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ArmaFlex

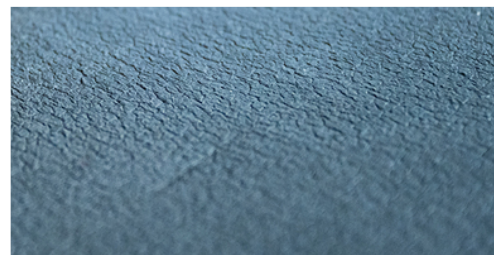
HT625 adhesive

The adhesive for superior ArmaFlex system reliability in high temperature and solar applications

// One-component adhesive

// Developed to bond ArmaFlex insulation applied on high temperatures

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TECHNICAL DATA - ARMAFLEX HT625 ADHESIVE

| | |
|---------------------------------|--|
| Brief description | Special adhesive developed for high temperature applications, especially for ArmaFlex EPDM-based products (e.g. HT/ArmaFlex). See also "Overview ArmaFlex Adhesives". |
| Material type | Contact adhesive on polychloroprene basis, free of aromatic solvents. |
| Additional material information | Liquid |
| Product colour range | Beige |
| Special features | Specially formulated adhesive for uniform and safe seam bonding of flexible ArmaFlex insulation materials. |
| Applications | Work should not be carried out on plants in operation or areas exposed to strong sunlight. Stir the adhesive with a brush well before use. Apply thinly with a brush or spatula to the areas to be bonded. In case of contact adhesion press together with force during the contact adhesion time. For further details see extensive ArmaFlex Application Manual. |
| Installation | Clean dirty surfaces and the ArmaFlex surface with ArmaFlex Cleaner before starting the application with the adhesive. 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). |
| Remarks | Setting time of the adhesive is 36 hours. Only then should the plant be put into operation. Wait 36 hours before applying coatings (exception: Armafinish 99), adhesive tape, coverings etc. |

| Property | Value / Assessment | | Standard / Test method |
|--|---|----------------------|--------------------------|
| Temperature range | | | |
| Service temperature | Min. °C ¹ | Max. °C ² | |
| | -50 | 150 | |
| Weather and UV resistance | | | |
| Weather resistance | Very good | | |
| Health and environment | | | |
| Volatile organic compounds (VOC) content | Fulfills all VOC requirements (French, Italian, Belgian, German AgBB, EMI CODE and Eurofins Indoor air Comfort GOLD). | | ISO 16000 Parts 3, 6 & 9 |
| Health aspects | MSDS available on request. | | |
| Green building assessment | Meets the sustainable construction requirements for BREEAM international and DGNB. | | |
| Other technical features | | | |
| Application conditions | Application temperature: ideally + 20 °C, not below 0 °C. At temperatures below + 5 °C or high relative humidity (above approx. 80%), increased condensation may form on the surfaces of the glued or adhesive films. In these cases, bonding is difficult or impossible. This can be tested using absorbent paper (blotting or crepe paper). | | |
| Disposal and 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. Residuals must be removed from packaging and when emptied completely disposed of in accordance with the regulations for waste removal. Incompletely emptied packaging must be disposed of in the form of disposal specified by the regional disposer. More details see relevant Safety Data Sheet. | | |
| Explosion limits | Lower: 1,0 Vol.% Upper: 12,8 Vol.% | | |
| Flash point | approx. - 26 °C | | |
| Hazard class | Highly flammable liquid and vapour | | |
| Shelf life | 18 months | | |
| Solids content | approx. 18 % | | |
| Storage | Material shall be stored in a closed (unopened) container in a dry, cool and well-ventilated place. Do not store together with: explosive substances; spontaneously combusting substances. Jellification due to frost is reversible. | | |
| Working time ³ | at 20 °C: 1. Minimum drying time (airing time): 3-5 minutes 2. Contact adhesion time (open time): 15-20 minutes 3. Setting time: 36 hours | | |
| | The airing and open time depends on the quantity as well as indoor climate conditions. | | |

| Property | Value / Assessment | Standard / Test method |
|----------|--|------------------------|
| Yield | <p>Yield of the adhesive applied to both surfaces:</p> <p>ArmaFlex tubes (thickness > consumption butt joint > consumption butt joint + longitudinal joint):</p> <p>10 mm > 1120 m/l > 140 m/l</p> <p>20 mm > 280 m/l > 70 m/l</p> <p>30 mm > 175 m/l > 45 m/l</p> <p>40 mm > 130 m/l > 35 m/l</p> <p>ArmaFlex sheets: 3-4 m² /l</p> <p>These figures are a guide only.</p> | |

¹For temperatures below -50 °C please contact our Customer Service Center to request for the corresponding technical information.

²For temperatures above +150 °C please contact our Customer Service Centre to request for the corresponding technical information.

³The full adhesion of the adhesive is achieved after 168 h.

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Adhesive and cleaner | ArmaFlex HT625 Adhesive (EMEA) | TDS | 012025 | en-GB

ABOUT ARMACELL

As the inventor of flexible foam for equipment insulation and a leading provider of engineered foams, Armacell develops innovative and safe thermal and mechanical solutions that create sustainable value for its customers. Armacell's products significantly contribute to global energy efficiency making a difference around the world every day. With more than 3,300 employees and 25 production plants in 19 countries, the company operates two main businesses, Advanced Insulation and Engineered Foams. Armacell focuses on insulation materials for technical equipment, high-performance foams for acoustic and lightweight applications, recycled PET products, next-generation aerogel technology and passive fire protection systems.



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