



SOLUTIONS FOR ENERGY SAVINGS

ArmaFlex 520 Adhesive

An air-drying contact adhesive specifically designed for use with ArmaFlex insulation products.

- // The original contact adhesive for ArmaFlex insulation
- // Years of on-the-job performance
- // Meets MIL-A-24179A and Amend-2



 **armacell**[®]
ArmaFlex[®]

TECHNICAL DATA - ARMAFLEX 520 ADHESIVE

Brief description	A special air-drying contact adhesive that is required for joining the seams and butt joints of ArmaFlex Pipe and Sheet Insulations as well as adhering ArmaFlex to ducts, tanks, chillers and other equipment / vessels.
Material type	Synthetic rubber base with synthetic resins and fillers added; hydrocarbon- and ketone-type solvents.
Product color range	Greenish yellow
Product range	Half-pint and pint brush-top cans and pint, quart, and gallon containers.

Approvals and compliance

Specification compliance	<ul style="list-style-type: none"> All Armacell facilities in North America are ISO 9001 certified. ASTM G21/C1338 MIL-A-24179A Type II, Class 1
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Property	Value / Assessment				Standard / Test method
Temperature range					
Service temperature	Min. °C	Min. °F	Max. °C	Max. °F	
	-50	-58	120	250	
Remarks	120 °C (250 °F) — ArmaFlex pipe insulation seams and joints 82 °C (180 °F) — Full bonding sheet insulation For applications below -50°C (-58°F), contact Armacell technical team.				

Fire Performance and Approvals

Surface burning characteristics ¹	Flame spread and smoke development index: 25/50 rated	ASTM E84
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Health and environment

Volatile organic compounds (VOC) content	615 g/l
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Other technical features

Bond time	Immediate after allowing for tack time.
Cure time	36 hours
Shelf life	1-1/2 years in original sealed container.
Solids content	Approximately 19% by weight.
Storage	Store in a well ventilated area with storage temperature 60° F to 80° F (16° C to 27° C).
Tack time	1-5 minutes depending on ambient conditions.
Wet flash point	-15°F (-26°C) (TOC).
Yield	200 sq ft per gallon (18.5 m ² /gallon or 5 m ² /l) max, single coat (depending upon porosity of materials bonded and air temperature).

¹ASTM E84 performance is for adhesive in the dry state.

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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.

For more information, please visit:
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