



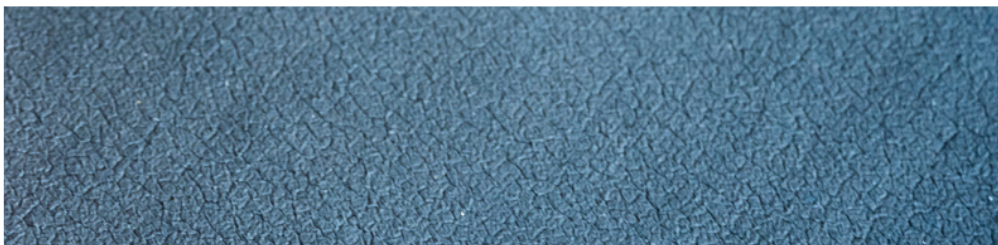
INSTALL IT. TRUST IT.

# ArmaFlex HT625 adhesive

The adhesive for superior ArmaFlex system reliability in high temperature and solar applications

// One-component adhesive

// Developed to bond ArmaFlex insulation applied on high temperatures



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

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# ArmaFlex Accessories

## ArmaFlex Toolbox - Tools for professionals!



When it comes to preventing condensation and energy losses on equipment, not only high-quality insulation material is crucial, but also the installation. ArmaFlex insulation materials not only have the required technical properties, they can also be installed quickly and easily. Armacell already offers various tools and aids such as the ArmaFlex Application Manual and the installation videos. Now all the tools and aids are available in a lightweight, robust, lockable aluminium case!

### // Measuring Correctly

- ArmaFlex Application Manual with fabrication and measuring instructions for ArmaFlex covers for complex shaped components
- Folding rule with circumference scale
- Callipers (300 mm) to determine diameters precisely
- Edding marker pen, Armacell ballpoint pen and silver-ink marker pen for marking, making notes and transferring measurements to ArmaFlex insulation material
- Bow compass with a holder for the silver-ink marker pen and protective cap for use on ArmaFlex insulation material

### // Cut Perfectly

- ArmaFlex template
- 4 knives: with blade length of 9, 17 and 27 cm for different cut-outs and 1 ceramic knife
- Knife holster for attaching to a belt
- Sharpening stone for the knives
- Sharpened copper pipe ends (6 different diameters) for cut-outs in ArmaFlex insulation material
- Tool for re-sharpening the copper pipe ends

### // Glue Neatly

- ArmaFlex short-bristle brush
- 14, 70mm flat brush
- ArmaFlex Gluemaster (adhesive pump)
- Cleaning cloth for the tools



Elastomeric insulation materials not only have good technical properties, they are also very user-friendly due to their high flexibility and ease of application. When installing these insulation materials it is crucial that they are glued professionally. Therefore, Armacell offers a broad range of accessories specifically developed for its products and regularly adds innovative solutions.

#### // Solvent-free Accessories

Armacell is the first manufacturer of elastomeric insulation materials to provide solvent-free products. ArmaFlex SF990 and ArmaFlex Ultima SF990 meet the higher requirements of green building schemes regarding environmental and health aspects of the building products used.

We also offer a solvent-free cleaner: the ArmaFlex SF Cleaner can be used to clean soiled surfaces of technical installations as well as the surface of insulation materials, thus ensuring perfect adhesion. The cleaner is supplied in a practical spray bottle so that it can be applied sparingly and precisely.

#### ArmaFlex 520



THE ADHESIVE FOR SUPERIOR ARMAFLEX SYSTEM RELIABILITY

#### ArmaFlex 525



SPECIAL ADHESIVE FOR NEXT GENERATION OF ARMAFLEX ELASTOMERIC INSULATION

#### ArmaFlex 750



SPECIAL ADHESIVE FOR SUPERIOR NH/ARMAFLEX SMART INSTALLATIONS

#### ArmaFlex HT625



THE ADHESIVE FOR SUPERIOR ARMAFLEX SYSTEM RELIABILITY IN HIGH TEMPERATURE & SOLAR APPLICATIONS

#### // Drip-free Gel Adhesive

The drip-free, thixotropic (gel-like) adhesive ArmaFlex RS850 guarantees neat application. The special consistency of this product means that it is very drip-resistant, which is a great benefit when working overhead or when it is important that the insulation is not soiled by drops of adhesive.

As it only releases minimal quantities of solvents when idle, the ArmaFlex RS850 adhesive is particularly suitable for installations in workshops and confined spaces.



## ArmaFlex Ultima Adhesives

ArmaFlex Ultima and ArmaFlex Rail, synthetic rubber insulation materials based on the innovative ArmaPrene technology, require the use of adhesives that have been specially formulated for this type of foam. For these materials too, Armacell offers in addition to the standard ArmaFlex Ultima 700 adhesive a solvent-free alternative (ArmaFlex Ultima SF990 adhesive).

