Soudabond 641

Technical data

Basis	Polyurethane
Consistency	Paste
Curing system	Moisture Curing (air humidity)
Skin formation* (23°C/50% R.H.)	Ca. 20 min
Curing speed * (23°C/50% R.H.)	2 mm/24h → 3 mm/24h
Hardness**	Ca. 65 Shore D
Density	1,43 g/ml
Shear strength**	After 24h ca. 2.8 N/mm², Final strength ca. 11 N/mm² (on Al99)
Temperature resistance**	-30 °C → 100 °C
Application temperature	5 °C → 35 °C

* These values may vary depending on environmental factors such as temperature, moisture, and type of substrates. ** This information relates to fully cured product.

Product description

Soudabond 641 is a 1-component construction adhesive based on polyurethane for bonding corner pieces in aluminum window profiles by pre-injection (injection before assembly).

Properties

- Excellent adhesion on aluminum
- Fast strength build-up
- Very high final strength
- Free of solvents and water
- Moisture curing
- Foaming penetration action to fill bond cavities
- Ready for use

Applications

- For bonding angle pieces in extruded aluminium window profiles by means of pre-injection (injection before assembly).
- Bonding of various metals

Packaging

Colour: black, beige
Packaging: 310 ml cartridge

Shelf life

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

Substrates

Substrates: metals, aluminium, wood, stone, PVC, Not suitable for glass, PE, PP, PA, EPDM and Teflon.
Nature: rigid, clean, dry, free of dust and grease.
Surface preparation: No pretreatment required. We recommend a preliminary adhesion test on every surface.

Application method

Application method: Apply sufficient Soudabond 641 into the cut window frame with a manual or pneumatic caulk-gun and slide the corner piece into the window frame before the adhesive starts to skin. Additional wetting in order to accelerate the curing is necessary. In doing so, care should be taken not to moisten the mitre cuts. Therefore it is preferable to apply Soudal AluSeal on the mitre cuts before injecting Soudabond 641. Another possibility is to immerse the corner piece in water just before assembly, to prevent water contact on the mitre cuts or Aluseal. Clamping the materials together, during curing, is required in order to achieve the highest possible final strength. The use of Soudabond 641 should be limited to the pre-injection method (application before assembly). For bonding through post-injection it is preferable to use Soudabond 642 Duo, a self-curing 2 component system.

Cleaning: Uncured Soudabond 641 can be removed from substrates and tools with Soudal Gun and Foam Cleaner. Cured Soudabond 641 can only be removed mechanically.
Repair: With the same material.

Health- and Safety Recommendations
Take the usual labour hygiene into account. Consult label for more information.

Environmental clauses
Leed regulation:
Soudabond 641 conforms to the requirements of LEED. Low –Emitting Materials: Adhesives and Sealants. SCAQMD rule 1168. Complies with USGBC LEED 2009 Credit 4.1: Low-Emitting Materials – Adhesives & Sealants concerning the VOC-content.

Liability
The content of this technical data sheet is the result of tests, monitoring and experience. It is general in nature and does not constitute any liability. It is the responsibility of the user to determine by his own tests whether the product is suitable for the application.