

**Armaflex®**  
520 Adhesive

PROFESSIONAL ADHESIVE FOR  
ARMAFLEX® INSTALLATION



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

## Technical Data - Armaflex 520

Brief description	Special adhesive for installing all flexible Armaflex insulation materials (with the exception of HT/Armaflex and Armaflex Ultima).
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 and Armaflex Ultima.
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, adhesive tape, coverings etc.

Property	Value/Assessment	Special Remark
<b>Temperature Range</b>		
Temperature Range	max. service temperature + 105 °C min. service temperature <sup>1</sup> - 50 °C	
<b>Other technical features</b>		
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	These figures are a guide only.
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 A1, 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 red lead paint (inseed oil based).	For more information pls. see Technical Bulletin no. 17.
Transport Classes	Please refer to Safety Data Sheet	
Recycling	Dispose waste according to applicable local, state and federal regulations.  European Waste Catalogue: EWC No. 08 04 09 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.	Packaging must be emptied of all residues. Packaging with traces of cured product can be recycled. Packaging with uncured product must be disposed of in the same manner as the medium.
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 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 Customer Service Center for further information. Armaflex 520 adhesive must be used to guarantee proper installation.