Find out more about all accessories in [www.armacell.eu](http://www.armacell.eu)

## TECHNICAL DATA - ARMAFLEX HT625 ADHESIVE

Brief description	Special adhesive developed for high temperature applications, especially for ArmaFlex EPDM-based products (e.g. HT/ArmaFlex). See also "Overview ArmaFlex Adhesives".
Material type	Contact adhesive on polychloroprene basis, free of aromatic solvents.
Additional material information	Liquid
Product colour range	Beige
Special features	Specially formulated adhesive for uniform and safe seam bonding of flexible ArmaFlex insulation materials.
Applications	Work should not be carried out on plants in operation or areas exposed to strong sunlight. Stir the adhesive with a brush well before use. Apply thinly with a brush or spatula to the areas to be bonded. In case of contact adhesion press together with force during the contact adhesion time. For further details see extensive ArmaFlex Application Manual.
Installation	Clean dirty surfaces and the ArmaFlex surface with ArmaFlex Cleaner before starting the application with the adhesive. 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 red lead paint (inseed oil based).
Remarks	Setting time of the adhesive is 36 hours. Only then should the plant be put into operation. Wait 36 hours before applying coatings (exception: Armafinish 99), adhesive tape, coverings etc.

Property	Value / Assessment	Standard / Test method
<b>Temperature range</b>		
Service temperature	Min. °C <sup>1</sup>	Max. °C <sup>2</sup>
	-50	150
<b>Weather and UV resistance</b>		
Weather resistance	Very good	
<b>Health and environment</b>		
Volatile organic compounds (VOC) content	Fulfills all VOC requirements (French, Italian, Belgian, German AgBB, EMICODE and Eurofins Indoor air Comfort GOLD).	ISO 16000 Parts 3, 6 & 9
Health aspects	MSDS available on request.	
Green building assessment	Meets the sustainable construction requirements for BREEAM international and DGNB.	
<b>Other technical features</b>		
Application conditions	Application temperature: ideally + 20 °C, not below 0 °C. At temperatures below + 5 °C or high relative humidity (above approx. 80%), increased condensation may form on the surfaces of the glued or adhesive films. In these cases, bonding is difficult or impossible. This can be tested using absorbent paper (blotting or crepe paper).	
Disposal and recycling	Allocation of a waste code number, according to the European Waste Catalogue, should be carried out in agreement with the regional waste disposal company. Residuals must be removed from packaging and when emptied completely disposed of in accordance with the regulations for waste removal. Incompletely emptied packaging must be disposed of in the form of disposal specified by the regional disposer. More details see relevant Safety Data Sheet.	
Explosion limits	Lower: 1,0 Vol.% Upper: 12,8 Vol.%	
Flash point	approx. - 26 °C	
Hazard class	Highly flammable liquid and vapour	
Shelf life	18 months	
Solids content	approx. 18 %	
Storage	Material shall be stored in a closed (unopened) container in a dry, cool and well-ventilated place. Do not store together with: explosive substances; spontaneously combusting substances. Jellification due to frost is reversible.	
Working time <sup>3</sup>	at 20 °C: 1. Minimum drying time (airing time): 3-5 minutes 2. Contact adhesion time (open time): 15-20 minutes 3. Setting time: 36 hours	
	The airing and open time depends on the quantity as well as indoor climate conditions.	

Property	Value / Assessment	Standard / Test method
Yield	Yield of the adhesive applied to both surfaces: ArmaFlex tubes (thickness > consumption unslotted > consumption slotted): 10 mm > 1120 m/l > 140 m/l 20 mm > 280 m/l > 70 m/l 30 mm > 175 m/l > 45 m/l 40 mm > 130 m/l > 35 m/l ArmaFlex sheets: 3-4 m <sup>2</sup> /l  These figures are a guide only.	

<sup>1</sup>For temperatures below -50 °C please contact our Customer Service Center to request for the corresponding technical information.

<sup>2</sup>For temperatures above +150 °C please contact our Customer Service Centre to request for the corresponding technical information.

<sup>3</sup>The full adhesion of the adhesive is achieved after 168 h.

Adhesive - standard. Portable packaging for ease of use.

Item	Description	Content [quantity]
ADH-HT625/0,25	ArmaFlex HT625 one-component adhesive. Available as 0.25 litre cans (with brush).	40 tin
ADH-HT625/0,5	ArmaFlex HT625 one-component adhesive. Available as 0.5 litre cans.	12 tin

Adhesive - standard

Item	Description	Content [quantity]
ADH-HT625/1,0	ArmaFlex HT625 one-component adhesive. Available as 1.0 litre cans.	12 tin

All data and technical information are based on results achieved under the specific conditions defined according to the testing standards referenced. Despite taking every precaution to ensure that said data and technical information are up to date, Armacell does not make any representation or warranty, express or implied, as to the accuracy, content or completeness of said data and technical information. Armacell also does not assume any liability towards any person resulting from the use of said data or technical information. Armacell reserves the right to revoke, modify or amend this document at any moment. It is the customer's responsibility to verify if the product is suitable for the intended application. The responsibility for professional and correct installation and compliance with relevant building regulations lies with the customer. This document does not constitute nor is part of a legal offer to sell or to contract.

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Adhesive and cleaner | ArmaFlex HT625 Adhesive (EMEA) | Brochure | 032024 | en-GB

## ABOUT ARMACELL

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As the inventor of flexible foam for equipment insulation and a leading provider of engineered foams, Armacell develops innovative and safe thermal 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 more than 3,300 employees and 25 production plants in 19 countries, the company operates two main businesses, Advanced Insulation and Engineered Foams. Armacell focuses on insulation materials for technical equipment, high-performance foams for acoustic and lightweight applications, recycled PET products, next-generation aerogel technology and passive fire protection systems.



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