

# K-FLEX® 420 ADHESIVE

## High Performance Contact Adhesive



### DESCRIPTION

K-FLEX® 420 Contact Adhesive is a one-part solvent-based high performance contact adhesive.

### AVAILABILITY

K-FLEX® 420 Contact Adhesive is gray / green in color and is available in quart containers.

### APPLICATIONS

K-FLEX® 420 Contact Adhesive is specially designed for use with K-FLEX Clad® IN Jacketing and K-FLEX HT® insulation. It has excellent initial strength, good resistance to high temperatures and is ideal for bonding rubber in demanding heating and refrigeration systems. The product forms a resilient, flexible, moisture- and heat-resistant bond when used with elastomeric products. A low viscosity allows it to be applied easily. It is ideal for bonding porous and non-porous materials, as it will not be absorbed easily, and may be used for bonding elastomeric insulation products to a variety of materials (i.e., other elastomers, metal, concrete, etc.).

### INSTALLATION

For proper adhesion, prepare the surface by removing all dust, dirt, oil, grease, etc. For best results, the temperature of the adhesive and surfaces should be at least 65°F. If stored below 30°F, warm up to room temperature in a warm room only (do not exceed 120°F).

Stir well before using for optimum results. The adhesive tacks in approximately 5-10 minutes. High humidity will slow drying times and high temperatures will speed drying times. The adhesive has a bonding range of approximately 30 minutes when applied to both bond surfaces under conditions of 70°F and 35% R.H.

To bond, apply a thin coat on the two surfaces to be joined, allow to become slightly tacky, and bond by applying strong, even pressure. If the adhesive becomes too dry, apply another thin coat of adhesive to one surface, allow to become slightly tacky, and bond.

Relative humidity above 50% can cause blushing (condensation of moisture on surface)

and a false bond. To avoid this, K-FLEX recommends a force drying temperature of 180°-220°F. Force drying also helps remove the solvent more rapidly.

K-FLEX® 420 Contact Adhesive can be applied via pumping, spraying, brushing or rolling. For pumping, a 2:1 divorced design pump is suggested. All material hoses should be nylon or PVA lined. Packings and glands in contact with the adhesive should be PTFE. For spraying, air pressure of 80 psi and fluid flow of 6 fl. oz/min should be used. For brushing or rolling, typical brushes and rollers designed for oil-based paint may be used.

*CAUTION: Direct contact of uncured adhesive irritates eyes and may irritate skin. Overexposure to vapor may irritate eyes, nose and throat. Avoid eye and skin contact. Use with adequate ventilation. Do not handle contact lenses with adhesive on hands. In case of eye contact, flush eyes with water for 15 minutes. Obtain medical attention. In case of skin contact, remove from skin and flush with water. Keep out of the reach of children.*

PHYSICAL PROPERTIES	K-FLEX® 420 CONTACT ADHESIVE
Color	Gray / Green
Base	Polychloroprene
Solvents	Petroleum Distillate, Acetone, MEK, Toluene, N-Hexane
Viscosity (approximate)	200 -450 cps
Brookfield Viscometer	RVF #2 Sp. @20 rpm @80°F (27°C)
Net Weight (approximate)	6.6 - 7.0 lbs/gal
Shelf Life	12 months when stored at recommended conditions in original sealed container
Storage Temperature	60°F to 80°F for maximum storage life
Suggested Application Method	Spray, brush, roll of flow
High Temperature Limits	300°F (150°C)
VOC (Volatile Organic Compounds) Content	≤674 g/L
Flash Point	-14°F (-26°C)
Solid Content	23 -27%
Coverage	300 ft <sup>2</sup> /gal (one surface)