

# Armaflex® 520 Adhesive

THE ADHESIVE FOR SUPERIOR  
ARMAFLEX® SYSTEM RELIABILITY



- Easy application
  - Fast drying of the seams
  - Specially formulated for Armaflex® insulation
  - Ensures reliable vapour-tight joints
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- For operating temperatures up to +105 °C
  - One-component industrial adhesive
  - Low viscosity, air drying adhesive

# Technical Data - Armaflex 520 [Adhesive]

Brief description	Special adhesive for installing all flexible 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 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 this cases bonding is bad or impossible. This can be tested by using absorbent paper (blotting or crepe paper). Work should not be carried out on working plants or areas exposed to strong sunlight.	
	Shake and stir well before use. Apply thinly to the places to be bonded with a brush or spatula. In case of contact adhesion press together with force during the contact adhesion time. Extensive notes for application are available.	
Remarks	The adhesive achieves its final strength after 36 hours. Only then should the plant be taken 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 <sup>1</sup>	- 50 °C
Other technical features		
Yield	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;  Sheets: 3-4 m <sup>2</sup> /l	
Storage & Shelf life	12 months in a closed (unopened) container in a dry, cool, well ventilated place.	In a cool, but frost-free place. Jellification due to frost is reversible.
Flash Point	approx. - 20 °C	
Explosion limits	Lower: approx. 1,0 Vol.%; Upper: approx. 13,0 Vol. %	
Hazard Class	VbF Al, 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 base. The compatibility with colour coated surfaces with adhesive needs to be tested.  Incompatible with: Asphalt, bitumen or read lead paint (inseed oil based).	
Transport Classes	Depending on the type of transport	
Recycling	Recycling Nr: EAK 080409 Adhesives and sealants containing organic solvents or other dangerous substances. Note: The waste classification can change depending on the application area. Please observe EC-directive 2001/118/EC.	Can need to be empty. Empty cans can be recycled. Cans with remaining adhesive have to be recycled as the 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	Before operation time the setting time need 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 Customer Service Center for further information. Armaflex 520 adhesive must be used to guarantee proper installation.

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