

K-Flex® 320 Contact Adhesive Field Performance and Use

K-Flex® 320 Contact Adhesive is an air-drying, solvent-based neoprene contact adhesive that is excellent for joining seams and butt joints of elastomeric pipe and sheet insulation.

When tested by an independent laboratory for tack and drying capability, K-Flex® 320 demonstrated a higher level of initial tack and faster drying than competitive adhesives, which is an advantage in the field to bond elastomeric insulations. The fast tack time provides excellent seam closure and prevents seams from opening up after being closed. The lab also found that K-Flex® 320 Contact Adhesive provided foam tearing bonds comparable to competing adhesives when tested for tensile and adhesion strength.

Applications

K-Flex® 320 Contact Adhesive makes durable moisture- and heat-resistant bonds when used with elastomeric insulation products. K-Flex® 320 Contact Adhesive's higher solids content allows it to be brushed or roller applied easily without running. It is ideal for bonding porous and non-porous materials, as it is not absorbed easily.

K-Flex® 320 Contact Adhesive may be used for bonding elastomeric products to a variety of materials. It is suitable for piping and mechanical systems with operating temperatures up to 220°F (104°C) on applications requiring bonded seams and joints. When applied to large flat or curve surfaces, it is suitable for temperatures up to 200°F (93°C).

For proper adhesion, application surfaces 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 insure complete contact. Avoid heat, sparks, and open flames while working with the adhesive, and provide proper ventilation. Close the container after use.

K-Flex® 320 Contact Adhesive 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 solvent reactivated by wiping with a toluene dampened cloth.

If there are any further questions regarding this type of application, please contact your K-Flex USA representative.

