



Armaflex® 520 ADHESIVE

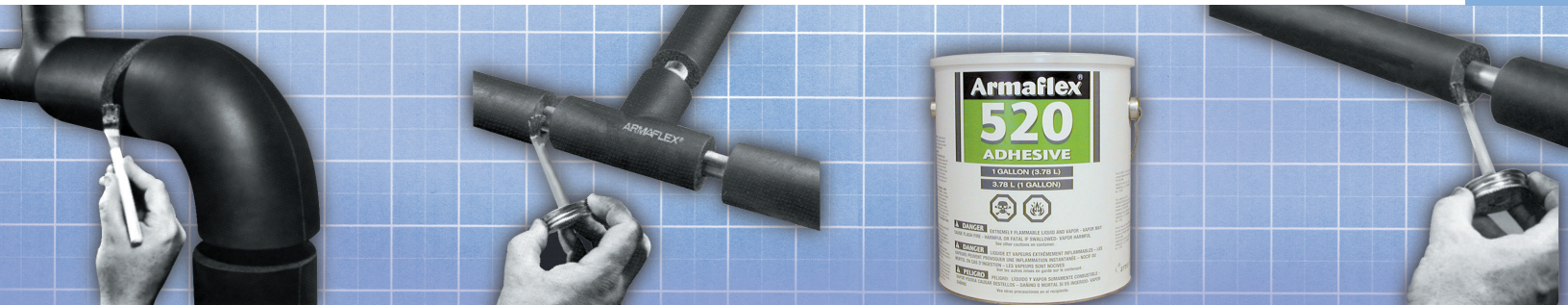
STRONGER BONDS, FOR TIGHTER SEAMS

Formulated
for Armaflex
Insulations

Air-drying
contact
adhesive

Years of
on-the-job
performance

Meets
MIL-A-24179A
and Amend-2



Description

Armaflex® 520 Adhesive is an 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). 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).

- Meets Military Specification MIL-A-24179A and Amend-2 as Type II, Class 1
- Dried film also meets 25/50 flame spread index and smoke developed index requirements of codes and specifications when tested by ASTM E 84 Test Method

Uses

520 Adhesive will make a resilient and heat-resistant bond with many materials where the use of a solvent-base neoprene contact adhesive is suitable and desirable.

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

Properties

Color

Light tan

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. V.O.C. Content: 432 g/l, calculated SCAQMD 1168

Solids Content

Approximately 22% by weight.

Coverage

200 sq ft (5m²/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; 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

Half-pint and pint brush-top cans and pint, quart, and gallon containers

Fire Performance

Wet: Flash point below 20°F (-7°C) (TOC)

Dry: ASTM E 84 Method*

Applied on steel plate

Flame Spread Index5

Smoke Developed Index15



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For any updates on this document, please refer to our website.

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, 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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