

# ArmaFlex HT625 adhesive

## THE HIGH TEMPERATURE ADHESIVE FOR USE WITH HT/ARMAFLEX

- Specially formulated for a wide range of temperatures and applications
- Water-tight bonding of HT/ArmaFlex® and ArmaFlex® DuoSolar insulation systems
- For operating temperatures up to +150 °C
- High performance, one component industrial grade adhesive
- Low-viscosity air-drying contact adhesive



<b>ARMAFLEX HT625</b> One-component adhesive for high temperature applications, specifically developed for HT/ArmaFlex installations but also suitable for all ArmaFlex synthetic rubber based insulation materials.	
<b>Material type</b>	Contact adhesive on polychloroprene basis, free of aromatic components.
<b>Colour</b>	Beige
<b>Material special info</b>	Liquid
<b>Applications</b>	Application on pipes and tanks with service temperature up to +150°C. Gluing of HT/ArmaFlex insulation materials and other ArmaFlex synthetic rubber based insulation materials (except ArmaFlex Ultima).
<b>Special features</b>	Specially formulated adhesive for uniform and safe seam bonding of ArmaFlex insulation materials applied on high temperature lines.
<b>Assembly</b>	Please observe our installation instructions/product data sheets. Application temperature: ideally +20°C, not below 0°C. At temperatures below +5°C or high humidity approx above 80%), increased condensation may form on the surfaces to be glued or adhesive films. In these cases bonding is poor or impossible. This can be tested by using absorbent paper (blotting or crepe paper). Work should not be carried out on operating plant or areas exposed to strong sunlight.
<b>Remarks</b>	The adhesive achieves its final strength after 36 hours. Only then should plant be put into operation. Wait 36 hours before applying coatings [exception: ArmaFinish 99], adhesive tape, coverings etc.

Temperature Range	
Max service temperature	+150 °C (For temperatures above +110 °C please contact our technical department)
Min service temperature	-50 °C (For temperatures below -50 °C please contact our technical department)
Performance	
Coverage (guidance only)	<p>Minimum consumption with the adhesive applied to both surfaces: ArmaFlex tubes (thickness &gt; consumption unslit &gt; consumption slit)</p> <ul style="list-style-type: none"> <li>• 10mm &gt; 1120m per litre &gt; 140m per litre</li> <li>• 20mm &gt; 280m per litre &gt; 70m per litre</li> <li>• 30mm &gt; 175m per litre &gt; 45m per litre</li> <li>• 40mm &gt; 130m per litre &gt; 35m per litre</li> </ul> <p>Sheets</p> <ul style="list-style-type: none"> <li>• 3-4 m<sup>2</sup> per litre</li> </ul>
Storage & shelf life	
	<p>12 months in an unopened container. Do not store with explosive substances / spontaneously combusting substances. Store as cool as possible but protected from frost. In the event of frost any gelification is reversible on warming</p>
Preparation of surfaces	
	<p>Clean surfaces and ArmaFlex surface with ArmaFlex Cleaner. Compatibility with bases:</p> <ul style="list-style-type: none"> <li>• Very good adhesion to metallic surfaces.</li> <li>• The adhesive's compatibility with colour coated surfaces needs to be tested.</li> <li>• Incompatible with Asphalt, bitumen and red lead (linseed oil-based)</li> </ul>
Working time	
Drying time	3- 5 mins
Contact adhesion	15 - 20 mins
Setting	36 hours
	The open time depends on the quantity as well as indoor climate conditions. Before operating plant the setting time needs to be allowed to lapse.
Other technical features	
Flash point	approx -26 °C
Explosion limits	Lower: approx 1.1 Vol % Upper: approx 12.8 Vol %
Hazard class	Highly flammable
Ageing stability	Very good
Resistance to weathering	Very good
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. For details see relevant Safety Data Sheet. Packaging must be emptied of all residues. Packaging with traces of cured product can be recycled. Packaging with uncured product must be recycled into new product.
Transport classes	Depending on the type of transport

## ARMAFLEX HT625 ADHESIVE



Code	Description	Pieces/carton	
ADH-HT625/0.25 •	ArmaFlex HT625 one component adhesive, 0.25 Litre can, with brush	40	
ADH-HT625/0.5	ArmaFlex HT625 one component adhesive, 0.5 Litre can, with brush	12	
ADH-HT625/1.0	ArmaFlex HT625 one component adhesive, 1 Litre can, with brush	12	