



AEROFLEX®

Special Purpose Contact Adhesive



REF 1520™

Professional-Grade Rubber Contact Adhesive





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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.



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 ft2/gal
Storage	60°F to 80°F (16°C to 27°C), protect from freezing
Shelf Life	1 year (date of purchase)



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