

THE RIGHT TOOLS & ACCESSORIES TO ENSURE PROFESSIONAL ARMAFLEX® INSTALLATIONS



- Complete set of professional tools and accessories
- Specially designed and optimised for use with Armaflex®
- Complete range with cleaner, knifes, adhesives, tapes, paints and others

## Technical Data - Armaflex Ultima 700

Brief description	One-component adhesive specifically developed for Armaflex Ultima and insulating materials based on Armaprene® synthetic n	ubbers.	
Material type	Contact adhesive on polychloroprene basis, free of aromatic components.		
Colour	blue		
Applications	Application on pipes and tanks with service temperatures up to +110 °C. Gluing of Armaflex Ultima and insulation materials based on Armaprene® synthetic rubbers.		
Special Features	Specially formulated adhesive for uniform and safe seam bonding of Armaflex Ultima and insulating materials based on Armaprene® synthetic rubbers.		
Assembly	Please observe our installation instructions / product data. Application temperature: ideally between +15 °C and + 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 these cases 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.		
Remarks	The adhesive achieves its final strength after 36 hours. Only then should plant be put into operation. Wait 36 hours before apply (exception: Armafinish 99), adhesive tape, coverings etc.	ying coatings	
Property	Value/Assessment	Special Remarks	
Temperature Range			
Temperature Range	Max. service temperature +110 °C		
	Min. service temperature -50 °C		
Other technical featur	res		
Yield	Minimum consumption with the adhesive applied to both surfaces: Armaflex tubes (thickness > consumption unslit tubes > consumption slit tubes): 10 mm > 1120 m/litre > 140 m/litre; 20 mm > 280 m/litre > 70 m/litre; 30 mm > 175 m/litre > 45 m/litre; 40 mm > 130 m/litre > 35 m/litre;	These figures are a guide only.	
	Sheets: 3-4 m² /litre		
Storage & Shelf life	12 months in a closed (unopened) container	As cool as possible, but protected from frost. In the event of frost any gelling is reversible on warming.	
Flash Point	approx: -20 °C		
Explosion limits	Lower: approx. 1,0 Vol.% Upper: approx. 13,0 Vol.%		
Hazard Class	VbF AI, 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 Armaflex Ultima surface with Armaflex Cleaner Compatibility with bases: very good adhesion to metallic surfaces. The adhesives compatibility with colour coated surfaces needs to be tested. Incompatible with Asphalt, bitumen or red lead (linseed oil-based).	For more information see Technical Bulletin no. 17	
Transport Classes	Depending on the type of transport		
Recycling	Dispose waste according to applicable local, state and federal regulations.	Packaging must be emptied of all	
	European Waste Catalogue: 08 04 09 (waste adhesives and sealants containing organic solvents or other dangerous substances). Please note: The classification of waste for this product may change according to the field of application. Please observe Decision 2001/118/EC.	residues. Packaging with traces of cured product can be recycled. Packaging with uncured product must be recycled into new 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	The open time depends on the quantity as well as indoor climate conditions. Before operating plant the setting time needs to be allowed to elapse.	

All statements and technical information are based on results obtained under typical conditions. It is the responsibility of the recipient to verify with us that the information is appropriate for the specific use intended. Installation instructions are given in our Armaflex installation manual. With some refrigerants the discharge temperature may exceed +110 °C, please consult our Technical Department for further information.

