

Armaflex® HT625 Adhesive

THE ADHESIVE FOR SUPERIOR
ARMAFLEX® SYSTEM RELIABILITY IN
HIGH TEMPERATURE & SOLAR
APPLICATIONS



- Specially formulated for wide range of temperatures and applications
- Easy application
- Superior, water-tight bonding of HT/Armaflex® and Armaflex® DuoSolar insulation systems
- For operating temperatures up to +150 °C

Technical Data - Armaflex HT625

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|------------------------------|---|
| Brief description | Specially formulated one-component adhesive developed for bonding Armaflex insulation applied at high temperatures, especially developed for use with HT/Armaflex, but also suitable for all other Armaflex synthetic rubber based insulation materials. |
| Material type | Contact adhesive on polychloroprene basis, free of aromatic components. |
| Colour | Beige |
| Material Special Information | Liquid |
| Applications | Application on pipes and tanks with service temperatures up to 150 °C. Gluing of HT/Armaflex insulation material and other Armaflex synthetic rubber based insulation materials (except Armaflex Ultima). |
| Special Features | Specially formulated adhesive for uniform and safe seam bonding of flexible Armaflex insulation materials applied on high temperature lines. |
| 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 layers. In these cases bonding is poor or impossible. This can be tested 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. Wait 36 hours before applying coatings (exception: Armafinish 99), adhesive tape, coverings etc. |

| Property | Value/Assessment | Special Remarks |
|--|---|---|
| Temperature Range | | |
| Temperature Range | Max. service temperature ¹ + 150 °C Min. service temperature ² -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 | 12 months in a closed (unopened) container . Do not store together with: explosive substances; spontaneously combusting substances. | In a cool, frost-free place. Gelification due to frost is reversible. |
| Flash Point | approx. -26 °C | |
| Explosion limits | Lower: approx. 1,1 Vol.% Upper: approx. 12,8 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. 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. Minimum drying time (airing time): 3-5 minutes 2. Contact adhesion time: 15-20 minutes 3. Setting time: 36 hours | The setting time must be allowed to lapse before plant can be operated. |

1. For temperatures above +150 °C please contact our Technical Department to request the corresponding technical information.

2. 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. Armaflex HT625 adhesive must be used to guarantee correct installation.