

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	
<b>Color:</b>	Light Tan	
<b>Net Weight:</b>	6.9 pounds per gallon (828 g/l)	
<b>Composition:</b>	Synthetic rubber base with synthetic resins and fillers added; hydrocarbon- and ketone-type solvents.	
<b>Volatile Organic Compounds (VOC) Content:</b>	596 g/l	
<b>Solids Content</b>	Approximately 22% by weight	
<b>Coverage</b>	200 sq ft (5m <sup>2</sup> /l) per gallon max, single coat (depending upon porosity of materials bonded and air temperature)	
<b>Shelf Life</b>	1-1/2 years in original sealed container; storage temperature 60°F to 80°F (16°C to 27°C)	
<b>Minimum Drying Time</b>	3-5 minutes under normal conditions	
<b>Temperature Limits</b>	250°F (120°C) — Armaflex Pipe Insulation seams and joints 180°F (82°C) — Full bonding sheet insulation	
<b>Container Sizes</b>	Half-pint and pint brush-top cans and pint, quart, and gallon containers	
<b>Fire Performance</b>	Wet: Flash point below 20°F (-7°C) (TOC) Dry: ASTM E 84 Method* Applied on steel plate Flame Spread Index: 5 Smoke Developed Index: 15	
<b>Flame Spread and Smoke Developed Index:</b>	25/50 rated	ASTM E 84
<b>Application Temperature:</b>	Recommended above 40°F (4°C); Not recommended below 32°F (0°C)	

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