## Technical Data - Armaflex Ultima RS850

Brief description	Non-drip one component adhesive in gel form. Specifically designed for processing Armaflex Ultima and insulating materials be synthetic rubbers.	ased on Armaprene®	
Material type	Thixotropic one component contact adhesive based on polychloroprene.		
Colour	blue		
Material Special Information	Gel based		
Applications	Application on pipes, ducts and tanks with service temperature up to +70 °C. Gluing of Armaflex Ultima and insulation materials Armaprene® synthetic rubbers.	s based on	
Assembly	Please observe our installation / product data. Application temperature: ideally between +15 °C and +25 °C, not below +10 °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 these cases 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.		
Remarks	Adhesive bond reaches full strength after 24 hours. The system should not be operated during this period and any self-adhesive coatings should only be applied after this period has elapsed.	e tape or protective	
Property	Value/Assessment	Special Remarks	
Temperature Range			
Temperature Range	Max. service temperature +70 °C		
	Min. service temperature -40 °C		
Other technical feature	and the product of th		
Yield	Minimum consumption with the adhesive applied to both surfaces: Armaflex tubes (thickness > consumption unslit tubes > consumption slit tubes): 10 mm > 1120 m/litre > 140 m/litre; 20 mm > 280 m/litre > 70 m/litre; 30 mm > 175 m/litre > 45 m/litre; 40 mm > 130 m/litre > 35 m/litre;	These figures are a guide only.	
	Sheets: 3-4 m² /litre		
Storage & Shelf life	15 months in a closed (unopened) container	As cool as possible, but protected from frost. Cold or frozen adhesive (under +5 °C) will become fully usuable again if slowly acclimatised up to working temperature (approx. +20 °C).	
Flash Point	-19 °C	,	
Explosion limits	Lower: 1,1 Vol. % Upper: 11,5 Vol. %		
Hazard Class	VbF AI, 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 Armaflex Ultima surface with Armaflex Cleaner. Compatibility with bases: very good adhesion to metallic surfaces. The adhesives compatibility with colour coated surfaces needs to be tested. Incompatible with: Asphalt, bitumen, red lead (linseed oil-based), polystyrene and plasticised PVC.	For more information see Technical Bulletin No. 17.	
Transport classes	Depending on the type of transport		
Recycling	Dispose waste according to applicable local, state and federal regulations.  European Waste Catalogue: 08 04 09 (waste adhesives and sealants containing organic solvents or other dangerous substances). Please note: The classification of waste for this product may change according to the field of application. Please observe Decision 2001/118/EC.	Packaging must be emptied of all residues. Packaging with traces of cured product can be recycled. Packaging	
	Decision 2001/116/EC.	with uncured product must be recycled into new product.	
Working time	at 20 °C  1. Minimum drying time (airing time): > 2 minutes 2. Contact adhesion time: 10 to 15 minutes 3. Setting time: 24 hours	The open time depends on the quantity as well as indoor climate conditions.  Before operating plant the setting time needs to be allowed to elapse.	

All statements and technical information are based on results obtained under typical conditions. It is the responsibility of the recipient to verify with us that the information is appropriate for the specific use intended. Installation instructions are given in our Armaflex installation manual. With some refrigerants the discharge temperature may exceed +110 °C, please consult our Technical Department for further information.

#### Technical Data - Armaflex 520

Brief description	Specially formulated adhesive for installing Armaflex insulation materials (with the exception of HT/Armaflex).
Material type	Contact adhesive on polychloroprene basis, free of aromatic solvent.
Colour	Beige
Material Special Information	Liquid
Applications	Gluing of all flexible Armaflex insulation materials, with the exception of HT/Armaflex.
Special Features	Specially formulated adhesive for uniform and safe seam bonding of flexible Armaflex insulation materials.
Assembly	Please observe our installation instructions / product data. 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 these cases bonding is poor 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 areas to be bonded with a brush or spatula. For contact adhesion press together with force during the contact adhesion time. Detailed application guidance is available.
Remarks	The adhesive achieves its final strength after 36 hours. Only then should plant be put into operation. Never insulate plant which is in operation or work in strong sunlight. Wait 36 hours before applying further coats (exception: Armafinish 99), adhesive tape, coverings etc.

Property	Value/Assessment		Special Remarks
Temperature Range			
Temperature Range	Max. service temperature	+ 110 °C	
	Min. service temperature <sup>1</sup>	- 50 °C	
Other technical featur	res		
Yield	Minimum consumption with the adhesive applied to both surfact Armaflex tubes (thickness > consumption unslit > consumption 10 mm > 1120 m per litre > 140 m per litre; 20 mm > 280 m per litre > 70 m per litre; 30 mm > 175 m per litre > 45 m per litre; 40 mm > 130 m per litre > 35 m per litre; Sheets:		These figures are a guide only.
	3-4 m <sup>2</sup> per litre		
Storage & Shelf life	Approx. 1 year		In a cool, frost-free place. Gelification 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 AI, highly flammable		Regulation of inflammable liquids
Ageing stability	Very good		
Resistance to weathering	Very good		
Pre-tratment of surface to be bonded.	Clean dirty surfaces and the Armaflex surface with Armaflex Cl Compatibility with bases: very good adhesion to metallic surfact tested.  Incompatible with: Asphalt, bitumen or red lead paint (linseed of	es. The compatibility with colour coated surfaces needs to be	For more information pls. see Technical Bulletin no. 17.
Transport Classes	Dependent on transport sector		
Recycling	Dispose waste according to applicable local, state and federal European Waste Catalogue: Recycling Nr. EAK 080409 Adhesives and sealants containing Note: The waste classification can change depending on the applications of the sealants of the sealants containing the sealants containing the sealants of	organic solvents or other dangerous substances.	Can must be emptied prior to recycling. Cans containing adhesive must be recycled into new product.
Working time	at 20 °C: 1. Wet adhesion time: up to 2 minutes 2. Minimum drying time (airing time): 3-5 minutes 3. Contact adhesion time: 15-20 minutes 4. Setting time: 36 hours		The setting time must be allowed to lapse before plant can be operated.

