

Code	Description	Size	Colour
20315	Soudaseal 2K	250ml	A – Grey, B - White

## 1. Description

Soudaseal 2K is a fast curing high quality two component Hybrid Polymer based adhesive/sealant. 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.

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, which is moisture and heat resistant. The adhesive has excellent adhesion to practically all common substrates used in the construction and building industry.

## 2. Characteristics

- Fast strength build-up
- Fast curing
- 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

## 3. Technical Data

<b>Base</b>	Hybrid polymer
<b>Curing System:</b>	Chemical Curing
<b>A Component</b>	
Consistency	Paste
Colour	Grey
Specific gravity (DIN 53479)	1,1 g/cm <sup>3</sup>
<b>B Component</b>	
Consistency	Paste
Colour	White
Specific gravity (DIN 53479)	1,7g/m <sup>3</sup>
<b>Set to load bearing*</b>	After 1 hour
<b>Shore D Hardness (A+B)</b>	40
<b>Elasticity Modulus 100% (DIN 53504)</b>	1.3MPa
<b>Elongation at Break (DIN 53504)</b>	350%
<b>Application Temperature</b>	+5°C until +40 °C
<b>Temperature Resistance (fully cured)</b>	-40 °C until +90 °C
<b>Shear strength</b>	>1,3 MPa
- <b>Substrate</b>	AlMgSi1
- <b>Thickness</b>	0.9mm
- <b>Shear velocity</b>	10mm/min

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

#### 4. Applications

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

- Elastic bonding between metal surfaces, coated surfaces and many plastics (not PE, PP, Teflon).
- Elastic high performance bonding, both interior and exterior.
- Elastic bonding applications in car-, coach-, caravan-, marine-, 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.

#### 5. Packaging

250ml. (A+B)

#### 6. Shelf Life

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

#### 7. Application Instructions

##### Surfaces

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: Clean, dry, free of dust and grease.  
Preparation: We recommend the use of Gorilla 669 Surface Activator on non-porous surfaces  
Application: 2mm Finished thickness for optimum bonding

##### Resistance to chemical agents:

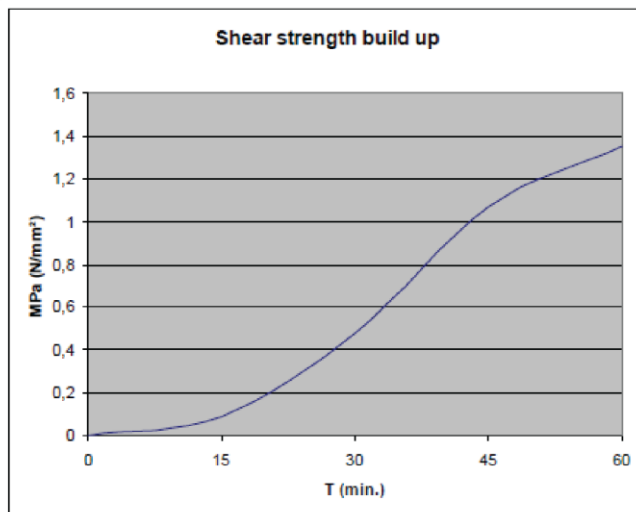
Good resistance to water, aliphatic solvents, mineral oils, grease, diluted inorganic acids and alkalis.

##### Bonding:

- Soudaseal 2K has excellent adhesion on many surfaces.
- The following metal surfaces have been tested; AlCuMg1, AlMgSi1, AlMg3, Al99, Brass, Electro galvanized Steel, Fire galvanized Steel, Steel ST1403 and Stainless Steel.
- Plastics that were tested include: polystyrene, polycarbonate (Makrolon®), polyamide (PA6), glass fibre 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.

There is no adhesion on PE, PP, PTFE (Teflon®) and ABS.



Clean: Gorilla Solvent Cleaner or Gorilla 696 Surface Activator, immediately after application.  
Finish: With soapy solution before skin formation.  
Repair: Soudaseal 2K

## 8. Limitations

- Due to the fact that specific substrates such as plastics, polycarbonate, etc, may differ from manufacturer to manufacturer, a preliminary adhesion test with these materials is imperative.
- This product cannot be used as a glazing sealant. Soudasel 2K has poor resistance to aromatic solvents, concentrated acids, chlorinated hydrogen.
- Soudaseal 2K is not suitable against the following materials; PE, PP, PTFE (Teflon) & ABS, Bituminous substrates, Copper or copper containing materials (Copper, Brass, Zinc-Bronze).  
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.

*Soudal recommends preliminary compatibility tests on surfaces on which PU Foams have not been applied previously.*

## 9. Health and Safety Recommendation

- Apply the usual industrial hygiene

### Remark

*The directives and data contained in this documentation is provided in good faith and accurately reflect Soudal's knowledge when its products are properly stored, handled and applied under normal conditions in accordance with Soudal's recommendations. In practice, the diversity of the materials, substrates, environments, site conditions, product storage, handling and application are such that no warranty can be given in respect to the merchantability or fit for purpose, of any product. All users must determine the product suitability for their purposes through testing. This technical data sheet and product properties may change without notice so users, suppliers and retailers of Soudal products should always check that the data sheets they have are the latest. To the maximum extent permitted by law, Soudal disclaims all warranties in relation to either the manufacture, storage and end use of the product. All orders are accepted subject to our current terms of trade. **If any clarification is required, please contact Soudal Technical Services or email [info@soudal.co.nz](mailto:info@soudal.co.nz).***

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