

Soudaseal 235 SF

Revision: 11/01/2007

Page 1 of 2

Technical Characteristics:

Base	MS Polymer®
Consistency	Stable Paste
Curing System	Moisture Cure
Skin Formation (*) (20°C/65% R.V.)	Ca. 12 min.
Curing Rate (*) (20°C/65% R.V.)	2 à 3 mm/24h
Hardness (DIN 53505)	38 ± 5 Shore A
Specific Gravity (DIN 53479)	1,40 g/mL
Maximum Deformation	± 20 %
Temperature Resistance (fully cured)	-40°C to +90°C
Elasticity Modulus 100 % (DIN 53504)	0,75 N/mm ²
Tear Strength (DIN 53504)	2,20 N/mm ²
Elastical Recovery (ISO 7389)	> 75 %
Elongation at break (DIN 53504)	800 %
shear stress	1,2 N/mm ²
substrate	AlMgSi1
bond thickness	2 mm
jaw separation speed	10 mm/min

(*) these values may vary depending on environmental factors such as temperature, moisture, and type of substrates

Product:

Soudaseal 235 SF is a high quality, single component joint adhesive/sealant based on MS-Polymer®. It is chemically neutral and fully elastic.

Characteristics:

- Outstanding bond strength on nearly all surfaces
- High performance mechanical properties
- Flexible elastic rubber – movement accommodation up to ±20%
- Straightforward application even in adverse conditions
- No bubble formation within sealant (in high temperature and humidity applications)
- Very easy to tool and finish
- Good extrudability even at low temperatures
- Colour stable and UV resistant
- Ecological advantages – free of isocyanates, solvents, halogens and acids
- Minimal health and safety considerations
- Can be painted with all water based paints and many other systems (to be tested)

Applications:

Structural bonding which requires elasticity and high end strength.

Structural bonding in vibrating constructions. Supplement bonding in car-bodies, busses, trains, caravans and containers.

Ship and boat building (not suited as deck caulking).

Adhesion:

Soudaseal 235 SF has an excellent adhesion on almost all substrates. Soudaseal 235 SF has been tested on the following metal surfaces: steel, AlMgSi1, brass, electrolytic galvanised steel, AlCuMg1, flame galvanised steel, AlMg3 and steel ST1403. Plastics that were tested include: polystyrene, polycarbonate (Makrolon®), PVC, polyamide, 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.

Remark: The directives contained in this documentation are the result of our experiments and of our experience and have been submitted in good faith. Because of the diversity of the materials and substrates and the great number of possible applications which are out of our control, we cannot accept any responsibility for the results obtained. In every case it is recommended to carry out preliminary experiments.



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Page 2 of 2

NOTICE: bonding plastics like polycarbonate (ie Makrolon® or Lexan®) in stress loaded applications can give rise to stress cracking and crazing in these substrates. The use of Soudaseal 235 SF is not recommended in these applications. There is no adhesion on PE, PP and PTFE (Teflon®).

Packaging:*Colour:* white, black*Packaging:* cartridge 290mL, foil bag 600mL (hobcock 20L and drums 200L on request)**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 and chlorinated hydrocarbons

Substrates:*Nature:* clean, dry, free of dust and grease*Priming:* porous surfaces in water loaded applications should be primed with Primer 150. Surface Activator may be used to pre-treat non-porous surfaces.

We recommend preliminary compatibility tests previous to application.

Joint dimensions:*Minimal width:* 2mm (bonding)
5mm (joints)*Maximal width:* 10mm (bonding)
30mm (joints)*Minimum depth:* 5mm (joints)*Recommendation:* width of joint = 2x depth of joint**Application:***Method:* Manual- or pneumatic caulking gun*Application temperature:* +5°C until +35°C*Cleaning:* White Spirit or Surface Cleaner

immediately after application and before curing

Tooling: with soapy solution before skin formation*Repair with:* Soudaseal 235 SF**Health- and Safety Recommendation:**

Apply the usual industrial hygiene

Check the packaging for more information

Remarks:

- Soudasal 235 SF may be overpainted, 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 235 SF can be applied to a wide variety of substrates. Due to the fact that specific substrates such as plastics, polycarbonate etc may differ from manufacturer to manufacturer, we recommend preliminary compatibility tests.
- This product can not be used as a deck caulking sealant
- This product can not be used as a glazing sealant

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