<sup>1.</sup> For temperatures below -50 °C please contact our Technical Department to request the corresponding technical information.

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#### Technical Data - Armaflex HT625

Brief description	Specially formulated one-component adhesive developed for bonding Armaflex insulation applied at high temperatures, especially developed for use with HT/Armaflex, but also suitable for all other Armaflex synthetic rubber based insulation materials.		
Material type	Contact adhesive on polychloroprene basis, free of aromatic components.		
Colour	Beige		
Material Special Information	Liquid		
Applications	Application on pipes and tanks with service temperatures up to 150 °C. Gluing of HT/Armaflex insulation material and other based insulation materials (except Armaflex Ultima).	er Armaflex synthetic rubber	
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. 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 layers. In these cases bonding is poor or impossible. This can be tested 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 areas to be bonded with a brush or spatula. For contact adhesion press the contact adhesion time. Detailed application guidance is available.	together with force during	
Remarks	The adhesive achieves its final strength after 36 hours. Only then should plant be put into operation. Wait 36 hours before (exception: Armafinish 99), adhesive tape, coverings etc.	applying coatings	
Property	Value/Assessment	Special Remarks	
Temperature Range			
Temperature Range	Max. service temperature <sup>1</sup> + 150 °C		
• • • • • • •	Min. service temperature <sup>2</sup> -50 °C		
Other technical featur			
Yield	Minimum consumption with the adhesive applied to both surfaces:  Armaflex tubes (thickness > consumption unslit > consumption slit):  10 mm > 1120 m per litre > 140 m per litre;  20 mm > 280 m per litre > 70 m per litre;  30 mm > 175 m per litre > 45 m per litre;  40 mm > 130 m per litre > 35 m per litre;	These figures are a guide only.	
	Sheets: 3-4 m² per litre		
Storage & Shelf life	12 months in a closed (unopened) container	In a cool, frost-free place. Gelification due to frost is reversible.	
Flash Point	approx20 °C		
Explosion limits	Lower: approx. 1,0 Vol.%; Upper: approx. 13,0 Vol.%		
Hazard Class	VbF AI, highly flammable	Regulation of inflammable liquids	
Ageing stability	Very Good		
Resistance to weathering	Very Good		
Pre-treatment of	Clean dirty surfaces and the Armaflex surface with Armaflex Cleaner.	For more	
surface to be bonded:	Compatibility with bases: very good adhesion to metallic surfaces. Compatibility with colour coated surfaces needs to be tested.	information pls. see Technical Bulletin no. 17.	
	Incompatible with: Asphalt, bitumen or red lead paint (linseed oil based).		
Transport classes	Dependent on transport sector.		
Recycling	Dispose waste according to applicable local, state and federal regulations.	Can must be	
	European Waste Catalogue: 08 04 09 (waste adhesives and sealants containing organic solvents or other dangerous substances). Please note: The classification of waste for this product may change according to the field of application. Please observe Decision 2001/118/EC.	emptied prior to recycling. Cans containing adhesive must be recycled into new 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	The setting time must be allowed to lapse before plant can be operated.	
For temperatures above	e +150 °C please contact our Technical Department to request the corresponding technical information.		

All statements and technical information are based on results obtained under typical conditions. It is the responsibility of the recipient to verify with us that the information is appropriate for the specific use intended. Installation instructions are given in our Armaflex installation manual. Armaflex HT625 adhesive must be used to guarantee correct installation.

<sup>2.</sup> For temperatures below -50 °C please contact our Technical Department to request the corresponding technical information.

