



SOLUTIONS FOR ENERGY SAVINGS

ArmaFlex HT625 Adhesive

A contact adhesive especially designed to bond ArmaFlex insulation to pipes and tanks at higher temperatures of up to 300° F

- // Recommended for use with ArmaFlex UT insulation
- // Thermally stable up to +300° F (150° C)
- // Bonds well to metallic surfaces
- // For joining insulation for higher temperature environments



 **armacell**[®]
ArmaFlex[®]

TECHNICAL DATA - ARMAFLEX HT625 ADHESIVE

Brief description	This adhesive is specifically designed for adhering all Armacell Insulation materials. Thermally stable up to 300° F (150° C). This product will bond well to metallic base. Check the compatibility and adhesive properties before applying to painted or lacquered surfaces.
Product color range	Yellowish
Product range	0.5 Liter container size.
Installation	Clean soiled surfaces and insulating materials with a non-oily solvent such as denatured alcohol. Apply a thin uniform layer of adhesive to both surfaces to be bonded. Allow the volatile materials of the applied adhesive to evaporate being careful of the short evaporation time. Allow the adhesive to come to tack (when adhesive will no longer stick to your fingernail when touched). Precisely join surfaces to be glued and press together with slight pressure. Keep container tightly closed and mix well before using again. Please follow the instructions for use carefully.

Property	Value / Assessment				Standard / Test method
Temperature range					
Service temperature	Min. °C	Min. °F	Max. °C	Max. °F	
	-50	-58	150	300	
	Remarks	For applications above 150°C (300°F), contact Armacell technical team. For applications below -50°C (-58°F), contact Armacell technical team.			

Health and environment

Volatile organic compounds (VOC) content 670 g/L

Other technical features

Application conditions	Ideally between 60°F and 70°F (15°C and 20°C). Not below 40°F (4°C)
Coverage	0.5-liter container will provide single coat coverage for 26 square feet.
Cure time ¹	36 hours
Shelf life	1-1/2 years in original unopened, sealed container.
Storage	Store in a cool, dry, well ventilated place and temperatures below 100°F. Gelling due to freezing is fully reversible when the material is thoroughly mixed.
Tack time	3-5 minutes under normal conditions.
Wet flash point	Below -4°F (-20°C) (TOC).

¹The adhesive will not reach full strength for 36 hours. Do not start the system before this curing is complete. Do not use HT 625 Adhesive on systems that are already in operation or when exposed to direct sunlight. Wait 36 hours before coating, taping or covering with jacketing except when using ArmaClad Arma-Chek coating.

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ABOUT ARMACELL

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:
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