

Armaflex HT 625 Adhesive - Special adhesive for treatment of HT/Armaflex. Application on pipes and tanks up to +150° C.

HT625 adhesive is a one-component adhesive which has been developed to bond Armaflex insulation applied on high temperature, especially well matched with HT/Armaflex material. It guarantees a homogeneous and safe bonding at joints and seams.

Type of Adhesive: Contact adhesive based on Polychloroprene, free of aromatic components.

Special Features: The Adhesive HT 625 contains substances which etch Armaflex and hence securely join the surface to be bonded. Application on pipes and tanks up to +150° C.



	Values	Remarks																				
Application Temperature	Ideal +20 °C , not below 0° C																					
Max. Service Temperature	+150° C	At temperatures close to +150° C please contact our customer service center. In the event of temperatures below 5° C excessive amounts of condensation can form on the surface to be bonded or on the adhesive film. In this case bonding is bad or impossible. This can be tested by using absorbant paper (blotting or crepe paper). Work should not be carried out on working plants or areas exposed to strong sunlight. For min. temperatures below -50° C, please consult our Technical Department. Tel. 0161 287 7100 · Fax 0161 633 2685																				
Min. Service Temperature	-50° C																					
Physical Details	Flashpoint: -20° C Lower explosion limits: 1,0 Vol. % Upper explosion limits: 13,0 Vol. %	Test according to DIN 51 755 (also apply for cleaner) DIN 51 794 (also apply for cleaner)																				
Hazard Class	VbF A1, slightly inflammable	Ordinance on Hazardous Substances (also apply for cleaner)																				
Ageing Stability	Very good																					
Resistance to Weathering	Very good																					
Bonding to Bases	Very good on metallic base																					
Working times at 20°C	Wet adhesion time: Up to 2 minutes Minimum drying time (airing time): 3 to 5 minutes Contact adhesion time: 15 to 20 minutes Setting time: 36 hours Note: Before starting up a plant the setting time must be allowed to elapse.																					
Consumption Data - Armaflex Tubes	Minimum consumption with adhesive application to both surfaces <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th></th> <th>10 mm</th> <th>20 mm</th> <th>30 mm</th> <th>40 mm</th> </tr> </thead> <tbody> <tr> <td>Thickness</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Tunslotted</td> <td>1120 m/l</td> <td>280 m/l</td> <td>175 m/l</td> <td>130 m/l</td> </tr> <tr> <td>Slotted</td> <td>140 m/l</td> <td>70 m/l</td> <td>45 m/l</td> <td>35 m/l</td> </tr> </tbody> </table>			10 mm	20 mm	30 mm	40 mm	Thickness					Tunslotted	1120 m/l	280 m/l	175 m/l	130 m/l	Slotted	140 m/l	70 m/l	45 m/l	35 m/l
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Consumption Data - Armaflex Sheets	Minimum consumption with adhesive application to both surfaces: 3 bis 4 m²/l																					
Application Notes	Shake and stire 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. Pre-treatment of surface to be bonded: Clean dirty surfaces and Armaflex surface with special cleaner Compatibility with bases: Perfect adhesion to metallic base. The compatibility of the adhesive with the base must be tested in the case of bases coated with other paint layers. Incompatibility with: Asphalt, bitumen or red lead coats of paint (oil-based). Note: For further information read our technical information "Armaflex and Corrosion Protection"																					



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