

Fiber Free

# HT 625 Insulation Adhesive

HT 625 Adhesive is designed to bond Armaflex insulation to high-temperature (300° F) pipes and tanks



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

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## Technical Data: HT 625 Adhesive

### 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.

### Instructions for Use:

Clean soiled surfaces and insulating materials with a non-oily solvent such as denatured alcohol. Apply a thin uniform layer of HT 625 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.

### Typical Properties

Specifications:	Values
<b>Color:</b>	Colorless
<b>Volatile Organic Compounds (VOC) Content:</b>	670 g/L
<b>Coverage</b>	0.5-liter container will provide single coat coverage for 26 square feet
<b>Application Temperature</b>	Ideally between 60 and 70° F (15 and 20° C). Not below 40° F (4° C)
<b>Thermal Stability (Temperature Limits)</b>	Maximum Service Temperature: 300° F (150° C) <sup>1</sup> Minimum Service Temperature: -58° F (-50° C) <sup>2</sup>
<b>Shelf Life</b>	1 year
<b>Storage Conditions</b>	Store in a cool, dry place. Material has a shelf life of one year when stored in the original unopened container. Gelling due to freezing is fully reversible when the material is thoroughly mixed.
<b>Minimum Drying Time</b>	3-5 minutes under normal conditions
<b>Container Sizes</b>	0.5 Liter
<b>Fire Performance</b>	Wet: Flash point below -4°F (-20°C) (TOC)

Note – The 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 Arma-Chek coating.

<sup>1</sup> For temperatures above 300° F (150° C) please contact Technical Support to request for the corresponding technical information.

<sup>2</sup> For temperatures below -58° F (50° C) please contact Technical Support to request for the corresponding technical information.

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