

# K-FLEX® 720 LVOC ADHESIVE

Low VOC Adhesive for K-FLEX FEF Insulation



## DESCRIPTION

K-FLEX® 720 LVOC Contact Adhesive is an air-drying, low VOC contact adhesive that is excellent for joining seams and butt joints of elastomeric pipe and sheet insulation. It meets Southcoast Air Quality Management Rule 1168 (SCAQMD) and LEED (Leadership in Energy and Environmental Design) IEQ 4.1 VOC emission regulations.

## AVAILABILITY

K-FLEX® 720 LVOC Contact Adhesive is black in color and is available in quart containers.

## APPLICATIONS

K-FLEX® 720 LVOC Contact Adhesive is recommended for applications with service temperatures up to +250°F (+120°C) on applications requiring bonded seams and joints. When the adhesive is applied directly to large flat or curve surfaces, it is suitable for a service temperature range of -20°F (-28°C) to +200°F (+93°C). 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.). It contains no halogens, making it ideal for use with K-FLEX ECO® (non-halogen) insulation.

## INSTALLATION

K-FLEX® 720 LVOC Contact Adhesive should be applied between 40°F (4°C) and 100°F (38°C) ambient temperatures and allowed to dry for 24 hours before equipment operation. 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. A thin even coat of adhesive should be brushed, rolled or sprayed on both surfaces to be joined. The adhesive films should be

dry to the touch, but tacky, before joining the surfaces. The insulation should be 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. 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. Thinning the adhesive is not recommended. Common lacquer thinners (Xylol or Trichloroethylene) can be used for clean up. Avoid heat, sparks, and open flames, and use only proper ventilation. Close container after use.

*Caution: Adhesive contains notable solvents and container, when 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® 720 LVOC CONTACT ADHESIVE
Color	Black
Solvent	Acetone
Viscosity	Medium Syrup
Weight per gallon	7.1 lbs.
Shelf Life	12 months in original sealed container. Storage temperature 60°F
Minimum Dry Time	2-4 minutes under normal conditions (1-10 minutes depending on conditions)
Full Bonding Time	0-25 minutes. Time depends on the temperature, humidity and film thickness. Bonding strength increases over time.
Open Time	Not to exceed 10 minutes
High Temperature Limits	250°F (120°C) for pipe insulation seams and joints 200°F (93°C) for full bonding sheets
Chemical Resistance	Resistant to moisture, aliphatic solvents, and oils
VOC (Volatile Organic Compounds) Content	0 g/L calculated and reported SCAQMD 1168 Meets LEED (IEQ 4.1), SCAQMD 1168 and EPA 40 CFR - 59 sub part 1 Requirements
Flash Point	-4°F (-20°C)
Flammability	<25/50 (ASTM E84)
Freight Classifications	<ul style="list-style-type: none"> <li>Adhesives NOS. Flammable Liquid 4620 Sub 5, class 60, Un 1133, IMDG class 3.1</li> <li>PG:II (Packaging Group)</li> </ul>
Odor	Mild
Solid Content	26%
Coverage	200 sq. ft. per gallon