SOUDAL

Technical Data Sheet

SOUDASEAL 2K

Technical Characteristics:

Base	Hybrid Polymer
Curing System	Chemical curing
A-component	
Consistency	Paste
Colour	grey
Specific gravity (DIN 53479)	1,1 g/cm³
B-component	
Consistency	Paste
Colour	White
Specific gravity (DIN 53479)	1,7 g/cm³
Mixture	
Ratio	A:B = 1:1
Consistency	Paste
Colour	Light grey
Specific gravity (DIN 53479)	1,4 g/cm³
Pot-life at 21°C and 50% RH*	5 minutes
Open time at 21°C and 50% RH*	10 minutes
Set to load bearing*	After 1 hour
Shore D Hardness (A+B)	40
Elasticity Modulus 100 % (DIN 53504)	1.3 MPa
Elongation at Break (DIN 53504)	350%
Tensile strength (DIN 53504)	2.2 MPa
Application Temperature	+5°C until +35°C
Temperature Resistance (fully cured)	-40°C until +90°C
Shear Strength	>1,3 MPa
Substrate	AlMgSi1
Thickness	0.9mm
Shear velocity	10mm/min

* This varies according to ambient conditions such as temperature, humidity, substrate etc.

Product:
Soudaseal 2K is a fast curing high quality two component hybrid polymer based adhesive.
For use in elastic bonding applications where fast curing is required or for those applications where the bond design does not allow the normal penetration of atmospheric moisture.

- High performance mechanical properties
- Permanently elastic after curing
- Does not contain isocyanates, silicone, solvents
- Cures without the presence of atmospheric moisture
- For indoor and outdoor use

Characteristics:
- Fast strength build-up
- Fast curing

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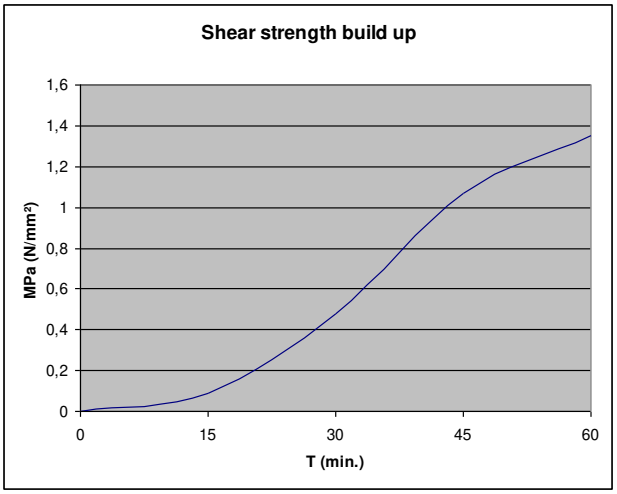
Description:
Soudaseal 2K cures by means of a chemical reaction between A- and B-component and therefore is not dependent on (atmospheric) moisture. Fully cured, an elastic and non-shrinkable adhesive layer is formed. The adhesive has excellent adhesion to most common substrates used in the construction and building industry.

Applications:
Soudaseal 2K is suitable for elastic bonding applications in industrial, automotive, as well as construction and building areas such as;

- Elastic bonding between metal surfaces, coated surfaces and many plastics (not PE, PP, PTFE (eg. Teflon®)
- Elastic high performance bonding, both interior and exterior
- Elastic bonding applications in car-, coach-, caravan-, train-, industries where fast curing and strength build-up is required
- Full surface bonding of non-porous (sheet) material and large areas which are not porous enough to let atmospheric moisture through

Bonding:
Soudaseal 2K has excellent adhesion on many surfaces. The following metal surfaces have been tested:, AlCuMg1, AlMgSi1, AlMg3, Al99, electro galvanized steel, fire galvanized steel, steel ST1403 and stainless steel.
Plastics that were tested include: polystyrene, polycarbonate (Makrolon®), polyamide (PA6), glasfiber reinforced epoxy and polyester (GRP).
While producing plastics very often releasing agents, processing aids and other protective agents (like protection foil) are used. These should be removed prior to bonding.
For optimum adhesion the use of Surface Activator is recommended.
NOTICE: bonding plastics like PMMA (ie Plexi® glass), polycarbonate (ie Makrolon® or Lexan®) in stress loaded applications can give rise to stress cracking and crazing in these substrates. The use of Soudaseal 2K is not recommended in these applications.
Not suitable for PE, PP, PTFE (eg Teflon®), bituminous substrates, copper or copper containing materials such as bronze and brass.



Substrates:
Type: various porous and non-porous substrates such as (natural)stone, concrete, bricks, wood, metal, aluminium, steel ceramic, glass, plastics and other common materials used in construction and building industry.
State of Surface: clean, dry, free of dust and grease
Preparation: Porous surfaces in water loaded applications should be primed with Primer 150. Prepare non-porous surfaces with Soudal primer or cleaner (see Technical Data Sheet).

We always recommend preliminary adhesion and compatibility tests previous to application.

Packaging:
Colour: Light grey
Packaging: Universal cartridge of 250 ml that fits every standard caulking gun or pneumatic gun **with plunger**. Soudaseal 2K has to be applied with the supplied static mixer for optimum mixing of both components.

Application method
Application method: Screw static mixer onto cartridge and dispense the first 10 cm of the product to waste (on piece of cardboard) until an even colour (light grey) is achieved and the product is well mixed.

SOUDASEAL 2K

Shelflife:
12 months in unopened packaging in a cool and dry storage place at temperatures between +5°C and +25°C.

Resistance to chemical agents:
Good resistance to water, aliphatic solvents, mineral oils, grease, diluted inorganic acids and alkalis.
Poor resistance to aromatic solvents, concentrated acids, chlorinated hydrogen.

Health- and Safety Recommendation:
Apply the usual industrial hygiene.
Consult the label for more information.

Remarks:
- Soudaseal 2K may be overpainted with water based paints, however due to the large number of paints and varnishes available we strongly suggest a compatibility test before application.
- The drying time of alkyd resin based paints may increase.
- Soudaseal 2K can be applied to a wide variety of substrates. Due to the fact that specific substrates such as plastics, like polycarbonate, etc, may differ from manufacturer to manufacturer, we recommend a preliminary compatibilty test.
- While producing plastics very often releasing agents, processing aids and other protective agents (like protection foil) are used. These should be removed prior to bonding. For optimum adhesion the use of Surface Activator is recommended.
- Soudaseal 2K cannot be used as a glazing sealant.
- Soudaseal 2K cannot be used for bonding of natural stone.
- A total absence of UV can cause a colour change of the sealant.
- When using different reactive joint sealants, the first joint sealant must be completely hardened before the next one is applied.
- Not suitable for bonding aquariums.
- Do not use in applications where continuous water immersion is possible.
- Discoloration due to chemicals, high temperatures, UV-radiation may occur. A change in colour does not affect the technical properties of the product.
- Contact with bitumen, tar or other plasticizer releasing materials such as EPDM, neoprene, butyl, etc. is to be avoided since it can give rise to discolouration and loss of adhesion.