

Fiber Free

Armaflex® 520 Adhesive

An air-drying contact adhesive that is excellent for joining seams and butt joints of Armaflex Pipe and Sheet Insulations



- Formulated for Armaflex Insulations
- Air-drying contact adhesive
- Years of on-the-job performance
- Meets MIL-A-24179A and Amend-2

 armacell®



Technical Data: Armaflex 520 Adhesive

Description:

An air-drying contact adhesive that is excellent for joining seams and butt joints of Armaflex Pipe and Sheet Insulations

Specifications Compliance:

MIL-A-24179A Amend-2, Type II, Class 1

Approvals, Certifications, Compliances:

• All Armacell facilities in North America are ISO 9001:2008 certified.

Typical Properties

Specifications:	Values
Color:	Light Tan
Net Weight:	6.9 pounds per gallon (828 g/l)
Composition:	Synthetic rubber base with synthetic resins and fillers added; hydrocarbon- and ketone-type solvents.
Volatile Organic Compounds (VOC) Content:	596 g/l
Solids Content	Approximately 22% by weight
Coverage	200 sq ft (5m ² /l) per gallon max, single coat (depending upon porosity of materials bonded and air temperature)
Shelf Life	1-1/2 years in original sealed container; storage temperature 60°F to 80°F (16°C to 27°C)
Temperature Limits	250°F (120°C) — Armaflex Pipe Insulation seams and joints 180°F (82°C) — Full bonding sheet insulation
Tack Time	1-5 minutes depending on ambient conditions
Bond Time	Immediate
Full Cure Time	36 hours
Container Sizes	Half-pint and pint brush-top cans and pint, quart, and gallon containers
Wet Flash Point	Below 20°F (-7°C) (TOC)
Flame Spread and Smoke Developed Index:	25/50 rated ASTM E 84
Minimum Application Temperature:	40°F (4°C)

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