

SOLUTIONS FOR ENERGY SAVINGS

ArmaFlex[®]

HT 625 Adhesive

A contact adhesive especially designed to bond Armaflex insulation to pipes and tanks at higher temperatures of up to 300° F

- // Recommended for use with UT SolaFlex insulation
- // Thermally stable up to +300° F (150° C)
- // Bonds well to metallic surfaces
- // For joining insulation for higher temperature environments

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 **armacell**[®]
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TECHNICAL DATA – ArmaFlex® HT 625 ADHESIVE

Description

This adhesive is specifically designed for adhering all Armacell Insulation materials. Thermally stable up to 300° F (150° C). This product will bond well to metallic base. Check the compatibility and adhesive properties before applying to painted or lacquered surfaces.

Instructions for Use:

Clean soiled surfaces and insulating materials with a non-oily solvent such as denatured alcohol. Apply a thin uniform layer of HT 625 Adhesive to both surfaces to be bonded. Allow the volatile materials of the applied adhesive to evaporate being careful of the short evaporation time. Allow the adhesive to come to tack (when adhesive will no longer stick to your fingernail when touched.) Precisely join surfaces to be glued and press together with slight pressure. Keep container tightly closed and mix well before using again. Please follow the instructions for use carefully.

Typical Properties

Specifications	Values
Color	Colorless
Volatile Organic Compounds (VOC) Content	670 g/L
Coverage	0.5-liter container will provide single coat coverage for 26 square feet
Shelf Life	18 months. Store in a well ventilated space and temperatures below 100 F. Keep container tightly closed.
Thermal Stability (Temperature Limits)	Maximum Service Temperature: 300° F (150° C) ¹ Minimum Service Temperature: -58° F (-50° C) ²
Storage Conditions	Store in a cool, dry place. Material has a shelf life of one year when stored in the original unopened container. Gelling due to freezing is fully reversible when the material is thoroughly mixed.
Minimum Drying Time	Minimum Drying Time 3–5 minutes under normal conditions
Container Size	0.5 Liter
Fire Performance	Wet: Flash point below -4°F (-20°C) (TOC)
Application Temperature	Ideally between 60 and 70° F (15 and 20° C). Not below 40° F (4° C)

Note: The adhesive will not reach full strength for 36 hours. Do not start the system before this curing is complete. Do not use HT 625 Adhesive on systems that are already in operation or when exposed to direct sunlight. Wait 36 hours before coating, taping or covering with jacketing except when using Arma-Chek coating.

¹ For temperatures above 300° F (150° C) please contact Technical Support to request for the corresponding technical information.

² For temperatures below -58° F (50° C) please contact Technical Support to request for the corresponding technical information.

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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 3,000 employees and 23 production plants in 15 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:
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