

K-FLEX® 320/620 CONTACT ADHESIVE



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 & polyolefin pipe and sheet Insulation. K-FLEX® 320 & 620 Contact Adhesives make resilient moisture- and heat-resistant bonds when used with elastomeric and polyolefin products. K-FLEX® 320 & 620 Contact Adhesives' 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.

Caution: Adhesive contains notable solvents and container 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.

USES

K-FLEX® 320 & 620 Contact Adhesives may be used for bonding elastomeric and polyolefin 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). The products are supplied in a variety of sizes ranging from pint brush top containers to gallon containers. Larger containers are available upon request.

APPLICATION INSTRUCTIONS

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.

PHYSICAL PROPERTIES

Color	Amber (320), Black (620)
Base	Neoprene
Solvents	Toluene, Hexane, Acetone
Viscosity	Medium Syrup
Solid Content	25% ± 2%
Weight per gallon	6.98± .2 lbs.
Coverage	200 sq. ft. per gallon (one surface)
Shelf Life	One year in original sealed container. Storage temperature 60°F
Minimum Dry Time	2-4 minutes under normal conditions
Open Time	Not to exceed 10 minutes
Temperature Limits	220°F (104°C) for pipe insulation seams and joints 200°F (93°C) for full bonding sheets
Flammability	ASTM E84 10/0 Flamespread/Smoke Developed
Flash Point	Less than -4°F
Freight Classifications	<ul style="list-style-type: none"> Adhesives NOS. Flammable Liquid 4620 Sub 5, class 60, Un 1133, IMDG class 3.1 PG:11 (packaging group II)

Made in USA



K-FLEX USA - 100 Nomaco Drive - Youngsville, NC 27596 - toll free 800-765-6475 - fax 800-765-6471 - www.kflexusa.com

©May 2010 K-FLEX USA. K-FLEX CLAD® is a registered trademark of K-FLEX USA. THE GREENGUARD® INDOOR AIR QUALITY CERTIFIED MARK IS A REGISTERED CERTIFICATION MARK USED UNDER LICENSE THROUGH THE GREENGUARD® ENVIRONMENTAL INSTITUTE.

KFDS-0096-0811