Armaflex® tool accessories

<table>
<thead>
<tr>
<th>Code</th>
<th>Article description</th>
<th>Pieces/carton</th>
</tr>
</thead>
<tbody>
<tr>
<td>CUTTING-SET</td>
<td>Armaflex® knife-set (3 knives + 1 sharpening stone)</td>
<td>1</td>
</tr>
<tr>
<td>GLUEM-BRUSH11MM</td>
<td>Gluemaster extra brush points with cap (11mm diameter)</td>
<td>5x4</td>
</tr>
<tr>
<td>GLUEM-BRUSH17MM</td>
<td>Gluemaster extra brush points with cap (17mm diameter)</td>
<td>5x4</td>
</tr>
<tr>
<td>GLUEMASTER B</td>
<td>Armaflex® Gluemaster (adhesive pump)</td>
<td>12</td>
</tr>
</tbody>
</table>