

Armaflex® Ultima Adhesive

ADHESIVES FOR SECURE BONDING OF
ARMAFLEX ULTIMA



- Adhesives in blue color to provide reliable bonding of Armaflex Ultima and Armaflex Rail SD insulation materials
- Armaflex® Ultima 700: Special adhesive for day-to-day applications
- Armaflex® Ultima SF990: Solvent free, environmentally friendly adhesive

Technical Data - Armaflex Ultima 700 [Adhesive]

Brief description	One-component adhesive specifically for processing Armaflex Ultima and insulating materials based on Armaprene® synthetic rubbers.
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	<p>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 this 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.</p> <p>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.</p>
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: Armafinish 99), adhesive tape, coverings etc.

Property	Value/Assessment	Special Remark
Temperature Range		
Temperature Range	max. service temperature +110 °C min. service temperature -50 °C	
Other technical features		
Yield	<p>Minimum consumption with 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;</p> <p>Sheets: 3-4 m²/l</p>	These figures are a guide only.
Storage & Shelf life	18 month in a closed (unopened) container. Do not store together with: explosive substances; spontaneously combusting substances.	As cool as possible, but protected from frost. In the event of frost any gelling is reversible on warming.
Flash Point	approx: -26 °C	
Explosion limits	Lower: approx. 1,0 Vol.% Upper: approx. 12,8 Vol.%	
Hazard Statement	highly flammable liquid and vapour	For more information pls. see EC Safety Data Sheet.
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 base. The compatibility with colour coated surface with adhesive needs to be tested. Incompatible with Asphalt, bitumen or red lead (inseed oil-based).	For more information see Technical Bulletin no. 17
Transport Classes	Depending on the type of transport	
Disposal considerations	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.	
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 operation time the setting time needs to be allowed to elapse.

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. For some refrigerants the discharge temperature may exceed +110 °C, please consult our Customer Service Center for further information.

Technical Data - Armaflex Ultima SF990 [Adhesive]

Brief description	Water-based one component solvent-free adhesive. Specifically formulated for processing Armaflex Ultima and insulating materials based on Armaprene® synthetic rubbers.
Material type	Solvent-free dispersion adhesive based on synthetic latex.
Colour	blue
Material Special Information	liquid
Applications	Gluing of Armaflex Ultima and insulation materials based on Armaprene® synthetic rubbers.
Assembly	Please observe our installation / product data. The maximum relative humidity must not exceed 70%. Work should not be carried out on working plants, for areas exposed to strong sunlight, and high wind speed. Apply adhesive with a brush in a thin uniform layer to both surfaces to be joined. Adhesive bond reaches full strength after 72 hours. The system should not be operated during this period and any self-adhesive tapes or protective coatings should only be applied after this period has elapsed. A detailed application advice is available.
Remarks	The application of the Armaflex Ultima SF990 shall be performed only by certified users. Before starting application work, a practical instruction training performed by the Armacell Technical Customer Service is obligatory!

Property	Value/Assessment	Special Remark
Temperature Range		
Temperature Range	max. service temperature	+100 °C
	min. service temperature	-30 °C
Processing temperature	Ideally between +20 °C and +30 °C For temperatures at low temperature e.g. +5 °C please contact our application specialist.	
Other technical features		
Yield	Minimum consumption with the adhesive applied to both surfaces:: 3-4 m ² / l	These figures are a guide only.
Storage & Shelf life	6 month in sealed original container.	In a cool (preferably not under +15 °C and not below +30 °C) and dry place. Protect from temperatures below +5 °C!
Pre-treatment of surface to be bonded	Clean dirty surfaces and Armaflex surface with Armaflex Cleaner or Armaflex SF Cleaner. Compatibility with bases: very good adhesion to metallic base, except galvanized surfaces. The compatibility with colour coated surfaces with adhesive needs to be tested.	
Transport classes	No hazardous material as defined by the transport regulations.	
Disposal considerations	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.	
Working time	at 20 °C; 55% : 1. Minimum drying time (airing time): approx. 12 - 60 minutes 2. Contact adhesion time (open time): approx. 5 to 10 minutes 3. Setting time: 72 hours	The open time depends on the quantity as well as indoor climate conditions. Before operation time the setting time needs to be allowed to elapse.

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. For some refrigerants the discharge temperature may exceed +110 °C, please consult our Customer Service Center for further information.

Armaflex Ultima 700 [Adhesive] adhesive



Code	Article description	Pieces/carton
AHU-700/1,0	Armaflex Ultima Adhesive 700, 1 liter cans	12

Armaflex Ultima SF990 [Adhesive] adhesive



Code	Article description	Pieces/carton
AHU-SF990/0,8	Armaflex Ultima Adhesive SF990, 0,8 liter cans	12

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