

SOLUTIONS FOR ENERGY SAVINGS

ArmaFlex

HT625 Adhesive

A contact adhesive especially designed to bond ArmaFlex insulation to pipes and tanks at higher temperatures of up to 300° F

// Recommended for use with ArmaFlex UT insulation
// Thermally stable up to +300° F (150° C)
// Bonds well to metallic surfaces
// For joining insulation for higher temperature environments

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TECHNICAL DATA - ARMAFLEX HT625 ADHESIVE

Brief description	This adhesive is specifically designed for adhering all Armacell Insulation materials. Thermally stable up to 300° F (150° C). This product will bond well to metallic base. Check the compatibility and adhesive properties before applying to painted or lacquered surfaces.
Product color range	Yellowish
Product range	0.5 Liter container size.
Installation	Clean soiled surfaces and insulating materials with a non-oily solvent such as denatured alcohol. Apply a thin uniform layer of adhesive to both surfaces to be bonded. Allow the volatile materials of the applied adhesive to evaporate being careful of the short evaporation time. Allow the adhesive to come to tack (when adhesive will no longer stick to your fingernail when touched). Precisely join surfaces to be glued and press together with slight pressure. Keep container tightly closed and mix well before using again. Please follow the instructions for use carefully.

Property	Value / Assessment				Standard / Test method
Temperature range					
Service temperature	Min. °C	Min. °F	Max. °C	Max. °F	
	-50	-58	150	300	
	Remarks	For applications above 150°C (300°F), contact Armacell technical team. For applications below -50°C (-58°F), contact Armacell technical team.			
Health and environment					
Volatile organic compounds (VOC) content	670 g/L				
Other technical features					
Application conditions	Ideally between 60°F and 70°F (15°C and 20°C). Not below 40°F (4°C) Apply a thin layer of adhesive to both surfaces to be adhered. Allow to tack and join both surfaces with firm pressure. Allow to cure a minimum of 36 hours. See Application Manual for additional instructions. ArmaFlex contact adhesives are solvent-based; solvents in the adhesive can adversely affect plastic piping or any plastic substrate. Armacell contact adhesives should not be used directly on plastic pipes or any plastic substrate. If adhesive does come in contact with the plastic substrate, it is highly recommended to wipe the surface immediately with a wet, clean cloth and allow it to dry. Inspect the plastic substrate after it has dried to ensure no damage has occurred. If damaged, it is best practice to replace the damaged substrate.				
Coverage	0.5-liter container will provide single coat coverage for 26 square feet.				
Cure time[1]	36 hours				
Shelf life	1-1/2 years in original unopened, sealed container.				
Storage	Store in a cool, dry, well ventilated place and temperatures below 100°F. Gelling due to freezing is fully reversible when the material is thoroughly mixed.				
Tack time	3-5 minutes under normal conditions.				
Wet flash point	Below -4°F (-20°C) (TOC).				

[1] The adhesive will not reach full strength for 36 hours. Do not start the system before this curing is complete. Do not use HT 625 Adhesive on systems that are already in operation or when exposed to direct sunlight. Wait 36 hours before coating, taping or covering with jacketing except when using ArmaClad Arma-Chek coating.

All data and technical information are based on results achieved under the specific conditions defined according to the testing standards referenced. Despite taking every precaution to ensure that said data and technical information are up to date, Armacell does not make any representation or warranty, express or implied, as to the accuracy, content or completeness of said data and technical information. Armacell also does not assume any liability towards any person resulting from the use of said data or technical information. Armacell reserves the right to revoke, modify or amend this document at any moment. It is the customer's responsibility to verify if the product is suitable for the intended application. The responsibility for professional and correct installation and compliance with relevant building regulations lies with the customer. This document does not constitute nor is part of a legal offer to sell or to contract.

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ABOUT ARMACELL

As the inventor of flexible foam for equipment insulation and a leading provider of engineered foams, Armacell develops innovative and safe thermal and mechanical insulation solutions that create sustainable value for its customers. Armacell's products significantly contribute to driving energy efficiency worldwide. With more than 3,100 employees and 26 production plants in 20 countries, Armacell operates two main businesses, Advanced Insulation and Engineered Foams. Armacell focuses on insulation materials for technical equipment, high-performance foams for acoustic and lightweight applications, recycled PET products, next-generation aerogel technology and passive fire protection systems.

For more information, please visit:
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