PROFESSIONAL ADHESIVE FOR HIGH TEMPERATURE, SOLAR AND INDUSTRIAL APPLICATION

- Specially formulated for wide range of temperatures and applications
- Superior, vapour-tight bonding with all Armaflex® materials
- Easy to apply and dries quickly
- For operating temperatures up to +125 °C
- High performance, one component industrial grade adhesive
- Low-viscosity air-drying contact adhesive
**Technical Data - Armaflex HT625 [Adhesive]**

**Brief description**
One-component adhesive which has been developed to bond Armaflex insulation applied on high temperatures, especially well matched with HT/Armaflex, but also suitable for all other Armaflex synthetic rubber based insulation materials.

**Material type**
Contact adhesive on polyisoprene basis, free of aromatic components.

**Colour**
Beige

**Material Special Information**
Liquid.

**Applications**
Application on pipes and tanks with service temperatures up to 125 °C. Gluing of HT/Armaflex insulation material and other Armaflex synthetic rubber based insulation materials.

**Special Features**
Specially formulated adhesive for uniform and safe seam bonding of flexible Armaflex insulation materials applied on high temperature lines

**Assembly**
Please observe our installation instructions / product data. Minimum Application temperature: ideally + 20 °C, not below 0 °C.
At temperatures below + 5 °C or high humidity (above approx. 80%), increased condensation may form on the surfaces to be glued or adhesive films. In this case bonding is bad or impossible. This can be tested by using absorbent paper (blotting or crepe paper). Work should not be carried out on working plants or areas exposed to strong sunlight.
Shake and stir well before use. Apply thinly to the places to be bonded with a brush or spatula. In case of contact adhesion press together with force during the contact adhesion time. Extensive notes for application are available.

**Remarks**
The adhesive achieves its final strength after 36 hours. Only then should the plant be taken into operation. Wait 36 hours before applying coatings (exception: Armaclean 98), adhesive tape, coverings etc.

<table>
<thead>
<tr>
<th>Property</th>
<th>Value/Accessment</th>
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<tbody>
<tr>
<td>Temperature Range</td>
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<tr>
<td>Temperature Range max. service temperature</td>
<td>+ 125 °C</td>
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<tr>
<td>Temperature Range min. service temperature</td>
<td>-60 °C</td>
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</tbody>
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**Other technical features**
Minimum consumption with the adhesive applied to both surfaces: Armaflex tubes (thickness > consumption unaslotted > consumption slotted):
10 mm > 1120 mL > 140 mL;
20 mm > 280 mL > 70 mL;
30 mm > 175 mL > 45 mL;
40 mm > 130 mL > 35 mL;
Sheets:
3.4 m²

**Storage & Shelf life**
12 months in a closed (unopened) container in a dry, cool, well ventilated place.

In a cool, but frost-free place. Jellification due to frost is reversible.

**Flash Point**
approx. -20 °C

**Explosion limits**
Lower: approx. 1.0 Vol.%;
Upper: approx. 13.0 Vol.%

**Hazard Class**
VbF A1, highly flammable

Regulation of inflammable liquids

**Ageing stability**
Very good

**Resistance to weathering**
Very good

**Pre-treatment of surface to be bonded:**
Clean dirty surfaces and the Armaflex surface with Armaflex Cleaner.
Compatibility with bases: very good adhesion to metallic base. The compatibility with colour coated surfaces with adhesive needs to be tested.
Incompatible with: Asphalt, bitumen or read lead paint (insnede oil based).

For more information pls. see Technical Bulletin no. 17.

**Transport classes**
Depending on the type of transport.

**Recycling**
Recycling Nr: EAK 08409 Adhesives and sealants containing organic solvents or other dangerous substances.
Note: The waste classification can change depending on the application area. Please observe EC-directive 2001/118/EC.
Can needs to be empty. Empty cans can be recycled. Cans with remaining adhesive have to be recycled as the product.

**Working time**
at 20 °C:
1. Minimum drying time (airing time): 3-5 minutes
2. Contact adhesion time: 15-20 minutes
3. Setting time: 36 hours

Before operation time the setting time needs to be allowed to elapse.

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1. For temperatures above +125 °C please contact our Technical Department to request for the corresponding technical information.
2. For temperatures below +60 °C please contact our Technical Department to request for the corresponding technical information.

All data and technical information are based on results achieved under typical application conditions. Recipients of this information should, in their own interest and responsibility, clarify with us in due time whether or not the data and information apply to the intended application area. Installation instructions are available in our Armaflex installation manual. Armaflex HT625 adhesive must be used to guarantee proper installation.

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