



# Soudabond 658 GB

## Product description

Soudabond 658 GB is a high-quality, elastic, one-component, solvent-free adhesive sealant based on SMX-polymer with high initial tack and rapid strength build-up.

## Properties

- Flexible
- High initial tack
- Fast strength build-up
- High end strength
- Good sag resistance
- Good weather and UV resistance
- Does not shrink

## Applications

- All kinds of bonding in industry.

## Technical data

Base		SMX Hybrid Polymer
Consistency		Stable paste
Curing system		Moisture curing
Skin formation		ca. 15 minutes
Curing speed		> 3 mm/24h
Density		1,47 g/ml
Elasticity modulus	ISO 37	2,20 N/mm <sup>2</sup>
Elongation at break	ISO 37	> 250 %
Maximum tension	ISO 37	ca. 3,40 N/mm <sup>2</sup>
Hardness		ca. 60 ± 5 Shore A
Application temperature		+5°C → +40°C
Temperature resistance		-30°C → +90°C

*Footnote: Skinning time and curing speed may vary depending on environmental factors such as temperature, moisture, and type of substrates.*

## Substrates

- Substrate condition  
The surface must be rigid, clean, dry, free of dust and grease.
- Substrate preparation  
The surfaces should be degreased before bonding them together. All smooth surfaces can be treated with Soudal Surface Activator.
- Substrate types  
Soudabond 658 GB has a good adhesion to following substrates: plastics, metals, etc.. Soudabond 658 GB has no good adhesion or is not suitable for PE, PP, PTFE (Teflon®), bituminous substrates. We recommend a preliminary adhesion and compatibility test on every surface.



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## Application method

- Application method  
Apply Soudabond 658 GB with a manual- or pneumatic caulking gun.
- Cleaning method  
Clean with Soudal Surface Cleaner or with Soudal Swipex Wipes, immediately after use.
- Finishing method  
Finish with a soapy solution or Finishing Solution before skinning.
- Repair method  
Repair with the same material.

## Health- and Safety Recommendations

Take the usual labour hygiene into account. Consult the packaging label and safety data sheet for more information.

## Packaging/Logistics

Colour: Please consult the product catalogue, the Soudal website or a Soudal representative.

Packaging: Please consult the product catalogue, the Soudal website or a Soudal representative.

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

This technical data sheet replaces all previous versions. The directives contained in this documentation are the result of our experiments and of our experience and have been submitted in good faith. It is general in nature and does not constitute any liability. 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. Since the design, the quality of the substrate and processing conditions are beyond our control, no liability under this publication is accepted. It is the responsibility of the user to determine by his own tests whether the product is suitable for the application. In every case it is recommended to carry out preliminary experiments. The manufacturer reserves the right to modify products without prior notice.