

SOLUTIONS FOR ENERGY SAVINGS

# ArmaFlex<sup>®</sup>

## 520 Adhesive

A air-drying contact adhesive specifically designed for use with ArmaFlex Insulation Products.

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

[www.armacell.us](http://www.armacell.us)



 **armacell**<sup>®</sup>  
ArmaFlex<sup>®</sup>

## TECHNICAL DATA – ArmaFlex® 520 ADHESIVE

### 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.

### Specification Compliance

MIL-A-24179A Type II, Class 1      ASTM G21/C1338

### Approvals, Certifications, Compliances

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

### Typical Properties

Specifications	Values
Color	Greenish yellow
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	615 g/l
Solids Content	Approximately 19% by weight
Coverage	200 sq ft (5 m <sup>2</sup> /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; Store in a well ventilated area with storage temperature 60° F to 80° F (16° C to 27° C).
Maximum Service Temperature	250°F (120°C) — ArmaFlex Pipe Insulation seams and joints 180°F (82°C) — Full bonding sheet insulation
Minimum Service Temperature <sup>1</sup>	-58° F (-50 °C)
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	-15 °F (-26 °C) [TOC]
Flame Spread and Smoke Developed Index	25/50 rated      ASTM E 84

<sup>1</sup> For applications of below -58°F (-50°C), contact Armacell technical team.

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ArmaFlex | 520 Adhesive TDS | 112022 | NA| EN-A | 083

## ABOUT ARMACELL

As the inventors of flexible foam for equipment insulation and a leading provider of engineered foams, Armacell develops innovative and safe thermal, acoustic 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 3,100 employees and 26 production plants in 18 countries, the company operates two main businesses, Advanced Insulation and Engineered Foams. Armacell focuses on insulation materials for technical equipment, high-performance foams for high-tech and lightweight applications and next generation aerogel blanket technology.

For more information, please visit:  
[www.armacell.us](http://www.armacell.us)  
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