

K-FLEX® 373 ADHESIVE

Contact Adhesive for K-FLEX FEF Insulation



DESCRIPTION

K-FLEX® 373 Contact Adhesive is an air-drying solvent-based neoprene contact adhesive (blue in color for easy identification) that is excellent for joining seams and butt joints of elastomeric pipe and sheet insulation.

AVAILABILITY

K-FLEX® 373 Contact Adhesive is blue in color and is available in a variety of sizes ranging from 1/2 pint brush top containers to gallon containers.

APPLICATIONS

K-FLEX® 373 Contact Adhesive may be used for bonding elastomeric products to a variety of materials (i.e., other elastomers, metal, plastics, wood, etc.). The adhesive will make a resilient moisture- and heat-resistant bond. It is suitable for line temperatures up to 220°F (104°C) on applications requiring bonded seams and joints. When the adhesive is applied to large flat or curved surfaces, it is suitable for temperatures up to 200°F (93°C).

INSTALLATION

For proper adhesion, the surfaces to which the insulation is to be applied must be thoroughly clean, 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 with proper ventilation. Close container after use. K-FLEX® 373 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. K-FLEX® 373 Contact Adhesive may be heat or solvent reactivated. To reactivate with heat, use approximately 250°F (125°C). To reactivate with solvent, wipe with a cloth dampened with toluene.

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.

Note: May damage the insulation if the intent is to remove it from the substrate (i.e. duct, tank, AHU, etc.) Thinning the adhesive is not recommended. Common lacquer thinners can be used for clean up. See the Technical Bulletin TAI for equipment recommendations.

PHYSICAL PROPERTIES	K-FLEX® 373 CONTACT ADHESIVE
Color	Blue
Base	Synthetic Rubber
Solvents	Aliphatic, Aromatic, Ketone
Viscosity	Thin Syrup
Weight	6.8 lbs/gal
Shelf Life	12 months in original sealed container. Storage temperature of 60°F is recommended.
Minimum Dry Time	5 - 10 minutes under normal conditions. Drying can be accelerated by using forced ventilation and/or heat.
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	593 g/L
Flash Point	Less than -4°F
Flammability	ASTM E84 <25/50-rated (5/5 when tested to UL 723)
Specification Compliance	Meets Mil-A-24179A, Type 2, Class 1 Amendment 2 (QPL #RUBQA-373)
Freight Classifications	Adhesive NOS. Flammable Liquid 4620 Sub 5, Class 60, UN 1133, IMDG class 3.1 PG:11 (packaging group II)
Solid Content	20% by weight
Coverage	200 - 300 ft ² /gal (one surface)