

K-FLEX PE ADHESIVE RECOMMENDATIONS

The following adhesives have been identified as having excellent adhesion to K-Flex PE flexible closed cell insulation. They have been subdivided into Brush applied adhesives and hot melt adhesive.

K-FLEX Brush/Roller Applied Solvent-Based Adhesives:

- K-FLEX 320 Amber color / fast dry
- K-FLEX 620 Black color / fast dry
- K-FLEX 720-LVOC* Black color / fast dry (non-halogen)

*Meets the VOC requirements of South Coast Air Quality Management District (SCAQMD) Regulation 1168. Should be used on stainless steel tube and pipe with intermittent or continuous operating temperatures above 90°F.

Surface Preparation

The seam and butt joint surfaces of insulation must be clean and free of any dust, dirt, scale, moisture, oil and grease.

Application Technique

Below are some general instructions and guidelines.

Brush Applied Adhesives:

Container contents must be mixed well. Apply at temperatures above 40°F. Coat BOTH surfaces to be joined with an adequate but thin, even coat. Allow adhesive to dry to the touch, approximately 3-10 minutes, depending on ambient conditions. Join surfaces with moderate pressure to ensure complete contact. Joined surfaces cannot be repositioned. Allow bond to set at least 24 hours before bringing pipes to service temperature.

Hot Melt Adhesives

Hot melt adhesives can be used to seal both insulation seams and butt joints. Hot melt adhesives have been used successfully for a number of years with polyethylene insulation. There are two general types of hot melt adhesives on the market; standard hot melts and “cool melt” hot melts. The use of “cool melt” products is recommended. H. B. Fuller and Bostik Findley are two of the largest manufacturers of hot melt adhesives. Bostik and Nordson also manufacture glue guns.

Hot Melt Adhesive Application

For seams and butt joints, a hot melt glue gun is typically used. These guns are commercially available and come in three types; electric, electric cordless and butane. Each type has its advantages. The electric (corded) gun is the least expensive and most readily available but requires an extension cord and should not be used in damp / moist conditions. The electric cordless gun has a heated holder which allows for use without an extension cord, but it has a limited use time before requiring re-heating. The butane cartridge gun is the most difficult to find and expensive to operate, but it allows for excellent mobility without the need for electricity. All guns are available with a variety of applicator tips. Hot melt adhesives are best applied in a thin layer rather than a “glob”.

Contact Information:

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