## Technical Data - Armaflex RS850

Brief description	Non-drip one-component adhesive in gel form. Specifically for processing all Armaflex insulating materials based on synthetic exception of HT/Armaflex.	rubber with the	
Material type	Thixotropic contact adhesive on polychloroprene basis		
Colour	Yellowish		
Material Special Information	Jellylike		
Applications	Application on pipes, ducts and tanks with service temperature up to +70 °C. Gluing of all Armaflex insulation materials with the exception of HT/Armaflex and Armaflex Ultima.		
Special Features	Specifically formulated adhesive for uniform and safe seam-bonding of flexible Armaflex insulation materials.		
Assembly	Please observe our installation instructions / product data. Application temperature: idealy between +15 °C and 25 °C, not below +10 °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 these cases 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.		
Remarks	Adhesive bond reaches full strength after 24 hours. The system should not be operated during this period and any self-adhesive coatings, except Armafinish 99 paint, should only be applied after this period has elapsed.	re tape or protective	
Property	Value/Assessment	Special Remarks	
Temperature Range		•	
Temperature Range	Max. service temperature +70 °C		
	Min. service temperature -40 °C		
Yield	Minimum consumption with the adhesive applied to both surfaces: Armaflex tubes (thickness > consumption unslit tubes > consumption slit tubes): 10 mm > 1120 m/litre > 140 m/litre; 20 mm > 280 m/litre > 70 m/litre; 30 mm > 175 m/litre > 45 m/litre; 40 mm > 130 m/litre > 35 m/litre; Sheets:	These figures are a guide only.	
	3-4 m² /litre		
Storage & Shelf life	36 months in a closed (unopened) container	As cool as possible, but protected from frost. Cold or frozen adhesive (under +5 °C) will become fully usable again if slowly acclimatised up to working temperature (approx. +20 °C).	
Flash Point	-19 °C		
Explosion limits	Lower: 1,1 Vol.% Upper: 11,5 Vol.%		
Hazard Class	VbF AI, 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 Armaflex surface with Armaflex Cleaner.  Compatibility with bases: The adhesives compatibility with colour coated surfaces needs to be tested.  Incompatible with: Asphalt, bitumen, red lead (linseed oil-based), polystyrene and plasticised PVC	For more information see Technical Bulletin No. 17	
Transport classes	Depending on type of transport		
Recycling	Dispose waste according to applicable local, state and federal regulations.  European Waste Catalogue:  08 04 09 (waste adhesives and sealants containing organic solvents or other dangerous substances).  Please note: The classification of waste for this product may change according to the field of application. Please observe	Packaging must be emptied of all residues. Packaging with traces of cured product can be	
	Decision 2001/118/EC.	recycled. Packaging with uncured product must be recycled into new product.	
Working time	at 20 °C  1. Minimum drying time (airing time): > 2 minutes 2. Contact adhesion time: 10 to 15 minutes 3. Setting time: 24 hours	The open time depends on the quantity as well as indoor climate conditions. Before operation of plant the setting time needs to be allowed to elapse.	

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# Technical Data - Armaflex Cleaner

Brief description	Special cleaner for use with all Armaflex adhesives	
Colour	Clear	
Material Special Information	Liquid	
Applications	Cleaning of surfaces where Armaflex Adhesive 520 or Adhesive HT625 are being used.	
Assembly	To ensure perfect adhesion all contaminated surfaces - including contaminated Armaflex - must be cleaned. In addition, the clean surfaces when Armafinish 99 is to be applied.	aner can also be used
Remarks	Armaflex Cleaner can also be used to clean tools.	
Storage & Shelf life	Approx. 1 year	Keep container tightly closed in a cool, well ventilated place.
Property	Value/Assessment	Special Remarks
Property Flash Point	Value/Assessment approx 20 °C	Special Remarks
. ,		Special Remarks
Flash Point	approx 20 °C  Lower: approx. 1 Vol-%	Special Remarks  Regulation of inflammable liquids
Flash Point Explosion limits	approx 20 °C  Lower: approx. 1 Vol-%  Upper: approx. 13 Vol-%	Regulation of

All statements and technical information are based on results obtained under typical conditions. It is the responsibility of the recipient to verify with us that the information is appropriate for the specific use intended. Installation instructions are available.

