

Armaflex®
520 Adhesive

PROFESSIONAL ADHESIVE FOR
ARMAFLEX® INSTALLATION



- Easy to apply and dries quickly
- Ensures high strength, vapour-tight joints
- Specially formulated for Armaflex® insulation
- For operating temperatures up to +105 °C

Technical Data - Armaflex 520 [Adhesive]

| | |
|------------------------------|---|
| Brief description | Special adhesive for installing all flexible Armaflex insulation materials (with the exception of HT/Armaflex). |
| 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 exception of HT/Armaflex. |
| Special Features | Specially formulated adhesive for uniform and safe seam bonding of flexible Armaflex insulation materials. |
| Assembly | <p>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.</p> <p>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.</p> |
| Remarks | The adhesive achieves its final strength after 36 hours. Only then should the plant be taken into operation. Never insulate a plant which is in operation or work in strong sunlight. Wait 36 hours before applying coatings (exception: Armafinish 99), adhesive tape, coverings etc. |

| Property | Value/Assessment | Special Remark |
|--|--|--|
| Temperature Range | | |
| Temperature Range | max. service temperature + 105 °C min. service temperature ¹ - 50 °C | |
| Yield | Minimum consumption with the adhesive applied to both surfaces: Armaflex tubes (thickness > consumption unslotted > consumption slotted): 10 mm > 1120 m/l > 140 m/l; 20 mm > 280 m/l > 70 m/l; 30 mm > 175 m/l > 45 m/l; 40 mm > 130 m/l > 35 m/l; Sheets: 3-4 m ² /l | |
| Other technical features | | |
| Storage & Shelf life | 12 months in a closed (unopened) container in a dry, cool, well ventilated place. | In a cool, but frost-free place. Jellification due to frost is reversible. |
| Flash Point | approx. - 20 °C | |
| Explosion limits | Lower: approx. 1,0 Vol.%; Upper: approx. 13,0 Vol. % | |
| Hazard Class | VbF A1, highly flammable | Regulation of inflammable liquids |
| Ageing stability | Very good | |
| Resistance to weathering | Very good | |
| 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 read lead paint (inseed oil based). | For more information pls. see Technical Bulletin no. 17. |
| Transport Classes | Depending on the type of transport | |
| Recycling | Recycling Nr: EAK 080409 Adhesives and sealants containing organic solvents or other dangerous substances. Note: The waste classification can change depending on the application area. Please observe EC-directive 2001/118/EC. | Can need to be empty. Empty cans can be recycled. Cans with remaining adhesive have to be recycled as the product. |
| 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 | Before operation time the setting time need to be allowed to elapse. |

1. 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. 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 guarantee proper installation.

Armacell India Pvt Ltd
 GAT No. 744-745, Village Lonikhand, Pune Nagar Road • 412 216 Pune • Maharashtra • India
 Phone +91 20 66782000 • Fax +91 20 66782020
 www.armacell.com • info.imea@armacell.com

IPDS-0055-130209-en(WW)