# SOUDAFLEX 611

## Sealant/Adhesive

**Technical Data:**

| | |
|---|---|
| Base | Polyurethane |
| Colour | White, Black |
| Consistency | Paste, easy to extrude |
| Skin formation (20°C/65% R.H.)* | 20 - 30 min. |
| Curing System | Moisture Cure |
| Curing Rate (20°C/65% R.H.)* | 4 mm/24h |
| Hardness (DIN 53505) | 45 ± 5 Shore A |
| Specific Gravity (DIN 53479) | 1,28 g/ml |
| Temperature Resistance | -40°C to +90°C * Short Term upto 120°C |
| Elastical Recovery (ISO 7389) | > 80% |
| Maximum allowed Distortion | 20% |
| Elasticity Modulus 100% (DIN 53504) | 0,60 N/mm$^2$ |
| Tensile strength (DIN 53504) | 1,85 N/mm$^2$ |
| Elongation at Break (DIN 53504) | 700 % |
| Solids Content | > 90% |

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

**Product:**

Soudaflex 611 has been specially developed for Indian subtropical conditions after a decade of research, practical application understanding of Indian climate conditions, it is most suitable in high temperature & extreme humid conditions.

Soudaflex 611 is specifically designed for sealing application in the Bus & Coach, Truck, Earth Moving Equipments, Tractor, Forklift, OEM, Repair Auto After Markets, Metro, Railway, Defence, Aviation, Marine & various other commercial and industrial vehicles.

It bonds a variety of material like are FRP, GRP, timber, plywood, metals, particularly aluminium (including anodized components), sheet steel (including phosphated, chromated and zinc-plated components), coated metals and paint coatings (two-part systems), ceramic materials & plastics.

**Characteristics:**

- Bonds well to a wide variety of substrates.
- Excellent resistance to many chemicals.
- Can be over-painted & non-sag consistency.
- Especially developed for automotive and bus industry, bodywork, container applications.
- Suitable for making permanent elastic seals of high adhesive strength.
- High mechanical/dynamic stress resistance – shock/impact resistant.
- Increases torsional stiffness of final assembly.
- Excellent resistance to aging, weathering – suitable for indoor and outdoor.
- Vibration and sound damping properties.
- Sandable & over-paintable with many water, solvent based paints (preliminary tests recommended).










# SOUDAFLEX 611

## Sealant/Adhesive

**Application:**

- All sealing & bonding applications in the automotive industry (car, bus, truck, train & marine applications).
- Repair and refinishing purpose in automotive/ car industry.
- General coach-building, caravans & motor-homes assembly and repairing.
- Bus & truck industries, container construction, including pipe-work and fittings.
- Thermal & acoustic insulation technology in refrigeration, air-conditioning.
- Suitable substrate materials are timber, metals, particularly aluminium (including anodised components), sheet steel (including phosphated, chromated and zinc-plated components), metal primers and paint coatings (two-part systems), ceramic materials and plastics.
- For elastic bonding to untreated metals & plastics the use of Primers is recommended.

**Packaging & Colour:**

Colour: Black, White

Packaging: 310ml Cartridge & 600ml sausage

**Storage/Shelf Life:**

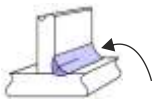
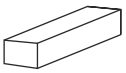
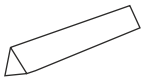
The storage and application of PU sealant affect the shelf life and usage. The shelf life of all given is understood to be 12 months from the date of manufacturing if kept in the temperature from 5°C to 35°C.

In the specific case of India, since practically the temperature rises up to 45°C to 50°C, the sealant can still be used, due to extreme heat or humidity, the skin formation time of the same may be little faster in those specific conditions, yet the sealant can still be used with effectiveness.

**Surface Preparation:**

The surfaces to be treated should be perfectly clean, dry and free from dust, oil and grease. It is necessary to apply Soudal Universal Cleaner 165 on glass.

The adhesion on normal vehicle varnishes generally does not require the use of Soudal Universal Primer 175. It is advisable to carry out preliminary adhesion tests on the support. Specific guidance regarding the use of Primers may be obtained by submitting substrate samples to our laboratory.

| Fillet bead | Flat bead | Triangular bead |
|---|---|---|
|  |  |  |

| General chart for bead size for various parts: | | |
|---|---|---|
| **Location** | **Type of bead** | **Dimension of bead** |
| Windows: 3 sides (not at the bottom) | Flat bead | 6 mm |
| Roof top joints | Flat bead | 10 mm |
| Wheel arches | Fillet | 6-8 mm |
| Tail lamps | Fillet | 4-6 mm |
| Internal or interior panel joints or gaps | Fillet | 8-10 mm |
| Between the structure and inner panels before window fitment | Fillet | 8-10 mm |
| Glass pasting/bonding | Triangular | 8-10 mm |