## Technical Data - Armafinish 99

Brief description	Armafinish 99 is a paint, which remains permanently elastic, is resistant to weathering and has good ageing resistance.		
Material type	Non-drip		
Colour	white (RAL 9001) or grey (RAL 7037)		
Material Special Information	Normal consumption: 0.55 litres per m² when two coats are applied (corresponds to a dry film thickness of 0.26mm).		
Applications	Protection of Armaflex insulation materials when installed outdoors and for marking purposes for interior use.		
Assembly	All Armaflex insulation (except HT/Armaflex and Armaflex Ultima, see relevant product data sheet) which is installed outdoors mean two complete coats of Armafinish 99.  Application temperature: + 10 °C to + 30 °C, maximum relative humidity 80%. Drying time at + 20 °C: approx. 2 hours. It is also this time between coats; the second coat must be applied within 7 days. Paint may be applied using a brush or roller. Clean too	necessary to allow	
Remarks	Unprotected Armaflex must not be exposed to weathering for more than 3 days, so the paint should be applied as soon as poss. The protective coating should be inspected at regular intervals. After 2 years at the latest, two further coats should be applied.	sible.	
	Refer to special instruction / safety data sheet.		
Other technical featur	res		
Storage & Shelf life	Shelf-life in unopened container: 12 months.	Keep container tightly closed and store in a cool, well ventilated and frost- free place.	
Property	Value/Assessment	Special Remarks	
Explosion limits	Lower: none Upper: none		
Hazard Class	Environmentally hazardous substance as defined by the transport regulations (ADR/RID, IMDG-Code, ICAO-TI/IATA-DGR).		
Recycling	Dispose waste according to applicable local, state and federal regulations.	Can must be emptied prior to	

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# **Armaflex accessories self-adhesive tapes**



Code	Colour	Width [mm]	Length [m]	Thickness [mm]	Rolls/carton
AF-TAPE-MC	black	50.0	15	3	12
HT-TAPE	black	50.0	15	3	12
NH-TAPE ●	black	50.0	15	3	12

<sup>•</sup> Not a stock item. Delivery on request.

### **Armaflex accessories adhesive**



Code	Description	pieces/carton
ADH-HT625/0,25 ●	Armaflex HT625 one-component adhesive, 0,25 litre cans (with brush)	40
ADH-HT625/0,5 Armaflex HT625 one-component adhesive, 0,5 litre cans		12
ADH-HT625/1,0	Armaflex® HT625 one-component adhesive, 1,0 litre cans	12
ADH-RS850/0,7	Armaflex Adhesive RS850, 0.75 litre cans	6
ADH520/0,25E	Armaflex adhesive 520, 0.25 litre cans (with brush)	24
ADH520/0,5E	Armaflex adhesive 520, 0.5 litre cans	12
ADH520/1,0E Armaflex adhesive 520, 1.0 litre cans		12
ADH520/2,5E Armaflex® 520 adhesive, 2.5 litre cans		8
AHU-700/1,0 ●	Armaflex Ultima Adhesive 700, blue one component adhesive, 1 litre cans	12
AHU-RS850/0,7 ●	Armaflex Ultima Adhesive RS850, reduced solvent, non-drip blue gel form adhesive, 0.75 litre cans	6

<sup>•</sup> Not a stock item. Delivery on request.

## **Armaflex accessories paint**



Code	Description	pieces/carton
FINISH/GY-2,5 Protective coat for Armaflex, silver grey (RAL-Nr. 7037), 2.5 litre buckets		4
FINISH/WH-2,5 Protective coat for Armaflex, white (RAL-Nr. 9001), 2.5 litre buckets		4
FINISH/BK-2,5 Protective coat for Armaflex, black, 2.5 litre buckets		4

#### **Armaflex accessories tools**



Code	Description	Pieces/carton
BLADES	Spare blades for tube slitter-knife (50x6 pcs)	50x6
BLADES-PCS	Spare blades for tube slitter-knife (6 pcs)	6
CERAMIC KNIFE	knife with ceramic blade (10 cm) and rubber grip (9 cm)	1
CUTTING-SET	Armaflex knite-set (3 knives + 1 sharpening stone)	1
GLUEM-BRUSH11MM	Gluemaster extra brush points with cap (11mm diameter)	5x4
GLUEM-BRUSH17MM	Gluemaster extra brush points with cap (17mm diameter)	5x4
GLUEM-BRUSH25MM	Gluemaster extra brush points with cap (25mm diameter)	5x4
GLUEMASTER B •	Armaflex Gluemaster (adhesive pump)	12
SLITTER	Special tube slitter-knife	10

<sup>•</sup> Not a stock item. Delivery on request.

#### **Armaflex Cleaner Cleaner**



Code	Description	pieces/carton
CLEANER/1,0	Special cleaner for use with Armaflex® Adhesive 520 and Armaflex® Adhesive HT625.	4