

# K-FLEX® 320 / 620 ADHESIVE

## Contact Adhesive for K-FLEX FEF Insulation



### DESCRIPTION

K-FLEX® 320 & 620 Contact Adhesives are air-drying solvent-based neoprene contact adhesives that are excellent for joining seams and butt joints of elastomeric pipe and sheet insulation.

### AVAILABILITY

K-FLEX® 320 and 620 Contact Adhesives are amber (320) and black (620) in color and are available in a variety of sizes ranging from 1/2 pint brush top containers to gallon containers.

### APPLICATIONS

K-FLEX® 320 & 620 Contact Adhesives may be used for bonding elastomeric products to a variety of materials (i.e., other elastomers, metal, wood, leather, felt, concrete, etc.). The adhesives will make resilient and heat-resistant bonds. They are suitable for line temperatures up to 220°F (104°C) on applications requiring bonded seams and joints. When the adhesives are applied to large flat or curve surfaces, they are suitable for temperatures up to 200°F

(93°C). Their higher solids content allows them to be brushed or roller applied easily without running. They are ideal for bonding porous and non-porous materials, as they will not be absorbed easily.

### INSTALLATION

For proper adhesion, the surfaces to which the insulation is to be applied must be thoroughly cleaned, dry and unheated. Primed and painted surfaces should be adhesive tested to be sure the insulation will not lift off after application. The adhesive should be thoroughly mixed. Brush or roll a thin even coat of adhesive on both surfaces to be joined. Allow the adhesive films to become dry to the touch, but tacky, before joining the surfaces. Press the two surfaces together. Be sure the insulation is in the desired position before the adhesive surfaces make initial contact, since the adhesive forms an instant bond, and repositioning after contact is difficult. Moderate pressure should then be applied to the entire bonding area to ensure complete contact. Avoid heat, sparks, and

open flames, and use only proper ventilation. Close container after use. K-FLEX® 320 & 620 Contact Adhesives should be applied at above 40°F (4°C) temperatures, and allowed to dry for 24 hours before equipment operation.

Protective coatings can be applied to applications with bonded joints and seams, after allowing 24 hours dry time. Applications such as large tanks, or vessels where full adhesive coverage is required, must be allowed to dry 7 days prior to applying a protective coating. The surface may be allowed to dry and can be solvent reactivated by wiping with a toluene dampened cloth. Thinning the adhesive is not recommended. Common lacquer thinners can be used for clean up.

*Caution: Adhesive contains notable solvents and containers not in use should be kept closed. Keep adhesive away from sparks and open flames. Use with adequate ventilation and avoid excessive contact with the skin.*

PHYSICAL PROPERTIES	K-FLEX® 320 / 620 CONTACT ADHESIVE
Color	Amber (320), Black (620)
Base	Neoprene
Solvents	Acetone, Toluene, Hexane
Viscosity	Medium Syrup
Weight	6.98 ± 0.2 lbs/gal
Shelf Life	12 months in original sealed container. Storage temperature 60°F.
Minimum Dry Time	2 - 4 minutes under normal conditions.
Open Time	Not to exceed 10 minutes.
High Temperature Limits	220°F (104°C) for pipe insulation seams and joints 200°F (93°C) for full bonding sheets
VOC (Volatile Organic Compounds) Content	447 g/L
Flash Point	Less than -4°F
Flammability	ASTM E84 25/50-rated (10/0 when tested to UL 723)
Freight Classifications	Adhesives NOS. Flammable Liquid 4620 Sub 5, class 60, Un 1133, IMDG class 3.1 PG:11 (packaging group II)
Solid Content	25% ± 2%
Coverage	200 ft <sup>2</sup> /gal (one surface)