

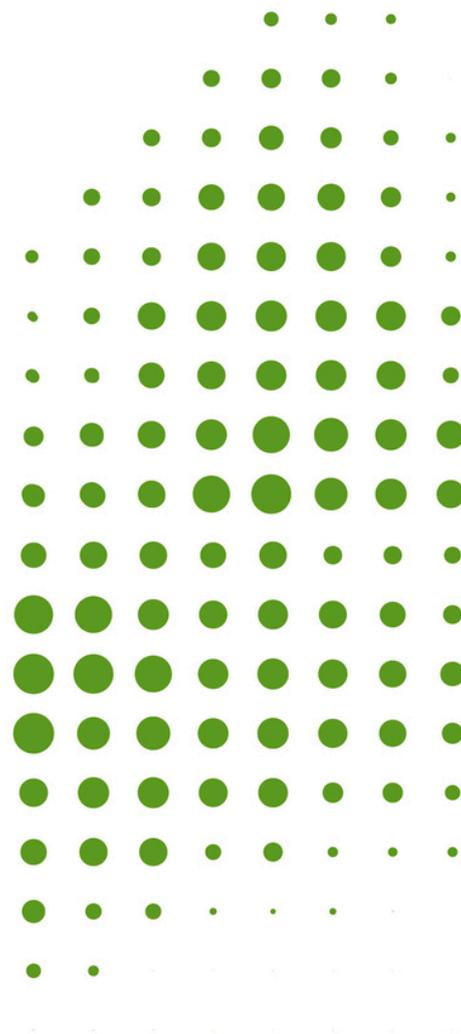
INSTALL IT. TRUST IT.

# ArmaFlex 525 adhesive

Special adhesive for next generation of  
ArmaFlex elastomeric insulation

- // Fast drying adhesive solution
- // Ensures reliable vapour-tight joints
- // Specially formulated for ArmaFlex insulation
- // For operating temperatures up to +105 °C

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 **armacell**<sup>®</sup>  
ArmaFlex<sup>®</sup>



## TECHNICAL DATA - ARMAFLEX 525 ADHESIVE

Brief description	Special premium adhesive for installing the next generation of flexible ArmaFlex insulation materials (e.g. AF/ArmaFlex Evo). See also "Overview ArmaFlex Adhesives".
Material type	Contact adhesive on polychloroprene basis, free of aromatic components.
Additional material information	Liquid
Product colour range	Beige
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
<b>Temperature range</b>		
Service temperature	Min. °C <sup>1</sup>	Max. °C
	-50	110
<b>Weather and UV resistance</b>		
Weather resistance	Very good.	
<b>Health and environment</b>		
Volatile organic compounds (VOC) content	Fulfills all VOC requirements (French, Italian, Belgian, German AgBB, EMICODE 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.	
<b>Other technical features</b>		
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 <sup>2</sup>	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	Yield of the adhesive applied to both surfaces: ArmaFlex tubes (thickness > consumption butt joint > consumption butt joint + longitudinal joint): 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 ArmaFlex sheets: 7-9 m <sup>2</sup> /l These figures are a guide only.	

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

<sup>2</sup>The full adhesion of the adhesive is achieved after 168 h.

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## ABOUT ARMACELL

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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.



For more information, please visit:  
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