

# SODAFLEX 621

Revision: 01/04/2024

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## Technical Data

Basis	Polyurethane
Consistency	Stable paste
Curing system	Moisture Curing
Skin formation* (23°C/50% R.H.)	Ca. 50 min
Curing speed * (23°C/50% R.H.)	3 mm/24h → 4 mm/24h
Hardness**	Ca. 40 ± 5 Shore A
Density	1.26 g/ml
Elastic recovery (ISO 7389)**	> 80 %
Maximum allowed distortion	± 20 %
Elasticity modulus 100% (ISO 37)**	1.34 N/mm <sup>2</sup>
Elongation at break (ISO 37)**	1.52 N/mm <sup>2</sup>
Max. tension (ISO 37)**	0.20 N/mm <sup>2</sup>
Temperature resistance**	-30°C → 90°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.

### Description:

Soudaflex 621 is a strong and permanently elastic polyurethane adhesive for bonding and sealing in the automotive and transport industry.

- Also bonding of upright parts
- For bonding container elements, car body parts, wind screens, wheel arch extensions, etc...
- Replaces the traditional weld or spot weld.

### Properties:

- Medium open time
- High viscosity
- Applicable in warm and humid climate.
- Permanently elastic after curing
- Good weather and UV resistance
- Water tight
- Excellent resistance to many chemicals
- Can be painted with all water based paint sand many other systems (to be tested)
- Very good primerless adhesion on many materials such as aluminium, steel, GRP, epoxy coatings etc.

### Packaging:

Colour: white, black  
Packaging: 600ml foil bag, other packaging on request

### Shelf life and storage:

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

### Health and Safety Recommendation:

Take the usual labour hygiene into account. Use only in well-ventilated areas.  
Consult the packaging label for more information.

### Applications:

- Supple bonding and sealing in vibrating constructions in car bodies, caravans and containers.

**Remark:** Remark: 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. 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. In every case it is recommended to carry out preliminary experiments. Soudal reserves the right to modify products without prior notice.

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**Substrates:**

Substrates: all metals, epoxy coatings, polyesters, There is no adhesion on PE, PP, PTFE (Teflon®) and bituminous substrates. No adhesion on glass and PVC. We recommend a preliminary adhesion test on any substrate.

Nature: Rigid, clean, dry, free of dust and grease.

Surface preparation: All smooth surfaces can be treated with Soudal Surface Activator.

**Application Method:**

Application method: With manual or pneumatic caulking gun.

Cleaning: Clean with Soudal Surface Cleaner or with Soudal Swipex, immediately after use

Finishing: With a soapy solution or Soudal Finishing Solution before skinning.

Repair: With the same material.

**Remarks:**

- Soudaflex 621 may be over painted with water based paints, however due to the large number of paints and varnishes available we strongly suggest a compatibility test before application.
- When painted with oxidative drying paints disturbances in the drying of the paint may occur (we recommend to do a compatibility test before application).
- Remove all traces of soap (tooling) because it will harm the adhesion of the paint onto the sealant

**Standards and certificates:**

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.

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