

SOLUTIONS FOR ENERGY SAVINGS

ArmaFlex
520 Adhesive

An air-drying contact adhesive specifically designed for use with ArmaFlex insulation products.

// The original contact adhesive for ArmaFlex insulation
// Years of on-the-job performance
// Meets MIL-A-24179A and Amend-2

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TECHNICAL DATA - ARMAFLEX 520 ADHESIVE

Brief description	A special air-drying contact adhesive that is required for joining the seams and butt joints of ArmaFlex Pipe and Sheet Insulations as well as adhering ArmaFlex to ducts, tanks, chillers and other equipment / vessels.
Material type	Synthetic rubber base with synthetic resins and fillers added; hydrocarbon- and ketone-type solvents.
Product color range	Greenish yellow
Product range	Half-pint and pint brush-top cans and pint, quart, and gallon containers.

Approvals and compliance

Specification compliance	• Armacell North America's quality management systems are certified as being in conformity with ISO 9001 by Intertek	• ASTM G21/C1338	• MIL-A-24179A Type II, Class 1

Property	Value / Assessment				Standard / Test method
Temperature range					
Service temperature	Min. °C	Min. °F	Max. °C	Max. °F	
	-50	-58	120	250	
	Remarks	120 °C (250 °F) — ArmaFlex pipe insulation seams and joints 82 °C (180 °F) — Full bonding sheet insulation For applications below -50°C (-58°F), contact Armacell technical team.			
Fire Performance and Approvals					
Surface burning characteristics[1]	Flame spread and smoke development index: 25/50 rated				ASTM E84
Health and environment					
Volatile organic compounds (VOC) content	615 g/l				
Other technical features					
Application conditions	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.				
Bond time	Immediate after allowing for tack time.				
Cure time	36 hours				
Shelf life	1-1/2 years in original sealed container.				
Solids content	Approximately 19% by weight.				
Storage	Store in a well ventilated area with storage temperature 60° F to 80° F (16° C to 27° C).				
Tack time	1–5 minutes depending on ambient conditions.				
Wet flash point	-15°F (-26°C) (TOC).				
Yield	200 sq ft per gallon (18.5 m^2/gallon or 5 m^2/l) max, single coat (depending upon porosity of materials bonded and air temperature).				

[1] ASTM E84 performance is for adhesive in the dry state.

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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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