

SOUDAPUR 6342

Revision: 1/04/2024

Page 1 of 2

Technical Data

Basis	Polyurethane
Consistency	Liquid
Curing system	Polymerisation through moisture
Density	1,15 g/ml
Viscosity (Brookfield)	Ca. 6.000 mPa.s
Open time (23°C, 55% RV) (*)	± 20 min
Shear	> 9 N/mm ² (Wood/Wood)
Consumption (*)	100-250 g/m ²
Temperature resistance**	-35°C to 80°C
Application temperature	5°C to 35°C

*These values may vary depending on environmental factors such as temperature, moisture and the type of substrate.

**This information relates to fully cured products.

Description:

Soudapur 6342 is a one-component, solvent-free, ready to use, universal construction adhesive based on polyurethane. It has excellent adhesion, a fast build-up of strength, and fast curing when moistened.

Properties:

- Professional quality
- Very high final strength
- Moisture- and weather-resistant
- Foams up slightly, fills up cavities
- Good temperature resistance

Packaging:

Colour: Yellow/brown

Packaging: 25 L jerrycan, 200 L drum, 1000 LIBC

Applications:

- All kinds of bonding in the industry
- Bonding of rigid plastic panels
- Bonding of soft and hard polystyrene
- Bonding of a.o. polyether, polyurethane, and polystyrene foams, metal foils, felt, textiles, cork, both among themselves and on paper, cardboard, wood, chipboard and metal

Shelf Life and Storage:

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

Remark: 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. In every case it is recommended to carry out preliminary experiments.

Health and Safety Recommendations:

Take the usual labor hygiene into account.

Wear gloves. Consult the label and material safety data sheet for more information.

Substrates:

Substrates: all usual substrates for bonding, a variety of porous and non-porous materials. Not suitable for PE, PP, PTFE, and bitumen.

We recommend a preliminary adhesion test on any substrate.

Nature: clean, free of dust and grease.

Application Method:

Application method: Soudapur 6342 cures by reacting with water and foams during this process. If the surface is moistened (e.g., by atomization), the curing process accelerates and the filling capacity of the adhesive increases. 3-5% water/glue is sufficient. Clamping of the materials during curing is necessary in order to achieve the final maximum possible strength. Due to the foaming reaction, clamping or pressing is recommended. The curing can be further accelerated by using a heated press; we recommend not to exceed 70°C.

Cleaning: Acetone or Iso-propanol, or with Soudal Swipex. Cured Soudapur 6342 can only be removed mechanically.

Repair: With the same material.