



**Armaflex®**  
**520 BLV ADHESIVE**

**BLACK, LOW VOC ADHESIVE**

Formulated for Armaflex Insulations

Developed to meet South Coast AQMD

Hexane-free Toluene-free contact adhesive

Proven: no gapping, no tape needed



**Description**

Armaflex® 520 BLV Adhesive is a black, low VOC air-drying contact adhesive that is excellent for joining seams and butt joints of Armaflex Pipe and Sheet Insulations for line temperatures up to 250°F (120°C). No additional tape wrap needed to prevent gapping and moisture infiltration. The adhesive may also be used to apply Armaflex Sheet Insulation to flat or curved metal surfaces that will operate at temperatures up to 180°F (82°C).

- Developed to meet South Coast Air Quality Management District (SCAQMD) Rule 1168.
- Dried film also meets 25/50 flame spread index and smoke developed index requirements of codes and specifications when tested by ASTM E 84 Method

**Uses**

520 BLV Adhesive will make a resilient and heat-resistant bond with many materials where the use of a toluene-free, hexane-free, low VOC, solvent-base rubber contact adhesive is suitable and desirable. Armaflex 520 BLV was developed to meet requirements for reduced emissions of Volatile Organic Compounds. Its black color helps achieve a neater, cleaner finished installation.

It will make a strong resilient bond for sealing laminated aluminum foil and kraft paper vapor retarder jackets.

**Properties**

**Color**

Black

**Net Weight**

6.9 lb per gallon (828 g/l)

**Composition**

Synthetic rubber base with synthetic resins and fillers added; hydrocarbon- and ketone-type solvents. Zero V.O.C. g/l calculated SCAQMD 1168

**Solids Content**

Approximately 30% by weight

**Coverage**

200 sq ft (5m<sup>2</sup>/l) per gallon max, single coat (depending upon porosity of materials bonded and air temperature)

**Shelf Life**

2 years in original sealed container; storage temperature 60°F to 80°F (16°C to 27°C)

**Minimum Drying Time**

3–5 minutes under normal conditions

**Temperature Limits**

250°F (120°C)—Armaflex Pipe Insulation seams and joints  
180°F (82°C)—full-bonding Armaflex Sheet Insulation

**Container Sizes**

Pint brush-top cans and gallon containers

**Fire Performance**

Wet: Flash point below -4°F (-20°C) (TOC)

Dry: ASTM E 84 Method\*

Applied on steel plate

Flame Spread Index . . . . .5

Smoke Developed Index . . . . .15

**DANGER**—Extremely flammable mixture; vapors may cause flash fire; vapors may ignite explosively; prevent buildup of vapors—open all windows and doors—use only with cross ventilation; keep away from heat, sparks, and open flame; do not smoke; extinguish all flames and pilot lights; and turn off stoves, heaters, electric motors, and other sources of ignition during use and until all vapors are gone; close container after use; avoid prolonged breathing of vapor and prolonged contact with skin; do not take internally; keep away from children.

Not for consumer use. Sold only for professional or industrial application.

**Application Instructions**

Mix well contents of the container and apply only to clean, dry, oil-free surfaces. For best results, the adhesive should be brush-applied in a thin, uniform coat to both bonding surfaces. Allow the adhesive to tack prior to joining both surfaces. Avoid open time of more than 10 minutes. 520 Adhesive bonds instantly, so pieces must be positioned accurately as contact is made. Moderate pressure should then be applied to the entire bonding area to insure complete contact.

It is recommended that the adhesive be applied at temperatures above 40°F (4°C) and not on heated surfaces. Where application between 32°F and 40°F (0°C and 4°C) can not be avoided, exercise more care in applying the adhesive and closing the joint. Applications below 32°F (0°C) are not recommended.

Where lines and tanks that are insulated and will operate at hot temperatures, 520 Adhesive must cure a minimum of 36 hours at room temperature to attain heat resistance for insulated pipe to 250°F (120°C) and insulated tanks and equipment to 180°F (82°C).

Adhesive-bonded seams and joints of Armaflex Pipe Insulation must cure before finishes are applied. Where the insulation is installed by adhering seams and butt joints, the adhesive must cure 24 to 36 hours.

Adhesive-bonded seams and joints of Armaflex Sheet Insulation must cure before finishes are applied. Where the insulation is installed by adhering seams and butt joints only, the adhesive must cure 24 to 36 hours. Where the insulation is installed against surfaces with full adhesive coverage, requiring wet adhesive at joints, the adhesive must cure seven days.

Thinning is not recommended.

Either methyl ethyl ketone or most lacquer thinners can be used to clean fresh residue from tools and workpieces.

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