



# AEROFLEX®

Special Purpose Contact Adhesive



## REF 1520™

Professional-Grade Rubber Contact Adhesive





# REF 1520™

## Professional-Grade Rubber Contact Adhesive

Refrigeration | HVAC | VRF | Chilled Water | Duct Liner | Ductwrap | Hot & Cold-Water Piping

Fast tack, solvent-based contact adhesive specially formulated for bonding adjoining seams of AEROFLEX EPDM™ insulation and to suitable substrates.

Colors: Amber and Black

Sizes: Gallon, quart, pint (flat-top), pint (brush-top), 1/2 pint (brush-top).

### Fast, simple to install

Trusted performance

Fast tack times of 1-5 minutes (depending on ambient conditions)

### Superior performance

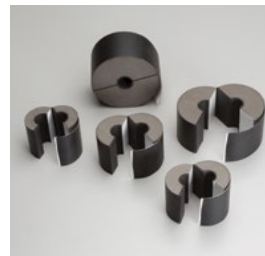
Strong permanent bonds

High water vapor resistance

Properly sealed seams minimize likelihood of corrosion under insulation (CUI)



### AEROFLEX EPDM™ insulation system solutions



#### Aerofix®

Light-weight, rigid pipe supports, pre-insulated with high-density, load-bearing closed-cell foam and encased with zero-perm EPDM polymer membrane. Includes built-in pressure sensitive Protape® closure system.



Courtesy of Nelson Insulation Company

#### Protape®

Zero-perm, EPDM-based, self-adhering rubber tape for sealing adjoining seams and termination points.



#### Aerocoat®

A premium specialty coating for exterior weather protection and as a decorative finish.



#### Aerocoat LVOC®

A low-VOC UV protective coating, best choice for LEED® projects.

**Product:** Synthetic rubber-based contact adhesive for bonding AEROFLEX EPDM™ insulation to itself and to suitable substrates such as clean metal.

**Application:** Stir contents thoroughly before use. Do not thin. Apply thin even coat to both clean and dry surfaces with short-bristle brush or adhesive roller. Allow short tack time (1-5 minutes or more depending on ambient conditions) until tacky to the touch (no transfer) before applying both glued surfaces together. The bond is immediate with no adjustability. Moderate pressure should be applied over the entire area to ensure complete contact and a vapor seal.

REF 1520 should be applied when ambient and surface temperatures are above 40°F (4°C) and below 100°F (38°C). Do not allow to freeze.

If AEROFLEX Protape®, Aerocoat® or Aerocoat LVOC® must be applied over glued seams, allow adhesive to cure for 24-36 hours before tape or coating is applied. For full adhesion of REF 1520 to AEROFLEX EPDM™ sheets and rolls, allow adhesive to cure for 7 days prior to taping or coating application.

**Read all warnings on product label before use.**

**Clean Up:** Use acetone to clean adhesive residue from tools.

### Physical Properties

Composition (Amber or Black)	Synthetic rubber base with added resins and fillers
Solids Content	Approximately 22% by weight
Net Weight	6.9 lbs/gal
VOC Content	615 g/L
Service Temperature Range	-20°F to 257°F (piping), 200°F (sheets & rolls) -28°C to 125°C (piping), 93°C (sheets & rolls)
Surface Buring/Flammability	0/0 (ASTM E 84)
Tack Time	1-5 minutes (tacky to touch, no transfer)
Dry Time	24-36 hours (seams), 7 days (full coverage)
Coverage	Up to 200 ft <sup>2</sup> /gal
Storage	60°F to 80°F (16°C to 27°C), protect from freezing
Shelf Life	1 year (date of purchase)



232 Industrial Park Road Sweetwater, TN 37874

866.237.6235

[www.aeroflexusa.com](http://www.aeroflexusa.com)

052924