

Armaflex® 520 Adhesive

THE ADHESIVE FOR SUPERIOR
ARMAFLEX® INSTALLATIONS



- Fast drying adhesive solution
- Ensures reliable vapour-tight joints
- Specially formulated for Armaflex® insulation
- For operating temperatures up to +105 °C

Technical Data - Armaflex 520

Brief description	Specially formulated adhesive for installing 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 the exception of HT/Armaflex.
Special Features	Specially formulated adhesive for uniform and safe seam bonding of flexible Armaflex insulation materials.
Assembly	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 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.
Remarks	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 further coats (exception: Armafinish 99), adhesive tape, coverings etc.

Property	Value/Assessment	Special Remarks
Temperature Range		
Temperature Range	Max. service temperature + 105 °C Min. service temperature ¹ - 50 °C	
Other technical features		
Yield	Minimum consumption with the adhesive applied to both surfaces: Armaflex tubes (thickness > consumption unslit > consumption slit): 10 mm > 1120 m per litre > 140 m per litre; 20 mm > 280 m per litre > 70 m per litre; 30 mm > 175 m per litre > 45 m per litre; 40 mm > 130 m per litre > 35 m per litre; Sheets: 3-4 m ² per litre	These figures are a guide only.
Storage & Shelf life	Approx. 1 year	In a cool, frost-free place. Gelification due to frost is reversible.
Flash Point	approx. - 20 °C	
Explosion limits	Lower: approx. 1.0 Vol.%; Upper: approx. 13.0 Vol. %	
Hazard Class	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 surfaces. The compatibility with colour coated surfaces needs to be tested. Incompatible with: Asphalt, bitumen or red lead paint (linseed oil based).	For more information pls. see Technical Bulletin no. 17.
Transport Classes	Dependent on transport sector	
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. More details see relevant Safety Data Sheet.	Can must be emptied prior to recycling. Cans containing adhesive must be recycled into new product.
Working time	at 20 °C: 1. Wet adhesion time: up to 2 minutes 2. Minimum drying time (airing time): 3-5 minutes 3. Contact adhesion time: 15-20 minutes 4. Setting time: 36 hours	The setting time must be allowed to lapse before plant can be operated.

1. For temperatures below -50 °C please contact our Technical Department to request the corresponding technical information.

All statements and technical information are based on results obtained under typical conditions. It is the responsibility of the recipient to verify with us that the information is appropriate for the specific use intended. Installation instructions are given in our Armaflex installation manual. With some refrigerants the discharge temperature may exceed +110 °C, please consult our Technical Department for further information. Armaflex 520 adhesive must be used to guarantee correct installation.