

## TECHNICAL DATA - ARMAFLEX 520 ADHESIVE

Brief description	ArmaFlex 520 adhesive is a quick drying contact adhesive specially formulated for uniform and safe seam bonding for ArmaFlex insulation materials (except ArmaFlex Ultima and HT/ArmaFlex). It is low viscosity for ease of use. When applied to clean surfaces and fully cured, it maintains high resistance to water vapour ingress.
Material type	Contact adhesive on polychloroprene basis, and free of aromatic solvent.
Colour	Yellow.
Installation	Please observe our installation instructions / product data. Ideal application temperature: +20 °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 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 in 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 in operation or work in strong sunlight. Wait for 36 hours to pass before applying coatings (exception: ArmaFinish 99), adhesive tape, or coverings.

Property	Value/Assessment	Standard/Test method
<b>Temperature range</b>		
Service temperature	Range	Minimum [°C]      Maximum+ [°C]
	Full range	-50      +105
<b>Other technical features</b>		
Pre-treatment of surface to be bonded	Clean all surfaces to be bonded with ArmaFlex cleaner. Compatibility with bases: very good adhesion to metal base. The compatibility with colour-coated surfaces needs to be tested. Incompatible with Asphalt, bitumen and red lead paint (inseed oil-based).	For more information, refer to Technical Bulletin No. 17.
Yield	Minimum consumption with adhesive applied to both surfaces. These figures are a guide only. ArmaFlex tubes (thickness > consumption unslit > consumption slilit): 13 mm > 840 m/l > 115 m/l; 19 mm > 280 m/l > 70 m/l; 25 mm > 230 m/l > 58 m/l; 40 mm > 130 m/l > 35 m/l  Sheets: 3-4 m <sup>2</sup> /l	
Working time	At +20 °C: Minimum drying time (airing time): 3 - 5 minutes Contact adhesion time: 15 - 20 minutes Setting time: 36 hours	
Hazard class	Highly flammable	Regulation of inflammable liquids
Shelf life	Up to 18 months from the manufacturing date when stored in original, unopened containers, in the recommended storage conditions.	
Storage	Store in a cool, dry and frost-free place, out of direct sunlight and away from all sources of ignition. Storage areas must be well-ventilated and comply with local, state and federal regulations. For maximum shelf life, store between +5 °C and +20 °C. Jellification due to frost is reversible.	
Disposal	Dispose waste according to applicable local, state and federal regulations. 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.	

1. For temperatures beyond the identified temperature range, please contact Armacell's Technical Department for more 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 our Technical department in due time whether or not the data and information apply to the intended application area.

### Accessories

Item	Carton content	Article description
AS-AD5201E	4 x 3.78 litre cans	ArmaFlex 520 adhesive (1 gallon)