ArmaFlex® 520

TRIED & TESTED FOR SUPERIOR ARMAFLEX RELIABILITY

- Fast drying contact adhesive
- Specially formulated for Armaflex® insulation
- Ensures reliable vapour-tight seal
- For operating temperatures up to +105 °C
- One-component industrial adhesive
- Low viscosity, air drying adhesive

Specially formulated adhesive for insulating Armaflex insulation.

<table>
<thead>
<tr>
<th>Material type</th>
<th>Contact adhesive on polychloroprene basis, free of aromatic components.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Colour</td>
<td>Beige</td>
</tr>
<tr>
<td>Material special info</td>
<td>Liquid</td>
</tr>
<tr>
<td>Applications</td>
<td>Gluing of all flexible ArmaFlex insulation materials (except HT/ArmaFlex &amp; ArmaFlex Ultima).</td>
</tr>
<tr>
<td>Special features</td>
<td>Specially formulated adhesive for uniform and safe seam bonding of ArmaFlex insulation materials.</td>
</tr>
<tr>
<td>Assembly</td>
<td>Application temperature: ideally +20°C, not below 0°C. At temperatures below +5°C or high humidity approx above 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 by using absorbent paper (blotting or crepe paper). Work should not be carried out on operating plant or areas exposed to strong sunlight. Shake and stir well before use. Apply thinly to the areas to be bonded with a brush or spatula. For contact adhesion press together with force during the contact adhesion time. Detailed application guidance is available.</td>
</tr>
<tr>
<td>Remarks</td>
<td>The adhesive achieves its final strength after 36 hours. Only then should plant be put into operation. Never insulate plant which is in operation or work in strong sunlight. Wait 36 hours before applying coatings (exception: ArmaFinish 99), adhesive tape, coverings etc.</td>
</tr>
</tbody>
</table>
## Temperature Range

<table>
<thead>
<tr>
<th>Max service temperature</th>
<th>+105°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Min service temperature</td>
<td>-50°C (for temperatures below -50 °C please contact our technical department)</td>
</tr>
</tbody>
</table>

## Performance

### Coverage (guidance only)

Minimum consumption with the adhesive applied to both surfaces:

- **ArmaFlex tubes** (thickness > consumption unslit > consumption slit):
  - 10mm > 1,120m per litre > 140m per litre
  - 20mm > 280m per litre > 70m per litre
  - 30mm > 175m per litre > 45m per litre
  - 40mm > 130m per litre > 35m per litre

- **ArmaFlex Sheets**
  - 3-4 m² per litre

## Storage & shelf life

12 months. Store as cool as possible but protected from frost. In the event of frost any gelification is reversible on warming.

## Preparation of surfaces

Clean surfaces and ArmaFlex Ultima surface with Armaflex Cleaner.

Compatibility with bases:
- Very good adhesion to metallic surfaces.
- The adhesive's compatibility with colour coated surfaces needs to be tested.
- Incompatible with asphalt, bitumen and red lead (linseed oil-based)

## Working time at 20 °C

- **Wet adhesion time**: Up to 2 minutes
- **Drying time**: 3-5 mins
- **Contact adhesion**: 15 - 20 mins
- **Setting**: 36 hours

The open time depends on the quantity as well as indoor climate conditions. Before operating plant the setting time needs to be allowed to elapse.

## Other technical features

- **Flash point**: approx -20 °C
- **Explosion limits**: Lower: approx 1 Vol %, Upper: approx 13 Vol %
- **Hazard class**: Highly flammable, Regulation of inflammable liquids.
- **Ageing stability**: Very good
- **Resistance to weathering**: Very good
- **Recycling**: Allocation of a waste code number, according to the European Waste Catalogue, should be carried out in agreement with the regional waste disposal company. For details see relevant Safety Data Sheet. Packaging must be emptied of all residues. Packaging with traces of cured product can be recycled. Packaging with uncured product must be recycled into new product.

## Transport classes

Depending on the type of transport

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### ARMAFLEX 520

<table>
<thead>
<tr>
<th>Code</th>
<th>Description</th>
<th>Pieces/carton</th>
<th>£/pc</th>
</tr>
</thead>
<tbody>
<tr>
<td>ADH-520/0.25E</td>
<td>ArmaFlex 520 0.25 Litre can with brush</td>
<td>24</td>
<td>8.82</td>
</tr>
<tr>
<td>ADH-520/0.5E</td>
<td>ArmaFlex 520 0.5 Litre can</td>
<td>12</td>
<td>15.20</td>
</tr>
<tr>
<td>ADH-520/1.0E</td>
<td>ArmaFlex 520 1.0 Litre can</td>
<td>12</td>
<td>25.67</td>
</tr>
<tr>
<td>ADH-520/2.5E</td>
<td>ArmaFlex 520 2.5 Litre can</td>
<td>8</td>
<td>64.19</td>
</tr>
</tbody>
</table>