

# K-FLEX ADHESIVE K-414



**COMPATIBLE  
TO K-FLEX  
INSULATION**

**RANGE** ▶ ADHESIVE K-414

K-FLEX K-414 Contact Adhesive is an air-drying, contact adhesive that is excellent for joining seams and butt joints of elastomeric pipe and sheet insulation.

**AVAILABILITY** ▶ ADHESIVE K-414

K-FLEX K-414 Contact Adhesive is black in color and is available in 1 Liter can.



**INSTALLATION ▶ ADHESIVE K-414**

K-FLEX K-414 Contact Adhesive should be applied between 4°C and 38°C ambient temperatures and allowed to dry for 24 hours before equipment operation. For proper adhesion, the surfaces to which the insulation 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.*

**APPLICATION ▶ ADHESIVE K-414**

K-FLEX K-414 Contact Adhesive is recommended for applications with service temperature up to +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 from -30°C to +100°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 and ensure maximum effective contact surfaces. 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.).

**TECHNICAL DATA ▶ ADHESIVE K-414**

K-FLEX ▶ K-414	
Color	Black
Solvent	Acetone
Viscosity	Medium Syrup
Weight per Liter	900 gr per Liter
Shelf Life	12 months in original sealed container. Storage temperature 25°C
Minimum Dry Time Full	2-4 minutes under normal conditions (1-10 minutes depending on conditions)
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	120°C for pipe insulation seams and joints 93°C for full bonding sheets
Chemical Resistance	Resistant to moisture, aliphetic solvents, and oils
Flash Point	-4°F (-20°C)
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	20%
Coverage	Approximately 5-7 sq. m. per Liter

**K-FLEX** reserves the right to change data and technical requirements without notice.

