

Technical Data - Armaflex 520

Brief description	Special adhesive for installing all flexible Armaflex insulation materials (with the exception of Armaflex EPDM-based products). See also "Overview Adhesive Application".
Material type	Contact adhesive on polychloroprene basis, free of aromatic solvent.
Colour	Beige
Material Special Information	Liquid
Applications	Gluing flexible Armaflex insulation materials (see above).
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 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 working plants or areas exposed to strong sunlight.</p> <p>Shake and stir well before use. Apply thinly to the areas to be bonded with a brush or spatula. In case of contact adhesion press together with force during the contact adhesion time. Extensive guidance for application are available.</p>
Remarks	The adhesive achieves its final strength after 36 hours. Only then should plant be put 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	
Other technical features		
Yield	<p>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;</p> <p>Sheets: 3-4 m² /l</p>	These figures are a guide only.
Storage & Shelf life	18 months in a closed (unopened) container in a dry, cool, well ventilated place. Do not store together with: explosive substances; spontaneously combusting substances.	In a cool, but frost-free place. Jellification due to frost is reversible.
Flash Point	approx. - 15 °C	
Hazard Statement	highly flammable liquid and vapour	For more information pls. see EC Safety Data Sheet.
Ageing stability	Very good	
Resistance to weathering	Very good	
Pre-treatment of surface to be bonded.	<p>Clean dirty surfaces and the Armaflex surface with Armaflex Cleaner.</p> <p>Compatibility with bases: very good adhesion to metallic base. The compatibility with colour coated surfaces with adhesive needs to be tested.</p> <p>Incompatible with: Asphalt, bitumen or red lead paint (inseed oil based).</p>	For more information pls. see Technical Bulletin no. 17.
Transport Classes	Depending on the type of transport	
Disposal considerations	<p>Allocation of a waste code number, according to the European Waste Catalogue, should be carried out in agreement with the regional waste disposal company.</p> <p>Packaging must be emptied of all residues. Packaging with traces of cured product can be re-cycled. Packaging with uncured product must be disposed of in the same manner as the medium.</p>	
Working time	<p>at 20 °C:</p> <ol style="list-style-type: none"> 1. Minimum drying time (airing time): 3-5 minutes 2. Contact adhesion time: 15-20 minutes 3. Setting time: 36 hours 	The open time depends on the quantity as well as indoor climate conditions. Before operation time the setting time needs 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 sales representatives for further information. Armaflex 520 adhesive and Clipse must be used to guarantee proper installation.